



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.		15764	28/50
2	Machined By		V.T.L. m/c Shop	Qty 100
3	Pallet Die No.		14787 (2.8)	Revised
4	Die Category	Drg. No.	59870	
5	Out Side Diameter	Drg. No.	620 mm	Step 00.623.8 mm
6	Inside Diameter	Drg. No.	520.14 mm	Step length 18 mm
7	Width of Pellet Die	Drg. No.	186 mm	Under cut 1.9 mm
8	Grooves as per Drawing	Drg. No.	13x8x3 mm / 13x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		m/c Shop	
12	Tapping PCD		565 mm	Tapping 12 of holes
13	Tapping Hole Diameter		H200 Check by H200 R15	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18 mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 4/9/25	
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 60
2	External Relief Dia	23-2 mm	Outside 23-3	Revised
3	External Relief Depth		25 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purge	
6	Material Sent For Hardening On Date		4 9 25	
Inspected By (Sign) & Date			Ravi 4/9/25	

Reviewed by (Engineer-CNC)

Manager-QA