



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 (Pellet Dies)

10236

S.No.	Check Paramotor	Speciflcation	Observations	Remarks
1	Work Order No.		16050	45/35
2	Machined By		V.T.I. H/c Shop	Dry No-25d-410
3	Pallet Die No.		15325 (8.0)mm	(Rev-01)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	630 mm	Step OD - 624 mm
6	Inside Diameter	Drg. No.	520.14 mm	Tapper - 12°
7	Width of Pellet Die	Drg. No.	186 mm	Step length - 18 mm
8	Grooves as per Drawing	Drg. No.	13x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x3 mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 mm	Tapping No of Holes - 19
13	Tapping Hole Diameter		M-20 check by M-20 Bolt	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth - 20.4 mm	Tapping depth - 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

1	As per programme no.		Ravi	24/9/25
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

Counter-60

1	Counter Sinking Depth & Finish	OK	outside	Inner			Row-14
2	External Relief Dia	(8.5 mm)	(3-3)	(10 mm)			
3	External Relief Depth		18 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		24	9	25		
Inspected By (Sign) & Date			Ravi	24-9-25			

Reviewed by (Engineer-CNC)

Manager-QA