



Lark Engineering Company (India) Pvt. Ltd.

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

7890

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.	11251	34100
2.	Visual Inspection	ok - 4.0 mm (SSSTD)	Print 633A
3.	Pellet Die No.	11394	WT-OK
4.	Hardened by	herts furnace	Relief - ok
5.	Received by after hardening (Name)	Janjau	(8.3) ± 20mm
6.	Hardness achieved on 1 st side	49.9 - 50.1 HRC	Relief 4.5 ± 16mm
7.	Hardness achieved on 2 nd side	49.7 - 49.5 HRC	Counter - ok
8.	Ovality after hardening 1 st side	(0.3) mm	POD - 565mm
9.	Ovality after hardening 2 nd side	(0.4) mm	Tapping M16
10.	Outside Diameter	620 mm	Deep - 19mm
11.	Inside Diameter	520 mm	Tapping Head
12.	Width of die	188 mm	Holes - 12

Inspected By (Sign) & Date Janjau 19/2/24

1.	Finish Fitting size 1 st side	620.6 ± 0.08 φ.10 mm Tapper 12°	Undercut = 1
2.	Finish Fitting size 2 nd side	620.6 ± 0.09 φ.11 mm Tapper 12°	
3.	Finish size made by		

Inspected By (Sign) & Date Janjau 19/2/24

1.	Supplied to (Customer Name)	Godrej Agrant, Maharashtra
2.	Dispatch Date	

Reported By (Sign) & Date Janjau 19/2/24

Reviewed by (Engineer-CNC)

Manager-CNC