



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)

10192

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15339	36/42
2	Machined By		V. T. L. H/c Shop	Dy. M. 13.2.1359
3	Pallet Die No.		15573(3.0) H/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	504 H/c Shop 00, 499 H/c	Tapping 12"
6	Inside Diameter	Drg. No.	420.14 H/c	Step length - 2 H/c
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/c 12 x 8 x 3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		H/c, Check by H/c Bull	Tapping H/c of L-100.8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 18.6 H/c	Tapping Depth 18.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/7/25

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

Counter As Low. 24

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5 H/c	Outside (2.2)		Inner		
3	External Relief Depth		12 H/c		6 H/c		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Furnace		
6	Material Sent For Hardening On Date		2	7	25		

Inspected By (Sign) & Date

Ravi 21/7/25

Satish 21/7/25

Reviewed by (Engineer-CNC)

Manager-QA