



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.			
2	Machined By		15897	46/51
3	Pallet Die No.		V.T.L M/c Shop	Dry No. 1.2.5.10.295
4	Die Category	Drg. No.	14518 (B.5) H-1	Rev. 02
5	Out Side Diameter	Drg. No.	H-1000	
6	Inside Diameter	Drg. No.	681.9 mm	Step 00 = Tapper 12°
7	Width of Pellet Die	Drg. No.	580.14 mm	Step length 98 mm
8	Grooves as per Drawing	Drg. No.	286 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	28.5 x 6 x 12 mm 28 x 8 x 12 mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/c Shop	Tapping No
13	Tapping Hole Diameter		630 mm	of Hole = 12
14	Tapping On Second Side	Half pitch of 1st side	H16 = Check by H16 B.12	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill depth = 25.4 mm	Tapping depth = 23.4
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 15/9/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		N/A

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK	outside	Inner	Counter - 50
2	External Relief Dia	4.0 mm	(3-3)		Row. 238
3	External Relief Depth		12 mm	5 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 9 25	

Inspected By (Sign) & Date

Ravi 15/9/25

Reviewed by (Engineer-CNC)

Manager-QA