



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 Parameter	Specification	Observations	Remarks
1	Work Order No.		14740	2-165
2	Machined By		V.T.L. H/c Shop	Dr. H/c 13.09.13
3	Pallet Die No.		15769 (B.5)	Rev. 01
4	Die Category	Drg. No.	3. Jumbo	
5	Out Side Diameter	Drg. No.	1032.2 mm - Step 02	1033 mm - Tapped
6	Inside Diameter	Drg. No.	900.12 mm	Step length 20.7
7	Width of Pellet Die	Drg. No.	375 mm	Under cut 20.4 mm
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13 mm / 29.5 x 8 x 12.9 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping of Holes 25
12	Tapping PCD		970 mm	Both Side
13	Tapping Hole Diameter		H24. Check by H24 Bore	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 38.4 mm	Tapping Depth 30.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/6/25

1	As per programme no.			2 Side
2	Gun Drilling Work Completed On			32.1 mm width
3	Hole Finish In Gun Drilling	Marked	ok	7.5 mm Depth
4	Defective Holes (If Any)		No - 2 Hole Closed	Both Side

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter Bore
2	External Relief Dia	4.0 mm	Outside	Inner				
3	External Relief Depth		13 mm	6 mm				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		21	6	25			

Inspected By (Sign) & Date

Ravi 21/6/25

Manager-QA

Reviewed by (Engineer-CNC)