



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 (Polot Dlos)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16061	30/4/66
2	Machined By		V.T.I. M/c Shop	Day No 2 130239
3	Pallet Die No.		15752 (8.0) mm	nears Rev. 08
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 mm	Step 00, 692.8 mm Tapped
6	Inside Diameter	Drg. No.	546.14 mm	(8.0, 548.2) mm Step length
7	Width of Pellet Die	Drg. No.	195 mm	Under cut 2.8 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 mm	(4 x 2) mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side
10	Drilling Area Surface Smoothness		OK	Both Side
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		619 mm	of Holes 22
13	Tapping Hole Diameter		M=162 Check by HIC 9.1	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 2 33.6 mm	Tapping depth 2 31
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

1	As per programme no.		Ravi	18/9/25
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	cut side				Counter 2 30
2	External Relief Dia	8.5 mm	9.0 mm	8.5 mm	All Rows 2 36 mm		Row 2 15
3	External Relief Depth			9.0 mm	All Rows 2 36 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			18	9	25	

Inspected By (Sign) & Date

			Ravi	17/9/25
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Reviewed by (Engineer-CNC)

Manager-QA