



# 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.			
2.	Visual Inspection		11530	33/50
3.	Pellet Die No.		ok - 3.0 mm (JEW)	Ph 00 Dwg No - 450 AHB
4.	Hardened by		11526	J.T. ok
5.	Received by after hardening (Name)		Lark Financer	Relief - ok
6.	Hardness achieved on 1 <sup>st</sup> side		Janjir 49.6 - 49.7 HRC (A)	(3.3) = 23 mm
7.	Hardness achieved on 2 <sup>nd</sup> side		50.1 - 50.2 HRC	Relief of 3.5 = 17 mm
8.	Ovality after hardening 1 <sup>st</sup> side		(0.4) mm	6 mm dia - ok
9.	Ovality after hardening 2 <sup>nd</sup> side		(0.8) mm (B)	PCD - 68.5 mm
10.	Outside Diameter		730 mm	Tapping M20
11.	Inside Diameter		630 mm	Deep - 18.8 mm
12.	Width of die		290 mm	Tapping No of Holes - 16
Inspected By (Sign) & Date		Janjir 1/4/24		
1.	Finish Fitting size 1 <sup>st</sup> side	740.5 ± 0.02 ± 0.01 mm Tapper 10°		Under cut = 5.2 mm
2.	Finish Fitting size 2 <sup>nd</sup> side	740.5 ± 0.03 ± 0.04 mm Tapper 10°		= 5.4 mm
3.	Finish size made by			
Inspected By (Sign) & Date		Janjir 1/4/24		
1.	Supplied to (Customer Name)	Reliable Hact, W.B		
2.	Dispatch Date			
Reported By (Sign) & Date		Janjir 1/4/24		

Janjir 1/4/24

viewed by (Engineer-CNC)

Manager-CNC

100x2 - CWPINK