



Lark Engineering Company (India) Pvt. Ltd.

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

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Polot Dlos)

10290

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15355	34/50
2	Machined By		V. T. L. n/c Shop	Dy H. 12.0 117
3	Pallet Die No.		15645 (2.8) n/c	Ream
4	Die Category	Drg. No.	M72 n/c	
5	Out Side Diameter	Drg. No.	700 n/c, Step on, 703 n/c	Tapping H. 12
6	Inside Diameter	Drg. No.	600.14 n/c	Step length 4.2 80 n/c
7	Width of Pellet Die	Drg. No.	230 n/c	Under cut, 1.4 n/c
8	Grooves as per Drawing	Drg. No.	10x10x6 n/c / 10x10x6 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping H. 12
12	Tapping PCD		645 n/c	of holes 12
13	Tapping Hole Diameter		M20 x Check by M20 Bolt	Ream Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 22.4 n/c	Tapping Depth. 20.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 12/7/25	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		N.	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter 49
2	External Relief Dia	3.3 n/c	Outside (3.3)	Inner
3	External Relief Depth		22 n/c	16 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ravnare	
6	Material Sent For Hardening On Date		17	7 25
Inspected By (Sign) & Date			Ravi 12/7/25	

Reviewed by (Engineer-CNC)

Manager-QA