



# 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

9889

| S.No. | Check Parameter                              | Specification Observations | Remarks        |
|-------|--|----------------------------|----------------|
| 1.    | Work order No.                               |                            | 80/80          |
| 2.    | Visual Inspection                            | 13134                      | OK             |
| 3.    | Pellet Die No.                               | OK - 3.0 mm (Jumbo)        | 9.98 AT        |
| 4.    | Hardened by                                  | 13816                      | UT-OK          |
| 5.    | Received by after hardening (Name)           | Keshav Heat                | Relief-OK      |
| 6.    | Hardness achieved on 1 <sup>st</sup> side    | Jain                       | 5 HRC          |
| 7.    | Hardness achieved on 2 <sup>nd</sup> side    | 52-5-54.0 HRC              | 5 "            |
| 8.    | Ovality after hardening 1 <sup>st</sup> side | 51-9-53.5 HRC              | Counter-OK     |
| 9.    | Ovality after hardening 2 <sup>nd</sup> side | (0.5) mm                   | PCD - 68.5 mm  |
| 10.   | Outside Diameter                             | (0.4) mm                   | Tapping 120    |
| 11.   | Inside Diameter                              | 790 mm                     | Deep - 18-6 mm |
| 12.   | Width of die                                 | 630 mm                     | Tapping Ho of  |
|       | Inspected By (Sign) & Date                   | 265 mm                     | Holes - 16     |
|       |  | Jain 16/1/25               |                |

|    |  |                                 |                    |
|----|--|---------------------------------|--------------------|
| 1. | Finish Fitting size 1 <sup>st</sup> side | 740.5 ± .05 ± .05 mm Tapper 10° | Final size check   |
| 2. | Finish Fitting size 2 <sup>nd</sup> side | 740.5 ± .05 ± .05 Tapper 10°    | by - Sandeep Singh |
| 3. | Finish size made by                      |                                 | Keshav op          |

|    |                             |                   |     |
|----|-----------------------------|-------------------|-----|
|    | Inspected By (Sign) & Date  | Jain 16/1/25      | Sus |
| 1. | Supplied to (Customer Name) | A.P. Refinery, PB |     |
| 2. | Dispatch Date               |                   |     |

|  |                           |              |  |
|--|---------------------------|--------------|--|
|  | Reported By (Sign) & Date | Jain 16/1/25 |  |
|--|---------------------------|--------------|--|

Satish 17/1/25  
Reviewed by (Engineer-CNC)

Manager-CNC