



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 (Pollet Dies)

9692

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14792	36/47
2	Machined By		V.T.L. N/C Shop	Qty No. 12.0.875
3	Pallet Die No.		14639 (3.0)mm	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	614mm	Step 00. 622.6mm, Step length 18
6	Inside Diameter	Drg. No.	520.12mm	Tapper: 12
7	Width of Pellet Die	Drg. No.	222mm	Undercut: 4.2mm
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No. of holes: 12 Both Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M20. Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.4mm	Tapping Depth: 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rawi 23/4/25

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

Coorden. Bo

1	Counter Sinking Depth & Finish	OK						Rawi 23/4/25
2	External Relief Dia	3-5mm	23-35	Inner				
3	External Relief Depth		17mm	11mm				
4	Inspection Done Before Hardening By (Name)							Rawi
5	Material Sent For Hardening By (Name)							Lark Porvase
6	Material Sent For Hardening On Date		23	4	25			

Inspected By (Sign) & Date

Rawi 23/4/25

Reviewed by (Engineer-CNC)

Manager-QA