



Lark Engineering Company (India) Pvt. Ltd.

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

Form No.

10344
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.		16022	40/40
2	Machined By		V.T.L M/c Shop	Dry No 2 Lark 2.15
3	Pallet Die No.		15177(4.0)mm	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.9mm	Step OD = 490.9mm
6	Inside Diameter	Drg. No.	420.14mm	Step length 17.5
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm 12x8x3mm	
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		454mm	of Holes 28
13	Tapping Hole Diameter		Water Check by H2O Ball	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.4mm	Tapping depth = 18.4mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 03/10/25

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 = 80
2	External Relief Dia	4.5mm	Outside (2.25)		Inner			Row = 2
3	External Relief Depth		4mm		Will			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			03	10	25		
Inspected By (Sign) & Date		Ravi 03/10/25						

31/10/25

Reviewed by (Engineer-CNC)

Manager-QA