



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)

10476

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15605	28/47
2	Machined By		V.T.L. H/C Shop	Qty 12, 2, 1400
3	Pallet Die No.		15714 (4.0) H-1	Rev. 00
4	Die Category	Drg. No.	J&D	
5	Out Side Diameter	Drg. No.	724 H-1, Step 00, 744 H-1	Tapping 10
6	Inside Diameter	Drg. No.	630.14 H-1	Step length 23
7	Width of Pellet Die	Drg. No.	290.6 H-1	End cut 10
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5 H-1 / 15.3 x 8 x 5 H-1	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	0.8 mm Deep
11	Tapping Operator		H/C Shop	Back Side
12	Tapping PCD		685 H-1	Tapping H-
13	Tapping Hole Diameter		H20. Check by H20 Bolt	of H-100 10
14	Tapping On Second Side	Half pitch of 1st side	OK	Back Side
15	Tapping Hole Depth		Drill Depth 20.5 H-1	Tapping Depth 28.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/8/25

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 60
Rev. 48

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.5 H-1	Outside (2-3)		Inner				
3	External Relief Depth		23 H-1		19 H-1				
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

Lark Purpore

7 8 25
Ravi 28/8/25

Reviewed by (Engineer-CNC)

Manager-QA