



Lark Engineering Company (India) Pvt. Ltd.

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

10029

Form No. CNC/QA/FM/02

Rev. No. 01

Rev. Date 31-07-2013

Inprocess Inspection (Polot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15142 ✓	413/50
2	Machined By		V. T. C. M/C Shop	Drilling 12.0.87C
3	Pallet Die No.		13252 (3.0) M	Reamed
4	Die Category	Drg. No.	88870	
5	Out Side Diameter	Drg. No.	620 M	Step on 622.2 M
6	Inside Diameter	Drg. No.	520.14 M	Step length 12 M
7	Width of Pellet Die	Drg. No.	186 M	Tapper 12
8	Grooves as per Drawing	Drg. No.	13x8x3 M	Under cut 1.1 M
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x3 M	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		565 M	
14	Tapping On Second Side	Half pitch of 1st side	M2 - Check by wire Ball	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 2.4 M	Tapping Depth 18.3
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

Ravi 6/6/25

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 2.60
2	External Relief Dia	3.5 M	Outside (3-3)		Inner					Reamed 3
3	External Relief Depth		14 M		8 M					
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 6/6/25

Reviewed by (Engineer-CNC)

Manager-QA