



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.	12830 to 13256	26/36/66
2.	Visual Inspection	OK - 8.0 mm (M. 14mm)	Dring H-609AD
3.	Pellet Die No.	13328	UT-OK
4.	Hardened by	hark permy	Relief-OK
5.	Received by after hardening (Name)	Janjan	φ 8.5 5 40 mm
6.	Hardness achieved on 1 st side	49.6 - 49.9 HRc	φ 9.0 30 mm
7.	Hardness achieved on 2 nd side	50.1 - 50.4 HRc	Counter-OK
8.	Ovality after hardening 1 st side	(0.5) mm	φ 10 - 619 mm
9.	Ovality after hardening 2 nd side	(0.4) mm	Tapping M16
10.	Outside Diameter	68 mm	Deep - 32 mm
11.	Inside Diameter	548.4 ± 0.10 ± 0.08 ± 0.06 ± 0.09 mm	Tapping Head
12.	Width of die	195 mm	Holes 2
Inspected By (Sign) & Date		Janjan 11/11/24	
1.	Finish Fitting size 1 st side	690 ± 0.12 ± 0.12 mm Tapper 8°	Under cut = 1 mm
2.	Finish Fitting size 2 nd side	690 ± 0.07 ± 0.08 mm Tapper 8°	
3.	Finish size made by		
Inspected By (Sign) & Date		Janjan 11/11/24	
1.	Supplied to (Customer Name)	Balaji Hitech Industries, Chhattisgarh	
2.	Dispatch Date		
Reported By (Sign) & Date		Janjan 11/11/24	

Janjan 11/11/24

Reviewed by (Engineer-CNC)

Manager-CNC