



# 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.	9901	40/50
2.	Visual Inspection	ok - 4.0 mm (SSGW)	Ph 10 Digitizer 406 A+B
3.	Pellet Die No.	10008	UT-OK
4.	Hardened by	hark Penny	Reluf - ok
5.	Received by after hardening (Name)	Janji	(3-3) $\approx$ 14 mm
6.	Hardness achieved on 1 <sup>st</sup> side	49.4 - 48.1 HR <sub>C</sub> (D)	$\oplus$ Reluf 4.5 $\approx$ 10 mm
7.	Hardness achieved on 2 <sup>nd</sup> side	49.1 - 50.1 HR <sub>C</sub> (D)	Center - ok
8.	Ovality after hardening 1 <sup>st</sup> side	(0.2) mm	PCD - 565 mm
9.	Ovality after hardening 2 <sup>nd</sup> side	(0.6) mm	Tapping M20
10.	Outside Diameter	620 mm	Deep - 18.8 mm
11.	Inside Diameter	520 mm	Tapping 10 c/c
12.	Width of die	222 mm	Hole - 12
Inspected By (Sign) & Date		Janji 18/7/23	
1.	Finish Fitting size 1 <sup>st</sup> side	621 $\pm$ 0.09 $\pm$ 0.08 mm Tapper 12 $^\circ$	Under cut = .5 mm
2.	Finish Fitting size 2 <sup>nd</sup> side	621 $\pm$ 0.12 $\pm$ 0.12 mm Tapper 12 $^\circ$	
3.	Finish size made by		
Inspected By (Sign) & Date		Janji 18/7/23	
1.	Supplied to (Customer Name)	Arihant fertilizer chemical, Moh	
2.	Dispatch Date		
Reported By (Sign) & Date		Janji 18/7/23	

Reviewed by (Engineer-CNC)

Manager-CNC