



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 (Polot Dies)

10419

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15601	21/40
2	Machined By		V.T.L. H/c Shop	Qty 40.177
3	Pallet Die No.		13951 (3.2) H/c	Rev 200
4	Die Category	Drg. No.	520	
5	Out Side Diameter	Drg. No.	500 H/c Step 002	Tappet = 12°
6	Inside Diameter	Drg. No.	420.14 H/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	182 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x4 H/c / 13x8x4 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		455 H/c	
13	Tapping Hole Diameter		03/4" = Check by 03/4" Ball	[Tapping H/c of Hole 0.8]
14	Tapping On Second Side	Half pitch of 1st side	ok	[Both Side]
15	Tapping Hole Depth		Drill Depth = 21.4 H/c	Tapping Depth 19.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 4/8/25	
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 - Hole Closed	
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	3.8 H/c	Outside 22.25	Inner 19 H/c
3	External Relief Depth		22 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	
Inspected By (Sign) & Date			Ravi 4/8/25	

Satish 4/8/25

Reviewed by (Engineer-CNC)

Manager-QA