



# 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.		12830	40/66
2.	Visual Inspection		OK = 8.0 mm (M. Jumbo)	Pro 5 Dog 16-320 AD
3.	Pellet Die No.		13329	127-OK
4.	Hardened by		Lark Permy	Relief - OK
5.	Received by after hardening (Name)		Jayin	Ø 90 = 26
6.	Hardness achieved on 1 <sup>st</sup> side		50.1 - 50.3 HRC	3 AB
7.	Hardness achieved on 2 <sup>nd</sup> side		50.5 - 50.7 HRC	Camfer - OK 30°
8.	Ovality after hardening 1 <sup>st</sup> side		(0.6) mm	Ø 10 - 619 mm
9.	Ovality after hardening 2 <sup>nd</sup> side		(0.4) mm	Tapping M16
10.	Outside Diameter		680.8 mm	Depth 619 mm
11.	Inside Diameter		548.1 - 1.07 + 0.4 + 1.06 + 1.40 mm	Tapping M16
12.	Width of die		195 mm	Hole - 4
Inspected By (Sign) & Date		Jayin 25/9/14		
1.	Finish Fitting size 1 <sup>st</sup> side		690.1 ± .10 ± .10 mm Tapper 8°	Under Cu - 1 mm
2.	Finish Fitting size 2 <sup>nd</sup> side		690.1 ± .09 ± .10 mm Tapper 8°	
3.	Finish size made by			
Inspected By (Sign) & Date		Jayin 25/9/14		
1.	Supplied to (Customer Name)	Yulong i Haryang		
2.	Dispatch Date			
Reported By (Sign) & Date		Jayin 25/9/14		

Jayin 25/9/14

Reviewed by (Engineer-CNC)

Manager-CNC