



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

6901

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	10005	301401 P5
2.	Visual Inspection	OK - 4.8 mm (CM Jumbo)	Re-co to 4.42 ArB
3.	Pellet Die No.	9712	U7-OK
4.	Hardened by	hark punny	Relief-OK
5.	Received by after hardening (Name)	Jayju	φ 5.3 ± 0.25 mm
6.	Hardness achieved on 1 st side	49.5 - 49.8 HRC	φ 5.8 ± 0.15 mm
7.	Hardness achieved on 2 nd side	49.7 - 49.9 HRC	Re-counter-OK
8.	Ovality after hardening 1 st side	(1.2) mm [die was re-centered]	PCD - 640 mm
9.	Ovality after hardening 2 nd side	(1.8) mm [due to ovality]	Tapping M20
10.	Outside Diameter	710 mm	Deep - 20 mm
11.	Inside Diameter	600 mm	Tapping H=up
12.	Width of die	222 mm	Holes - 12

Inspected By (Sign) & Date

Jayju 17/8/23

1. Finish Fitting size 1st side

690 + 0.12 ± 0.10 mm Tapper 12°

Final size check

2. Finish Fitting size 2nd side

690 + 0.10 ± 0.10 mm Tapper 12°

Sy - Sandeep Singh

3. Finish size made by

Keth - ap

Inspected By (Sign) & Date

Jayju 17/8/23

Sign - [Signature]

1. Supplied to (Customer Name)

Multikraft India, Tamil Nadu

2. Dispatch Date

Reported By (Sign) & Date

Jayju 17/8/23

1002 - CWP/INK

[Signature] 17/8/23

Reviewed by (Engineer-CNC)

Manager-CNC