



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)

10649

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		16031	33/CC
3	Pallet Die No.		V.T.L M/c Shop	Dry No 2 18.0.59
4	Die Category	Drg. No.	16258(6.0) H-H	Pen 203
5	Out Side Diameter	Drg. No.	H-Jumbo	Pen 203
6	Inside Diameter	Drg. No.	680.7 H-H	Step OD 2 692.9 H-H Tapper 8°
7	Width of Pellet Die	Drg. No.	546.14 H-H (Box 2 548.4)	Step length 31 H-H
8	Grooves as per Drawing	Drg. No.	194.9 H-H	Under cut = 2.5 H-H
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.2 H-H / 32 x 7 x 9.2 H-H (4 x 8)	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 H-H Deep Both Side
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		619 H-H	of holes = 2
13	Tapping Hole Diameter		H16	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 33.6 H-H	Tapping depth = 31.4 H-H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

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

1	Counter Sinking Depth & Finish	OK	outside	inner				Counter 60°
2	External Relief Dia	7.5 H-H		All Rows				Row 12
3	External Relief Depth			33 H-H				
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

Reviewed by (Engineer-CNC)

Manager-QA