

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Gasouli 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.		16228	30/55
2	Machined By		V.T.I. M/c Shop	Dry No. 12.9.430
3	Pallet Die No.		15495(4.0) mm	Rec 100
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	709.9 mm	Dep of D = 691.2 mm
6	Inside Diameter	Drg. No.	600.14 mm	Dep length = 19.0
7	Width of Pallet Die	Drg. No.	222.5 mm	Maintain in Final M/c
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 mm / 12.5 x 8 x 7 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		645 mm	of Holes = 12
13	Tapping Hole Diameter		422 Check by 422 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.4 mm	Tapping depth = 20.4 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 15/10/25

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 = 65
2	External Relief Dia	4.5 mm	Outside (2-3)		Inner			Row = 32
3	External Relief Depth		29 mm		25 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			15	10	25		

Inspected By (Sign) & Date

Ravi 15/10/25

Reviewed by (Engineer-CNC)

Manager-QA