



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10166

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.		15234	36/50
2	Machined By		V. T. L. H/c Shop	Dry H. 18.0.41
3	Pallet Die No.		14417 (3.0) H/c	Revised
4	Die Category	Drg. No.	H. 70mbo	
5	Out Side Diameter	Drg. No.	700 H/c Step on 691.9 H/c	Step length 1.17
6	Inside Diameter	Drg. No.	600.14 H/c	
7	Width of Pellet Die	Drg. No.	22.2 H/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 H/c	12.5 x 8 x 7 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		645 H/c	
13	Tapping Hole Diameter		H20. Check by H20 B.1	Tapping H. of H. 12.12
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 22.4 H/c	Tapping Depth 20.
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Row: 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)		No	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter: 60
2	External Relief Dia	3.5 H/c	Outside 3.3	Inner 3.8
3	External Relief Depth		20 H/c	14 H/c
4	Inspection Done Before Hardening By (Name)		Row:	
5	Material Sent For Hardening By (Name)		Lark Purchase	
6	Material Sent For Hardening On Date		28	6
Inspected By (Sign) & Date			Row: 28/6/25	

Manager-QA

Reviewed by (Engineer-CNC)