

10253



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.		14251	36110
2.	Visual Inspection		OK - 4-5 mm (M-Sumber)	Ph w Dmg rt - 493AB
3.	Pellet Die No.		13559	UT-OK
4.	Hardened by		Lark Perrow	Relief - OK
5.	Received by after hardening (Name)		Janju	(3-3) 8 13 mm
6.	Hardness achieved on 1 st side		51.1-51.5 HRc	Relief 5-0 5 14 mm
7.	Hardness achieved on 2 nd side		51.1-51.4 HRc	Counter - OK
8.	Ovality after hardening 1 st side		(0.6) mm	RCD - 640 mm
9.	Ovality after hardening 2 nd side		(0.5) mm	Tapping M20
10.	Outside Diameter		700 mm	Deep 18-6 mm
11.	Inside Diameter		600 mm	Tapping M6 cap
12.	Width of die		222 mm	Holes - 12
Inspected By (Sign) & Date		Janju 28/2/15		
1.	Finish Fitting size 1 st side	690 ± 0.2 ± 0.9 mm Tapper 12°		
2.	Finish Fitting size 2 nd side	690 ± 0.12 ± 0.12 mm Tapper 12°		
3.	Finish size made by	_____		
Inspected By (Sign) & Date		Janju 28/2/15		
1.	Supplied to (Customer Name)	Meharney Agritech, U.P.		
2.	Dispatch Date	_____		
Reported By (Sign) & Date		Janju 28/2/15		

Janju 28/2/15

Reviewed by (Engineer-CNC)

Manager-CNC