



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 (Pollet Dies)

10876

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16241	19/66
2	Machined By		V. T. L. N/A Shop	Dr. H. 18.2.2009
3	Pallet Die No.		16463(6.0) mm	Row 203
4	Die Category	Drg. No.	M. Jomha	Row 203
5	Out Side Diameter	Drg. No.	680.7 mm	698 mm Tapper. 8"
6	Inside Diameter	Drg. No.	546.14 mm (100, 548.4) mm	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	6 den cut 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm 32 x 7 x 9.2 mm (4 x 8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/A Shop	
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		HIG. Check by HIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 38.5 mm	Tapping Depth 21.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/10/25

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 23

1	Counter Sinking Depth & Finish	ok							Row 12
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 Burrace					
6	Material Sent For Hardening On Date		14	10	25				

Inspected By (Sign) & Date

Ravi 14/10/25

Satyam 14/10/25

Reviewed by (Engineer-CNC)

Manager-QA