



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.		15740	40/45/65
2	Machined By		V. T. L. n/c Shop	40/50/65
3	Pallet Die No.		15860 (6.0) n/c	Dy n/c 12.078
4	Die Category	Drg. No.	M. Jumbo	Recess
5	Out Side Diameter	Drg. No.	678 n/c Step 00, 693 n/c	Tapper 8"
6	Inside Diameter	Drg. No.	546.1 n/c (Bore 548.4)	Step length 78 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut 2.86
8	Grooves as per Drawing	Drg. No.	31x8x9.2 n/c / 31x8x9.2 n/c (5x8) n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side 84 n/c
10	Drilling Area Surface Smoothness		ok	Inner Deep Bore Side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	Tapping n/c
13	Tapping Hole Diameter		H16, Check by H16 Bolt	of holes 22
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 38.4 n/c	Tapping Depth 36 n/c
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	Ist Rad	IIrd	Counter Bore
2	External Relief Dia	6.5 n/c 7.0 n/c	6.5 n/c All Rows 25 n/c	6.5 n/c All Rows 25	Row 12
3	External Relief Depth		7.0 n/c All Rows 25 n/c	7.0 n/c All Rows 15	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark Porname		
6	Material Sent For Hardening On Date		18 8 25		

Inspected By (Sign) & Date

Ravi 18/8/25

Satish 18/8/25

Reviewed by (Engineer-CNC)

Manager-QA