



# 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

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

| S.No.                      | Check Parameter                              | Specification<br>Observations     | Remarks                     |
|----------------------------|----------------------------------------------|-----------------------------------|-----------------------------|
| 1.                         | Work order No.                               | 14340                             | 37/50                       |
| 2.                         | Visual Inspection                            | OK (3.5) S S E W                  | (Per 00) Proj No - 4480 HAW |
| 3.                         | Pellet Die No.                               | 14196                             | UT - OK                     |
| 4.                         | Hardened by                                  | Lark furnace                      | Relief - OK                 |
| 5.                         | Received by after hardening (Name)           | Sanjeev                           | (3-3) = 20mm                |
| 6.                         | Hardness achieved on 1 <sup>st</sup> side    | 49.3 - 49.4 HRC                   | Relief 0.4 = 13mm           |
| 7.                         | Hardness achieved on 2 <sup>nd</sup> side    | 49.6 - 49.7 HRC                   | Counter - OK                |
| 8.                         | Ovality after hardening 1 <sup>st</sup> side | (0.5)mm                           | PCD - 565 mm                |
| 9.                         | Ovality after hardening 2 <sup>nd</sup> side | (0.4)mm                           | Tapping Hole - M20          |
| 10.                        | Outside Diameter                             | 620 mm                            | Cal - 18.6                  |
| 11.                        | Inside Diameter                              | 520 mm                            | Tapping No. of              |
| 12.                        | Width of die                                 | 222 mm                            | Holes - 12 ✓                |
| Inspected By (Sign) & Date |                                              | Sanjeev 19/03/25                  |                             |
| 1.                         | Finish Fitting size 1 <sup>st</sup> side     | 618.5 + 0.05 + 0.05 Taper - 12°   |                             |
| 2.                         | Finish Fitting size 2 <sup>nd</sup> side     | 618.5 + 0.04 + 0.04 Taper - 12° ✓ |                             |
| 3.                         | Finish size made by                          |                                   |                             |
| Inspected By (Sign) & Date |                                              | Sanjeev 19/03/25                  |                             |
| 1.                         | Supplied to (Customer Name)                  | Lumbini Agro Har Pur              |                             |
| 2.                         | Dispatch Date                                |                                   |                             |
| Reported By (Sign) & Date  |                                              | Sanjeev 19/03/25                  |                             |

Reviewed by (Engineer-CNC)

Manager-CNC

1002 - CWP/INK