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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)

S.No.	Check Paramotor	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		16172 ✓	27/40 ✓
3	Pallet Die No.		V.T.L M/c Shop	Dry No 2 1.4.15.62
4	Die Category	Drg. No.	15101 (3.0) M4 ✓	Rev. 00
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	5mm M4	Step OD = 498.8, Tapper 12°
7	Width of Pellet Die	Drg. No.	420.14 M4	Step length = 18 M4
8	Grooves as per Drawing	Drg. No.	158 M4	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3mm 12x8x3mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/c Shop	Tapping No
13	Tapping Hole Diameter		454 M4	of Holes = 8
14	Tapping On Second Side	Half pitch of 1st side	M20x Check by M20 Bolt	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill depth = 18.4 M4	Tapping depth = 18.4
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

Ravi 10/10/25

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

Counter 360

1	Counter Sinking Depth & Finish	OK	outside	Inner				Row 2
2	External Relief Dia	13.5 M4	(2-2)					
3	External Relief Depth		16 M4	13 M4				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date			10	10	25		

Inspected By (Sign) & Date

Ravi 10/10/25

Reviewed by (Engineer-CNC)

Manager-QA