



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 (Pollot Dies)

10484

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15718	45/50
2	Machined By		V.T.L. H/c Shop	By N. B. C. 1090
3	Pallet Die No.		15318(4.0) H/c	Rev: 01
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	760 H/c Step 00. 792 H/c Step length 27 H/c	
6	Inside Diameter	Drg. No.	660.14 H/c	Under cut 16 H/c
7	Width of Pellet Die	Drg. No.	324 H/c	
8	Grooves as per Drawing	Drg. No.	21 x 8 x 10 H/c / 21 x 8 x 10 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		725 H/c	
13	Tapping Hole Diameter		H20, Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 27.4 H/c	Tapping Depth 25.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

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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	4.5 H/c	20 Side (3.3)		Inner				
3	External Relief Depth		13 H/c		5 H/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		14	8	25				

Inspected By (Sign) & Date

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16/6/25

Reviewed by (Engineer-CNC)

Manager-QA