



Lark Engineering Company (India) Pvt. Ltd.

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

Form No.

14582

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.	14978 14735	66/66
2.	Visual Inspection	OK - 12.0 mm (M. Jumbo)	no. 3 Dmg to - 609 AB
3.	Pellet Die No.	14978	UT-OK
4.	Hardened by	hards Runny	Relief - OK
5.	Received by after hardening (Name)	Jangir	3 M14
6.	Hardness achieved on 1 st side	51.6 - 51.9 HRC	THI
7.	Hardness achieved on 2 nd side	51.4 - 51.8 HRC	Coarse fin - OK
8.	Ovality after hardening 1 st side	(0.4) mm	PCD - 619 mm
9.	Ovality after hardening 2 nd side	(0.5) mm	Tapping M16
10.	Outside Diameter	680 mm	Deep - 31.4 mm
11.	Inside Diameter	548.4 $\pm$ 0.10 $\pm$ 0.12 - 548.4 $\pm$ 0.14 $\pm$ 0.12 mm	Tapping No. of
12.	Width of die	195 mm	Holes - 2
Inspected By (Sign) & Date		Jangir 28/4/15	
1.	Finish Fitting size 1 st side	690 $\pm$ 0.10 - 690 $\pm$ 0.11 Tapper 8°	Undercut - 1 mm
2.	Finish Fitting size 2 nd side	690 $\pm$ 0.10 - 690 $\pm$ 0.10 Tapper 8°	
3.	Finish size made by		
Inspected By (Sign) & Date		Jangir 28/4/15	
1.	Supplied to (Customer Name)	Shubh Engg - Rajasthan	
2.	Dispatch Date		
Reported By (Sign) & Date		Jangir 28/4/15	

Satya 28/4/15.

Reviewed by (Engineer-CNC)

Manager-CNC

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