



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 (Pollet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15748	39/5-
3	Pallet Die No.		V.T.L. H/C Shop	120.344
4	Die Category	Drg. No.	15975 (3.0) H/C	Renewal
5	Out Side Diameter	Drg. No.	H 7 & 12	
6	Inside Diameter	Drg. No.	700 H/C Step on G92 H/C Step length	19.8
7	Width of Pellet Die	Drg. No.	600.14 H/C	
8	Grooves as per Drawing	Drg. No.	265.6 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	15.3 x 8 x 7 H/C / 15.3 x 8 x 9 H/C	
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		H/C Shop	0.8 H/C Deep
12	Tapping PCD		640 H/C	Both Side
13	Tapping Hole Diameter		H 20, Check by H 20 Roll	Tapping H.
14	Tapping On Second Side	Half pitch of 1st side	OK	of holes .16
15	Tapping Hole Depth		Drill Depth .20.7 H/C	Both Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth 8.6
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 20/8/25

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 Sink
2	External Relief Dia	3.5 H/C	60 Side (3-3)		Inner				Ravi 4/8
3	External Relief Depth		17 H/C		11 H/C				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		20	8	25				

Inspected By (Sign) & Date

Ravi 20/8/25

Reviewed by (Engineer-CNC)

Manager-QA