



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 (Pollock Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15307	415/55
2	Machined By		M.T.C. H/c Shop	Drilling 12.2.63
3	Pallet Die No.		12397 (8.0) H/c	Rev. 05
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	629.9 H/c	Step 00. 822.8 H/c
6	Inside Diameter	Drg. No.	520.14 H/c	Step length. 18
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		565 H/c	of holes = 12
13	Tapping Hole Diameter		M20. Check by H/c Ball	Rev Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth - 18
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sasi 1/7/25

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 60

1	Counter Sinking Depth & Finish	ok							Rev. 18
2	External Relief Dia	8.5 H/c	Outside (3-3)		Inner				
3	External Relief Depth		18 H/c		10 H/c				
4	Inspection Done Before Hardening By (Name)				Sasi				
5	Material Sent For Hardening By (Name)				Lark's Furnace				
6	Material Sent For Hardening On Date		1	7	25				

Inspected By (Sign) & Date

Sasi 1/7/25

Reviewed by (Engineer-CNC)

Manager-QA