



Lark Engineering Company (India) Pvt. Ltd.

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

10402

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		15615	33/48/70
3	Pallet Die No.		V.T.L H/c Shop	Drg No 180.372
4	Die Category	Drg. No.	14343(G.O) H/c	Rev 103
5	Out Side Diameter	Drg. No.	H. 7.0 mm	
6	Inside Diameter	Drg. No.	688 H/c Step 00. 697.7 H/c	Tapping 1.5
7	Width of Pellet Die	Drg. No.	546.14 H/c (Box 548.4) H/c	Step length 28.5
8	Grooves as per Drawing	Drg. No.	215 H/c	Under cut 1.8
9	Fitting Sizes on CNC Plate	Drg. No.	29.5 x 10 x 9.2 H/c (29.5 x 10 x 9.2 H/c (G & 8) H/c	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		ok	2 H/c Depth
12	Tapping PCD		H/c Shop	Both Side
13	Tapping Hole Diameter		618 H/c	Tapping H/c
14	Tapping On Second Side	Half pitch of 1st side	H/c Check by H/c Bolt	of holes 2
15	Tapping Hole Depth		ok	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 32.4 H/c	Tapping Depth 30
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 9/8/25

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 30
Rev 214

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5 H/c 7.0 H/c	6.5 H/c	All Rows 2 37 H/c			
3	External Relief Depth		7.0 H/c	All Rows 2 37 H/c			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		4	8	25		
				Ravi	4/8/25		

Inspected By (Sign) & Date

Satya 4/8/25

Manager-QA

Reviewed by (Engineer-CNC)