



Lark Engineering Company (India) Pvt. Ltd.

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

10221

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Polot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15298	15/06
2	Machined By		V.T.L. H/c Shop	Dy. 18/02/88
3	Pallet Die No.		15333 (G.O) H/c	Renewal
4	Die Category	Drg. No.	Mr. 10000	
5	Out Side Diameter	Drg. No.	678 H/c, Step 00 - 693 H/c	Taper - 8
6	Inside Diameter	Drg. No.	546.12 H/c (Bo. 548.4 H/c)	Step length 28 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut, 2.8 H/c
8	Grooves as per Drawing	Drg. No.	31x8x9.1 H/c / 31x8x9.1 H/c (5x8)	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	1 H/c Deep
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		619 H/c	Tapping H/c
13	Tapping Hole Diameter		H16. Check by H16 Ball	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 38.4 H/c	Tapping Depth 38.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 3/7/25

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	4.0 H/c	211 R H/c						30212
3	External Relief Depth		24 H/c						
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Performance						
6	Material Sent For Hardening On Date		3	7	25				
Inspected By (Sign) & Date			Ravi	3/7/25					

Reviewed by (Engineer-CNC)

Manager-QA