



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.		16119	
2	Machined By		V.T.I. M/c Shop	30/40
3	Pallet Die No.		15270 (B.O) M/c	Dray No 2 - Lark Shop
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.9 M/c	Step 02: 490.9 M/c
6	Inside Diameter	Drg. No.	420.14 M/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	158 M/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 M/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 M/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		453.9 M/c	Tapping No of Holes 28
13	Tapping Hole Diameter		420.2 Check by 420 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 218.4 M/c	Tapping depth 215.4
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 26
2	External Relief Dia	3.3 M/c	Outside 82-25	Row 224
3	External Relief Depth		13 M/c	
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