



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.		15798	44/66
2	Machined By		V. T. C. H/c Shop	Drill 13.0.136
3	Pallet Die No.		16089 (8.0) H/c	Revol
4	Die Category	Drg. No.	M. Tomba	
5	Out Side Diameter	Drg. No.	680.1 H/c	Step 00. 693 H/c
6	Inside Diameter	Drg. No.	548.12 H/c (Box 548.2)	Step length 31.9
7	Width of Pellet Die	Drg. No.	205.6 H/c	Order cut 12.3 H/c
8	Grooves as per Drawing	Drg. No.	32.3 x 6 x 9.1 H/c	32.3 x 6 x 9.1 H/c (4 x 8 x 4 x 8)
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Stick
10	Drilling Area Surface Smoothness		OK	2.3 H/c Back
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		619 H/c	Tapping H/c
13	Tapping Hole Diameter		H/c 2 Check by H/c 3.12	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.7 H/c	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 20/8/25

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 30
Ravi 10

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	9.0 H/c	All holes				
3	External Relief Depth		22 H/c				
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Burnace				
6	Material Sent For Hardening On Date		20	8	25		

Inspected By (Sign) & Date

Ravi 20/8/25

Manager-QA

Reviewed by (Engineer-CNC)