



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9742

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.	13547	40/48/55
2.	Visual Inspection	ok - 6.0 mm (M. Jumbo)	Done by - 666A
3.	Pellet Die No.	13873	UT-010
4.	Hardened by	Herb Pinsky	Relief - ok
5.	Received by after hardening (Name)	Janji	ø 6.5 ± 15 μm
6.	Hardness achieved on 1 <sup>st</sup> side	49.3 - 52.0 HR <sup>ⓐ</sup>	ø 7.0 ± 7 μm
7.	Hardness achieved on 2 <sup>nd</sup> side	49.4 - 52.0 HR <sup>ⓐ</sup>	Geometry - ok
8.	Ovality after hardening 1 <sup>st</sup> side	(0.5) mm	ø 10 - 540 μm
9.	Ovality after hardening 2 <sup>nd</sup> side	(0.8) mm	Tapping No
10.	Outside Diameter	710 mm	Depth - 18.6 mm
11.	Inside Diameter	600 mm	Tapping No of
12.	Width of die	222 mm	holes 12
Inspected By (Sign) & Date		Janji 25/12/14	
1.	Finish Fitting size 1 <sup>st</sup> side	690 ± .12 ± .12 mm Tapper 12°	Final size check
2.	Finish Fitting size 2 <sup>nd</sup> side	690 ± .12 ± .12 mm Tapper 12°	by - Rahul
3.	Finish size made by		op UT-1 - Horn
Inspected By (Sign) & Date		Janji 25/12/14	Suri
1.	Supplied to (Customer Name)	SKM - Tamil Nadu	
2.	Dispatch Date		
Reported By (Sign) & Date		Janji 25/12/14	

Janji 25/12/14

Reviewed by (Engineer-CNC)

Manager-CNC