



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

9760

| S.No. | Check Parameter | Specification Observations | Remarks |
|----------------------------|--|-----------------------------------|------------------|
| 1. | Work order No. | 13142 | 40150 |
| 2. | Visual Inspection | OK - 4.0 mm (J&W) | Depth 450 B |
| 3. | Pellet Die No. | 13156 | UT-OK |
| 4. | Hardened by | hark finny | Relief-OK |
| 5. | Received by after hardening (Name) | Janjan | (3-3) 3 14 mm |
| 6. | Hardness achieved on 1 st side | 49.7 - 50.0 HRc ✓ | Relief 4-5 10 mm |
| 7. | Hardness achieved on 2 nd side | 49.2 - 49.7 HRc ⓐ | Cam for-OK |
| 8. | Ovality after hardening 1 st side | (0.8) mm ⓐ | Per - 585 mm |
| 9. | Ovality after hardening 2 nd side | (0.5) mm ✓ | Tapping 120 |
| 10. | Outside Diameter | 730 mm | Deep 18-6 mm |
| 11. | Inside Diameter | 630 mm | Tapping 140 |
| 12. | Width of die | 290 mm | Holes - 16 |
| Inspected By (Sign) & Date | | Janjan 27/12/14 | |
| 1. | Finish Fitting size 1 st side | 740.5 ± 0.02 - 0.03 mm Tapper 10° | Undercut = 5 mm |
| 2. | Finish Fitting size 2 nd side | 740.5 ± 0.04 - 0.05 mm Tapper 10° | |
| 3. | Finish size made by | | |
| Inspected By (Sign) & Date | | Janjan 27/12/14 | |
| 1. | Supplied to (Customer Name) | T.D. Arora, PB | |
| 2. | Dispatch Date | | |
| Reported By (Sign) & Date | | Janjan 27/12/14 | |

Sats 28/12/14

Reviewed by (Engineer-CNC)

Manager-CNC