



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		16240	35/40
3	Pallet Die No.		V.T.I M/c Shop	Day No 2 Look
4	Die Category	Drg. No.	13964(3.5) 44	
5	Out Side Diameter	Drg. No.	58 44	
6	Inside Diameter	Drg. No.	5mm 44	Step OD 2 49.02mm Step length 17mm
7	Width of Pellet Die	Drg. No.	42.14mm	
8	Grooves as per Drawing	Drg. No.	182 44	
9	Fitting Sizes on CNC Plate	Drg. No.	12.8 x 3 44	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454mm	Tapping No of Holes = 8
13	Tapping Hole Diameter		M20. Check by M20 Ball	Both Sides
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.7mm	Tapping depth = 16.4mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 15/10/25

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 260
2	External Relief Dia	4.0mm	Outside (2-2)		Inner			Row 22
3	External Relief Depth		8mm		5mm			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Appare			
6	Material Sent For Hardening On Date			15	10	25		

Inspected By (Sign) & Date

Ravi 15/10/25

Reviewed by (Engineer-CNC)

Manager-QA