



# Lark Engineering Company (India) Pvt. Ltd.

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

8245

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.	11626 to 11670	33/53/66
2.	Visual Inspection	OK - 6.0 mm (M. Jumbo)	Process Drg No 609 A/B
3.	Pellet Die No.	12039	UT-OK
4.	Hardened by	Herb Fenney	Relief - OK
5.	Received by after hardening (Name)	Jayjeer	Ø 6.5 = 33 mm
6.	Hardness achieved on 1 <sup>st</sup> side	51.3 - 51.5 HRC	Ø 7.0 = 13 mm
7.	Hardness achieved on 2 <sup>nd</sup> side	51.7 - 51.9 HRC	Chamfer - Ø 30°
8.	Ovality after hardening 1 <sup>st</sup> side	(0.3) mm	R10 - 61.9 mm
9.	Ovality after hardening 2 <sup>nd</sup> side	(0.1) mm	Tapping M16
10.	Outside Diameter	Ø 68.0 mm	Depth - 31.6 mm
11.	Inside Diameter	548.5 ± 0.10 ± 0.12 ± 0.06 ± 0.12 mm	Tapping M16
12.	Width of die	135 mm	Holes - 4
Inspected By (Sign) & Date		Jayjeer 16/4/24	
1.	Finish Fitting size 1 <sup>st</sup> side	690 p. 0.2 p. 10 mm Tapper 8°	Undercut = 1 mm
2.	Finish Fitting size 2 <sup>nd</sup> side	690 ± 0.12 ± 0.12 mm Tapper 8°	
3.	Finish size made by		
Inspected By (Sign) & Date		Jayjeer 16/4/24	
1.	Supplied to (Customer Name)	Yulong, Haryana, to Mohit Industries	
2.	Dispatch Date		
Reported By (Sign) & Date		Jayjeer 16/4/24	

Satya 16/4/24

Reviewed by (Engineer-CNC)

Manager-CNC