



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.	13789	3515T
2.	Visual Inspection	ok - 3-5 mm (tumbler)	3515T New Tag No - 457A
3.	Pellet Die No.	13925	OT-OK
4.	Hardened by	hark permas	Relief ok
5.	Received by after hardening (Name)	Janji	(3-3) 2.4 mm
6.	Hardness achieved on 1 st side	50.1-50.5 HRc ✓	Relief 4-0 2.0 mm
7.	Hardness achieved on 2 nd side	50.2-50.4 HRc ✓	Re-Camfu - ok
8.	Ovality after hardening 1 st side	(1.5) mm [Die is Recounted]	PCD - 725 mm
9.	Ovality after hardening 2 nd side	(1.1) mm [due to ovality]	Tapping M20
10.	Outside Diameter	770 mm	Deep - 23-5 mm
11.	Inside Diameter	660 mm	Tapping No. of
12.	Width of die	316 mm	Hols - 18
Inspected By (Sign) & Date		Janji 27/1/25	
1.	Finish Fitting size 1 st side	798.6 ± 0.05 ± 0.08 mm Tappet 10-4°	Under cut = 15 μ
2.	Finish Fitting size 2 nd side	798.6 ± 0.10 ± 0.11 mm Tappet 10-6°	= 14.7 μ
3.	Finish size made by		
Inspected By (Sign) & Date		Janji 27/1/25	
1.	Supplied to (Customer Name)	Lotus Perms, Koroatka	
2.	Dispatch Date		
Reported By (Sign) & Date		Janji 27/1/25	

Reviewed by (Engineer-CNC)
28/1/25

Manager-CNC