



# 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

10473

| S.No.                      | Check Parameter                              | Specification Observations                        | Remarks                |
|----------------------------|----------------------------------------------|---------------------------------------------------|------------------------|
| 1.                         | Work order No.                               | 14560                                             | 60/66                  |
| 2.                         | Visual Inspection                            | OK - 10.0 mm (M. Lubed) -                         | Ph. 8                  |
| 3.                         | Pellet Die No.                               | 14773                                             | Done at 320 Ash        |
| 4.                         | Hardened by                                  | herk permy                                        | UT-OK                  |
| 5.                         | Received by after hardening (Name)           | Jayjir                                            | TRelief OK             |
| 6.                         | Hardness achieved on 1 <sup>st</sup> side    | 50.0 - 50.3 HRC                                   | Ø 11.0 ± 0.05 mm       |
| 7.                         | Hardness achieved on 2 <sup>nd</sup> side    | 49.7 - 49.9 HRC                                   | 3 Ash                  |
| 8.                         | Ovality after hardening 1 <sup>st</sup> side | (0.4) mm                                          | Counter - OK           |
| 9.                         | Ovality after hardening 2 <sup>nd</sup> side | (0.4) mm                                          | PCD - 61.9 mm          |
| 10.                        | Outside Diameter                             | 68.0 mm                                           | Tapping M16            |
| 11.                        | Inside Diameter                              | 64.8.1 ± 0.08 ± 0.10 mm / 64.8.1 ± 0.05 ± 0.08 mm | Deep - 31.0 mm         |
| 12.                        | Width of die                                 | 195 mm                                            | Tapping Ho of Hols - 2 |
| Inspected By (Sign) & Date |                                              | Jayjir 31/3/25                                    |                        |
| 1.                         | Finish Fitting size 1 <sup>st</sup> side     | 690.1 ± 0.08 mm / 690.1 ± 0.08 mm                 | Tappet 8°              |
| 2.                         | Finish Fitting size 2 <sup>nd</sup> side     | 690.1 ± 0.09 mm / 690 ± 0.10 mm                   | Tappet 8°              |
| 3.                         | Finish size made by                          |                                                   |                        |
| Inspected By (Sign) & Date |                                              | Jayjir 31/3/25                                    |                        |
| 1.                         | Supplied to (Customer Name)                  | Manikaran Power Ltd, HR.                          |                        |
| 2.                         | Dispatch Date                                |                                                   |                        |
| Reported By (Sign) & Date  |                                              | Jayjir 31/3/25                                    |                        |

Reviewed by (Engineer-CNC)

Manager-CNC