



# Lark Engineering Company (India) Pvt. Ltd.

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

10048

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.		To do 14045	39/10
2.	Visual Inspection		ok - 3.0 mm (SS20)	me 3380 AD
3.	Pellet Die No.		13727	UT-ak
4.	Hardened by		huk Pinnus	Relief - ak
5.	Received by after hardening (Name)		Jaijiv	(3-3) 17mm
6.	Hardness achieved on 1 <sup>st</sup> side		50-2-10-4 HR	11mm
7.	Hardness achieved on 2 <sup>nd</sup> side		99.4-49-6 HR	Counter - ak
8.	Ovality after hardening 1 <sup>st</sup> side		(0.4) mm	Relief - ak
9.	Ovality after hardening 2 <sup>nd</sup> side		(0.7) mm	Counter - ak
10.	Outside Diameter		620 mm	PCD - 565 mm
11.	Inside Diameter		520 mm	Tapping M20
12.	Width of die		222 mm	Deep 18-6 mm
Inspected By (Sign) & Date		Jaijiv 12/25		Tapping M20
1.	Finish Fitting size 1 <sup>st</sup> side		618.5 ± 0.05 ± 0.05 mm Tapper 12°	Hole - 12
2.	Finish Fitting size 2 <sup>nd</sup> side		618.5 ± 0.04 ± 0.05 mm Tapper 12°	
3.	Finish size made by			
Inspected By (Sign) & Date		Jaijiv 12/25		
1.	Supplied to (Customer Name)	To do Horizon freeze U.S		
2.	Dispatch Date			
Reported By (Sign) & Date		Jaijiv 12/25		

Satyam 12/25

Reviewed by (Engineer-CNC)

Manager-CNC