



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		154642	58/66
2	Machined By		V.T.L. N/C Shop	
3	Pallet Die No.		15551 (9.10) 44	Rev 208
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 44	Step 02, 693.44, Tabber. 8
6	Inside Diameter	Drg. No.	546.12 44 (B. 2 = 548.2)	Step length 31.4
7	Width of Pellet Die	Drg. No.	195 44	Widen cut, 2.8
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 44	(4 x 8)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		N/C Shop	2nd Deep
12	Tapping PCD		619 44	Both Side
13	Tapping Hole Diameter		HIG, Check by N/C Belt	Tapping 44
14	Tapping On Second Side	Half pitch of 1st side	ok	of Hole 2
15	Tapping Hole Depth		Drill Depth 33.6 44	Both Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth 31.6
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 24/7/25	
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 60
2	External Relief Dia	10.0 44	All Rows	Row 8
3	External Relief Depth		8 44	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ravi	
6	Material Sent For Hardening On Date		24 7 25	
Inspected By (Sign) & Date			Ravi 24/7/25	

Reviewed by (Engineer-CNC)

Manager-QA