

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	Spocifcation	Observations	Remarks
1	Work Order No.		16202	29/40
2	Machined By		VTL M/c Shop	Prz No 2199 len 15 STD
3	Pallet Die No.		13961 (3.2)mm	
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	500 mm Step OD 490.9mm	
6	Inside Diameter	Drg. No.	420.14	Step Length 17.5mm
7	Width of Pellet Die	Drg. No.	182 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	TAPPING NOOF
10	Drilling Area Surface Smoothness		OK	Hole 8
11	Tapping Operator		M/c Shop	Both side
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		m 20 Check by m 20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.5 Tapping Depth 16.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			mahesh 7/10/25	
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				
1	Counter Sinking Depth & Finish	OK		Counter 60°
2	External Relief Dia	3.8	outer (2.2)	Inner 2.8
3	External Relief Depth		14.5mm	11mm
4	Inspection Done Before Hardening By (Name)		Mahesh	
5	Material Sent For Hardening By (Name)		Lark furnace	
6	Material Sent For Hardening On Date		7 10 25	
Inspected By (Sign) & Date			mahesh 7/10/25	

Reviewed by (Engineer-CNC)

Manager-QA