



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.		15801	53/55
2	Machined By		V. T. L. H/c Shop	Drill 12.0680
3	Pallet Die No.		14386(3.8) H/c	Rev 200
4	Die Category	Drg. No.	320	
5	Out Side Diameter	Drg. No.	530 H/c Step 00.490.9 H/c	
6	Inside Diameter	Drg. No.	420.14 H/c	Step length 17 H/c
7	Width of Pellet Die	Drg. No.	182 H/c	
8	Grooves as per Drawing	Drg. No.	10x10x5 H/c / 10x10x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		455 H/c	Tapping H/c of holes 8
13	Tapping Hole Diameter		03/4" 2 Check by 03/4" Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19.4 H/c	Tapping Depth 17 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 9/9/25

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 6
2	External Relief Dia	4.3 H/c	outside 22-22		Inner			Row 26
3	External Relief Depth		9 H/c		2 H/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		9	9	25			

Inspected By (Sign) & Date

Ravi 9/9/25

Reviewed by (Engineer-CNC)

Manager-QA