



# Lark Engineering Company (India) Pvt. Ltd.

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

15117

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.                               | Tw to 15385                          | 351 RD        |
| 2.                         | Visual Inspection                            | OK - 3.0 mm (SS4W)                   | Done 22.80 AM |
| 3.                         | Pellet Die No.                               | 14836                                | U7-alc        |
| 4.                         | Hardened by                                  | Mark Perry                           | Relief - alc  |
| 5.                         | Received by after hardening (Name)           | Jangin                               | (3-3) 3.21 mm |
| 6.                         | Hardness achieved on 1 <sup>st</sup> side    | 49.9 - 50.5 HRC                      | 15 mm         |
| 7.                         | Hardness achieved on 2 <sup>nd</sup> side    | 49.6 - 49.9 HRC                      | Gunter - ok   |
| 8.                         | Ovality after hardening 1 <sup>st</sup> side | (0.4) mm                             | Pd - 565 mm   |
| 9.                         | Ovality after hardening 2 <sup>nd</sup> side | (0.4) mm                             | Tapping 1120  |
| 10.                        | Outside Diameter                             | 620 mm                               | Deep 18.6 mm  |
| 11.                        | Inside Diameter                              | 520 mm                               | Tapping 1120  |
| 12.                        | Width of die                                 | 222 mm                               | tools - 12    |
| Inspected By (Sign) & Date |                                              | Jangin 11/7/25                       |               |
| 1.                         | Finish Fitting size 1 <sup>st</sup> side     | 618.5 ± 0.5 - 618.5 ± 0.5 Tapper 12° |               |
| 2.                         | Finish Fitting size 2 <sup>nd</sup> side     | 618.5 ± 0.5 - 618.5 ± 0.5 Tapper 12° |               |
| 3.                         | Finish size made by                          |                                      |               |
| Inspected By (Sign) & Date |                                              | Jangin 11/7/25                       |               |
| 1.                         | Supplied to (Customer Name)                  | Tw to Manhad fresh wib               |               |
| 2.                         | Dispatch Date                                |                                      |               |
| Reported By (Sign) & Date  |                                              | Jangin 11/7/25                       |               |

100x2 - CW/PINK

Sat 31/7/25

Reviewed by (Engineer-CNC)

Manager-CNC