



# 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.			60/66
2.	Visual Inspection		12013 ✓	Finalist
3.	Pellet Die No.		OK - 3.5 mm (S. Jumbo) ✓	Length - 9136 AB ✓
4.	Hardened by		13170 ✓	UT - OK
5.	Received by after hardening (Name)		heek finney	Relief - OK
6.	Hardness achieved on 1 <sup>st</sup> side		47.8 - 48.0 HR ✓	(4-4) F 13 mm ✓
7.	Hardness achieved on 2 <sup>nd</sup> side		47.9 - 48.0 HR ✓	Relief 4.0, 6 mm ✓
8.	Ovality after hardening 1 <sup>st</sup> side		(1.0) mm [Die is Re-counter]	Re-counter - OK
9.	Ovality after hardening 2 <sup>nd</sup> side		(2.0) mm [due to ovality]	POD - 970 mm ✓
10.	Outside Diameter		1032 mm ✓	Tapping M24 ✓
11.	Inside Diameter		900 mm ✓	Deep - 36.5 mm ✓
12.	Width of die		375 mm ✓	Tapping Holec ✓

Inspected By (Sign) & Date

Jaujan 18/8/14

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

1030 ± 0.08 ± 0.10 mm Tapper 3° 2 Slot Both side ✓

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

1030 ± 0.07 ± 0.11 mm Tapper 3° 32 X 7.5 mm ✓

3. Finish size made by

Inspected By (Sign) & Date

Jaujan 18/8/14

1. Supplied to (Customer Name)

Sneha Formy, A.P.

2. Dispatch Date

Reported By (Sign) & Date

Jaujan 18/8/14

Reviewed by (Engineer-CNC)

Manager-CNC