



Lark Engineering Company (India) Pvt. Ltd.

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

10482

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.			
2	Machined By		15251	Go/OK
3	Pallet Die No.		V.T.L. H/c Shop	Dr. No. 12.0.9136
4	Die Category	Drg. No.	16198 (2.5)	Revol
5	Out Side Diameter	Drg. No.	S. Jumbo	
6	Inside Diameter	Drg. No.	1032 H/c, Step OD. 1033 H/c	Tapper. 3"
7	Width of Pellet Die	Drg. No.	900.14 H/c	Step length 37 H/c
8	Grooves as per Drawing	Drg. No.	375 H/c	Under 50.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	29.5 x 8 x 13 H/c 29.5 x 8 x 13 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		970 H/c	Tabbing No. of holes = 15
14	Tapping On Second Side	Half pitch of 1st side	H242 Check by H24 Bolt	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth = 38.4 H/c	Tabbing Depth. 35.7
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

1	As per programme no.			Raw: 16/8/25	2 Slot
2	Gun Drilling Work Completed On				32.1 H/c wireth
3	Hole Finish In Gun Drilling	Marked			7.5 H/c (Deep)
4	Defective Holes (If Any)		OK		Both Side
			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	4.0 H/c	Outside 4.4		Inner			Per. 59
3	External Relief Depth		13 H/c		6 H/c			
4	Inspection Done Before Hardening By (Name)							Raw:
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		16	8	25			

Inspected By (Sign) & Date

Raw: 16/8/25

Raw: 16/8/25

Reviewed by (Engineer-CNC)

Manager-QA