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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.	12115 to 12116	33/48/70
2.	Visual Inspection	ok - 6.0 mm (M. dubel)	longer 377 A+ U7 die
3.	Pellet Die No.	12762	
4.	Hardened by	Lark Furnace	Relief - ok
5.	Received by after hardening (Name)	Jayjir	φ6.5 ≥ 37 mm
6.	Hardness achieved on 1 st side	49.4 - 49.8 HRC	φ7.3 22 mm
7.	Hardness achieved on 2 nd side	49.6 - 49.9 HRC	Green fu - ok 30°
8.	Ovalty after hardening 1 st side	(0.1) mm	RCD - 618 mm
9.	Ovalty after hardening 2 nd side	(0.2) mm	Tapping M16
10.	Outside Diameter	6.88 mm	Deep - 30.5 mm
11.	Inside Diameter	548.3 +0.04 +0.05 +0.05 +0.06 mm	Tapping Holes
12.	Width of die	215 mm	Holes 2
Inspected By (Sign) & Date		Jayjir 20/6/24	
1.	Finish Fitting size 1 st side	694.8 +0.10 φ 11 mm Tapper 5°	
2.	Finish Fitting size 2 nd side	694.8 +0.08 φ 12 mm Tapper 5°	
3.	Finish size made by		
Inspected By (Sign) & Date		Jayjir 20/6/24	
1.	Supplied to (Customer Name)	Return master, HR, to Green, Pellet,	
2.	Dispatch Date		
Reported By (Sign) & Date		Jayjir 20/6/24	

Signature
20/6/24

Reviewed by (Engineer-CNC)

Manager-CNC