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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 Dlos)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14850	58/66
2	Machined By		V.T.C. H/a. Shop	Qty 11, Lot No. 820
3	Pallet Die No.		14989 (9.0) H/a	Rev 08
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	68.1 H/a. Step 00. 69.3 H/a. Tapper 8	
6	Inside Diameter	Drg. No.	54.6.12 H/a. (Bar, 54.8.1 H/a)	Step length 31 H/a
7	Width of Pellet Die	Drg. No.	19.5 H/a	Under cut 2.8 H/a
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/a. 32 x 7 x 9.1 H/a. (4 x 8) H/a	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 H/a Deep
11	Tapping Operator		H/a. Shop	Both Side
12	Tapping PCD		619 H/a	Tapping H/a
13	Tapping Hole Diameter		H/a. Check by H/a Bolt	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 H/a. Tapping Depth 31.0 H/a	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sai: 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/a	6.0 H/a	All loose				Rev 08
3	External Relief Depth			8 H/a				
4	Inspection Done Before Hardening By (Name)			Sai				
5	Material Sent For Hardening By (Name)			Lark Perware				
6	Material Sent For Hardening On Date		8	5	25			
Inspected By (Sign) & Date				Sai: 8/5/25				

Reviewed by (Engineer-CNC)

Manager-QA