



Lark Engineering Company (India) Pvt. Ltd.

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

9712

Form No. CNC/QA/FM/02

Rev. No. 01

Rev. Date 31-07-2013

Inprocess Inspection (Polot Dlos)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14822 ✓	27/66
2	Machined By		V.T.L. H/c Shop	Dr. No. 120-32
3	Pallet Die No.		14821 (B.O) H/c	Revised
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 H/c	Step 001 693 H/c
6	Inside Diameter	Drg. No.	546.12 H/c (B.O. 548.1 H/c)	Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut 2.8 H/c
8	Grooves as per Drawing	Drg. No.	32-7-9.1 H/c	32-7-9.1 H/c (4-81 H/c)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 H/c	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.4 H/c	Tapping Depth 31.4 H/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 24/4/25	
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				
1	Counter Sinking Depth & Finish	OK		Counter 30
2	External Relief Dia	7.0 H/c	All Rows	Row 12
3	External Relief Depth		39 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Lorraine	
6	Material Sent For Hardening On Date		24 4 25	
Inspected By (Sign) & Date			Ravi 24/4/25	

Reviewed by (Engineer-CNC)

Manager-QA