



Lark Engineering Company (India) Pvt. Ltd.

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

10743

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.			
2	Machined By		15955 ✓	33/50
3	Pallet Die No.		V.T.I H/c Shop	Dry No. 18.0.931
4	Die Category	Drg. No.	15891(4.0) ✓	Rev 200
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	519.9 ✓	Step OD = 491.9 ✓
7	Width of Pellet Die	Drg. No.	420.14 ✓	Step length = 16.5
8	Grooves as per Drawing	Drg. No.	160 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	10x8x5 ✓	10x8x5 ✓
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	Tapping No
13	Tapping Hole Diameter		454 ✓	of Holes = 8
14	Tapping On Second Side	Half pitch of 1st side	03/4" = Check by 03/4" Pol	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill depth = 18.6 ✓	Tapping depth = 18.5
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

1	As per programme no.		Ravi 25/9/25	
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						Counter 60
2	External Relief Dia	4.5 ✓	22-25	Inner				Row = 21
3	External Relief Depth		21 ✓	17 ✓				
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				
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Reviewed by (Engineer-CNC)

Manager-QA