



Lark Engineering Company (India) Pvt. Ltd.

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

10480

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		15703	32/40
3	Pallet Die No.		V.T.L. H/C Shop	Qty 11-12-9-33
4	Die Category	Drg. No.	15272 (3.5)	Revised
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 H/C Shop 00.490.9 H/C	
7	Width of Pellet Die	Drg. No.	420.14 H/C	Step length 17.5
8	Grooves as per Drawing	Drg. No.	158 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H/C / 12x8x3 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	Tapping no of holes = 8
14	Tapping On Second Side	Half pitch of 1st side	03/4" 2 Check by 001/4" Ball	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 18.7 H/C	Tapping Depth 18.6
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

Sas: 16/8/25

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

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

1	Counter Sinking Depth & Finish	OK						Counter 60
2	External Relief Dia	4.0 H/C	80% Side	22.2	Inner	2 H/C		22
3	External Relief Depth		8 H/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

Sas: 16/8/25

Sas: 16/8/25

Reviewed by (Engineer-CNC)

Manager-QA