



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	Specifcation	Observations	Remarks
1	Work Order No.		15465	45/55
2	Machined By		V. T. L. n/c Shop	Done 12.02.10
3	Pallet Die No.		14277(5.0)H	Rev. no.
4	Die Category	Drg. No.	H. 700 B	
5	Out Side Diameter	Drg. No.	709.9 H	Step 00, 393 H
6	Inside Diameter	Drg. No.	600.14 H	Tapped 12
7	Width of Pellet Die	Drg. No.	222 H	Step length 20 mm
8	Grooves as per Drawing	Drg. No.	12x8x7 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		640 H	
13	Tapping Hole Diameter		120, Check by H2 Ball	Tapping Holes of Holes 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		1 Drill Depth 20.4 H	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		Y & Z	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rawi 18/2/25

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							
2	External Relief Dia	5.5 H	Outside (R-3)		Inner				
3	External Relief Depth		15 H		10 H				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		18	7	25				

Inspected By (Sign) & Date

Rawi 18/2/25

Reviewed by (Engineer-CNC)

Manager-QA