



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.		11739	40/85
2.	Visual Inspection		Bkr 4.0 mm (S. Jumbo)	22.00 DMGN-1048
3.	Pellet Die No.		12101	U7-die
4.	Hardened by		Hark Pency	Relief - ok
5.	Received by after hardening (Name)		Jarjan	(3-3) = 33
6.	Hardness achieved on 1 st side		48.1 - 47.7 HRC	Addn (3-3) = 29
7.	Hardness achieved on 2 nd side		49.1 - 49.2 HRC	Relief 5.0 = 25
8.	Ovality after hardening 1 st side		(1.7) mm	Re-counters due to
9.	Ovality after hardening 2 nd side		(0.9) mm	ovality PCD - 970 mm
10.	Outside Diameter		1030 mm	Tapping M24
11.	Inside Diameter		900 mm	Deep - 32.8 mm
12.	Width of die		337 mm	Tapping H0 ok
Inspected By (Sign) & Date		Jarjan		Relief - 16
1.	Finish Fitting size 1 st side	1038.5 ± .12 ± .12 mm Tappa 4°		Undercut 5.0 mm
2.	Finish Fitting size 2 nd side	1038.5 ± .12 ± .12 mm Tappa 4°		= 5.8 mm
3.	Finish size made by	←		Final size check by
Inspected By (Sign) & Date		Jarjan		Sandek Singh
1.	Supplied to (Customer Name)	Tiwana oil mill, PB		Sy - 21111
2.	Dispatch Date	←		
Reported By (Sign) & Date		Jarjan 19/7/24		

Satya
19/7/24

Reviewed by (Engineer-CNC)

Manager-CNC