



# 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.	12600 to 12645	35/40/66 ✓
2.	Visual Inspection	ok - 6.0 mm (M. number)	206 Depth - 320 HRC ✓
3.	Pellet Die No.	12944	UT-OK
4.	Hardened by	work finish	Relief - OK
5.	Received by after hardening (Name)	Jain	06.5 2 31mm
6.	Hardness achieved on 1 <sup>st</sup> side	51.1 - 50.9 HRC ✓	07.0 3 26mm
7.	Hardness achieved on 2 <sup>nd</sup> side	50.5 - 50.8 HRC ✓	Counter - OK 30°
8.	Ovality after hardening 1 <sup>st</sup> side	(0.6) mm	Red - 619 mm
9.	Ovality after hardening 2 <sup>nd</sup> side	(0.8) mm (A)	Tapping HRC
10.	Outside Diameter	680.1 mm	Depth - 31.8 mm
11.	Inside Diameter	248.1 + 0 + 1.95 + 0 + 1.50 mm (A)	Tapping HRC
12.	Width of die	195 mm	Tools - 2
Inspected By (Sign) & Date		Jain 28/8/24	
1.	Finish Fitting size 1 <sup>st</sup> side	690.14 .12 +.12 mm Tapper 8°	Dies used with neeraj Sir & Sonjee Sir
2.	Finish Fitting size 2 <sup>nd</sup> side	690.14 .12 +.12 mm Tapper 8°	
3.	Finish size made by		
Inspected By (Sign) & Date		Jain 28/8/24	
1.	Supplied to (Customer Name)	Yulong, Haryana to Manikaran, HR	
2.	Dispatch Date		
Reported By (Sign) & Date		Jain 28/8/24	

Reviewed by (Engineer-CNC)

Manager-CNC