



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		157591	35/40/66
2	Machined By		V.T.L. H/c Shop	Qty No. 12032
3	Pallet Die No.		15569(6.0) H/c	Rev. 02
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.2 H/c	Step 00. 693 H/c
6	Inside Diameter	Drg. No.	546.14 H/c	(Pos. 548.2) Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut 22.7 H/c
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 H/c	32.7 x 9.1 H/c (4 x 8) H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face side Step
11	Tapping Operator		H/c Shop	2 H/c Deep Bottom Side
12	Tapping PCD		619 H/c	Tapping No. of holes 22
13	Tapping Hole Diameter		M16.2 Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.7 H/c	Tapping Depth 31.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 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

1	Counter Sinking Depth & Finish	ok								Counter 30
2	External Relief Dia	6.5 H/c	7.0 H/c	6.5 H/c	All Rows 231 H/c					Row 12
3	External Relief Depth			7.0 H/c	All Rows 228 H/c					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Ravi					
6	Material Sent For Hardening On Date				18	8	25			

Inspected By (Sign) & Date

Ravi 18/8/25

Reviewed by (Engineer-CNC)

Manager-QA