



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. | 1368 | 50/50 |
| 2. | Visual Inspection | ok - 4.0 mm (SS57D) | 5-Deg of heat 179 |
| 3. | Pellet Die No. | 13053 | OT-ok |
| 4. | Hardened by | hark singh | Relief-ok |
| 5. | Received by after hardening (Name) | Janjua | (2-3) 5 mm |
| 6. | Hardness achieved on 1 st side | 48.2 - 50.1 HR | Relief 4-5 HRC |
| 7. | Hardness achieved on 2 nd side | 50.1 - 50.8 HR | Amount - ok |
| 8. | Ovality after hardening 1 st side | (0.1) mm | PCD - 585 mm |
| 9. | Ovality after hardening 2 nd side | (0.3) mm | Tapping 120 |
| 10. | Outside Diameter | 620 mm | Deep - 12.6 mm |
| 11. | Inside Diameter | 520 mm | Tapping 120 of |
| 12. | Width of die | 186 mm | Hold - 62 |
| Inspected By (Sign) & Date | | Janjua 22/1/25 | |
| 1. | Finish Fitting size 1 st side | 610 ± 0.05 ± 0.05 mm | |
| 2. | Finish Fitting size 2 nd side | 610 ± 0.04 ± 0.05 mm | |
| 3. | Finish size made by | | |
| Inspected By (Sign) & Date | | Janjua 22/1/25 | |
| 1. | Supplied to (Customer Name) | Borsanati, Maharashtra | |
| 2. | Dispatch Date | | |
| Reported By (Sign) & Date | | Janjua 22/1/25 | |

Janjua 23/1/25

Reviewed by (Engineer-CNC)

Manager-CNC