



# 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.	10606	40/50
2.	Visual Inspection	ok - 3.8 mm (N.Jumbo)	Depth = 1.25 mm Revised
3.	Pellet Die No.	9966	UT ok
4.	Hardened by	Lark Furnace	Relief = 0.1
5.	Received by after hardening (Name)	Sanjeev	outside (3-3) 2.14 mm
6.	Hardness achieved on 1 <sup>st</sup> side	50.3 - 50.7 H.R.C.	Inner = 1.0 mm
7.	Hardness achieved on 2 <sup>nd</sup> side	50.7 - 51.1 H.R.C.	Relief dia = 4.3 mm Coaster = ok
8.	Ovality after hardening 1 <sup>st</sup> side	(0.7) mm	Per = 64 mm
9.	Ovality after hardening 2 <sup>nd</sup> side	(0.5) mm	Tapping = H20
10.	Outside Diameter	7.00 mm	Depth = 1.9 mm
11.	Inside Diameter	6.00 mm	Tapping No. of
12.	Width of die	2.22 mm	Holes = 12 Behind
Inspected By (Sign) & Date		Ravi 9/11/23	
1.	Finish Fitting size 1 <sup>st</sup> side	6.90 + .10 + .12 mm Taper = 12°	
2.	Finish Fitting size 2 <sup>nd</sup> side	6.90 + .08 + .12 mm Taper = 12°	
3.	Finish size made by		
Inspected By (Sign) & Date		Ravi 9/11/23	
1.	Supplied to (Customer Name)	Guru industries, Maharashtra	
2.	Dispatch Date		
Reported By (Sign) & Date		Ravi 9/11/23	

Sats  
9/11/23

Reviewed by (Engineer-CNC)

Manager-CNC