



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pollot Dies)

9647

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14435	5-155
2	Machined By		V.T.L. H.C. Shop	Pythar 1.2.2.14951
3	Pallet Die No.		13591 (4.5) H.H.	Rem 2.00
4	Die Category	Drg. No.	Part wide	
5	Out Side Diameter	Drg. No.	630 H.H. Step 00. 821.5 H.H.	Tapping 12"
6	Inside Diameter	Drg. No.	520.12 H.H.	Step length 2.5
7	Width of Pellet Die	Drg. No.	222 H.H.	
8	Grooves as per Drawing	Drg. No.	13x8x5 H.H. 13x8x5 H.H.	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H.C. Shop	
12	Tapping PCD		565 H.H.	Tapping no. of holes 12
13	Tapping Hole Diameter		1200 Check by H2 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 H.H. Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 17/4/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60

1	Counter Sinking Depth & Finish	ok								Raw: 29
2	External Relief Dia	5.0 H.H.	Outside (2-3)		Inner					
3	External Relief Depth		14 H.H.		5 H.H.					
4	Inspection Done Before Hardening By (Name)									Raw:
5	Material Sent For Hardening By (Name)									Lark Parnace
6	Material Sent For Hardening On Date		17	4	25					

Inspected By (Sign) & Date

Raw: 17/4/25

Reviewed by (Engineer-CNC)

Manager-QA