



# 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)

| S.No.                                                                          | Check Parameter                            | Specification          | Observations                            | Remarks                       |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|-----------------------------------------|-------------------------------|
| 1                                                                              | Work Order No.                             |                        |                                         |                               |
| 2                                                                              | Machined By                                |                        | 15948                                   | 42/55                         |
| 3                                                                              | Pallet Die No.                             |                        | V.7.L H/c Shop                          | Drg No. 129                   |
| 4                                                                              | Die Category                               | Drg. No.               | 15282(4.0)H                             | Rev. 00                       |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 88870                                   |                               |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 622.9 H/c Step 00. 611.9 H/c            |                               |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 520.14 H/c                              | Step length 8.0 H/c           |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 126 H/c                                 |                               |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | 13x8x3 H/c 13x8x3 H/c                   |                               |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | ok                                      |                               |
| 11                                                                             | Tapping Operator                           |                        | ok                                      |                               |
| 12                                                                             | Tapping PCD                                |                        | 565 H/c                                 |                               |
| 13                                                                             | Tapping Hole Diameter                      |                        | H202 Check by H20B.12                   | [Tapping of hole 12 Bot Side] |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | ok                                      |                               |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 20.4 H/c Tapping Depth 18.4 |                               |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                                     |                               |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | ok                                      |                               |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 17/9/25                            |                               |
| 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 Sink                  |
| 2                                                                              | External Relief Dia                        | 4.5 H/c                | Outside 3-3                             | Inner 13 H/c                  |
| 3                                                                              | External Relief Depth                      | ✓                      | 17 H/c                                  |                               |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                                    |                               |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Forward                            |                               |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 17 9 25                                 |                               |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 17/9/25                            |                               |

Reviewed by (Engineer-CNC)

Manager-QA