



Lark Engineering Company (India) Pvt. Ltd.

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

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.		16085	22/22/66
2	Machined By		V.T.L M/c Shop	Dry No. 1-22-230
3	Pallet Die No.		15755 (6.0) H	Rev. 02
4	Die Category	Drg. No.	H. 70 mm	
5	Out Side Diameter	Drg. No.	680.144	Step 0 D: 692.2 H
6	Inside Diameter	Drg. No.	546.144	(8.0) 548.2 H
7	Width of Pellet Die	Drg. No.	195 H	Tapper, 8"
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 H	Step length = 31 H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Under cut, 2.8 H
10	Drilling Area Surface Smoothness		OK	Face Side Step 3 H
11	Tapping Operator		M/c Shop	Deep Bot Side
12	Tapping PCD		619 H	Tapping No
13	Tapping Hole Diameter		M16	of Hole 20
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill depth = 33.4 H	Tapping depth 31 H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 20/9/25	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		No	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK	Counter = 30	
2	External Relief Dia	6.5 H 7.0 H	6.5 H	Row = 12
3	External Relief Depth		7.0 H	All Rows = 33 H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		20 9 25	
Inspected By (Sign) & Date			Ravi 20/9/25	

Reviewed by (Engineer-CNC)

Manager-QA