

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

14701

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.		
2.	Visual Inspection	14633 to 14872	35/50/66 - Mo 3
3.	Pellet Die No.	OK - 6.0 mm (M. Jumbo) - 14823	Dring - 609 AB WT - OK
4.	Hardened by	Lark Perony	Relief - OK
5.	Received by after hardening (Name)	Jangir	Φ 6.5 → 31 mm
6.	Hardness achieved on 1 st side	58.6 - 51.9 HR	Φ 7.0 → 16 mm
7.	Hardness achieved on 2 nd side	51.1 - 51.6 HR	Bo under - OK
8.	Ovality after hardening 1 st side	(0.1) mm	PCD - 619 mm
9.	Ovality after hardening 2 nd side	(0.3) mm	Tapping M16
10.	Outside Diameter	680 mm	Deep - 31.6 mm
11.	Inside Diameter	548.4 ± 0.8 ± 0.9 → 548.4 ± 1.0 ± 1.2 mm	Tapping No. 6
12.	Width of die	135 mm	Tools - 2
Inspected By (Sign) & Date		Jangir 14/5/25	✓
1.	Finish Fitting size 1 st side	690 ± 1.0 → 690 ± 1.0 Tapper 8°	Undercut = 1 mm
2.	Finish Fitting size 2 nd side	690 ± 1.0 → 690 ± 1.0 Tapper 8°	
3.	Finish size made by		
Inspected By (Sign) & Date		Jangir 14/5/25	
1.	Supplied to (Customer Name)	Yutong, HR	
2.	Dispatch Date		
Reported By (Sign) & Date		Jangir 14/5/25	

Satyajit
14/5/25

100x2 - CWPINK

Reviewed by (Engineer-CNC)

Manager-CNC