



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.		16130	57/70
2	Machined By		V.T.L M/c Shop	Dry No. 1-3-9-377
3	Pallet Die No.		14344 (10.0) M	Rev. 03
4	Die Category	Drg. No.	H. Tumbo	
5	Out Side Diameter	Drg. No.	688 M	Step AD 2-697.7 M Tapping 5
6	Inside Diameter	Drg. No.	546.12 M (Bot. 548.3)	Step length 38.5
7	Width of Pellet Die	Drg. No.	215 M	Uden cut 1.8 M
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 92 M	(6 x 2) M
9	Fitting Sizes on CNC Plate	Drg. No.	29.5 x 10 x 92 M	(6 x 2) M
10	Drilling Area Surface Smoothness		OK	[Face Side Step]
11	Tapping Operator		H/c Shop	[Both Side]
12	Tapping PCD		618 M	Tapping No
13	Tapping Hole Diameter		M16	of Holes 22
14	Tapping On Second Side	Half pitch of 1st side	Check by M16 Bolt	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill depth 2 32.4 M	Tapping depth 2 30.3 M
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

1	As per programme no.		Ravi	27/9/25
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 2 45
2	External Relief Dia	11.0 M		All Pows				Row 2 8
3	External Relief Depth			13 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			27	9	25		

Inspected By (Sign) & Date

			Ravi	27/9/25
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Reviewed by (Engineer-CNC)

Manager-QA