



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

15322

Form No.

CNC/QA/FM/03

Rev. No.

01

Rev. Date

31-07-2013

Final Inspection (Polot Dies) after Hardening & Finishing

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	15625	36/45/50
2.	Visual Inspection	OK - 4.0 mm (SSEW)	Mo 2
3.	Pellet Die No.	15391	Drill No - 259 A/B
4.	Hardened by	Wark Furnace	UT-OK
5.	Received by after hardening (Name)	J. Anjan	Relief - OK
6.	Hardness achieved on 1 st side	50.2 - 50.3 HRC	Φ 4.5 = 14 mm
7.	Hardness achieved on 2 nd side	50.1 - 50.2 HRC	Φ 5.0 = 5 mm
8.	Ovality after hardening 1 st side	(0.4) mm	Gearing - OK
9.	Ovality after hardening 2 nd side	(0.4) mm	PCD = 56.5 mm
10.	Outside Diameter	620 mm	Tapping M20
11.	Inside Diameter	520 mm	Deep - 18.4 mm
12.	Width of die	222 mm	Tapping M10 x 12
Inspected By (Sign) & Date		J. Anjan 13/8/25	
1.	Finish Fitting size 1 st side	621 ± 0.07 - 621 ± 0.07 Tapper 12°	undercut = 5 mm
2.	Finish Fitting size 2 nd side	621 ± 0.08 - 621 ± 0.08 Tapper 12°	
3.	Finish size made by		
Inspected By (Sign) & Date		J. Anjan 13/8/25	
1.	Supplied to (Customer Name)	Madriy Agrawal, Bihar	
2.	Dispatch Date		
Reported By (Sign) & Date		J. Anjan 13/8/25	

Reviewed by (Engineer-CNC)

Manager-CNC