



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. | 12704 to 12912 ✓ | 30/66 ✓ |
| 2. | Visual Inspection | OK - 6.0 mm (M. Jumbo) ✓ | to 609 Pno 2 Drg No 320 AB Ro 5 ✓ |
| 3. | Pellet Die No. | 12949 ✓ | UT - OK ✓ |
| 4. | Hardened by | Lark Penny ✓ | Relief - OK ✓ |
| 5. | Received by after hardening (Name) | Jayjin ✓ | Ø 7.0 = 36 mm ✓ |
| 6. | Hardness achieved on 1 st side | 49.7 - 49.9 HR ✓ | = ALL ✓ |
| 7. | Hardness achieved on 2 nd side | 50.2 - 50.5 HR ✓ | Counter - OK 30° ✓ |
| 8. | Ovality after hardening 1 st side | (0.3) mm ✓ | PCD - 61.9 mm ✓ |
| 9. | Ovality after hardening 2 nd side | (0.6) mm ✓ | Tapping M16 ✓ |
| 10. | Outside Diameter | 680 mm (A) ✓ | Deep - 32 mm ✓ |
| 11. | Inside Diameter | 548.4 + 0.08 + 0.05 + 0.08 + 0.06 mm ✓ | Tapping No of ✓ |
| 12. | Width of die | 195 mm ✓ | Holes - 2 ✓ |
| Inspected By (Sign) & Date | | Jayjin 25/9/24 | |
| 1. | Finish Fitting size 1 st side | 690 + 0.06 + 0.09 mm Tapper 8° ✓ | Under cut = 1 mm ✓ |
| 2. | Finish Fitting size 2 nd side | 690 + 0.08 + 0.11 mm Tapper 8° ✓ | |
| 3. | Finish size made by | _____ | |
| Inspected By (Sign) & Date | | Jayjin 25/9/24 | |
| 1. | Supplied to (Customer Name) | Yulong, HR to Proveg, Rajasthan | |
| 2. | Dispatch Date | _____ | |
| Reported By (Sign) & Date | | Jayjin 25/9/24 | |

Jayjin
25/9/24

Reviewed by (Engineer-CNC)

Manager-CNC