



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

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	9324 to 10136	120/120
2.	Visual Inspection	OK - 3.5 mm (Cylinder)	Re-ov Edge M-559 AD
3.	Pellet Die No.	10466	UT-OK
4.	Hardened by	Keshav Kumar	Relief OK
5.	Received by after hardening (Name)	Jayjir	3 HRL
6.	Hardness achieved on 1 st side	42.5 - 43.7 HR [ⓑ]	4 HRL
7.	Hardness achieved on 2 nd side	43.1 - 43.9 mm [ⓑ]	Re-Counter-OK
8.	Ovality after hardening 1 st side	(1.7) mm [Die was Re-counter]	PCD - 685 mm
9.	Ovality after hardening 2 nd side	(1.3) mm [due to ovality]	Tapping M20
10.	Outside Diameter	870 mm	Deep - 18.8 mm
11.	Inside Diameter	630 mm	Tapping M16
12.	Width of die	265 mm	Holes - 16

Inspected By (Sign) & Date: Jayjir 7/11/23

1.	Finish Fitting size 1 st side	740.5 ± 0.05 ± 0.05 mm Tapper 10°	Final Sign check
2.	Finish Fitting size 2 nd side	740.5 ± 0.05 ± 0.05 mm Tapper 10°	by - Sandeep Singh
3.	Finish size made by		Keshav Kumar

Inspected By (Sign) & Date: Jayjir 7/11/23

1.	Supplied to (Customer Name)	K.L. Salver, PB to Shiva Park, HR
2.	Dispatch Date	

Reported By (Sign) & Date: Jayjir 7/11/23

Reviewed by (Engineer-CNC): Jayjir 7/11/23

Manager-CNC