



Lark Engineering Company (India) Pvt. Ltd.

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

6851

Form No.	CNC/QA/FM/03
Rev. No.	01
Rev. Date	31-07-2013

Final Inspection (Pellet Dies) after Hardening & Finishing

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	9996	40150
2.	Visual Inspection	OK - 4.0 mm (MJEU)	Pin Dwg No 16178 Arb
3.	Pellet Die No.	8814	07-OK
4.	Hardened by	work furnace	Relief - OK
5.	Received by after hardening (Name)	Jayjir	(3.3) > 14mm
6.	Hardness achieved on 1 st side	50.5 - 50.2 HRC	Relief ϕ 4.5 S 10mm
7.	Hardness achieved on 2 nd side	50.0 - 50.2 HRC	Counter - OK
8.	Ovality after hardening 1 st side	(0.9) mm $\text{\textcircled{D}}$	PCD - 640 mm
9.	Ovality after hardening 2 nd side	(0.8) mm $\text{\textcircled{D}}$	Tapping M20
10.	Outside Diameter	701 mm	Deep - 18.8 mm
11.	Inside Diameter	600 mm	Tapping Hough
12.	Width of die	265 mm	Hols - 12
Inspected By (Sign) & Date		Jayjir 7/8/23	
1.	Finish Fitting size 1 st side	700 \pm 0.04 \pm 0.05 mm Tapper 12 $^{\circ}$	Under cut - .5mm
2.	Finish Fitting size 2 nd side	700 \pm 0.05 \pm 0.05 mm Tapper 12 $^{\circ}$	
3.	Finish size made by		
Inspected By (Sign) & Date		Jayjir 7/8/23	
1.	Supplied to (Customer Name)	T. D Arora Ards, PB	
2.	Dispatch Date		
Reported By (Sign) & Date		Jayjir 7/8/23	

[Signature]
7/8/23

Reviewed by (Engineer-CNC)

Manager-CNC