



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

6424

Final Inspection (Pellet Dies) after Hardening & Finishing

S.No.	Check Parameter	Specification	Observations	Remarks
1.	Work order No.			
2.	Visual Inspection		10318	33/53/79
3.	Pellet Die No.	OK - 6.0 mm	CS. Jumbo	Dmg Hr - 717 Arb
4.	Hardened by		10384	U7-OK
5.	Received by after hardening (Name)		Lark Finney	Reluf - OK
6.	Hardness achieved on 1 st side		50.1 - 51.1 HRC	ø 6.5 → 46 mm
7.	Hardness achieved on 2 nd side		50.4 - 50.3 HRC	ø 7.0 → 26 mm
8.	Ovality after hardening 1 st side		(0.6) mm	Countin - side 30°
9.	Ovality after hardening 2 nd side		(0.3) mm	PCD - 935 mm
10.	Outside Diameter		1008 mm	Tapping M20
11.	Inside Diameter		850 ± 0.10 ± 0.15 ± 0.10 ± 0.17 mm	Deep - 40.7 mm
12.	Width of die		266 mm	(Vernier check) Tapping Head

Inspected By (Sign) & Date

Jayjw 18/10/23

1. Finish Fitting size 1st side

1020 + 0.2 + 0.10 mm Tapper 8°

Undercut - 5.5 mm

2. Finish Fitting size 2nd side

1020 + 0.10 + 0.10 mm Tapper 8°

3. Finish size made by

Inspected By (Sign) & Date

Jayjw 18/10/23

1. Supplied to (Customer Name)

670 Green Biofuel, Rajasthan

2. Dispatch Date

Reported By (Sign) & Date

Jayjw 18/10/23

Sobha 18/10/23

Reviewed by (Engineer-CNC)

Manager-CNC

1002 - CWP/INK