



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10156

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Paramotor	Speciflcation	Observations	Remarks
1	Work Order No.			
2	Machined By		15251	45/50
3	Pallet Die No.		V.T.L. n/a Shop	Drg. No. (28/6/25)
4	Die Category	Drg. No.	15311 (4.0) n/a	Rev. 01
5	Out Side Diameter	Drg. No.	760 n/a	792 n/a
6	Inside Diameter	Drg. No.	66.14 n/a	Order cut - 16 n/a
7	Width of Pellet Die	Drg. No.	324 n/a	
8	Grooves as per Drawing	Drg. No.	21 x 8 x 10 n/a / 21 x 8 x 10 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	Tapping n/a
12	Tapping PCD		725 n/a	of Holes 12
13	Tapping Hole Diameter		1120 = Check by 1120 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 27.4 n/a	Tapping Depth 27.4 n/a
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Saw: 28/6/25	
1	As per programme no.			2810
2	Gun Drilling Work Completed On			32.1 mm width
3	Hole Finish In Gun Drilling	Marked	ok	9 mm Deep
4	Defective Holes (If Any)		No	Both Side
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counters 60
2	External Relief Dia	4.5 n/a	Outside 3-3	Row 48
3	External Relief Depth		13 n/a	5 n/a
4	Inspection Done Before Hardening By (Name)		Saw!	
5	Material Sent For Hardening By (Name)		Lark Permacore	
6	Material Sent For Hardening On Date		28 6 25	
Inspected By (Sign) & Date			Saw: 28/6/25	

Reviewed by (Engineer-CNC)

Manager-QA