



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 (Pollock Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15331	48/50
2	Machined By		V.T.L. n/a Shop	Dr. H. 12.2.15
3	Pallet Die No.		13441(4.0)mm	Rev. 01
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	52mm Step no. 499	Tapper 12
6	Inside Diameter	Drg. No.	42.14mm	Step length 20mm
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/a Shop	
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	Tapping Holes 28
14	Tapping On Second Side	Half pitch of 1st side	OK	Both side
15	Tapping Hole Depth		Drill Depth 18.4mm	Tapping Depth 18.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 4/7/25

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						Count on 80
2	External Relief Dia	4.5mm	20 Side (2-2)		Inner			Rev. 20
3	External Relief Depth		13mm		8mm			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date		4	7	25			

Inspected By (Sign) & Date

Ravi 4/7/25

Reviewed by (Engineer-CNC)

Manager-QA