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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 (Pollot Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15125	110/50
2	Machined By		V.T.I. H/C Shop	Dry H. 1-2-5176
3	Pallet Die No.		14257 (6.0) H/C	Rev 200
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.9 H/C Step 00. 491 H/C	Step length 18.5
6	Inside Diameter	Drg. No.	420.14 H/C	
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C 12x8x3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping H/C of Holes: 8 Both Side
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		H20. Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.4 H/C	Tapping Depth: 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 9/6/25

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: 60°
2	External Relief Dia	6.5 H/C	Outside (2.2)		inner			100: 15
3	External Relief Depth		16 H/C		10 H/C			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		9	6	25			

Inspected By (Sign) & Date

Raw: 9/6/25

Reviewed by (Engineer-CNC)

Manager-QA