



# 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.	9761	39/50
2.	Visual Inspection	OK - 3.5 mm (859W)	Drilling hole looks good
3.	Pellet Die No.	10.323	UT-OK
4.	Hardened by	Lark furnace	Relief - OK
5.	Received by after hardening (Name)	Janjir	(3-3) $\geq 18$ mm
6.	Hardness achieved on 1 <sup>st</sup> side	53.6 - 50.8 HRC	Relief $\phi$ 4.0 $\geq 11$ mm
7.	Hardness achieved on 2 <sup>nd</sup> side	51.2 - 51.7 HRC	Counter - OK
8.	Ovality after hardening 1 <sup>st</sup> side	(0.6) mm	PID - 565 mm
9.	Ovality after hardening 2 <sup>nd</sup> side	(0.5) mm	Tapping M20
10.	Outside Diameter	620 mm	Deep - 18.7 mm
11.	Inside Diameter	520 mm	Tapping M6 of hole - 12
12.	Width of die	222 mm	
Inspected By (Sign) & Date		Janjir 2/7/23	
1.	Finish Fitting size 1 <sup>st</sup> side	610 $\pm$ 0.03 $\pm$ 0.04 mm	
2.	Finish Fitting size 2 <sup>nd</sup> side	610 $\pm$ 0.04 $\pm$ 0.05 mm	
3.	Finish size made by		
Inspected By (Sign) & Date		Janjir 3/7/23	
1.	Supplied to (Customer Name)	Kanhaya Agre, Maharashtra	
2.	Dispatch Date		
Reported By (Sign) & Date		Janjir 3/7/23	

Reviewed by (Engineer-CNC)

Manager-CNC