



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15305	5050
2	Machined By		V-T.L. H/c Shop	Dry H/c L.E.C. 990
3	Pallet Die No.		14489 (410) H/c	Rev. 100
4	Die Category	Drg. No.	Endrenside	
5	Out Side Diameter	Drg. No.	6.20 H/c	Step on
6	Inside Diameter	Drg. No.	5.20-14 H/c	Tabber 12
7	Width of Pellet Die	Drg. No.	22.2 H/c	Step length 18.5
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 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		56.5 H/c	
13	Tapping Hole Diameter		H202 Check by H2 B-11	Tapping H/c of Hole 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 2.4 H/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 28/6/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		H/c - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 26

1	Counter Sinking Depth & Finish	ok						Rep. 31
2	External Relief Dia	4.5 H/c	Outside (3-3)		Inner			
3	External Relief Depth		5 H/c		Nil			
4	Inspection Done Before Hardening By (Name)				Raw			
5	Material Sent For Hardening By (Name)				Lark R. G. R. R. R.			
6	Material Sent For Hardening On Date		28	6	25			

Inspected By (Sign) & Date

Raw: 28/6/25

Reviewed by (Engineer-CNC)

Manager-QA