



Lark Engineering Company (India) Pvt. Ltd.

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

10231

Form No.	CNC/QA/FM/02
Rev. No.	01
Rev. Date	31-07-2013

Inprocess Inspection (Pollot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15403	35/66
3	Pallet Die No.		V. T. L. Shop	Dy. No. 12.0.32
4	Die Category	Drg. No.	15336 (8.0) 4.4	Rev. 08
5	Out Side Diameter	Drg. No.	H. Jumbo	
6	Inside Diameter	Drg. No.	380.144, Step 0.0. G93 4.4	Tapper, 2
7	Width of Pellet Die	Drg. No.	546.144 (Bar. 548.2 4.4)	Step length 31.44
8	Grooves as per Drawing	Drg. No.	195 4.4	Under cut 2.8 4.4
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 7.9.1 4.4 / 32.7 7.9.1 4.4 (4.42) 4.4	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		ok	2 mm Deep
12	Tapping PCD		ok Shop	Back Side
13	Tapping Hole Diameter		619 4.4	Tapping 2
14	Tapping On Second Side	Half pitch of 1st side	HIG, Check by HIG Ball	of holes 2
15	Tapping Hole Depth		ok	Back Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.4 4.4	Tapping Depth 31.6
17	Visual Inspection Before Gun Drilling		yes	
			ok	
Inspected By (Sign) & Date			Ravi 8/7/25	
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, 30
2	External Relief Dia	9.0 4.4	All Rows	Row 10
3	External Relief Depth		31 4.4	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lanka Perma-re	
6	Material Sent For Hardening On Date		8 7 25	
Inspected By (Sign) & Date			Ravi 8/7/25	

Reviewed by (Engineer-CNC)

Manager-QA