



# 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.                               | 12209 to 12247                     | 28/38/66             |
| 2.    | Visual Inspection                            | ok - 6.0 mm (M. Jumbo)             | Profil Dinger 609A/B |
| 3.    | Pellet Die No.                               | 12798                              | UT-OK                |
| 4.    | Hardened by                                  | Lark Penny                         | Relief - ok          |
| 5.    | Received by after hardening (Name)           | Jaujan                             | ø 6.5 ± 0.038 mm     |
| 6.    | Hardness achieved on 1 <sup>st</sup> side    | 49.2 - 49.3 HRC                    | ø 7.0 ± 0.028 mm     |
| 7.    | Hardness achieved on 2 <sup>nd</sup> side    | 49.6 - 49.7 HRC                    | Counter - ok 30°     |
| 8.    | Ovality after hardening 1 <sup>st</sup> side | (0.1) mm                           | PCD 619 mm           |
| 9.    | Ovality after hardening 2 <sup>nd</sup> side | (0.1) mm                           | Tapping M16          |
| 10.   | Outside Diameter                             | 680 mm                             | Depth - 32 mm        |
| 11.   | Inside Diameter                              | 548.5 ± 0.08, 1.10 ± 0.12, 1.15 mm | Tapping M16          |
| 12.   | Width of die                                 | 195 mm                             | Holes - 8 & 4        |

Inspected By (Sign) & Date: Jaujan 13/7/24

|    |  |                                |                 |
|----|--|--------------------------------|-----------------|
| 1. | Finish Fitting size 1 <sup>st</sup> side | 690 ± 0.10 ± 0.10 mm Tapper 8° | Undercut - 1 mm |
| 2. | Finish Fitting size 2 <sup>nd</sup> side | 690 ± 0.11 ± 0.12 mm Tapper 8° |                 |
| 3. | Finish size made by                      |                                |                 |

Inspected By (Sign) & Date: Jaujan 13/7/24

|    |                             |                                   |  |
|----|-----------------------------|-----------------------------------|--|
| 1. | Supplied to (Customer Name) | Yulong H2 do shi karani, Rajsthan |  |
| 2. | Dispatch Date               | _____                             |  |

Reported By (Sign) & Date: Jaujan 13/7/24

Reviewed by (Engineer-CNC): [Signature] 13/7/24

Manager-CNC