



Lark Engineering Company (India) Pvt. Ltd.

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

10669

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.		18020	35/40
2	Machined By		V.T.L. H/c Shop	Drill 18.8 mm
3	Pallet Die No.		15096 (3.5) mm	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm	Step 02. 498.8
6	Inside Diameter	Drg. No.	480.14 mm	Tabber 12
7	Width of Pellet Die	Drg. No.	158 mm	Step length 18 mm
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		H 202	Check by H 202
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.8 mm	Tabbing Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/9/25

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

Count on 6

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.0 mm	Outside 22.2	Inner					
3	External Relief Depth		8 mm	5 mm					
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		18	9	25				

Inspected By (Sign) & Date

Ravi 18/9/25

Reviewed by (Engineer-CNC)

Manager-QA