

8705

PHD



# 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	Observations	Remarks
1.	Work order No.			
2.	Visual Inspection		Inv to 12311	33/50
3.	Pellet Die No.		OK - 3.0 mm (SSCW)	Longer 998011
4.	Hardened by		12583	UT-OK
5.	Received by after hardening (Name)		Lark firm	Relief-OK
6.	Hardness achieved on 1 <sup>st</sup> side		49.4 - 49.6 HRc	(3-3) ≥ 23 mm
7.	Hardness achieved on 2 <sup>nd</sup> side		49.7 - 49.8 HRc	3-5 - 17 mm
8.	Ovality after hardening 1 <sup>st</sup> side		(0.3) mm	Counter-OK
9.	Ovality after hardening 2 <sup>nd</sup> side		(0.1) mm	PCD - 565 mm
10.	Outside Diameter		620 mm	Tapping 120
11.	Inside Diameter		520 mm	Deep - 18.7 mm
12.	Width of die		222 mm	Tapping 120 Holes - 12

Inspected By (Sign) & Date: Janjan 31/7/14

1.	Finish Fitting size 1 <sup>st</sup> side	618.5 ± 0.01 7.01 mm Tapper 12°
2.	Finish Fitting size 2 <sup>nd</sup> side	618.5 ± 0.01 7.01 mm Tapper 12°
3.	Finish size made by	

Inspected By (Sign) & Date: Janjan 31/7/14

1.	Supplied to (Customer Name)	Inv to KC feed, CO.B
2.	Dispatch Date	

Reported By (Sign) & Date: Janjan 31/7/14

Reviewed by (Engineer-CNC): 31/7/14

Manager-CNC