



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	Speciflcation	Observations	Remarks
1	Work Order No.		14926	22/4-
2	Machined By		V.T.L. n/c Shop	Drg. 12.04.00
3	Pallet Die No.		14945(4.0) n/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5mm Step 00. 491.9mm	Step length 3.5
6	Inside Diameter	Drg. No.	42.14mm	
7	Width of Pellet Die	Drg. No.	159mm	
8	Grooves as per Drawing	Drg. No.	7x7x5mm 7x7x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		455mm	
13	Tapping Hole Diameter		03/4" Check by 03/4" Ball	Tapping No. of holes 8 Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 23mm Tapping Depth 21mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 17/5/25

1	As per programme no.			2 Slot
2	Gun Drilling Work Completed On			20.1mm width 7mm Deep
3	Hole Finish In Gun Drilling	Marked	ok	Bottom Side
4	Defective Holes (If Any)		No	2 Case per dy Slot Counter Go

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

1	Counter Sinking Depth & Finish	ok							Ravi 21
2	External Relief Dia	4.5mm	Outside 2.2		Inner				
3	External Relief Depth		6mm		2mm				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		17	5	25				

Inspected By (Sign) & Date

Ravi 17/5/25

Reviewed by (Engineer-CNC)

Manager-QA