



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.	12348	30/40
2.	Visual Inspection	OK - 3.0 mm (center)	Profil ED angle 21.4°
3.	Pellet Die No.	11844	WT-OK
4.	Hardened by	work furnace	Relief - OK
5.	Received by after hardening (Name)	Jain	(2-2) 213 mm
6.	Hardness achieved on 1 st side	50.0 - 50.2 HRC	Relief 3.5 5 10 mm
7.	Hardness achieved on 2 nd side	50.0 - 50.0 HRC	Counter - OK
8.	Ovality after hardening 1 st side	(0.1) mm	R.D - 4.54 mm
9.	Ovality after hardening 2 nd side	(0.1) mm	Tapping 9/314
10.	Outside Diameter	500 mm	Deep - 16.5 mm
11.	Inside Diameter	420 mm	Tapping 110 of
12.	Width of die	158 mm	holes - 8
Inspected By (Sign) & Date		Jain 17/7/13	
1.	Finish Fitting size 1 st side	496.3 ± .10 9.11 mm Tapper 12°	
2.	Finish Fitting size 2 nd side	496.3 ± .09 9.10 mm Tapper 12°	
3.	Finish size made by	_____	
Inspected By (Sign) & Date		Jain 17/7/13	
1.	Supplied to (Customer Name)	Yantrik, Maharashtra	
2.	Dispatch Date	_____	
Reported By (Sign) & Date		Jain 17/7/13	

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Reviewed by (Engineer-CNC)

Manager-CNC