



# 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 (Pollet Dies)

10826

| S.No. | Check Parameter                       | Specification          | Observations                          | Remarks           |
|-------|---------------------------------------|------------------------|---------------------------------------|-------------------|
| 1     | Work Order No.                        |                        | 16161                                 | 44/50             |
| 2     | Machined By                           |                        | UTL M/C Shop                          | 150 245 Re 01     |
| 3     | Pallet Die No.                        |                        | 14584                                 |                   |
| 4     | Die Category                          | Drg. No.               | M-Jumbo (4.0) mm                      |                   |
| 5     | Out Side Diameter                     | Drg. No.               | 700 mm - Step 22693 mm                |                   |
| 6     | Inside Diameter                       | Drg. No.               | 600 mm                                | Step length 20 mm |
| 7     | Width of Pellet Die                   | Drg. No.               | 222 mm                                |                   |
| 8     | Grooves as per Drawing                | Drg. No.               | 14x8x7 mm                             | Tapping No of     |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | OK                                    | Hole 12           |
| 10    | Drilling Area Surface Smoothness      |                        | OK                                    | Both side         |
| 11    | Tapping Operator                      |                        | M/C Shop                              |                   |
| 12    | Tapping PCD                           |                        | 640                                   |                   |
| 13    | Tapping Hole Diameter                 |                        | M20 check by mgo                      |                   |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                                    |                   |
| 15    | Tapping Hole Depth                    |                        | Drill depth 825 mm Tapping depth 18.5 |                   |
| 16    | Perpendicularity of Tapped Hole       |                        | Yes                                   |                   |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                                    |                   |

Inspected By (Sign) & Date

mallesh 8/10/25

|   |                                |        |    |
|---|--------------------------------|--------|----|
| 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                        | 4.5 mm | outer (2-3)  |    | inner 63 mm |  | For 31     |
| 3 | External Relief Depth                      |        | 14.4 mm      |    |             |  |            |
| 4 | Inspection Done Before Hardening By (Name) |        | mallesh      |    |             |  |            |
| 5 | Material Sent For Hardening By (Name)      |        | Lark furnace |    |             |  |            |
| 6 | Material Sent For Hardening On Date        |        | 8            | 10 | 25          |  |            |

Inspected By (Sign) & Date

Mallesh

Reviewed by (Engineer-CNC)

Manager-QA