



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

Final Inspection (Pellet Dies) after Hardening & Finishing

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	9741	30/40/70
2.	Visual Inspection	OK - 6.0 mm (center)	Ro 3
3.	Pellet Die No.	10479	DRY 377 AD
4.	Hardened by	hakshoni vacuum	U7-OK
5.	Received by after hardening (Name)	Jayjun	Relief OK
6.	Hardness achieved on 1 st side	51.8 - 51.5 HRC	Ø 6.5 → 40 mm
7.	Hardness achieved on 2 nd side	51.9 - 53.3 HRC	Ø 7.3 → 30 mm
8.	Ovality after hardening 1 st side	(1.2) mm [Die was re-centered]	Re-center - OK
9.	Ovality after hardening 2 nd side	(1.0) mm [due to ovality]	Ø ID - 618 mm
10.	Outside Diameter	688 mm	Tapping M16
11.	Inside Diameter	548.3 ± 0.05 ± 0.25 ± 0.10 ± 0.20 mm	Deep - 30.5 mm
12.	Width of die	215 mm	Tapping Ho ef
Inspected By (Sign) & Date		Jayjun 13/7/23	Ho 4 - 2
1.	Finish Fitting size 1 st side	694.8 ± 0.10 ± 0.10 mm Tapper 5°	
2.	Finish Fitting size 2 nd side	694.8 ± 0.10 ± 0.11 mm Tapper 5°	
3.	Finish size made by		
Inspected By (Sign) & Date		Jayjun 13/7/23	
1.	Supplied to (Customer Name)	Banjanin Industries, Gujrat	
2.	Dispatch Date		
Reported By (Sign) & Date		Jayjun 13/7/23	

Reviewed by (Engineer-CNC)
13/7/23

Manager-CNC