

10418

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Basouli 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.		15630	22/6
2	Machined By		V. T. L. H/C Shop	Dr. 12.12.13
3	Pallet Die No.		15559 (2.0)	Rev. 02
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	68.02 mm Step 0.6 69.3 mm	Tapping 0.6
6	Inside Diameter	Drg. No.	54.6 mm (Bore 54.8.2)	Step length 2.9 mm
7	Width of Pallet Die	Drg. No.	19.5 mm	Under cut 2.75 mm
8	Grooves as per Drawing	Drg. No.	32.9 x 9.1 mm / 32.9 x 9.1 mm	(4.2) mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side
10	Drilling Area Surface Smoothness		OK	8 mm Deep
11	Tapping Operator		H/C Shop	Back Side
12	Tapping PCD		61.9 mm	Tapping 4.0
13	Tapping Hole Diameter		H16. Check by H16 Ball	of hole 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Back Side
15	Tapping Hole Depth		Drill Depth 33.7 mm	Tapping Depth 31.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 5/8/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		Nil

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

Considered 2.0

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.0 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 Purrace					
6	Material Sent For Hardening On Date			5	8	25			
Inspected By (Sign) & Date				Ravi 5/8/25					

5/8/25

Reviewed by (Engineer-CNC)

Manager-QA