



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.			36145/10
2.	Visual Inspection		12418	202 259M
3.	Pellet Die No.	ok - 4.0 mm (SSEW)	12632	UT-ok
4.	Hardened by	Lark Perma		Relief-ok
5.	Received by after hardening (Name)	Jayju		Ø 4.5 ± 14 μm
6.	Hardness achieved on 1 st side	49.6 - 49.2 HR		Ø 5.0 ± 5 μm
7.	Hardness achieved on 2 nd side	49.7 - 49.8 HR		Re-Cam for ok
8.	Ovality after hardening 1 st side	(1.0 μm)	Re-counter due to ovality.	PCD = 565 μm
9.	Ovality after hardening 2 nd side	(1.5 μm)		Tapping M20
10.	Outside Diameter	620 mm		Dep - 18.8 μm
11.	Inside Diameter	520 mm		Tapping H9/h8
12.	Width of die	222 mm		H9/h8 - 12
Inspected By (Sign) & Date		Jayju 31/7/13		
1.	Finish Fitting size 1 st side	621 ± .12 ± .12 mm Tapper 12°		Under ut - 5 μm
2.	Finish Fitting size 2 nd side	621 ± .10 ± .11 mm Tapper 12°		
3.	Finish size made by			
Inspected By (Sign) & Date		Jayju 31/7/13		
1.	Supplied to (Customer Name)	Vedraj Agent, Bahor		
2.	Dispatch Date			
Reported By (Sign) & Date		Jayju 31/7/13		

Satya 31/7/13

Reviewed by (Engineer-CNC)

Manager-CNC