



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)

10175

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15346	L15/60/
3	Pallet Die No.		V.7.1 n/a Shop	Original 12.0408
4	Die Category	Drg. No.	15510 (B.O) n/a	Review
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	72 mm, Step 002 692.8 mm	Tapping 12
7	Width of Pellet Die	Drg. No.	600.14 mm	Step length 2 mm
8	Grooves as per Drawing	Drg. No.	222 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x 8x 7 mm / 12x 8x 7 mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		n/a Shop	
13	Tapping Hole Diameter		640 mm	Tapping of hole = 12
14	Tapping On Second Side	Half pitch of 1st side	12 - Check by 12 3.12	Back side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 2.4 mm	Tapping Depth 8
17	Visual Inspection Before Gun Drilling		Yes	
			OK	
Inspected By (Sign) & Date			Ravi 27/6/25	
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 6
2	External Relief Dia	8.5 mm	Outside 23.35	Inner 15 mm
3	External Relief Depth		23 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ravi	
6	Material Sent For Hardening On Date		27 6 25	
Inspected By (Sign) & Date			Ravi 27/6/25	

Reviewed by (Engineer-CNC)

Manager-QA