



Lark Engineering Company (India) Pvt. Ltd.

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

10412

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		15468 ✓	40/50/70 ✓
3	Pallet Die No.		V.T.L. H/C Shop	Dy H.C. 12.0.370
4	Die Category	Drg. No.	1537-2 (G.O) H/C ✓	Rev. 02
5	Out Side Diameter	Drg. No.	H. Jumbo	
6	Inside Diameter	Drg. No.	636mm / 632mm / Step 0.01	630.5mm / 543mm
7	Width of Pellet Die	Drg. No.	480.12mm / 489.12mm / 500.12mm	Step length 16.5mm
8	Grooves as per Drawing	Drg. No.	182mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	37x12x8x9.5mm / 37x12x8x9.5mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/C Shop	
13	Tapping Hole Diameter		54mm H/C	
14	Tapping On Second Side	Half pitch of 1st side	HIG. Check by HIG Ball	[Tapping H of holes 4]
15	Tapping Hole Depth		Same Side Tapping and 11rd Side One St.	
16	Perpendicularity of Tapped Hole		Drill Depth 228.4mm	Tapping Depth 284
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Rev: 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 ✓	

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5mm / 7.0mm	6.5mm	All Rows 2 288mm ✓					
3	External Relief Depth		7.0mm	All Rows 2 88mm ✓					
4	Inspection Done Before Hardening By (Name)			Rev:					
5	Material Sent For Hardening By (Name)			Lark Engineering					
6	Material Sent For Hardening On Date		4	8	25				

Inspected By (Sign) & Date

Rev: 4/8/25

Reviewed by (Engineer-CNC)

Manager-QA