



Lark Engineering Company (India) Pvt. Ltd.

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

6451

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.	10423	32/4/10
2.	Visual Inspection	OK - 4.0 mm (3SEW)	Rev 02 Dwg No - 259A/B
3.	Pellet Die No.	10839	WT-OK
4.	Hardened by	work force	Relief - OK
5.	Received by after hardening (Name)	Janjan	φ 4.3 ± 0.18 mm
6.	Hardness achieved on 1 st side	50.0 - 50.0 HRC	φ 4.8 ± 0.10 mm
7.	Hardness achieved on 2 nd side	50.1 - 50.0 HRC	Re-county - OK
8.	Ovality after hardening 1 st side	(0.8) mm [Die was Re-counter]	PCD - 565 mm
9.	Ovality after hardening 2 nd side	(1.0) mm [due to ovality]	lapping M20
10.	Outside Diameter	620 mm	Deep - 18.8 mm
11.	Inside Diameter	520 mm	lapping M20 of
12.	Width of die	222 mm	Healy - 12

Inspected By (Sign) & Date

Janjan 2/10/23

1. Finish Fitting size 1st side

621 ± 0.07 ± 0.10 mm Tapper 12°

Undersize = -5 mm

2. Finish Fitting size 2nd side

621 ± 0.08 ± 0.12 mm Tapper 12°

3. Finish size made by

Inspected By (Sign) & Date

Janjan 2/10/23

1. Supplied to (Customer Name)

Grodrej Agrovet, Bihar

2. Dispatch Date

Reported By (Sign) & Date

Janjan 2/10/23

Sahar 2/10/23

Reviewed by (Engineer-CNC)

Manager-CNC

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