



# 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.                             |                        | 15627                       | 36/50                 |
| 2                                                                              | Machined By                                |                        | V. T. C. H/C Shop           | 36/50                 |
| 3                                                                              | Pallet Die No.                             |                        | 12496(3.0)H                 | Rev 2.00              |
| 4                                                                              | Die Category                               | Drg. No.               | M. Tumb                     |                       |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 730mm - Step OD. 743mm      | Tapber 4              |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 630.14mm                    | Step length 7.5       |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 255mm                       | Under cut 6.5mm       |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 22 x 8 x 7mm / 22 x 8 x 7mm |                       |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | ok                          |                       |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | ok                          |                       |
| 11                                                                             | Tapping Operator                           |                        | H/C Shop                    |                       |
| 12                                                                             | Tapping PCD                                |                        | 685mm                       | Tapping H. of hole 12 |
| 13                                                                             | Tapping Hole Diameter                      |                        | M22 - Check by M2-B.1       | Both Side             |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | ok                          |                       |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 28.4mm          | Tapping Depth 26.4    |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                         |                       |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | ok                          |                       |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 12/8/25                |                       |
| 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 |                                            |                        |                             |                       |
| 1                                                                              | Counter Sinking Depth & Finish             | ok                     |                             | Counter 60            |
| 2                                                                              | External Relief Dia                        | 3.5mm                  | Outside 3-35                | Rev 2.42              |
| 3                                                                              | External Relief Depth                      |                        | 20mm                        | Inner 14mm            |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                        |                       |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Rurnare                |                       |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 12/8/25                     |                       |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 12/8/25                |                       |

Reviewed by (Engineer-CNC)

Manager-QA