



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

Inprocess Inspection (Pollet Dies)

Rev. Date

31-07-2013

10468

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15681	5-150
2	Machined By		V.T.L. H/c Stop	Dry hole 18.04.3
3	Pallet Die No.		15610 (8.0) H/c	Renew
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 H/c - Step 002 491 H/c	Step length 17.5
6	Inside Diameter	Drg. No.	420.14 H/c (Inner Rad-R-118 - A117.2)	
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12.4 x 8 x 3 H/c / 12.4 x 8 x 3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Stop	
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		03/4" x 2 Check by 03/4" Ball	Tapping 4- of hole 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.4 H/c	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 12/8/25

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

1	Counter Sinking Depth & Finish	OK						Row 12
2	External Relief Dia	8.5 H/c	Outside 82.25		Inner			
3	External Relief Depth		5 H/c		Mill			
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 12/8/25

Reviewed by (Engineer-CNC)

Manager-QA