



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.	12640	Go/ok
2.	Visual Inspection	ok - 3.5 mm (S. Jumbo)	20/2 Dyptk 9/36/12
3.	Pellet Die No.	13357	07-ok
4.	Hardened by	hark Kumar	Relief - ok
5.	Received by after hardening (Name)	Janji	(4-4) 3 13 mm
6.	Hardness achieved on 1 st side	48.3-48.7 HRc (A)	Relief 4.0 3 6 mm
7.	Hardness achieved on 2 nd side	48.1-48.1 HRc (A)	Re-counter - ok
8.	Ovality after hardening 1 st side	(2-3) mm [Die's Re-counter]	PID - 970 mm
9.	Ovality after hardening 2 nd side	(1.2) mm [due to ovality]	Tapping M24
10.	Outside Diameter	1032 mm	Deep - 36.5 mm
11.	Inside Diameter	900 mm	Tapping Hole
12.	Width of die	275 mm	Holes - 15

Inspected By (Sign) & Date

Janji 20/9/14

1. Finish Fitting size 1st side

1030 1.08 1.08 mm Tappin 3°

2 Plot Both side

2. Finish Fitting size 2nd side

1030 1.07 1.08 mm Tappin 3°

= 32x7.5 mm

3. Finish size made by

Inspected By (Sign) & Date

Janji 20/9/14

1. Supplied to (Customer Name)

Sancho for out, Telangana

2. Dispatch Date

Reported By (Sign) & Date

Janji 20/9/14

Sancho 20/9/14

Reviewed by (Engineer-CNC)

Manager-CNC