



Lark Engineering Company (India) Pvt. Ltd.

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

10348

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pollot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15524 ✓	38/66 ✓
3	Pallet Die No.		V. T. L. H/C Shop	Dy. No. 13.2.32
4	Die Category	Drg. No.	15554 (6.0) ✓	Rev. 08
5	Out Side Diameter	Drg. No.	H. 7.0 mm	Rev. 03
6	Inside Diameter	Drg. No.	680.2 mm ✓ Step 00, 692.8 mm ✓ Tapper 8"	
7	Width of Pellet Die	Drg. No.	546.14 mm ✓ (Box - 548.2) ✓ Step length 3 mm	
8	Grooves as per Drawing	Drg. No.	195 mm ✓	Under cut 2.75 mm
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.1 mm ✓ 32.7 x 9.1 mm ✓ (4 x 2)	
10	Drilling Area Surface Smoothness		OK	Force Side Step
11	Tapping Operator		H/C Shop	2 mm Diaob Both Side
12	Tapping PCD		619 mm ✓	Tapping H/C of H. 1.0 x 2 Both Side
13	Tapping Hole Diameter		11.6 - Check by H/C Bolt	Tapping Depth 31.7
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.7 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 25/7/25	
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		7.0 mm ✓	Rev. 12
3	External Relief Depth		All Rps 28 mm ✓	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		25 7 25	
Inspected By (Sign) & Date			Ravi 25/7/25	

Reviewed by (Engineer-CNC)

Manager-QA