



Lark Engineering Company (India) Pvt. Ltd.

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

9865

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.		14860	28/38/66
2	Machined By		V. T. L. H/c Shop	Day 4, 12.9.09
3	Pallet Die No.		14995 (6.0) H/c	Rev 203
4	Die Category	Drg. No.	H. Tumbo	
5	Out Side Diameter	Drg. No.	680.7 H/c	Step 001 693 H/c
6	Inside Diameter	Drg. No.	546.12 H/c	Topper 8
7	Width of Pellet Die	Drg. No.	(Box 548.4 H/c)	Step length 31 H/c
8	Grooves as per Drawing	Drg. No.	195 H/c	Under cut 2.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.2 H/c	32.7 x 9.2 H/c
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 H/c	
13	Tapping Hole Diameter		H/c	
14	Tapping On Second Side	Half pitch of 1st side	H/c Check by H/c Ball	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		OK	
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

1	As per programme no.		Pass 14/5/25
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 230
2	External Relief Dia	6.5 H/c	7.0 H/c	6.5 H/c	All Rows	2	38	H/c		Row 12
3	External Relief Depth			7.0 H/c	All Rows	2	38	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					14	5	25		

Inspected By (Sign) & Date

Pass 14/5/25	Pass 14/5/25
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Reviewed by (Engineer-CNC)

Manager-QA