



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

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	10151 to 20221 to 10537	40/40
2.	Visual Inspection	ok-5-0 mm (Scratched)	Depth - 16.8mm
3.	Pellet Die No.	9779	07-OK
4.	Hardened by	Lark Ferrus	Pre-lub - OK
5.	Received by after hardening (Name)	Jayju	(2-2) 3 4 mm
6.	Hardness achieved on 1 st side	51.1 - 52.7 HRC	3 HRC
7.	Hardness achieved on 2 nd side	52.4 - 51.0 HRC	Accuracy - OK
8.	Ovality after hardening 1 st side	(0.2) mm	PCD - 474 mm
9.	Ovality after hardening 2 nd side	(0.1) mm	Tapping M20
10.	Outside Diameter	500 mm	Deep - 16.8 mm
11.	Inside Diameter	420 mm	Tapping M16
12.	Width of die	158 mm	Tools - 8
Inspected By (Sign) & Date		Jayju 19/10/23	
1.	Finish Fitting size 1 st side	489 ± 0.04 ± 0.05 mm	
2.	Finish Fitting size 2 nd side	489 ± 0.03 ± 0.04 mm	
3.	Finish size made by		
Inspected By (Sign) & Date		Jayju 19/10/23	
1.	Supplied to (Customer Name)	J&K Acels, HR, to Vredic India, U.P. to	AAA Acels, Jammu
2.	Dispatch Date		
Reported By (Sign) & Date		Jayju 19/10/23	

Saty 19/10/23

Reviewed by (Engineer-CNC)

Manager-CNC

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