



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 (Pollet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15924	28/55
2	Machined By		V.T.L. M/c Shop	Dry No. 1 & 2
3	Pallet Die No.		12391 (3.5) M	Rev 200
4	Die Category	Drg. No.	9-1-2-4-4	
5	Out Side Diameter	Drg. No.	629.9 M	Step OD = 621.4 M
6	Inside Diameter	Drg. No.	520.14 M	Step length = 2.5
7	Width of Pellet Die	Drg. No.	222 M	
8	Grooves as per Drawing	Drg. No.	13-8-5 M	13-8-5 M
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		565 M	of Holes = 12
13	Tapping Hole Diameter		42.2	Check by 42.2 Ball Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.5 M	Tapping depth = 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 25/9/25

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						Counter = 60
2	External Relief Dia	4.0 M	Outside (3-3)		Inner			Row = 35
3	External Relief Depth		30 M		27 M			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			25	9	25		

Inspected By (Sign) & Date

Ravi 25-9-25

Reviewed by (Engineer-CNC)

Manager-QA