



Lark Engineering Company (India) Pvt. Ltd.

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

10422

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		15605	46/50
3	Pallet Die No.		V.T.L. n/c Shop	Dryness 12.0.150
4	Die Category	Drg. No.	15713 (4.0) n/c	Rev. 02
5	Out Side Diameter	Drg. No.	740	
6	Inside Diameter	Drg. No.	730 mm - Step 0.2, 744 mm - Tapper 10	
7	Width of Pellet Die	Drg. No.	630.14 mm (Box 629.8)	Step length 23.3
8	Grooves as per Drawing	Drg. No.	290.6 mm	Under 6.0 287m
9	Fitting Sizes on CNC Plate	Drg. No.	15.3 x 8 x 5 mm / 15.3 x 8 x 5 mm	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		ok	0.8 mm Deep
12	Tapping PCD		n/c Shop	Both Side
13	Tapping Hole Diameter		Q85 mm	Tapping H
14	Tapping On Second Side	Half pitch of 1st side	H20. Check by H20 Bolt	of holes 1.6
15	Tapping Hole Depth		ok	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 220.8 mm	Tapping Depth 18.3
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Rev: 5/8/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		n/c

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	4.5 mm	Outside (3.3)			Inner				Rev: 42
3	External Relief Depth		14 mm			6 mm				
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date									

Inspected By (Sign) & Date

Rev: 5/8/25

5/8/25

Reviewed by (Engineer-CNC)

Manager-QA