



Lark Engineering Company (India) Pvt. Ltd.

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

7430

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.	8934 to 10764	35/50
2.	Visual Inspection	OK - 3.2 mm (SSEW)	Pro Dang 76-9380 to
3.	Pellet Die No.	9427	UT-OK
4.	Hardened by	Lark Furnace	Relief - OK
5.	Received by after hardening (Name)	Janjan	(3-3) > 21 mm
6.	Hardness achieved on 1 st side	50.5 - 51.4 HR	Relief 3.8, 15 mm
7.	Hardness achieved on 2 nd side	50.0 - 50.2 HR	Re - Counter - OK
8.	Ovality after hardening 1 st side	(1.1) mm [die was re-counter]	Pro - 565 mm
9.	Ovality after hardening 2 nd side	(0.8) mm due to ovality	Tapping M20
10.	Outside Diameter	620 mm	Deep 18.8 mm
11.	Inside Diameter	520 mm	Tapping No. of
12.	Width of die	222 mm	Holes - 12
Inspected By (Sign) & Date		Janjan 29/11/23	
1.	Finish Fitting size 1 st side	618.5 ± 0.05 ± 0.05 mm Tapper 12°	
2.	Finish Fitting size 2 nd side	618.5 - 10 ± 0.14 mm Tapper 12°	Amil Kyan
3.	Finish size made by		
Inspected By (Sign) & Date		Janjan 29/11/23	
1.	Supplied to (Customer Name)	Safal Steels, HR	
2.	Dispatch Date		
Reported By (Sign) & Date		Janjan 29/11/23	

Janjan 29/11/23

Reviewed by (Engineer-CNC)

Manager-CNC

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