



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.	12769	35/55
2.	Visual Inspection	OK - 4.5 mm (M. Jumbo)	Re w 955 AD
3.	Pellet Die No.	11540	UT-OK
4.	Hardened by	Work piece	Reluf ok
5.	Received by after hardening (Name)	Jayjeer	(2-3) 2.25 mm
6.	Hardness achieved on 1 st side	49.5 - 50.4 HRC	Reluf 950 20 mm
7.	Hardness achieved on 2 nd side	50.3 - 50.1 HRC	Caumfu - ok
8.	Ovality after hardening 1 st side	(0.2) mm	PO - 689 mm
9.	Ovality after hardening 2 nd side	(0.4) mm	Tapping M24
10.	Outside Diameter	737 mm	Deep - 26.5 mm
11.	Inside Diameter	627, 632 mm	Tapping M24
12.	Width of die	258 mm	Holes - 12
Inspected By (Sign) & Date		Jayjeer 14/9/14	
1.	Finish Fitting size 1 st side	751.3 ± .10 ± .11 mm Tapper 10°	Under cut = 7.5 mm
2.	Finish Fitting size 2 nd side	751.3 ± .09 ± .10 mm Tapper 10°	7.7 mm
3.	Finish size made by	→	
Inspected By (Sign) & Date		Jayjeer 14/9/14	
1.	Supplied to (Customer Name)	Srinivasa Ramu, A.P	
2.	Dispatch Date	→	
Reported By (Sign) & Date		Jayjeer 14/9/14	

Jayjeer 14/9/14

Reviewed by (Engineer-CNC)

Manager-CNC