



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

Final Inspection (Pellet Dies) after Hardening & Finishing

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	12258 to 12468	33/66
2.	Visual Inspection	OK - 6.0 mm (M. Sample)	Pro 1 Drg 10-609AB
3.	Pellet Die No.	12792	UT-OK
4.	Hardened by	hark Benny	Relief - ok
5.	Received by after hardening (Name)	Jayin	Ø 7.5 ± 0.03 mm
6.	Hardness achieved on 1 st side	49.5 - 49.7 HRC	ALL
7.	Hardness achieved on 2 nd side	50.3 - 50.7 HRC	Counter - ok 30°
8.	Ovality after hardening 1 st side	(0.3) mm	PCD - 619 mm
9.	Ovality after hardening 2 nd side	(0.4) mm	Tapping 1776
10.	Outside Diameter	680 mm	Deep - 32.0 mm
11.	Inside Diameter	548.5 ± 0.3 ± 0.0 ± 0.12 ± 0.00 mm	Tapping Hole
12.	Width of die	195 mm	Holes - 4
Inspected By (Sign) & Date		Jayin 5/8/24	

1.	Finish Fitting size 1 st side	690 ± 0.12 ± 0.12 mm Tapper 8°	Under cut = 1mm
2.	Finish Fitting size 2 nd side	690 ± 0.12 ± 0.12 mm Tapper 8°	
3.	Finish size made by		
Inspected By (Sign) & Date		Jayin 5/8/24	

1.	Supplied to (Customer Name)	Yulong HR to Dharneshwar, Rajasthan	
2.	Dispatch Date		
Reported By (Sign) & Date		Jayin 5/8/24	

Jayin 6/8/24

Reviewed by (Engineer-CNC)

Manager-CNC