



# 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

7307

S.No.	Check Parameter	Specification	Observations	Remarks
1.	Work order No.		10131	20/65-5 18/28/65-5
2.	Visual Inspection		OK - 6.0 mm (Mid diameter)	Rev 01 Drawing No. 891A/B
3.	Pellet Die No.		1162	U7-OK
4.	Hardened by		Work Furnace	Relief - OK
5.	Received by after hardening (Name)		J. Anjan	
6.	Hardness achieved on 1 <sup>st</sup> side		50.4 - 50.6 HR	1 <sup>st</sup> / 06.5 > 47.5 mm 07.3 3 37.5 mm
7.	Hardness achieved on 2 <sup>nd</sup> side		50.2 - 50.4 HR	2 <sup>nd</sup> / 07.5 - 45 mm
8.	Ovality after hardening 1 <sup>st</sup> side		(0.6) mm	Center - OK 30°
9.	Ovality after hardening 2 <sup>nd</sup> side		(0.5) mm	PCD - 650 mm
10.	Outside Diameter		711 mm	Tapping M16
11.	Inside Diameter		580 ± 0.01 mm	Depth - 34 mm
12.	Width of die		193 mm	Tapping M0 of
Inspected By (Sign) & Date		J. Anjan 4/11/23		Moly - 4
1.	Finish Fitting size 1 <sup>st</sup> side		722 ± 0.07 ± 0.10 mm Tapper 5°	Undercut = 2.8 mm
2.	Finish Fitting size 2 <sup>nd</sup> side		722 ± 0.07 ± 0.10 mm Tapper 5°	
3.	Finish size made by			
Inspected By (Sign) & Date		J. Anjan 4/11/23		
1.	Supplied to (Customer Name)	Mastermind Commercial, A.P.		
2.	Dispatch Date			
Reported By (Sign) & Date		J. Anjan 4/11/23		

Satyam 4/11/23

Reviewed by (Engineer-CNC)

Manager-CNC