



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

Final Inspection (Pellet Dies) after Hardening & Finishing

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	12257 to 12606	35/10/66
2.	Visual Inspection	OK - 6.0 mm (M. Jumber)	Long No - 609 AD
3.	Pellet Die No.	12789	UT-OK
4.	Hardened by	work finney	Relief - OK
5.	Received by after hardening (Name)	Janjin	φ 6.5 ± 0.1 mm
6.	Hardness achieved on 1 st side	58.1 - 58.4 HR	φ 7.0 ± 0.16 mm
7.	Hardness achieved on 2 nd side	48.4 - 49.7 HR (B)	Counter - OK 30°
8.	Ovality after hardening 1 st side	(0.4) mm	RD - 619 mm
9.	Ovality after hardening 2 nd side	(0.2) mm	Tapping M16
10.	Outside Diameter	680 mm	Deep - 31.8 mm
11.	Inside Diameter	548.5 ± 0.10 ± 0.12 ± 0.28 ± 0.40 mm (B)	Tapping M16 of
12.	Width of die	195 mm	Holes - 4
Inspected By (Sign) & Date		Janjin 24/8/14	
1.	Finish Fitting size 1 st side	690 ± 0.10 ± 0.12 mm Tapper 8°	Undercut - 1 mm
2.	Finish Fitting size 2 nd side	690 ± 0.11 ± 0.12 mm Tapper 8°	
3.	Finish size made by		
Inspected By (Sign) & Date		Janjin 24/8/14	
1.	Supplied to (Customer Name)	Yulong, HR to Newdurga, Rajasthan	
2.	Dispatch Date		
Reported By (Sign) & Date		Janjin 24/8/14	

Signature
24/8/14

Reviewed by (Engineer-CNC)

Manager-CNC