



Lark Engineering Company (India) Pvt. Ltd.

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

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pollot Dlog)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15187	50/50
2	Machined By		N.T.L. n/c Shop	Dy. No. 12.0.450
3	Pallet Die No.		15463 (G.O) n/c	Rev. 00
4	Die Category	Drg. No.	785	
5	Out Side Diameter	Drg. No.	730 n/c	Step 00, 743.9 n/c
6	Inside Diameter	Drg. No.	630.14 n/c	Tapping 10
7	Width of Pellet Die	Drg. No.	290 n/c	Step length = 23 n/c
8	Grooves as per Drawing	Drg. No.	15x8x5 n/c / 15x8x5 n/c	Under cut = 3.75
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		685 n/c	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.5 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 16/6/25	
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		
2	External Relief Dia	6.5 n/c	Outside 23-25	Inner
3	External Relief Depth		6 n/c	Nil
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		16	6 25
Inspected By (Sign) & Date			Ravi 16/6/25	

Reviewed by (Engineer-CNC)

Manager-QA