

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 (Polot Dies)

Remarks

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14941	14/50
3	Pallet Die No.		V. T. C. H/C Shop	Drg. No. 12.9.261
4	Die Category	Drg. No.	15117 (4.0) H/C	Rev. 00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	519.8 H/C	498.8 Tapping 12"
7	Width of Pellet Die	Drg. No.	42.12 H/C	Step length 18"
8	Grooves as per Drawing	Drg. No.	158 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 H/C / 12 x 8 x 3 H/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping 12"
12	Tapping PCD		454 H/C	at hole 8
13	Tapping Hole Diameter		H202 Check by H202 Ball	Bottom Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.6 H/C	Tapping Depth 18"
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	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	4.5 H/C	20 Side (2-2)		Inner					
3	External Relief Depth		14 H/C		6 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 19/5/25

Signature 19/5/25

Reviewed by (Engineer-CNC)

Manager-QA