



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14757 ✓	34/40 ✓
2	Machined By		V.T.C. H/c Shop	Dry H/c 1.3.7.881
3	Pallet Die No.		14964 (3.0) H/c	Rev. 1.00
4	Die Category	Drg. No.	32 H/c	
5	Out Side Diameter	Drg. No.	500 H/c Step 00. 490.7 H/c	Step length 6.5
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	173 H/c	
8	Grooves as per Drawing	Drg. No.	12x10x5 H/c 12x10x5 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		455 H/c	
13	Tapping Hole Diameter		03/4" = Check by 003/4" Ball	Tapping No. of Holes 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c Tapping Depth 18.7	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	APPROVED.
Inspected By (Sign) & Date			Pass: 5/5/25	AS Per
1	As per programme no.		✓	Discussion with
2	Gun Drilling Work Completed On		✓	Sales team &
3	Hole Finish In Gun Drilling	Marked	OK	Management.
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 = 60
2	External Relief Dia	3.3 H/c	20 Side (2-2)	Inner
3	External Relief Depth		12 H/c	6 H/c
4	Inspection Done Before Hardening By (Name)		Pass:	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		5 5 25	
Inspected By (Sign) & Date			Pass: 5/5/25	

Reviewed by (Engineer-CNC)

Manager-QA