



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 (Pollet Dies)

10183

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15315	62166
2	Machined By		V-7.1 n/c Shop	Dy. No. 12.069
3	Pallet Die No.		15335 (9.0) n/c	Remo 3
4	Die Category	Drg. No.	M.10000	Remo 4
5	Out Side Diameter	Drg. No.	680.7 mm Step 00. 692.8 mm Tapped	8
6	Inside Diameter	Drg. No.	546.14 mm (Bore 548.4 mm) Step length 3 mm	
7	Width of Pellet Die	Drg. No.	195 mm	
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 mm / 32.7 x 9.2 mm (4 x 2) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	9 mm Drill Bore
11	Tapping Operator		n/c Shop	Side
12	Tapping PCD		619 mm	Tapping Hole
13	Tapping Hole Diameter		H16. Check by H16 Ball	of holes. 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 mm	Tapping Depth 81.
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 1/8/25

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							Row. 8
2	External Relief Dia	10.0 mm	All	Rows					
3	External Relief Depth			4 mm					
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date

Ravi 1/8/25

Manager-QA

Reviewed by (Engineer-CNC)