



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

9615

S.No.	Check Parameter	Specification	Observations	Remarks
1.	Work order No.		13204	3615T
2.	Visual Inspection		ok - 9.0 mm (M. Jumbo)	2-Dongle - 407A
3.	Pellet Die No.		13867	UT-ak
4.	Hardened by		Lark Perma	Relief - ak
5.	Received by after hardening (Name)		Jayjir	(2-3) 3 23 mm
6.	Hardness achieved on 1 st side		50-3-50-5 HRC	Relief 4-5 19 mm
7.	Hardness achieved on 2 nd side		49.7-50.0 HRC	Counter - ak
8.	Ovality after hardening 1 st side		(0-7) mm	Pop - 640 mm
9.	Ovality after hardening 2 nd side		(0-4) mm	Tapping M30
10.	Outside Diameter		710 mm	Deep - 18.5 mm
11.	Inside Diameter		600 mm	Tapping M30 of
12.	Width of die		222 mm	Hole - 12
Inspected By (Sign) & Date		Jayjir 31/7/13		
1.	Finish Fitting size 1 st side	690 \pm .12 \pm .12 mm Tapper 12°		Final size check
2.	Finish Fitting size 2 nd side	690 \pm .12 \pm .12 mm Tapper 12°		by - Sandeep Singh
3.	Finish size made by	_____		
Inspected By (Sign) & Date		Jayjir 31/7/13		
1.	Supplied to (Customer Name)	Heritage - U.P		
2.	Dispatch Date	_____		
Reported By (Sign) & Date		Jayjir 31/7/13		

Satyam 31/7/13

Reviewed by (Engineer-CNC)

Manager-CNC