



# 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 (Pollet Dies)

| S.No.                                                                          | Check Parameter                            | Specification          | Observations                        | Remarks                |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|-------------------------------------|------------------------|
| 1                                                                              | Work Order No.                             |                        | 14729                               | 115/45                 |
| 2                                                                              | Machined By                                |                        | V.T.L. H/C Shop                     | Qty No. 1302541        |
| 3                                                                              | Pallet Die No.                             |                        | 14791(8.0) H/C                      | Rev 2.00               |
| 4                                                                              | Die Category                               | Drg. No.               | Junior                              |                        |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 410 H/C - Step 002 395 H/C          | Step length 14.5       |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 320.12 H/C                          |                        |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 142 H/C                             |                        |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 15.5 x 7 x 2 H/C   15.5 x 7 x 2 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 |
| 12                                                                             | Tapping PCD                                |                        | 355 H/C                             | Both Side              |
| 13                                                                             | Tapping Hole Diameter                      |                        | HIS = Check by HIS Bolt             |                        |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | OK                                  |                        |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 20.4 H/C                | Tapping Depth 18.6     |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Yes                                 |                        |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                                  |                        |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 2/5/25                         |                        |
| 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                        | 8.5 H/C                | Outside (2.25)                      | Inner                  |
| 3                                                                              | External Relief Depth                      |                        | 8 H/C                               | Mill                   |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                                |                        |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Furnace                        |                        |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 2 5 25                              |                        |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 2/5/25                         |                        |

Reviewed by (Engineer-CNC)

Manager-QA