

9690



# 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.                               | 13543                           | 40170                |
| 2.                         | Visual Inspection                            | OK - 4.0 mm CMJEW               | 148024               |
| 3.                         | Pellet Die No.                               | 1203                            | VT-OK                |
| 4.                         | Hardened by                                  | Lark Penny                      | Relief - OK          |
| 5.                         | Received by after hardening (Name)           | Jangir                          | (3-3) 14mm           |
| 6.                         | Hardness achieved on 1 <sup>st</sup> side    | 50.3 - 50.4 HRC                 | Relief 4-5 10mm      |
| 7.                         | Hardness achieved on 2 <sup>nd</sup> side    | 49.7 - 50.1 HRC                 | Relief - Camfer - OK |
| 8.                         | Ovality after hardening 1 <sup>st</sup> side | (1.4) mm [Die's Recounter]      | PID - 640mm          |
| 9.                         | Ovality after hardening 2 <sup>nd</sup> side | (1.2) mm due to ovality         | Tapping H20          |
| 10.                        | Outside Diameter                             | 701 mm                          | Deep - 18-8mm        |
| 11.                        | Inside Diameter                              | 600 mm                          | Tapping H20          |
| 12.                        | Width of die                                 | 265 mm                          | Hols - 16            |
| Inspected By (Sign) & Date |  | Jangir 18/12/24                 |                      |
| 1.                         | Finish Fitting size 1 <sup>st</sup> side     | 700 ± 0.05 ± 0.10 mm Tapper 12° |                      |
| 2.                         | Finish Fitting size 2 <sup>nd</sup> side     | 700 ± 0.07 ± 0.10 mm Tapper 12° |                      |
| 3.                         | Finish size made by                          |                                 |                      |
| Inspected By (Sign) & Date |  | Jangir 17/12/24                 |                      |
| 1.                         | Supplied to (Customer Name)                  | T. D. Arora PB                  |                      |
| 2.                         | Dispatch Date                                |                                 |                      |
| Reported By (Sign) & Date  |  | Jangir 17/12/24                 |                      |

Saty 20/12/24

Reviewed by (Engineer-CNC)

Manager-CNC