



# 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

6222

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

| S.No.                      | Check Parameter                              | Specification Observations      | Remarks                   |
|----------------------------|--|---------------------------------|---------------------------|
| 1.                         | Work order No.                               | 9752                            | 36/10                     |
| 2.                         | Visual Inspection                            | OK - 4.0 mm (M-Jumbo)           | Relief<br>Dwg No - 505A/B |
| 3.                         | Pellet Die No.                               | 10282                           | WT-OK                     |
| 4.                         | Hardened by                                  | Lark Furner                     | Relief - OK               |
| 5.                         | Received by after hardening (Name)           | Janjan                          | (3-3) 3 18 mm             |
| 6.                         | Hardness achieved on 1 <sup>st</sup> side    | 48.2 - 48.5 HR <sub>C</sub> (B) | Relief 4.5 - 3 14 mm      |
| 7.                         | Hardness achieved on 2 <sup>nd</sup> side    | 48.1 - 48.2 HR <sub>C</sub> (B) | Center - OK               |
| 8.                         | Ovality after hardening 1 <sup>st</sup> side | (0.3) mm                        | POD - 885 mm              |
| 9.                         | Ovality after hardening 2 <sup>nd</sup> side | (0.2) mm                        | Tapping M22               |
| 10.                        | Outside Diameter                             | 730 mm                          | Dep - 26.7                |
| 11.                        | Inside Diameter                              | 630 mm                          | Tapping No. of            |
| 12.                        | Width of die                                 | 255 mm                          | Hobs - 12                 |
| Inspected By (Sign) & Date |  | Janjan 12/7/23                  |                           |
| 1.                         | Finish Fitting size 1 <sup>st</sup> side     | 740 ± .07 ± .10 mm Taper 4°     | Undercut - 5 mm           |
| 2.                         | Finish Fitting size 2 <sup>nd</sup> side     | 740 ± .11 ± .12 mm Taper 4°     |                           |
| 3.                         | Finish size made by                          |                                 |                           |
| Inspected By (Sign) & Date |  | Janjan 12/7/23                  |                           |
| 1.                         | Supplied to (Customer Name)                  | Maharashtra Fed, Assam          |                           |
| 2.                         | Dispatch Date                                |                                 |                           |
| Reported By (Sign) & Date  |  | Janjan 12/7/23                  |                           |

Reviewed by (Engineer-CNC)  
*[Signature]*  
12/7/23

Manager-CNC