



# 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

2568

## Final Inspection (Pellet Dies) after Hardening & Finishing

| S.No.                      | Check Parameter                              | Specification                     | Observations   | Remarks                     |
|----------------------------|--|-----------------------------------|----------------|-----------------------------|
| 1.                         | Work order No.                               |                                   |                | 39/50                       |
| 2.                         | Visual Inspection                            |                                   | 10854          |                             |
| 3.                         | Pellet Die No.                               | OK - 3.0 mm (SSW)                 | 11240          | Dring No - 9980A/B<br>07-ak |
| 4.                         | Hardened by                                  |                                   | hark Punner    | Reluf - ak                  |
| 5.                         | Received by after hardening (Name)           |                                   | Janji          | (8-3) > 17 mm               |
| 6.                         | Hardness achieved on 1 <sup>st</sup> side    |                                   | 50.3 - 50.4 HR | > 11 mm                     |
| 7.                         | Hardness achieved on 2 <sup>nd</sup> side    |                                   | 49.7 - 49.8 HR | Plum - ak                   |
| 8.                         | Ovality after hardening 1 <sup>st</sup> side |                                   | (0.4) mm       | P.D - 565 mm                |
| 9.                         | Ovality after hardening 2 <sup>nd</sup> side |                                   | (0.4) mm       | Tapping M20                 |
| 10.                        | Outside Diameter                             |                                   | 620 mm         | Deep - 19 mm                |
| 11.                        | Inside Diameter                              |                                   | 520 mm         | Tapping Mandrel             |
| 12.                        | Width of die                                 |                                   | 222 mm         | Hole - 12                   |
| Inspected By (Sign) & Date |  | Janji 21/12/23                    |                |                             |
| 1.                         | Finish Fitting size 1 <sup>st</sup> side     | 618.5 ± 0.05 ± 0.05 mm Tapper 12° |                |                             |
| 2.                         | Finish Fitting size 2 <sup>nd</sup> side     | 618.5 ± 0.05 ± 0.05 mm Tapper 12° |                |                             |
| 3.                         | Finish size made by                          | _____                             |                |                             |
| Inspected By (Sign) & Date |  | Janji 21/12/23                    |                |                             |
| 1.                         | Supplied to (Customer Name)                  | Marion foods Bihar                |                |                             |
| 2.                         | Dispatch Date                                | _____                             |                |                             |
| Reported By (Sign) & Date  |  | Janji 21/12/23                    |                |                             |

Reviewed by (Engineer-CNC)

Manager-CNC