



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

10096

S.No.	Check Parameter	Specification	Observations	Remarks
1.	Work order No.		In to 14151	33/50
2.	Visual Inspection	ak - 3.0 mm (SSEW)		new Dmg to 9980A
3.	Pellet Die No.	13726		07-ak
4.	Hardened by	Lark Punjab		Relief - ak
5.	Received by after hardening (Name)	Jayjun		(2-3) > 23 mm
6.	Hardness achieved on 1 st side	49.2 - 49.5 HRC	Relief 3-5	> 17 mm
7.	Hardness achieved on 2 nd side	49.3 - 49.5 HRC		Counter - ak
8.	Ovality after hardening 1 st side	(0.7) mm		Pop - 565 mm
9.	Ovality after hardening 2 nd side	(0.5) mm		Tapping M20
10.	Outside Diameter	620 mm		Deep - 18-6 mm
11.	Inside Diameter	520 mm		Tapping Ho of
12.	Width of die	222 mm		Holes - 12
Inspected By (Sign) & Date		Jayjun 20/2/25		
1.	Finish Fitting size 1 st side	618.5 ± 0.02 ± 0.03 mm Tapper 72°		
2.	Finish Fitting size 2 nd side	618.5 ± 0.04 ± 0.04 mm Tapper 62°		
3.	Finish size made by	_____		
Inspected By (Sign) & Date		Jayjun 10/2/25		
1.	Supplied to (Customer Name)	In to Moleka, Aslam		
2.	Dispatch Date	_____		
Reported By (Sign) & Date		Jayjun 10/2/25		

Sats
10/2/25

Reviewed by (Engineer-CNC)

Manager-CNC

1002 - CW/PNK