

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 (Pollot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15538	50/50
3	Pallet Die No.		V.T.L. H/C Shop	Dy. 1.2.02/376
4	Die Category	Drg. No.	15608 (8.0) mm	Rev. 00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	520 mm Shop 00. 491 mm	Step length 17.5
7	Width of Pellet Die	Drg. No.	420.14 mm	
8	Grooves as per Drawing	Drg. No.	158 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 mm / 12 x 8 x 3 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/C Shop	
13	Tapping Hole Diameter		454 mm	
14	Tapping On Second Side	Half pitch of 1st side	H202 Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 18.4 mm	Tapping Depth 16.4
17	Visual Inspection Before Gun Drilling		yes	
			ok	
Inspected By (Sign) & Date			Ravi 26/7/25	
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 Bore
2	External Relief Dia	8.3 mm	Outside 22.25	Inside 12
3	External Relief Depth		4 mm	Nil
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Borne	
6	Material Sent For Hardening On Date		06	25
Inspected By (Sign) & Date			Ravi 26/7/25	

Reviewed by (Engineer-CNC)

Manager-QA