



# 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.	12258 to 12468	33/66
2.	Visual Inspection	OK - 6.0 mm (M. Hub)	ED Degree No. 1 609/15
3.	Pellet Die No.	12791	UT-OK
4.	Hardened by	Lark Furnace	Relief-OK
5.	Received by after hardening (Name)	Janjir	Ø 7.5 & 33 mm
6.	Hardness achieved on 1 <sup>st</sup> side	49.6 - 50.1 HRC (A)	> 40
7.	Hardness achieved on 2 <sup>nd</sup> side	49.6 - 49.7 HRC (A)	Corner - OK 30°
8.	Ovality after hardening 1 <sup>st</sup> side	(0.2) mm	PCD - 619 mm
9.	Ovality after hardening 2 <sup>nd</sup> side	(0.1) mm	Tapping M16
10.	Outside Diameter	680 mm	Deep - 320 mm
11.	Inside Diameter	548.5 ± 0.12 ± 0.15 ± 0.15 ± 0.22 mm (A)	Tapping M16
12.	Width of die	195 mm	Hobs - 4
Inspected By (Sign) & Date		Janjir 31/7/24	-
1.	Finish Fitting size 1 <sup>st</sup> side	690 ± 0.05 ± 0.06 mm Tapper 8°	Under cut - 1 mm
2.	Finish Fitting size 2 <sup>nd</sup> side	690 ± 0.10 ± 0.11 mm Tapper 8°	-
3.	Finish size made by	→	-
Inspected By (Sign) & Date		Janjir 31/7/24	-
1.	Supplied to (Customer Name)	Yulong mt to Dhaneshwar, Rajasthan	-
2.	Dispatch Date	→	-
Reported By (Sign) & Date		Janjir 31/7/24	-

Sutja  
31/7/24

Reviewed by (Engineer-CNC)

Manager-CNC