



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	Speciflcation	Observations	Remarks
1	Work Order No.		16262	45/66
2	Machined By		V.T.L. n/c Shop	Drg No. 12.0136-
3	Pallet Die No.		16091(8.0)H4	Revised
4	Die Category	Drg. No.	H. Jamba	Uncovered
5	Out Side Diameter	Drg. No.	680.144 Step 00	693.44 Tapper 8°
6	Inside Diameter	Drg. No.	546.144 (Bore 2548.2)	Step length 31.3
7	Width of Pellet Die	Drg. No.	205.6H4	Under cut 2.8mm
8	Grooves as per Drawing	Drg. No.	32.3 x 8 x 9.144 / 32.3 x 6 x 9.144	(4 x 8.44)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		n/c Shop	2.344 Deep
12	Tapping PCD		819.44	Both Side
13	Tapping Hole Diameter		H16, Check by H16 Ball	Tapping Holes
14	Tapping On Second Side	Half pitch of 1st side	ok	Holes 2 & 3 Both Side
15	Tapping Hole Depth		Drill Depth = 33.444	Tapping Depth 31.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/10/25

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 30°
2	External Relief Dia	9.044			All Rows			Row 10
3	External Relief Depth				21.44			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Permare			
6	Material Sent For Hardening On Date				16	10	25	

Inspected By (Sign) & Date

Ravi 16/10/25

Reviewed by (Engineer-CNC)

Manager-QA