



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)

9873

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15000	26/40
2	Machined By		V.T.L. H/c Shop	95
3	Pallet Die No.		14527 (3.2) H/c	Dy. Lark 9873
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.9 H/c	Step on 490.9 H/c
6	Inside Diameter	Drg. No.	420.12 H/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		H/c	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 H/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/5/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		H/c

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter Bo

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.8 H/c	Outside (2.2)		Inner				
3	External Relief Depth		18 H/c		14 H/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date

Ravi 15/5/25

Sat 15/5/25

Reviewed by (Engineer-CNC)

Manager-QA