



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

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	13494	28/38/66
2.	Visual Inspection	ok - 60 mm (M.umbo)	no 3, Dorgit 60AB
3.	Pellet Die No.	13928	UT-OK
4.	Hardened by	Lark Furnace	Relief-OK
5.	Received by after hardening (Name)	Jain	Ø 6.5 9 38 mm
6.	Hardness achieved on 1 st side	49.4 - 50.1 HRc	Ø 7.0 3 28 mm
7.	Hardness achieved on 2 nd side	49.5 - 49.6 HRc	Concave - OK
8.	Ovality after hardening 1 st side	(0.4) mm	PCD - 619 mm
9.	Ovality after hardening 2 nd side	(0.1) mm	Tapping M16
10.	Outside Diameter	680 mm	Depth = 31.6 mm
11.	Inside Diameter	548.4 ± 0.07 to 0.08 ± 0.02 to 0.03 mm	Tapping Holes
12.	Width of die	195 mm	Holes - 2
Inspected By (Sign) & Date		Jain 28/12/14	
1.	Finish Fitting size 1 st side	690 ± 0.07 to 0.08 mm Tapper 8°	Undercut = 1 mm
2.	Finish Fitting size 2 nd side	690 ± 0.07 to 0.07 mm Tapper 8°	
3.	Finish size made by		
Inspected By (Sign) & Date		Jain 28/12/14	
1.	Supplied to (Customer Name)	Shri Kasturi Pellet, Rajasthan	
2.	Dispatch Date		
Reported By (Sign) & Date		Jain 28/12/14	

Satyam
31/12/14

Reviewed by (Engineer-CNC)

Manager-CNC