



Lark Engineering Company (India) Pvt. Ltd.

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

6858

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.		9999	45/12
2.	Visual Inspection		OK - 3.2 mm (SSCW)	Rm co 406 ATB
3.	Pellet Die No.		10563	U7-OK
4.	Hardened by		Lark furnace	Relief - OK
5.	Received by after hardening (Name)		Jaujan	(3-3) > 12 mm
6.	Hardness achieved on 1 st side		50.0 - 50.1 HRC	Relief ϕ 3.8 \leq 8.5 mm
7.	Hardness achieved on 2 nd side		49.4 - 49.6 HRC	Counters - OK
8.	Ovality after hardening 1 st side		(0.3) mm	PCD - 565 mm
9.	Ovality after hardening 2 nd side		(0.1) mm	Tapping M20
10.	Outside Diameter		620 mm	Deep - 18.8 mm
11.	Inside Diameter		520 mm	Tapping No of
12.	Width of die		229 mm	Holes - 12

Inspected By (Sign) & Date Jaujan 8/8/23

1.	Finish Fitting size 1 st side	621 \pm .12 \pm .12 mm Tapper 12°	Under cut = .5 mm
2.	Finish Fitting size 2 nd side	621 \pm .12 \pm .11 mm Tapper 12°	
3.	Finish size made by		

Inspected By (Sign) & Date Jaujan 8/8/23

1.	Supplied to (Customer Name)	Gyan Tech Alliance
2.	Dispatch Date	

Reported By (Sign) & Date Jaujan 8/8/23

Reviewed by (Engineer-CNC) [Signature] 9/8/23

Manager-CNC