



# 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.                               |                             | 14124        | 38150              |
| 2.    | Visual Inspection                            | ok - 40 mm (SS304)          |              | Dinght 39406 AD    |
| 3.    | Pellet Die No.                               | 13837                       |              | OT-OK              |
| 4.    | Hardened by                                  | Lark Furnace                |              | Relief - ok        |
| 5.    | Received by after hardening (Name)           | Jain                        |              | (3-3) 2 16 mm      |
| 6.    | Hardness achieved on 1 <sup>st</sup> side    | 48.1 - 49.3 HR <sub>C</sub> |              | Relief 4.5 5 12 mm |
| 7.    | Hardness achieved on 2 <sup>nd</sup> side    | 49.8 - 50.2 HR <sub>C</sub> |              | County - ok        |
| 8.    | Ovality after hardening 1 <sup>st</sup> side | (0.3) mm                    |              | Pop - 565 mm       |
| 9.    | Ovality after hardening 2 <sup>nd</sup> side | (0.5) mm                    |              | Tapping M20        |
| 10.   | Outside Diameter                             | 620 mm                      |              | Deep - 18-6 mm     |
| 11.   | Inside Diameter                              | 520 mm                      |              | Tapping M10 x 1    |
| 12.   | Width of die                                 | 222 mm                      |              | Holes - 12         |

Inspected By (Sign) & Date

Jain 13/2/25

1. Finish Fitting size 1<sup>st</sup> side

621 + .09 + .10 mm Tapper 12°

Under cut = .5 mm

2. Finish Fitting size 2<sup>nd</sup> side

621 + .08 + .09 mm Tapper 12°

3. Finish size made by

Inspected By (Sign) & Date

Jain 13/2/25

1. Supplied to (Customer Name)

Meera Nutritech, U.P.

2. Dispatch Date

Reported By (Sign) & Date

Jain 13/2/25

Jain 17/2/25

Reviewed by (Engineer-CNC)

Manager-CNC