



Lark Engineering Company (India) Pvt. Ltd.

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

10483

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		15684 ✓	48/50 ✓
3	Pallet Die No.		V. T. L. H/C Shop	Dr. H. L. D. 415
4	Die Category	Drg. No.	14661 (AS-2)	Revised
5	Out Side Diameter	Drg. No.	Series (6.0)	
6	Inside Diameter	Drg. No.	520 H/C Step OD. 499 H/C	
7	Width of Pellet Die	Drg. No.	420.14 H/C	Tabber 12
8	Grooves as per Drawing	Drg. No.	158 H/C	Step length. 80 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 H/C / 12 x 8 x 3 H/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/C Shop	
13	Tapping Hole Diameter		454 H/C	Tabbing H. of Holes. 8
14	Tapping On Second Side	Half pitch of 1st side	H20. Check by H20 B. L.	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth. 18.4 H/C	Tabbing Depth 6.4
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

Ravi 14/8/25

1	As per programme no.								
2	Gun Drilling Work Completed On								
3	Hole Finish In Gun Drilling	Marked							
4	Defective Holes (If Any)		OK						

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

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	6.5 H/C	Outside 22-25		lines				
3	External Relief Depth		8 H/C		2 H/C				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		14	8	25				

Inspected By (Sign) & Date

Ravi 14/8/25

Satish 14/8/25

Reviewed by (Engineer-CNC)

Manager-QA