



Lark Engineering Company (India) Pvt. Ltd.

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

9791

Form No.

CNC/QA/FM/03

Rev. No.

01

Final Inspection (Pellet Dies) after Hardening & Finishing

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	13484	28/38/66
2.	Visual Inspection	OK - 60 mm (M-dumb)	no 3 Drgt 609AB
3.	Pellet Die No.	13927	VT-die
4.	Hardened by	Lark Finery	Relief die
5.	Received by after hardening (Name)	Janjari	OK 3.38 mm
6.	Hardness achieved on 1 st side	49.2 - 50.0 HRC	47.0 28 mm
7.	Hardness achieved on 2 nd side	49.7 - 50.1 HRC	Counter - ok
8.	Ovality after hardening 1 st side	(0.5) mm	PO - 619 mm
9.	Ovality after hardening 2 nd side	(0.2) mm	Tapping M16
10.	Outside Diameter	620 mm	Deep - 31.6 mm
11.	Inside Diameter	548.4 ± 0.2 ± 0.10 ± 0.07 ± 0.08 mm	Tapping Hoop
12.	Width of die	195 mm	Hobs - 2
Inspected By (Sign) & Date		Janjar 28/12/14	
1.	Finish Fitting size 1 st side	690 ± 0.12 ± 0.12 mm Tapper 8°	Undercut - 1 mm
2.	Finish Fitting size 2 nd side	690 ± 0.10 ± 0.11 mm Tapper 8°	
3.	Finish size made by		
Inspected By (Sign) & Date		Janjar 28/12/14	
1.	Supplied to (Customer Name)	Shru Kanyani Pellets Rajasthan	
2.	Dispatch Date		
Reported By (Sign) & Date		Janjar 28/12/14	

Satya 31/12/14

Reviewed by (Engineer-CNC)

Manager-CNC