



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14850	58/66
2	Machined By		V. T. h/c Shop	Dr. H. 18.0.390
3	Pallet Die No.		14988 (9.0) H	Rev. 08
4	Die Category	Drg. No.	H. Jumbo	4-3
5	Out Side Diameter	Drg. No.	680.1 H	Step 005 693 H
6	Inside Diameter	Drg. No.	546.12 H	(Bar. 548.1 H) Step length 30 H
7	Width of Pellet Die	Drg. No.	195 H	End cut. 2.8 H
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H	32 x 7 x 9.1 H (4 x 8) H
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side 30
10	Drilling Area Surface Smoothness		ok	2 H Dash
11	Tapping Operator		h/c Shop	Both Side
12	Tapping PCD		619 H	Tapping H
13	Tapping Hole Diameter		H16 2	Check by H16 Ball
14	Tapping On Second Side	Half pitch of 1st side	ok	of holes = 2
15	Tapping Hole Depth		Drill Depth = 33.4 H	Tapping Depth = 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Res: 8/5/25

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. 60
2	External Relief Dia	10.0 H		All Rows				Res: 8
3	External Relief Depth			8 H				
4	Inspection Done Before Hardening By (Name)			Res:				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date			8	5	25		

Inspected By (Sign) & Date

Res: 8/5/25

Reviewed by (Engineer-CNC)

Manager-QA