



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)

10174

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15254 ✓	36/45
3	Pallet Die No.		V.T.L. n/c Shop	Drg. No. 12.2 868
4	Die Category	Drg. No.	13489 (B.2) n/c	Rev. no
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	510 n/c Step on 491 n/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	420.74 n/c	
8	Grooves as per Drawing	Drg. No.	164 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	15x8 = 3 n/c / 15x8x3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		455 n/c	Tapping Holes of Hole 8
14	Tapping On Second Side	Half pitch of 1st side	0.31 n/c 2 Check by 0.31 n/c	Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 81.4 n/c	Tapping Depth 89.4
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

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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 Sink
2	External Relief Dia	6.5 n/c	Outside (2-2)		Inner			Rev: 75
3	External Relief Depth		15 n/c		9 n/c			
4	Inspection Done Before Hardening By (Name)							Rev:
5	Material Sent For Hardening By (Name)							Lark Engineering
6	Material Sent For Hardening On Date		28	6	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA