



Lark Engineering Company (India) Pvt. Ltd.

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

10488

Form No. CNC/QA/FM/02
Rev. No. 01
Rev. Date 31-07-2013

Inprocess Inspection (Polot Dlos)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15684	45/50
2	Machined By		N.T.L. n/c Shop	1 Day 12/02/15
3	Pallet Die No.		15729 (G.O) n/c	Revised
4	Die Category	Drg. No.	Senior (AS-1)	
5	Out Side Diameter	Drg. No.	520 n/c	499 n/c, Tapper 12
6	Inside Diameter	Drg. No.	420.14 n/c	Step length 2
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c	[Tapping n/c of holes & Both Side]
13	Tapping Hole Diameter		M20: Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.4 n/c	Tapping Depth: 16.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 18/8/25

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
Raw: 15

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5 n/c	Outside (2.2)	11 n/c	Inner 5 n/c		
3	External Relief Depth						
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		18	8	25		

Inspected By (Sign) & Date

Raw: 18/8/25

Raw: 18/8/25
Reviewed by (Engineer-CNC)

Manager-QA