



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 (Pollet Dlos)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15625 ✓	30/45/50 ✓
2	Machined By		V. T. L. H/c Shop	Drill 11, 18.0059
3	Pallet Die No.		15391 (4.0) H/c	Revised ✓
4	Die Category	Drg. No.	8 x 2 x 10 side	
5	Out Side Diameter	Drg. No.	620 mm, Step 00, 620.3 mm ✓	
6	Inside Diameter	Drg. No.	520.14 mm ✓	Tapping 12 ✓
7	Width of Pellet Die	Drg. No.	222 mm ✓	Step length 18 mm ✓
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 mm 13 x 8 x 5 mm ✓	Undercut 1.2 mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	
10	Drilling Area Surface Smoothness		OK ✓	
11	Tapping Operator		H/c Shop	Tapping 11 ✓
12	Tapping PCD		585 mm ✓	of holes 12 ✓
13	Tapping Hole Diameter		420, Check by H2 Bolt ✓	Both Side ✓
14	Tapping On Second Side	Half pitch of 1st side	OK ✓	
15	Tapping Hole Depth		Drill Depth 20.4 mm ✓	Tapping Depth 18.4 ✓
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		OK ✓	

Inspected By (Sign) & Date

Ravi 8/8/25

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, 6 ✓

1	Counter Sinking Depth & Finish	OK ✓							Row 31 ✓
2	External Relief Dia	4.5 mm 5.0 mm	4.5 mm	All Rows 214 mm ✓					
3	External Relief Depth		5.0 mm	All Rows 25 mm ✓					
4	Inspection Done Before Hardening By (Name)			Ravi ✓					
5	Material Sent For Hardening By (Name)			Lark Purrore ✓					
6	Material Sent For Hardening On Date		8	8	25				

Inspected By (Sign) & Date

Ravi 8/8/25

Satya 8/8/25

Reviewed by (Engineer-CNC)

Manager-QA