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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.                             |                        | 15367                    | 36/44/50               |
| 2                                                                              | Machined By                                |                        | V.T.L. H/c Shop          | 1 Day H. Lark          |
| 3                                                                              | Pallet Die No.                             |                        | 15287 (6.0) H/c          |                        |
| 4                                                                              | Die Category                               | Drg. No.               | Extrude                  |                        |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 619.9 H/c, Shop 002      | 611.9 H/c, Shop length |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 520.14 H/c               |                        |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 222 H/c                  |                        |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 13x8x5 H/c / 13x8x5 H/c  |                        |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | OK                       |                        |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                       |                        |
| 11                                                                             | Tapping Operator                           |                        | H/c Shop                 |                        |
| 12                                                                             | Tapping PCD                                |                        | 565 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 20.4 H/c     | Tapping Depth 18.5 H/c |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Yes                      |                        |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | OK                       |                        |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 21/7/25             |                        |
| 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                     |                          |                        |
| 2                                                                              | External Relief Dia                        | 6.5 H/c / 7.0 H/c      | 6.5 H/c All Rows 2 H/c   |                        |
| 3                                                                              | External Relief Depth                      |                        | 7.0 H/c All Rows 2 G H/c |                        |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                     |                        |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Furnace             |                        |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 1 7 25                   |                        |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 11/7/25             |                        |

Reviewed by (Engineer-CNC)

Manager-QA