



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Paramotor	Specification	Observations	Remarks
1	Work Order No.		15718	50/55
2	Machined By		V.T.L. H/O Shop	Dy. No. 1.2.5743
3	Pallet Die No.		15640 (B.5) H/O	Revised
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	770 H/O Step 00, 792.7 H/O	
6	Inside Diameter	Drg. No.	660.14 H/O	Step length 27 H/O
7	Width of Pellet Die	Drg. No.	324 H/O	Lead cut 11.5 H/O
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 12 H/O / 21.5 x 8 x 12 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		725 H/O	Tapping H/O of Holes = 12
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 31.4 H/O	Tapping Depth 28.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

1	As per programme no.			Rev: 27/8/25	2 side
2	Gun Drilling Work Completed On				32.1 H/O width
3	Hole Finish In Gun Drilling	Marked	OK		8 H/O 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						Counter Bo
2	External Relief Dia	4.0 H/O	Outside 3-3		Inner			Rev: 52
3	External Relief Depth		12 H/O		5 H/O			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		27	8	25			

Inspected By (Sign) & Date

Reviewed by (Engineer-CNC)

Manager-QA