



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

9255

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	13157 ✓	60/66
2.	Visual Inspection	OK - 3.5 mm CS-Subbed	longer 9136 B
3.	Pellet Die No.	13941	07-OK
4.	Hardened by	huk finny	Relief OK
5.	Received by after hardening (Name)	Janji	(4-4) > 13 mm
6.	Hardness achieved on 1 st side	50.0-50.1 HRC	Relief 4.0, 6 mm
7.	Hardness achieved on 2 nd side	49.3-50.0 HRC	Counter OK
8.	Ovality after hardening 1 st side	(1.9) mm	Recounter } P.D. 970 mm
9.	Ovality after hardening 2 nd side	(1.1) mm	due to ovality } Tapping M24
10.	Outside Diameter	1032 mm	Deep - 36.9
11.	Inside Diameter	900 mm	Tapping M24
12.	Width of die	375 mm	Mold - 15
Inspected By (Sign) & Date		Janji 26/12/14	
1.	Finish Fitting size 1 st side	1030 ± 0.04-0.09 mm Taper 3°	286+ Both sid.
2.	Finish Fitting size 2 nd side	1030 ± 0.08 7.12 mm Taper 0.3°	32 x 7.5 mm
3.	Finish size made by		
Inspected By (Sign) & Date		Janji 26/12/14	
1.	Supplied to (Customer Name)	Sachu ferrary Telangana	
2.	Dispatch Date		
Reported By (Sign) & Date		Janji 26/12/14	

Janji 27/12/14

Reviewed by (Engineer-CNC)

Manager-CNC