



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.	Invt to 13571	34/40
2.	Visual Inspection	OK - 2-8 mm (Series)	Res Dy 16 18062M
3.	Pellet Die No.	11820	UT-OK
4.	Hardened by	work persons	Reluf OK
5.	Received by after hardening (Name)	Jayin	(2-2) - 3 12 mm
6.	Hardness achieved on 1 st side	50.2 - 50.5 HRC	Reluf 3.3 - 5
7.	Hardness achieved on 2 nd side	50.2 - 50.3 HRC	Counter-OK
8.	Ovality after hardening 1 st side	(0.2) mm	PID - 4.54 mm
9.	Ovality after hardening 2 nd side	(0.2) mm	Tapping 12°
10.	Outside Diameter	5.00 mm	Deep - 16-6 mm
11.	Inside Diameter	4.20 mm	Tapping 14° of
12.	Width of die	158 mm	Hols - 8
Inspected By (Sign) & Date		Jayin 18/12/24	
1.	Finish Fitting size 1 st side	495.88 ± 0.03 ± 0.05 mm Tapper 12°	
2.	Finish Fitting size 2 nd side	495.88 ± 0.04 ± 0.05 mm Tapper 12°	
3.	Finish size made by		
Inspected By (Sign) & Date		Jayin 18/12/24	
1.	Supplied to (Customer Name)	Invt to Rings beds WB	
2.	Dispatch Date		
Reported By (Sign) & Date		Jayin 18/12/24	

Reviewed by (Engineer-CNC)
 Jayin
 18/12/24

Manager-CNC