



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 Dlos)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15138 ✓	40/5 ✓
2	Machined By		V. T. L. n/c Shop	① Dy. H. G. 11/28/06
3	Pallet Die No.		14311 (4.0) ✓	Revised ✓
4	Die Category	Drg. No.	SS870	
5	Out Side Diameter	Drg. No.	620 mm, Step 00 623 mm	② Tapper 12
6	Inside Diameter	Drg. No.	520.14 mm	Step length 18 mm
7	Width of Pellet Die	Drg. No.	186 mm ✓	Under cut 2.5 mm
8	Grooves as per Drawing	Drg. No.	13x8x3 mm 13x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		420.2 Check by 420 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 9/6/25 ✓

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 6.2
2	External Relief Dia	4.5 mm	8.3-35		Inner				10.2 25
3	External Relief Depth		14 mm		10 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		9	6	25				

Inspected By (Sign) & Date

Raw: 9/6/25

Reviewed by (Engineer-CNC)

Manager-QA