



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 (Pollot Dies)

10164

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15251	45/50
2	Machined By		V.T.L. n/c Shop	Dry run for 10969
3	Pallet Die No.		14552 (4.0) n/c	Rev=01
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	76mm	Step 00-792mm
6	Inside Diameter	Drg. No.	66.14mm	Step length 97
7	Width of Pellet Die	Drg. No.	323-9mm	Under cut 46mm
8	Grooves as per Drawing	Drg. No.	21x8x10mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		725mm	
13	Tapping Hole Diameter		M20 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 27.4mm	Tapping Depth 25.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sasi 28/6/25

1	As per programme no.								
2	Gun Drilling Work Completed On								
3	Hole Finish In Gun Drilling	Marked							
4	Defective Holes (If Any)								

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5mm	Outside (3-3)		Inner				
3	External Relief Depth		13mm		5mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		28	6	25				

Inspected By (Sign) & Date

Sasi 28/6/25

Reviewed by (Engineer-CNC)

Manager-QA