



# 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 Dlos)

10342

| S.No.                                                                          | Check Parameter                            | Specification          | Observations                             | Remarks            |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|------------------------------------------|--------------------|
| 1                                                                              | Work Order No.                             |                        |                                          |                    |
| 2                                                                              | Machined By                                |                        | 15535                                    | GG/CC              |
| 3                                                                              | Pallet Die No.                             |                        | V.T.L. n/c Shop                          | Dry Holes 12.2.3de |
| 4                                                                              | Die Category                               | Drg. No.               | 15629(10.0) n/c                          | Rev. 02            |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | M. Jambh                                 |                    |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 680.1 mm, Step 06.692.7 mm               | Tabber. 8"         |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 546.14 mm (Box. 548.2)                   | Step length 4.2 mm |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 195 mm                                   | Width 0.228.75 mm  |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | 32.7 x 9.1 mm / 32.7 x 9.1 mm (4 x 8) mm |                    |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | ok                                       | Face Side          |
| 11                                                                             | Tapping Operator                           |                        | ok                                       | Back Side          |
| 12                                                                             | Tapping PCD                                |                        | n/c Shop                                 | Back Side          |
| 13                                                                             | Tapping Hole Diameter                      |                        | 619 mm                                   | Tapping No         |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | M16 Check by M16 Ball                    | of Holes 2         |
| 15                                                                             | Tapping Hole Depth                         |                        | ok                                       | Back Side          |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Drill Depth. 33.7 mm                     | Tapping Depth 31.7 |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | yes                                      |                    |
|                                                                                |                                            |                        | ok                                       |                    |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 25/7/25                             |                    |
| 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                     |                                          | Counter. G.        |
| 2                                                                              | External Relief Dia                        |                        | No Ret. g                                | Row. 8             |
| 3                                                                              | External Relief Depth                      |                        |                                          |                    |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                                     |                    |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Furnace                             |                    |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 25 7 25                                  |                    |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 25/7/25                             |                    |

Reviewed by (Engineer-CNC)

Manager-QA