



# Lark Engineering Company (India) Pvt. Ltd.

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

9780

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.	13218 to 13671	50/66
2.	Visual Inspection	OK - $\phi$ 0 mm CM-subd	208 Dmg to 320 AB
3.	Pellet Die No.	13633	UT-OK
4.	Hardened by	herk, fenny	Relief-OK
5.	Received by after hardening (Name)	Jayin	$\phi$ 9.0 $\pm$ 16 mm
6.	Hardness achieved on 1 <sup>st</sup> side	49.7 - 50.0 HRC	All
7.	Hardness achieved on 2 <sup>nd</sup> side	49.2 - 49.5 HRC	Counter-OK
8.	Ovality after hardening 1 <sup>st</sup> side	(0-4) mm	$\phi$ 619 mm
9.	Ovality after hardening 2 <sup>nd</sup> side	(0-2) mm	Tapping M16
10.	Outside Diameter	680-1 mm	Deep - 31.4 mm
11.	Inside Diameter	549. $\pm$ 1.10 $\pm$ 1.10 $\pm$ 0.8 $\pm$ 1.10 mm	Tapping M20
12.	Width of die	195 mm	file 2
Inspected By (Sign) & Date		Jayin 30/12/14	
1.	Finish Fitting size 1 <sup>st</sup> side	690-1 $\pm$ .12 $\pm$ .12 mm Tappin 8°	
2.	Finish Fitting size 2 <sup>nd</sup> side	690-1 $\pm$ .12 $\pm$ .12 mm Tappin 8°	
3.	Finish size made by		
Inspected By (Sign) & Date		Jayin 30/12/14	
1.	Supplied to (Customer Name)	White hotels, Maharashtra, to Dueskesh, byjorai	
2.	Dispatch Date		
Reported By (Sign) & Date		Jayin 30/12/14	

Sat 30  
31/12/14

Reviewed by (Engineer-CNC)

Manager-CNC