



# 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)

10560

| S.No. | Check Parameter                       | Specification          | Observations        | Remarks            |
|-------|---------------------------------------|------------------------|---------------------|--------------------|
| 1     | Work Order No.                        |                        | 15831               | 48/47              |
| 2     | Machined By                           |                        | N.T.L. n/c Shop     | Dy. n/c 15.6.1543  |
| 3     | Pallet Die No.                        |                        | 15432 (3.5) n/c     | Rev. m             |
| 4     | Die Category                          | Drg. No.               | Outside             |                    |
| 5     | Out Side Diameter                     | Drg. No.               | 614 mm              | Step on 611.9 mm   |
| 6     | Inside Diameter                       | Drg. No.               | 520.14 mm           | Step length 7.5    |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 mm              |                    |
| 8     | Grooves as per Drawing                | Drg. No.               | 13x8x5 mm           | 13x8x5 mm          |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | ok                  |                    |
| 10    | Drilling Area Surface Smoothness      |                        | ok                  |                    |
| 11    | Tapping Operator                      |                        | n/c Shop            |                    |
| 12    | Tapping PCD                           |                        | 565 mm              |                    |
| 13    | Tapping Hole Diameter                 |                        | 12 mm               | Check by 42 Bolt   |
| 14    | Tapping On Second Side                | Half pitch of 1st side | ok                  |                    |
| 15    | Tapping Hole Depth                    |                        | Drill Depth 20.4 mm | Tapping Depth 18.4 |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                 |                    |
| 17    | Visual Inspection Before Gun Drilling |                        | ok                  |                    |

### Inspected By (Sign) & Date

Res: 30/8/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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

Counter. Go

|   |                                            |        |               |  |       |  |  |  |  |
|---|--------------------------------------------|--------|---------------|--|-------|--|--|--|--|
| 1 | Counter Sinking Depth & Finish             | ok     |               |  |       |  |  |  |  |
| 2 | External Relief Dia                        | 4.0 mm | Outside (3-3) |  | Inner |  |  |  |  |
| 3 | External Relief Depth                      |        | 12 mm         |  | 5 mm  |  |  |  |  |
| 4 | Inspection Done Before Hardening By (Name) |        |               |  |       |  |  |  |  |
| 5 | Material Sent For Hardening By (Name)      |        |               |  |       |  |  |  |  |
| 6 | Material Sent For Hardening On Date        |        |               |  |       |  |  |  |  |

### Inspected By (Sign) & Date

Res: 30/8/25

Reviewed by (Engineer-CNC)

Manager-QA