



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 (Pollet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15417	50/50
2	Machined By		V.T.L. n/c Shop	Drill size 12.0 = 18
3	Pallet Die No.		14972 (5.0) n/c	Revised
4	Die Category	Drg. No.	See	
5	Out Side Diameter	Drg. No.	519.9 n/c	Step 00.49 n/c
6	Inside Diameter	Drg. No.	420.14 n/c	Step length 7.5
7	Width of Pellet Die	Drg. No.	182 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		120, Check by 120 Ball	Tapping H. of Hole 8
14	Tapping On Second Side	Half pitch of 1st side	OK	Back Side
15	Tapping Hole Depth		Drill Depth 18.4 n/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 17/7/25

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

Counter, Go

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	5.3 n/c	Outside 2.25		Inner				
3	External Relief Depth		5.2 n/c		Nil				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Purnace				
6	Material Sent For Hardening On Date		17	7	25				

Inspected By (Sign) & Date

Ravi 17/7/25

30/7/17/25

Reviewed by (Engineer-CNC)

Manager-QA