



Lark Engineering Company (India) Pvt. Ltd.

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

10888

6

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		16840/	35/406
3	Pallet Die No.		V.T.L M/c Shop	Dry No: 1072370
4	Die Category	Drg. No.	13965(3.5)	
5	Out Side Diameter	Drg. No.	520	
6	Inside Diameter	Drg. No.	499.9mm	Step OD = 490.9mm
7	Width of Pellet Die	Drg. No.	420.14mm	Step length 117
8	Grooves as per Drawing	Drg. No.	122mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3mm	
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		12 x 2 Crack by 420 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 18.7	Tapping depth = 16.4
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

Counter = 60°

Row 1 = 27

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.0mm	22.25	Inner			
3	External Relief Depth	8mm		5mm			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date			15	10	25	

Inspected By (Sign) & Date

Ravi 15/10/25

Reviewed by (Engineer-CNC)

Manager-QA