



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)

11003

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16218 ✓	7d/70 ✓
2	Machined By		V. T. L. n/c Shop	Dr. No. 18.0.1.51
3	Pallet Die No.		16453 (5.0) ✓	Rev = 01 ✓
4	Die Category	Drg. No.	Jumbo (AST)	
5	Out Side Diameter	Drg. No.	769.6 mm, Step OD = 743.6 mm	Tapped 100%
6	Inside Diameter	Drg. No.	630.14 mm	Step length = 28.3
7	Width of Pellet Die	Drg. No.	265.6 mm	
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 5 mm / 15.3 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	0.8 mm Deep
11	Tapping Operator		n/c Shop	Back Side
12	Tapping PCD		685 mm	Tapping H.
13	Tapping Hole Diameter		M20, Check by M20 Bolt	of Hole 16
14	Tapping On Second Side	Half pitch of 1st side	OK	Back Side
15	Tapping Hole Depth		Drill Depth = 20.6 mm	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

8/11/25

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 Bo.
2	External Relief Dia	—	—	No	Relief			Rev 233
3	External Relief Depth							
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date							

Inspected By (Sign) & Date

8/11/25

Reviewed by (Engineer-CNC)

Manager-QA