



Lark Engineering Company (India) Pvt. Ltd.

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

10216

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

Inprocess Inspection (Polot Dlos)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15336	34/50/55
3	Pallet Die No.		V.T.L. H/c Shop	Drg No. 13.0.017
4	Die Category	Drg. No.	15316 (4.0) H/c	Rev. 00
5	Out Side Diameter	Drg. No.	Turn 60	
6	Inside Diameter	Drg. No.	79.0 H/c Step 00 = 79.2 H/c	Step length 265
7	Width of Pellet Die	Drg. No.	66.14 H/c	Undercut 1 H/c
8	Grooves as per Drawing	Drg. No.	323.9 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 8 H/c / 21.5 x 8 x 8 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		72.5 H/c	Tapping H/c of H/c 12
13	Tapping Hole Diameter		H20 = Check by H/c Bolt	Bolt Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 31.4 H/c Tapping Depth 29.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 5/7/25	2 S1.2
1	As per programme no.			32.1 H/c width
2	Gun Drilling Work Completed On			8 H/c Depth
3	Hole Finish In Gun Drilling	Marked	ok	Bolt Side
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 6 H/c
2	External Relief Dia	4.5 H/c / 5.0 H/c	4.5 H/c All Rows 2 31 H/c	Row 2 42
3	External Relief Depth		5.0 H/c All Rows 2 15 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ponnace	
6	Material Sent For Hardening On Date		5 7 25	
Inspected By (Sign) & Date			Ravi 5/7/25	

Reviewed by (Engineer-CNC)

Manager-QA