



Lark Engineering Company (India) Pvt. Ltd.

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

Form No. CNC/QA/FM/03

Rev. No. 01

Final Inspection (Pellet Dies) after Hardening & Finishing

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1.	Work order No.	11921 to 12047 to 12239		30/66
2.	Visual Inspection	OK - 6-0 mm (M. diameter)		Pr. 01 Dmg No - 609A+B
3.	Pellet Die No.	12483		UT-OK
4.	Hardened by	Lark Penny		Relief - OK
5.	Received by after hardening (Name)	Jayjir		Ø 70 → 36 mm
6.	Hardness achieved on 1 st side	58.1 - 50.3 HRC		3 ALB
7.	Hardness achieved on 2 nd side	49.8 - 50.1 HRC		Center - OK
8.	Ovality after hardening 1 st side	(0.4) mm		Ø CD - 619 mm
9.	Ovality after hardening 2 nd side	(0.5) mm		Tapping M16
10.	Outside Diameter	680 mm		Deep - 31.5 mm
11.	Inside Diameter	548.5 ± 0.07 - 1.10 - 1.08 - 1.12 mm		Tapping M16
12.	Width of die	195 mm		Holes - 4
Inspected By (Sign) & Date		Jayjir 1/7/24		
1.	Finish Fitting size 1 st side	690 ± 0.12 ± 0.12 mm	Tapper 8°	Wonders at - 1 mm
2.	Finish Fitting size 2 nd side	690 ± 0.12 ± 0.12 mm	Tapper 8°	
3.	Finish size made by			
Inspected By (Sign) & Date		Jayjir 1/7/24		
1.	Supplied to (Customer Name)	Kulong, HR, SNU, Rajasthan to		Man Packing
2.	Dispatch Date			
Reported By (Sign) & Date		Jayjir 1/7/24		

Reviewed by (Engineer-CNC)
S. S. S. 1/7/24

Manager-CNC