



Lark Engineering Company (India) Pvt. Ltd.

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

10083

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pollet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15189	45/60
2	Machined By		V. T. L. N/C Shop	Dry Holes 1.3.0. 343
3	Pallet Die No.		15638(8.0) H	Revs 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H	Step 00, 798 H
6	Inside Diameter	Drg. No.	660.14 H	Step length 25.5
7	Width of Pellet Die	Drg. No.	384 H	Under cut 9
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 7 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		725 H	
13	Tapping Hole Diameter		H20 - Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 30.4 H	Tapping Depth 28.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 14/6/25

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	8.5 H	Outside 23.3		Inner				
3	External Relief Depth		23 H		15 H				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		14	6	25				

Inspected By (Sign) & Date

Ravi 14/6/25

Reviewed by (Engineer-CNC)

Manager-QA