



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 (Polot Dlos)

10862

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13241	19/66
2	Machined By		V.T.L. M/c Shop	Dray No 12.2.09
3	Pallet Die No.		13460 (6.0) mm	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	Rev. 03
5	Out Side Diameter	Drg. No.	680.7 mm	Step oD 692.9 mm Tapper 8°
6	Inside Diameter	Drg. No.	546.14 mm (Bar = 548.4) mm	Step Length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut 2.5 mm
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 mm 32.7 x 9.2 mm (4 x 2) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 mm Deep Ball
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		619 mm	of Holes = 2
13	Tapping Hole Diameter		M16. Check by M16 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 33.4 mm	Tapping depth = 31 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 13/9/25

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

Counter = 30
Row = 12

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	7.5 mm		All Rows			
3	External Relief Depth			47 mm			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date			13	10	25	

Inspected By (Sign) & Date

Ravi 13/10/25

Manager-QA

Reviewed by (Engineer-CNC)