



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10400

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		15600	32/50
3	Pallet Die No.		V.T.L H/c Shop	Py H. 1.25.125-1
4	Die Category	Drg. No.	14574(4.0) H/c	Rev. 01
5	Out Side Diameter	Drg. No.	H. 10mm	
6	Inside Diameter	Drg. No.	700 H/c - Shop 00. 692.9mm	Tapping 12
7	Width of Pellet Die	Drg. No.	600.14 H/c	Shop length 20mm
8	Grooves as per Drawing	Drg. No.	222 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x7 H/c / 12x8x7 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		640 H/c	
13	Tapping Hole Diameter		H20. Check by H20 B-12	Tapping H. of Hole 12.12
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 4/8/25

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

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

Counter. 63
Cor. 32

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5 H/c	Outside (3-3)	Inner			
3	External Relief Depth		22 H/c	18 H/c			
4	Inspection Done Before Hardening By (Name)		Raw:				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		4	8	25		

Inspected By (Sign) & Date

Raw: 4/8/25

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4/8/25

Reviewed by (Engineer-CNC)

Manager-QA