



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10647

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.			
2	Machined By		15984 ✓	53/58 ✓
3	Pallet Die No.		V.T.I M/c Shop	Dry No. 1.6.6386
4	Die Category	Drg. No.	15356 (B.8) ✓	Rev. 00
5	Out Side Diameter	Drg. No.	Jumbo	
6	Inside Diameter	Drg. No.	776 mm	Step OD = 800 mm
7	Width of Pellet Die	Drg. No.	660.14 mm	Step length = 38 mm
8	Grooves as per Drawing	Drg. No.	316 mm	Under cut = 12 mm
9	Fitting Sizes on CNC Plate	Drg. No.	20 x 8 x 7.5 mm / 20 x 8 x 7.5 mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		725 mm	
13	Tapping Hole Diameter			Tapping H. of holes 12
14	Tapping On Second Side	Half pitch of 1st side	H20 = Check by H20 Bolt	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill depth = 25.4 mm	Tapping depth = 25.4 mm
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 15/9/25

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

Counter-60°
Row 248

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.3 mm	Outside (3-3)	Inner			
3	External Relief Depth		12 mm	5 mm			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date			15	9	25	

Inspected By (Sign) & Date

Ravi 15-9-25

Satya 16/9/25

Reviewed by (Engineer-CNC)

Manager-QA