



Lark Engineering Company (India) Pvt. Ltd.

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

10405

Form No.

CNC/QA/FM/02

Rev. No.

01

Inprocess Inspection (Pollet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15633	66/66
2	Machined By		V.T.L. w/o Shop	Drg No. 18.0.3-9
3	Pallet Die No.		15548(10.0) w/o	Rev. 03
4	Die Category	Drg. No.	M. Tumbler	
5	Out Side Diameter	Drg. No.	680.7 mm Step 00, 693 mm	Tabber 8"
6	Inside Diameter	Drg. No.	546.14 mm (Bore 548.4) mm	Step length 314
7	Width of Pellet Die	Drg. No.	195 mm	Under cut 28.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm / 32 x 7 x 9.2 mm (428) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 mm Deep
11	Tapping Operator		w/o Shop	Back Side
12	Tapping PCD		619 mm	Tapping
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	of Holes 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Back Side
15	Tapping Hole Depth		Drill Depth 33.6 mm	Tapping Depth 316
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/8/25

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

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 260

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia								
3	External Relief Depth								
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

Ravi 21/8/25

Reviewed by (Engineer-CNC)

Manager-QA