



Lark Engineering Company (India) Pvt. Ltd.

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

10661

Form No. CNC/QA/FM/02

Rev. No. 01

Rev. Date 31-07-2013

Inprocess Inspection (Polot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15896	40/60
2	Machined By		V.T.I. M/c Shop	Dry No. 12d-1361
3	Pallet Die No.		14748 (5.0) mm	(Rev 00)
4	Die Category	Drg. No.	MJCLW	
5	Out Side Diameter	Drg. No.	719.9 mm	Step 60, 691.9 mm
6	Inside Diameter	Drg. No.	600.14 mm	Step length 19.8
7	Width of Pellet Die	Drg. No.	265.6 mm	
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 7 mm	15.3 x 8 x 7 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No
12	Tapping PCD		640 mm	of Holes - 12
13	Tapping Hole Diameter		M.20 Check by M.20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 mm	Tapping depth 18.4
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

1	Counter Sinking Depth & Finish	OK	outside	Inner	Counter-60
2	External Relief Dia	5.5 mm	(3-3)	(2 mm)	Row. 33
3	External Relief Depth		25 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		16	9	25

Inspected By (Sign) & Date

Ravi 16/9/25

Reviewed by (Engineer-CNC)

Manager-QA