



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		12-302	48155
3.	Pellet Die No.	ok - 4.0 mm	(M. Jumber)	Revised 5261
4.	Hardened by	12668		07-06
5.	Received by after hardening (Name)	hark pinner		Relief - ok
6.	Hardness achieved on 1 st side	50.0 - 50.1 HRc		(3-3) > 15 mm
7.	Hardness achieved on 2 nd side	50.0 - 50.0 HRc		Relief @ 4.5 3 7 mm
8.	Ovality after hardening 1 st side	(0.8) mm		Center - ok
9.	Ovality after hardening 2 nd side	(0.5) mm		PCD - 685 mm
10.	Outside Diameter	740 mm		Tapping M22
11.	Inside Diameter	630 mm		Deep - 26.5 mm
12.	Width of die	255 mm		Tapping Hole of
Inspected By (Sign) & Date		Jaujan 8/7/14		
1.	Finish Fitting size 1 st side	740 ± .10 full min Tapper 4°		
2.	Finish Fitting size 2 nd side	740 ± .09 4.10 mm Tapper 4°		
3.	Finish size made by			
Inspected By (Sign) & Date		Jaujan 8/7/14		
1.	Supplied to (Customer Name)	Suguna food		
2.	Dispatch Date			
Reported By (Sign) & Date		Jaujan 8/7/14		

Satyam
9/7/14

Reviewed by (Engineer-CNC)

Manager-CNC