

# 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 (Pallet Dies)

| S.No.                                                                          | Check Parameter                            | Specification          | Observations                | Remarks            |
|--------------------------------------------------------------------------------|--------------------------------------------|------------------------|-----------------------------|--------------------|
| 1                                                                              | Work Order No.                             |                        |                             |                    |
| 2                                                                              | Machined By                                |                        | 15444                       | 37/50              |
| 3                                                                              | Pallet Die No.                             |                        | V.L. T.L. w/c Shop          | Qty 1000           |
| 4                                                                              | Die Category                               | Drg. No.               | 14614 (3.5) H               | Rev 05             |
| 5                                                                              | Out Side Diameter                          | Drg. No.               | 9 x 20 side                 |                    |
| 6                                                                              | Inside Diameter                            | Drg. No.               | 6.2 mm, Step 0.12           | Tapken 12          |
| 7                                                                              | Width of Pellet Die                        | Drg. No.               | 5.20.14 H                   | Step length 18.5   |
| 8                                                                              | Grooves as per Drawing                     | Drg. No.               | 2.2.2 H                     |                    |
| 9                                                                              | Fitting Sizes on CNC Plate                 | Drg. No.               | 13 x 8 x 5 H / 13 x 8 x 5 H |                    |
| 10                                                                             | Drilling Area Surface Smoothness           |                        | OK                          |                    |
| 11                                                                             | Tapping Operator                           |                        | OK                          |                    |
| 12                                                                             | Tapping PCD                                |                        | H/C Shop                    |                    |
| 13                                                                             | Tapping Hole Diameter                      |                        | 5.65 H                      |                    |
| 14                                                                             | Tapping On Second Side                     | Half pitch of 1st side | H20. Check by H20 Bolt      |                    |
| 15                                                                             | Tapping Hole Depth                         |                        | OK                          |                    |
| 16                                                                             | Perpendicularity of Tapped Hole            |                        | Drill Depth 20.4 H          | Tapping Depth 18.6 |
| 17                                                                             | Visual Inspection Before Gun Drilling      |                        | Yes                         |                    |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 5/7/25                 |                    |
| 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 |                                            |                        |                             |                    |
| 1                                                                              | Counter Sinking Depth & Finish             | OK                     |                             | Counter Bo         |
| 2                                                                              | External Relief Dia                        | 4.0 H                  | Outer 2.8-3.5               | Inner              |
| 3                                                                              | External Relief Depth                      |                        | 1.7 H                       | 1.3 H              |
| 4                                                                              | Inspection Done Before Hardening By (Name) |                        | Ravi                        |                    |
| 5                                                                              | Material Sent For Hardening By (Name)      |                        | Lark Ravi                   |                    |
| 6                                                                              | Material Sent For Hardening On Date        |                        | 5 7 25                      |                    |
| Inspected By (Sign) & Date                                                     |                                            |                        | Ravi 5/7/25                 |                    |

Reviewed by (Engineer-CNC)

Manager-QA