



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

9598

S.No.	Check Parameter	Specification	Observations	Remarks
1.	Work order No.		13400	33/40
2.	Visual Inspection		ok - 3.0 mm (Service)	Depth 150/200
3.	Pellet Die No.		12705	UT-OK
4.	Hardened by		heer, Purny	Relief ok
5.	Received by after hardening (Name)		Jain	(2.5) 3 13 mm
6.	Hardness achieved on 1 st side		49.1-49.2 HRC	Relief 2.5, 3 7 mm
7.	Hardness achieved on 2 nd side		49.3-49.9 HRC	Center - ok
8.	Ovality after hardening 1 st side		(0.2) mm	POD - 454 mm
9.	Ovality after hardening 2 nd side		(0.1) mm	Tapping 120
10.	Outside Diameter		500 mm	Deep - 16.7 mm
11.	Inside Diameter		420 mm	Tapping Mandrel
12.	Width of die		158 mm	held &
		Inspected By (Sign) & Date		Jain 31/7/13
1.	Finish Fitting size 1 st side	495.88 ± 0.05 ± 0.05 mm Tapper 12°		
2.	Finish Fitting size 2 nd side	495.88 ± 0.05 ± 0.05 mm Tapper 12°		
3.	Finish size made by			
		Inspected By (Sign) & Date		Jain 31/7/13
1.	Supplied to (Customer Name)	Mandheria, Min, UP		
2.	Dispatch Date			
		Reported By (Sign) & Date		Jain 31/7/13

Jain 31/7/13

Reviewed by (Engineer-CNC)

Manager-CNC