

Lark Engineering Company (India) Pvt. Ltd.

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

10319

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		15214 / 1556 /	50/66
3	Pallet Die No.		V. T. L. n/c Shop	Dy. 12.2.20
4	Die Category	Drg. No.	15326 (B.0) n/c	Rev. 02
5	Out Side Diameter	Drg. No.	M. Jamba	
6	Inside Diameter	Drg. No.	68.1 mm Step 002 69.2.8 mm	Taper 8"
7	Width of Pellet Die	Drg. No.	54.12 mm (Bor = 54.8.2)	Step length 31 mm
8	Grooves as per Drawing	Drg. No.	19.5 mm	Under cut 2.8 mm
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.1 mm / 32 x 7 x 9.1 mm	(4 x 2)
10	Drilling Area Surface Smoothness		OK	Face Side
11	Tapping Operator		OK	Back Side
12	Tapping PCD		n/c Shop	Tapping H.
13	Tapping Hole Diameter		619 mm	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	n/c	Back Side
15	Tapping Hole Depth		Drill Depth 33.6 mm	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 23/7/25	
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		9.0 mm	Ravi 10
3	External Relief Depth		16 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purnace	
6	Material Sent For Hardening On Date		23 7 25	
Inspected By (Sign) & Date			Ravi 23/7/25	

Reviewed by (Engineer-CNC)

Manager-QA