



# 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)

| S.No.                                                                          | Check Paramotor                            | Speciflcation          | Observations          | Remarks          |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|-----------------------|------------------|
| 1                                                                              | Work Order No.                             |                        | 18806                 | 31/47            |
| 2                                                                              | Machined By                                |                        | V. T. L. n/c Shop     | 1543             |
| 3                                                                              | Pallet Die No.                             |                        | 12908 (3.0) n/c       | Rev. 00          |
| 4                                                                              | Die Category                               | Drg. No.               | Extrusion die         |                  |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 614 n/c               | Step length 19.5 |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 520.14 n/c            |                  |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 222 n/c               |                  |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 13x8x5 n/c            |                  |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | 13x8x5 n/c            |                  |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | ok                    |                  |
| 11                                                                             | Tapping Operator                           |                        | n/c Shop              |                  |
| 12                                                                             | Tapping PCD                                |                        | 565 n/c               |                  |
| 13                                                                             | Tapping Hole Diameter                      |                        | M22 Check by M20 Bolt |                  |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | ok                    |                  |
| 15                                                                             | Tapping Hole Depth                         |                        | Drill Depth 20.4 n/c  |                  |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | yes                   |                  |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | ok                    |                  |
| Inspected By (Sign) & Date                                                     |                                            |                        | Raw: 9/10/25          |                  |
| 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             |                        |                       |                  |
| 2                                                                              | External Relief Dia                        |                        | 3.5 n/c               |                  |
| 3                                                                              | External Relief Depth                      |                        | 18 n/c                |                  |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        |                       |                  |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        |                       |                  |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 9                     | 10 25            |
| Inspected By (Sign) & Date                                                     |                                            |                        | Raw: 9/10/25          |                  |

Reviewed by (Engineer-CNC)

Manager-QA