



# 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 (Polot Dies)

| S.No.                                                                          | Check Parameter                            | Specification          | Observations           | Remarks                    |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|------------------------|----------------------------|
| 1                                                                              | Work Order No.                             |                        |                        |                            |
| 2                                                                              | Machined By                                |                        | 15249 ✓                | 32155 ✓                    |
| 3                                                                              | Pallet Die No.                             |                        | V. T. L. n/c Shop      | Dy. H. L. R. G. G. Rev. 00 |
| 4                                                                              | Die Category                               | Drg. No.               | 14275 (G. 0) n/c       |                            |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | H. J. J. n/c           |                            |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 710 n/c Step 02 - 692  | 2mm Tapper 12              |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 600.14 n/c             | Step length 12             |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 222 n/c                |                            |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | 127107 7.5 n/c         | 127107 7.5 n/c             |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                     |                            |
| 11                                                                             | Tapping Operator                           |                        | OK                     |                            |
| 12                                                                             | Tapping PCD                                |                        | n/c Shop               |                            |
| 13                                                                             | Tapping Hole Diameter                      |                        | 640 n/c                |                            |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | H20, Check by H20 Bolt |                            |
| 15                                                                             | Tapping Hole Depth                         |                        | OK                     |                            |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Drill Depth 2.4 n/c    | Tapping Depth 18.5         |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | Yes                    |                            |
|                                                                                |                                            |                        | OK                     |                            |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 27/6/25           |                            |
| 1                                                                              | As per programme no.                       |                        |                        |                            |
| 2                                                                              | Gun Drilling Work Completed On             |                        |                        |                            |
| 3                                                                              | Hole Finish In Gun Drilling                | Marked                 | OK                     |                            |
| 4                                                                              | Defective Holes (If Any)                   |                        | N/A                    |                            |
| 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 n/c                | Outside (3-3)          | Inner                      |
| 3                                                                              | External Relief Depth                      |                        | 29 n/c                 | 23 n/c                     |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                   |                            |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark R. R. R. R.       |                            |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 27                     | 6 25                       |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 27/6/25           |                            |

Reviewed by (Engineer-CNC)

Manager-QA