

# 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<br>Observations  | Remarks                      |
|----------------------------|----------------------------------------------|--------------------------------|------------------------------|
| 1.                         | Work order No.                               | 14340                          | 45/50                        |
| 2.                         | Visual Inspection                            | OK (6.0) SSW                   | Dev 00<br>Orig No - 9980 A+B |
| 3.                         | Pellet Die No.                               | 14197                          | UT - OK                      |
| 4.                         | Hardened by                                  | Lark furnace                   | Relief - OK                  |
| 5.                         | Received by after hardening (Name)           | Sanjeev                        | (3-3) = 11mm                 |
| 6.                         | Hardness achieved on 1 <sup>st</sup> side    | 49.4 - 49.5 HRC                | Relief 0.65 = 5mm            |
| 7.                         | Hardness achieved on 2 <sup>nd</sup> side    | 49.2 - 49.6 HRC                | Counter - OK                 |
| 8.                         | Ovality after hardening 1 <sup>st</sup> side | (0.1) mm                       | PCD = 565 mm                 |
| 9.                         | Ovality after hardening 2 <sup>nd</sup> side | (0.3) mm                       | Tapping H20                  |
| 10.                        | Outside Diameter                             | 620 mm                         | Deep - 18.6 mm               |
| 11.                        | Inside Diameter                              | 520 mm                         | Tapping No. of               |
| 12.                        | Width of die                                 | 229 mm                         | Holes - 12                   |
| Inspected By (Sign) & Date |                                              | Sanjeev 19/03/25               |                              |
| 1.                         | Finish Fitting size 1 <sup>st</sup> side     | 618.5 + 0.04 + 0.05 Taper - 12 |                              |
| 2.                         | Finish Fitting size 2 <sup>nd</sup> side     | 618.5 + 0.04 + 0.04 Taper - 12 |                              |
| 3.                         | Finish size made by                          |                                |                              |
| Inspected By (Sign) & Date |                                              | Sanjeev 19/03/25               |                              |
| 1.                         | Supplied to (Customer Name)                  | Lumbini Agro Harpur            |                              |
| 2.                         | Dispatch Date                                |                                |                              |
| Reported By (Sign) & Date  |                                              | Sanjeev 19/03/25               |                              |

Reviewed by (Engineer-CNC)

Manager-CNC