



Lark Engineering Company (India) Pvt. Ltd.

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

10481

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		15715 ✓	26/50 ✓
3	Pallet Die No.		N.T.L. n/c Shop	Drg. H.L.G.G. 978
4	Die Category	Drg. No.	15412 (3.2) n/c	
5	Out Side Diameter	Drg. No.	Extr. side	
6	Inside Diameter	Drg. No.	619.9 n/c	Step 002
7	Width of Pellet Die	Drg. No.	520.14 n/c	Tapper 12.4°
8	Grooves as per Drawing	Drg. No.	222 n/c	Step length 18.5
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		565 n/c	
14	Tapping On Second Side	Half pitch of 1st side	n/c	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

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

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.8 n/c	20.8 Side			Inner			
3	External Relief Depth		27 n/c			24 n/c			
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

Reviewed by (Engineer-CNC) 16/8/25

Manager-QA