

10372



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 (Polot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15499	32/50
2	Machined By		V.T.L n/c Shop	Qty 100
3	Pallet Die No.		14318 (3.0) mm	
4	Die Category	Drg. No.	38870	
5	Out Side Diameter	Drg. No.	6.20 mm	Step 002 G11.9 mm
6	Inside Diameter	Drg. No.	5.20-14 mm	Step length 4.19
7	Width of Pellet Die	Drg. No.	186 mm	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		56.5 mm	
13	Tapping Hole Diameter		M20 - Check by M20 Rod	Tapping Holes of Holes 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

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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 260
Rows 30

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5 mm	Outside (3.3)		Inner		
3	External Relief Depth		2.0 mm		1.8 mm		
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		26	7	25		

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA