



Lark Engineering Company (India) Pvt. Ltd.

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

9896

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Polot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14867	45/60
2	Machined By		V. T. L. H/C Shop	Dr. No. 18.2.584
3	Pallet Die No.		14540 (8.0) H/C	Renol
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H/C	Step 00. 798 H/C
6	Inside Diameter	Drg. No.	660.14 H/C	Step length 25.5
7	Width of Pellet Die	Drg. No.	324 H/C	Under cut 9 H/C
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping
12	Tapping PCD		725 H/C	of holes 12
13	Tapping Hole Diameter		H20. Contact by H20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 30.4 H/C	Tapping Depth 28.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/5/25

1	As per programme no.			2 slot
2	Gun Drilling Work Completed On			32.1 H/C width
3	Hole Finish In Gun Drilling	Marked	ok	8 H/C Depth
4	Defective Holes (If Any)		No	Both Side

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

Counter 60

1	Counter Sinking Depth & Finish	ok						Ravi 27
2	External Relief Dia	8.5 H/C	Outside 23.3		Inner			
3	External Relief Depth		23 H/C		15 H/C			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		19	5	25			

Inspected By (Sign) & Date

Ravi 19/5/25

Reviewed by (Engineer-CNC)

Manager-QA