



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.		15644	50/55
2	Machined By		V.T.L M/c Shop	Dry No - 15cl-215
3	Pallet Die No.		16323 (3.5) mm	(Rev 00)
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	630mm	Step OD - 611.9mm
6	Inside Diameter	Drg. No.	520.14 mm	Step length 19.5
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No of Holes - 12
12	Tapping PCD		565 mm	Both Side
13	Tapping Hole Diameter		M.20 Check key M.20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping depth - 18.4 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 16/9/25

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 35

1	Counter Sinking Depth & Finish	OK	outside	(Inner)
2	External Relief Dia	4.0 mm	(3-3)	(5mm)
3	External Relief Depth		12mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		16 9 25	

Inspected By (Sign) & Date

Ravi 16-9-25

Manager-QA

Reviewed by (Engineer-CNC)