



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)

10379

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15431	30/66
2	Machined By		V. T. L. N/C Shop	Dr. H. L. S. 28
3	Pallet Die No.		15543 (6.0) mm	Rev. 08
4	Die Category	Drg. No.	H. T. L. 60	478
5	Out Side Diameter	Drg. No.	680.2 mm	Step 02, 682.8 mm
6	Inside Diameter	Drg. No.	546.14 mm	(Box - 548.2) mm
7	Width of Pellet Die	Drg. No.	195 mm	Step length 31
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 mm	Side cast 2.7 mm
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.1 mm	(478) mm
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		N/C Shop	2 mm Deep
12	Tapping PCD		619 mm	Both Side
13	Tapping Hole Diameter		H16, Check by H16 Ball	Tapping No
14	Tapping On Second Side	Half pitch of 1st side	ok	of Hole 2
15	Tapping Hole Depth		Drill Depth 33.7 mm	Both Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth 31.8
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/7/25

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 30

1	Counter Sinking Depth & Finish	ok						Ravi 28/7/25
2	External Relief Dia	7.0 mm		All Rows				
3	External Relief Depth			36 mm				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Permare				
6	Material Sent For Hardening On Date		28	7	25			

Inspected By (Sign) & Date

Ravi 28/7/25

Satish 28/7/25

Reviewed by (Engineer-CNC)

Manager-QA