



# 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.		12209 to 12243	26/36/66
2.	Visual Inspection		ok - 6-0 mm (M. Jank)	Per co Dongro - Gogard
3.	Pellet Die No.		12796	UT etc
4.	Hardened by		Lark Finca	Relief etc
5.	Received by after hardening (Name)		Jayji	
6.	Hardness achieved on 1 <sup>st</sup> side		48.5 - 50.2 HRC	Ø 6.5 = 40 mm
7.	Hardness achieved on 2 <sup>nd</sup> side		50.1 - 50.3 HRC	Ø 7.0 = 30 mm Counter sink 30°
8.	Ovality after hardening 1 <sup>st</sup> side		(0.1) mm	PCD - 619 mm
9.	Ovality after hardening 2 <sup>nd</sup> side		(0.1) mm	Tapping M26
10.	Outside Diameter		680 mm	Deep 33 mm
11.	Inside Diameter		548.5 ± 0.02 ± 0.03 ± 0.05 ± 0.10 mm	Tapping M26
12.	Width of die		195 mm	Holdy - 4
Inspected By (Sign) & Date		Jayji 31/7/13		
1.	Finish Fitting size 1 <sup>st</sup> side	690 ± 0.12 ± 0.12 mm Tapper 8°		Under cut - 1 mm
2.	Finish Fitting size 2 <sup>nd</sup> side	690 ± 0.12 ± 0.12 mm Tapper 8°		
3.	Finish size made by	_____		
Inspected By (Sign) & Date		Jayji 31/7/13		
1.	Supplied to (Customer Name)	Yulong to SNU Green Rajadham		
2.	Dispatch Date	_____		
Reported By (Sign) & Date		Jayji 31/7/13		

Jayji 31/7/13

Reviewed by (Engineer-CNC)

Manager-CNC