



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

Inprocess Inspection (Pollet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15213	45/5
2	Machined By		V.T.L. n/c Shop	Drg. 4.1.2.3.2.3.70
3	Pallet Die No.		15123 (G.-) n/c	Rev. 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	522 n/c, Step 00. 491 n/c	Step length 13.5
6	Inside Diameter	Drg. No.	420.14 n/c	19 n/c
7	Width of Pellet Die	Drg. No.	159.5 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c / 13.5x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c	Tapping n/c of 4.1.2.3.2.3.70
13	Tapping Hole Diameter		23/4" - Check by 23/4" Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.6 n/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/6/25

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 60
2	External Relief Dia	8.5 n/c	Outside 2-23		Inner			Rev. 15
3	External Relief Depth		11 n/c		5 n/c			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Purnore			
6	Material Sent For Hardening On Date		18	6	25			

Inspected By (Sign) & Date

Ravi 18/6/25

Reviewed by (Engineer-CNC)

Manager-QA