



Lark Engineering Company (India) Pvt. Ltd.

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

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pollot Dies)

10863

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		18241	19/06
2	Machined By		V. T. L. N/A Shop	Dry Hole 12.9.69
3	Pallet Die No.		18461 (G.O.)	Rev. 02
4	Die Category	Drg. No.	H. 7.0.0.0	Rev. 02
5	Out Side Diameter	Drg. No.	680.7 mm	Tap hole 8"
6	Inside Diameter	Drg. No.	546.12 mm (Bore - 548.4)	Side 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	(4.2 x 2) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side 8.5 mm
10	Drilling Area Surface Smoothness		ok	Side 8.5 mm
11	Tapping Operator		N/A Shop	Side 8.5 mm
12	Tapping PCD		619 mm	Side 8.5 mm
13	Tapping Hole Diameter		H16. Check by H16 Ball	Side 8.5 mm
14	Tapping On Second Side	Half pitch of 1st side	ok	Side 8.5 mm
15	Tapping Hole Depth		Drill Depth 33.4 mm	Side 8.5 mm
16	Perpendicularity of Tapped Hole		yes	Side 8.5 mm
17	Visual Inspection Before Gun Drilling		ok	Side 8.5 mm

Inspected By (Sign) & Date

Ravi 13/10/25

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

Counter 32

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	1.5 mm							
3	External Relief Depth								
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date								

Inspected By (Sign) & Date

Ravi 13/10/25

Satish 13/10/25

Reviewed by (Engineer-CNC)

Manager-QA