



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

## Inprocess Inspection (Pollot Dies)

10506

| S.No. | Check Parameter                       | Specification          | Observations                    | Remarks             |
|-------|---------------------------------------|------------------------|---------------------------------|---------------------|
| 1     | Work Order No.                        |                        | 15747                           | 2014                |
| 2     | Machined By                           |                        | V.T.L. H/c Shop                 | Dr. 13.12.13        |
| 3     | Pallet Die No.                        |                        | 15277 (2.8) H/c                 | Severely            |
| 4     | Die Category                          | Drg. No.               | Senior                          |                     |
| 5     | Out Side Diameter                     | Drg. No.               | 5mm H/c                         | 499 H/c Tapping 13  |
| 6     | Inside Diameter                       | Drg. No.               | 420.14 H/c                      | Step length 1.7 H/c |
| 7     | Width of Pellet Die                   | Drg. No.               | 158 H/c                         |                     |
| 8     | Grooves as per Drawing                | Drg. No.               | 12 x 8 x 3 H/c / 12 x 8 x 3 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         |
| 12    | Tapping PCD                           |                        | 454 H/c                         | of holes 28         |
| 13    | Tapping Hole Diameter                 |                        | 0.314" 2 Check by 0.314" Ball   | Both Side           |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                              |                     |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 18.8 H/c            | Tapping Depth 18.7  |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                             |                     |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                              |                     |

### Inspected By (Sign) & Date

21/8/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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 = 20 |
| 2 | External Relief Dia                        | 3.3 H/c | Outside (2.2) |   | Inner  |  |  |  |  | 20 = 20      |
| 3 | External Relief Depth                      |         | 20 H/c        |   | 18 H/c |  |  |  |  |              |
| 4 | Inspection Done Before Hardening By (Name) |         |               |   |        |  |  |  |  |              |
| 5 | Material Sent For Hardening By (Name)      |         |               |   |        |  |  |  |  |              |
| 6 | Material Sent For Hardening On Date        |         | 21            | 8 | 25     |  |  |  |  |              |

### Inspected By (Sign) & Date

21/8/25

Reviewed by (Engineer-CNC)

Manager-QA