

Lark Engineering Company (India) Pvt. Ltd.

L.T.I. Basouli Road, Yamuna Nagar - 136 001 (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.		15948 ✓	39/50 ✓
2	Machined By		M.T.L M/c Shop	Dry No 2 Lark ✓
3	Pallet Die No.		14333 (C.O.) ✓	Rev 2 ✓
4	Die Category	Drg. No.	88370	
5	Out Side Diameter	Drg. No.	612.9 mm	Step OD 2611.9 mm
6	Inside Diameter	Drg. No.	580.14 mm	Step length 19.5
7	Width of Pellet Die	Drg. No.	186 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	13x8x5 mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping No
12	Tapping PCD		565 mm	of Holes 212
13	Tapping Hole Diameter		42.2	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 220.4 mm	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 13/9/25

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	outside	Inner			Counter 30
2	External Relief Dia	3.5 mm	(3-3)				Row 30
3	External Relief Depth		17 mm	11 mm			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark	Furnace		
6	Material Sent For Hardening On Date			13	9	25	

Inspected By (Sign) & Date

Ravi 13/9/25

Reviewed by (Engineer-CNC)

Manager-QA