



# 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
Rev. Date	31-07-2013

## Final Inspection (Pellet Dies) after Hardening & Finishing

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	12470	28/38/66
2.	Visual Inspection	ok - 6.0 mm CM-Jumbo	Dring No 609 A/B
3.	Pellet Die No.	12890	UT-OK
4.	Hardened by	hark ferny	Relief ok
5.	Received by after hardening (Name)	Janju	$\phi 6.5 = 38 \text{ mm}$
6.	Hardness achieved on 1 <sup>st</sup> side	50.0-50.3 HRC	$\phi 7.0 = 28 \text{ mm}$
7.	Hardness achieved on 2 <sup>nd</sup> side	50.1-50.5 HRC	Counter at 30°
8.	Ovality after hardening 1 <sup>st</sup> side	(0.4) mm	PCD - 619 mm
9.	Ovality after hardening 2 <sup>nd</sup> side	(0.8) mm	Tapping M16
10.	Outside Diameter	680 mm	Deep - 31.5 mm
11.	Inside Diameter	548.5 $\pm 0.06$ $\pm 0.10$ $\pm 0.02$ $\pm 0.10$ mm	Tapping M16
12.	Width of die	195 mm	Keys - 4
Inspected By (Sign) & Date		Janju 14/8/24	
1.	Finish Fitting size 1 <sup>st</sup> side	690 $\pm 0.10$ $\pm 0.11$ mm Tapper 8°	Underset = 1 mm
2.	Finish Fitting size 2 <sup>nd</sup> side	690 $\pm 0.11$ $\pm 0.12$ mm Tapper 8°	
3.	Finish size made by		
Inspected By (Sign) & Date		Janju 14/8/24	
1.	Supplied to (Customer Name)	Shri Laxmi Pellet, Rajasthan	
2.	Dispatch Date		
Reported By (Sign) & Date		Janju 14/8/24	

Janju 14/8/24

Reviewed by (Engineer-CNC)

Manager-CNC