



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

Final Inspection (Pellet Dies) after Hardening & Finishing

Rev. Date

31-07-2013

| S.No. | Check Parameter | Specification | Observations | Remarks |
|----------------------------|----------------------------------------------|----------------------------------------|------------------------------------------------------|--------------------------------------------|
| 1. | Work order No. | | 10539 | 33/43/66 |
| 2. | Visual Inspection | | OK - 6-0 mm (M. Jumbo) | 201 Dwg No - 609A/B |
| 3. | Pellet Die No. | | 11189 | UT-OK |
| 4. | Hardened by | | Lark Engineer | Relief OK |
| 5. | Received by after hardening (Name) | | J. Anju | |
| 6. | Hardness achieved on 1 st side | | 50.1 - 50.3 HRC | 66.5 \rightarrow 33 mm |
| 7. | Hardness achieved on 2 nd side | | 49.9 - 50.2 HRC | 67.3 \rightarrow 23 mm Counter-OK 30° |
| 8. | Ovality after hardening 1 st side | | (0.6) mm | P.D - 619 mm |
| 9. | Ovality after hardening 2 nd side | | (0.3) mm | Tapping M16 |
| 10. | Outside Diameter | | 681 mm | Deep - 31.8 mm |
| 11. | Inside Diameter | | 548.5 \pm 0.10 \pm 0.12 \pm 0.10 \pm 0.10 mm | Tapping M16 |
| 12. | Width of die | | 195 mm | Holes - 2 |
| Inspected By (Sign) & Date | | J. Anju 8/11/23 | | |
| 1. | Finish Fitting size 1 st side | 690 \pm 0.10 \pm 0.11 mm Tapper 8° | | Undercut = 1 mm |
| 2. | Finish Fitting size 2 nd side | 690 \pm 0.12 \pm 0.12 mm Tapper 8° | | |
| 3. | Finish size made by | | | |
| Inspected By (Sign) & Date | | J. Anju 8/11/23 | | |
| 1. | Supplied to (Customer Name) | DDS Agro, Maharashtra | | |
| 2. | Dispatch Date | | | |
| Reported By (Sign) & Date | | J. Anju 8/11/23 | | |

8/11/23

Reviewed by (Engineer-CNC)

Manager-CNC