



# 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.	12585	45160
2.	Visual Inspection	OK - 4.0 mm (Jumbo)	Per Drawn 11A15
3.	Pellet Die No.	12998	U7-die
4.	Hardened by	hark pency	Relief die
5.	Received by after hardening (Name)	Jayju	(3-3) 3 23mm 5
6.	Hardness achieved on 1 <sup>st</sup> side	50.1 - 49.7 HRC	Relief 4.5 15mm
7.	Hardness achieved on 2 <sup>nd</sup> side	49.6 - 49.8 HRC	Re-counter-OK
8.	Ovality after hardening 1 <sup>st</sup> side	(1.4) mm [die was Re-counter die]	PCD - 725 mm
9.	Ovality after hardening 2 <sup>nd</sup> side	(0.8) mm to ovality.	Tapping M20
10.	Outside Diameter	780 mm	Deep 29.5 mm
11.	Inside Diameter	660 mm	Tapping No of
12.	Width of die	324 mm	holes - 12

Inspected By (Sign) & Date

Jayju 30/8/14

1. Finish Fitting size 1<sup>st</sup> side

790 <sup>(A)</sup> +0.06 +1.10 mm

Undercut = 5.2 mm

2. Finish Fitting size 2<sup>nd</sup> side

790 +0.09 +1.12 mm

3. Finish size made by

28/6/14 Both side

Inspected By (Sign) & Date

Jayju 30/8/14

32x8 mm

1. Supplied to (Customer Name)

Smeha forms AD

2. Dispatch Date

Reported By (Sign) & Date

Jayju 30/8/14

Jot 30/8/14

Reviewed by (Engineer-CNC)

Manager-CNC