



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 (Pollot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		15963	30/45
3	Pallet Die No.		V.T.I M/c Shop	Dry No. 1.20.14747
4	Die Category	Drg. No.	15879 (10.0) H	Rev. 1.00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	509.9 H	Step OD = 490.9 H
7	Width of Pellet Die	Drg. No.	420.14 H	Step length = 17.5
8	Grooves as per Drawing	Drg. No.	158 H	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 H / 12 x 8 x 3 H	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/c Shop	Tapping No
13	Tapping Hole Diameter		454 H	of Holes = 8
14	Tapping On Second Side	Half pitch of 1st side	H20, Check by H20 Ball	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill depth = 18.6 H	Tapping depth = 16.6
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	11.0 H						Row = 8
3	External Relief Depth				All Rows			
4	Inspection Done Before Hardening By (Name)				15 H			
5	Material Sent For Hardening By (Name)				Ravi			
6	Material Sent For Hardening On Date				Lark Furnace			
					25	9	25	
	Inspected By (Sign) & Date				Ravi	25-9-25		

Reviewed by (Engineer-CNC)

Manager-QA