

8430



# 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.		11882 ✓	40/60
2.	Visual Inspection		OK - 4.0 mm (Chamber)	Part / 584 AD ✓
3.	Pellet Die No.		12230 ✓	07-OK
4.	Hardened by		hark, puney	Relief OK
5.	Received by after hardening (Name)		Janjiri	(3-3) = 24 mm
6.	Hardness achieved on 1 <sup>st</sup> side		52.9 - 51.5 HRC	Relief 4.5 20 mm
7.	Hardness achieved on 2 <sup>nd</sup> side		52.9 - 51.3 HRC	Counter - OK
8.	Ovality after hardening 1 <sup>st</sup> side		(2.0) mm [Recounter due to]	P.D - 725 mm
9.	Ovality after hardening 2 <sup>nd</sup> side		(1.7) mm ovality.	Tapping M20
10.	Outside Diameter		780 mm	Dep - 28.8 mm
11.	Inside Diameter		660 mm	Tapping Ho of
12.	Width of die		324 mm	Holes - 12

Inspected By (Sign) & Date

Janjiri 17/5/24

1.	Finish Fitting size 1 <sup>st</sup> side	795 + 0.08 + 0.08 mm Tapper 4°	under cut = 7.2 mm
2.	Finish Fitting size 2 <sup>nd</sup> side	795 + 0.08 + 0.09 mm Tapper 4°	2 slot both side
3.	Finish size made by		32 x 8 mm

Inspected By (Sign) & Date

Janjiri 17/5/24

1.	Supplied to (Customer Name)	Kamdhenu cattle, O.P
2.	Dispatch Date	

Reported By (Sign) & Date

Janjiri 17/5/24

Satyan 17/5/24

Reviewed by (Engineer-CNC)

Manager-CNC