



Lark Engineering Company (India) Pvt. Ltd.

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

Form No. CNC/QA/FM/02

Rev. No. 01

Rev. Date 31-07-2013

Inprocess Insopction (Polot Dlos)

S.No.	Check Parameter	Speciflcation	Observations	Remarks
1	Work Order No.			
2	Machined By		15603	28/40/55
3	Pallet Die No.		V.T.L. H/C Shop	10423
4	Die Category	Drg. No.	15345(4.0) H/C	Rev. 1.00
5	Out Side Diameter	Drg. No.	H. Jumbo	
6	Inside Diameter	Drg. No.	709.9 H/C	Step on 692.9 H/C
7	Width of Pellet Die	Drg. No.	600.14 H/C	Tapper 12"
8	Grooves as per Drawing	Drg. No.	222 H/C	Step length 20mm
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x7 H/C	12x8x7 H/C
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/C Shop	
13	Tapping Hole Diameter		340 H/C	
14	Tapping On Second Side	Half pitch of 1st side	H20. Clock by H20 Bolt	Tapping H/C of Holes 12"
15	Tapping Hole Depth		OK	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 H/C	Tapping Depth 18.4
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

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

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

1	Counter Sinking Depth & Finish	OK								Count on 60
2	External Relief Dia	4.6 H/C	5.0 H/C	4.6 H/C	All Rows 287 H/C					Rows 32
3	External Relief Depth			5.0 H/C	All Rows 215 H/C					
4	Inspection Done Before Hardening By (Name)				Rev:					
5	Material Sent For Hardening By (Name)				Lark Purrace					
6	Material Sent For Hardening On Date				5	8	25			

Inspected By (Sign) & Date

										Rev: 5/8/25
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Satya 5/8/25

Reviewed by (Engineer-CNC)

Manager-QA