



# 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.		12814 to 12866	26/66, 28/66
2.	Visual Inspection		OK - 6.0 mm (M. Jumbo)	Run 06 Depth - 320 $\mu$ m
3.	Pellet Die No.		<del>13337</del> 13337	UT-OK
4.	Hardened by		Lark Furnace	Relief-OK
5.	Received by after hardening (Name)		Janjan	IST $\phi$ 7.0 $\pm$ 40 $\mu$ m
6.	Hardness achieved on 1 <sup>st</sup> side		48.7 - 50.1 HRC (A)	Hard $\phi$ 7.0 $\pm$ 38 $\mu$ m
7.	Hardness achieved on 2 <sup>nd</sup> side		48.1 - 49.1 HRC (A)	Geometric OK 3 $^{\circ}$
8.	Ovality after hardening 1 <sup>st</sup> side		(0.1) mm	RCD - 619 mm
9.	Ovality after hardening 2 <sup>nd</sup> side		(0.1) mm	Tapping M16
10.	Outside Diameter		680 mm	Deep - 31.7 mm
11.	Inside Diameter		548.1 $\pm$ 0.05 $\pm$ 0.08 $\pm$ 0.7 $\pm$ 0.15 mm	Tapping M16
12.	Width of die		195 mm	Holes - 2
Inspected By (Sign) & Date		Janjan 21/10/24		
1.	Finish Fitting size 1 <sup>st</sup> side	690.1 $\pm$ 0.10 $\pm$ 0.10 mm Tapper 8 $^{\circ}$		
2.	Finish Fitting size 2 <sup>nd</sup> side	690.1 $\pm$ 0.10 $\pm$ 0.10 mm Tapper 8 $^{\circ}$		
3.	Finish size made by			
Inspected By (Sign) & Date		Janjan 21/10/24		
1.	Supplied to (Customer Name)	Yelong, HR, to Nakshara, Gujarat		
2.	Dispatch Date			
Reported By (Sign) & Date		Janjan 21/10/24		

Satya 21/10/24

Reviewed by (Engineer-CNC)

Manager-CNC