



# Lark Engineering Company (India) Pvt. Ltd.

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

8452

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	11662 to 11941 ✓	26/36/66
3.	Pellet Die No.	OK - 8.0 mm (M. Jumbo) ✓ 12248	Run 01 Diameter 609 AD ✓ UT-OK
4.	Hardened by	Lark Permer ✓	Relief - OK
5.	Received by after hardening (Name)	Janji ✓	
6.	Hardness achieved on 1 <sup>st</sup> side	49.4 - 49.8 HB (A) ✓	φ 8.5 ± 40 mm ✓
7.	Hardness achieved on 2 <sup>nd</sup> side	50.1 - 50.3 HB ✓	φ 9.0 ± 30 mm ✓
8.	Ovality after hardening 1 <sup>st</sup> side	(0.8) mm (A) ✓	Count - OK 30 ✓
9.	Ovality after hardening 2 <sup>nd</sup> side	(0.1) mm ✓	PCD - 619 mm ✓
10.	Outside Diameter	680 mm ✓	Tapping M16 ✓
11.	Inside Diameter	548.5 ± 1.10 ± 0.20 ± 0.8 ± 0.5 mm ✓	Deep - 31.6 mm ✓
12.	Width of die	195 mm ✓	Tapping Hole ✓
Inspected By (Sign) & Date		Janji 21/5/24	Holes - 24 ✓
1.	Finish Fitting size 1 <sup>st</sup> side	690 ± .12 ± .12 mm Tapper 8° ✓	Undercut - 1 mm ✓
2.	Finish Fitting size 2 <sup>nd</sup> side	690 ± .10 ± .11 mm Tapper 8° ✓	
3.	Finish size made by	_____ ✓	
Inspected By (Sign) & Date		Janji 21/5/24	
1.	Supplied to (Customer Name)	Yulong, HR to Balaji Hitachi, Cuttack ✓	
2.	Dispatch Date	_____ ✓	
Reported By (Sign) & Date		Janji 21/5/24	

Satyam  
22/3/24

Reviewed by (Engineer-CNC)

Manager-CNC