



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.		12636	60/70 New
2.	Visual Inspection		ok - 3.5 mm (S. Jumbo)	Done - 86/AB
3.	Pellet Die No.		14038	VT-ak
4.	Hardened by		Lark New furnace	Relief - ak
5.	Received by after hardening (Name)		Janji	17 mm
6.	Hardness achieved on 1 st side		52.5 - 53.1 HRC	Relief 4.0 10 mm
7.	Hardness achieved on 2 nd side		51.1 - 51.6 HRC	RP - Counter - ak
8.	Ovality after hardening 1 st side		(1.4) mm [Die is Re counter]	PO - 970 mm
9.	Ovality after hardening 2 nd side		(1.6) mm [due to ovality]	Tapping M24
10.	Outside Diameter		1042 mm	Deep - 35.8 mm
11.	Inside Diameter		900 mm	Tapping M24
12.	Width of die		375 mm	Hole - 15
Inspected By (Sign) & Date		Janji 31/7/13		
1.	Finish Fitting size 1 st side	1030 ± .10 ± .12 mm Tapper 3°		2 Slot = 32x7.5
2.	Finish Fitting size 2 nd side	1030 ± .10 ± .10 mm Tapper 3°		32x7.7 mm
3.	Finish size made by			
Inspected By (Sign) & Date		Janji 31/7/13		
1.	Supplied to (Customer Name)	Sneha for my A.P		
2.	Dispatch Date			
Reported By (Sign) & Date		Janji 31/7/13		

Janji 31/7/13

Reviewed by (Engineer-CNC)

Manager-CNC