



# 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 Parameter                       | Specification          | Observations                          | Remarks            |
|-------|---------------------------------------|------------------------|---------------------------------------|--------------------|
| 1     | Work Order No.                        |                        |                                       |                    |
| 2     | Machined By                           |                        | 16202                                 | 37/405             |
| 3     | Pallet Die No.                        |                        | V.7.1 M/C Shop                        | Dry No 2 Lark 2.10 |
| 4     | Die Category                          | Drg. No.               | 13962 (3.5)                           |                    |
| 5     | Out Side Diameter                     | Drg. No.               | 520                                   |                    |
| 6     | Inside Diameter                       | Drg. No.               | 500 mm Step OD 2 490 2 mm Step 117    |                    |
| 7     | Width of Pellet Die                   | Drg. No.               | 420.14 mm                             |                    |
| 8     | Grooves as per Drawing                | Drg. No.               | 182 mm                                |                    |
| 9     | Fitting Sizes on CNC Plate            | Drg. No.               | 12 x 8 x 3 mm 12 x 8 x 3 mm           |                    |
| 10    | Drilling Area Surface Smoothness      |                        | OK                                    |                    |
| 11    | Tapping Operator                      |                        | M/C Shop                              | Tapping No         |
| 12    | Tapping PCD                           |                        | 453.9 mm                              | of Hole 28         |
| 13    | Tapping Hole Diameter                 |                        | N2.2 Check by H2 Ball                 | Both side          |
| 14    | Tapping On Second Side                | Half pitch of 1st side | OK                                    |                    |
| 15    | Tapping Hole Depth                    |                        | Drill depth 218.7 Tapping depth 216.3 |                    |
| 16    | Perpendicularity of Tapped Hole       |                        | yes                                   |                    |
| 17    | Visual Inspection Before Gun Drilling |                        | OK                                    |                    |

### Inspected By (Sign) & Date

|   |                                |        |               |  |
|---|--------------------------------|--------|---------------|--|
| 1 | As per programme no.           |        | Ravi 15/10/25 |  |
| 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 28 |
| 2 | External Relief Dia                        | 4.0 mm | 22.2 |    | Inner        |    |  | Row 22     |
| 3 | External Relief Depth                      |        | 7 mm |    | 3 mm         |    |  |            |
| 4 | Inspection Done Before Hardening By (Name) |        |      |    | Ravi         |    |  |            |
| 5 | Material Sent For Hardening By (Name)      |        |      |    | Lark Furnace |    |  |            |
| 6 | Material Sent For Hardening On Date        |        |      | 15 | 10           | 25 |  |            |

### Inspected By (Sign) & Date

|  |  |  |               |  |
|--|--|--|---------------|--|
|  |  |  | Ravi 15/10/25 |  |
|--|--|--|---------------|--|

Reviewed by (Engineer-CNC)

Manager-QA