



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.	13157	60/66
2.	Visual Inspection	OK - 3.5 mm (S. Jumbo)	Sheet 9136
3.	Pellet Die No.	13942 ✓	DT-01
4.	Hardened by	Lark Furnace	Relief - OK
5.	Received by after hardening (Name)	Jaybir	(4-4) → 13mm
6.	Hardness achieved on 1 st side	50.2 - 51.0 HRC	Relief 4.0 6mm
7.	Hardness achieved on 2 nd side	51.0 - 51.3 HRC ✓	Re-counter - OK
8.	Ovality after hardening 1 st side	(1.6) mm [die is re-counter]	PCD - 97.0 mm
9.	Ovality after hardening 2 nd side	(1.7) mm [due to ovality]	Tapping M24
10.	Outside Diameter	10.32 mm	Deep - 36-4mm
11.	Inside Diameter	9.00 mm	Tapping M16
12.	Width of die	37.5 mm	Holes .15
Inspected By (Sign) & Date		Jaybir 31/7/13	
1.	Finish Fitting size 1 st side	1030 φ - 0.12 mm Tapper 3'	2 flat Both side
2.	Finish Fitting size 2 nd side	1030 φ .08 1.12 mm Tapper 3'	32-X 7.5 mm
3.	Finish size made by		
Inspected By (Sign) & Date		Jaybir 31/7/13	
1.	Supplied to (Customer Name)	Saneha, Telangana	
2.	Dispatch Date		
Reported By (Sign) & Date		Jaybir 31/7/13	

Reviewed by (Engineer-CNC)
Sats 31/7/13

Manager-CNC