



Lark Engineering Company (India) Pvt. Ltd.

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

14789

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.		55/55
2.	Visual Inspection	15004 ✓	Re-co 14924 ✓
3.	Pellet Die No.	OK - 4.0 mm (SSW)	UT-OK
4.	Hardened by	14049 ✓ Lark Finney	Relief - OK
5.	Received by after hardening (Name)	Jain	(33) 5 mm
6.	Hardness achieved on 1 st side	49.6 - 49.9 HRC	Relief 4-5
7.	Hardness achieved on 2 nd side	50.1 - 50.3 HRC	Re-Grinding - OK
8.	Ovality after hardening 1 st side	(1.7) mm [Die Recounter]	PCD - 585 mm
9.	Ovality after hardening 2 nd side	(1.8) mm [due to ovality]	Tapping M20
10.	Outside Diameter	630 mm	Deep - 18-6 mm
11.	Inside Diameter	520 mm	Tapping H&C
12.	Width of die	222 mm	H&C - 12 ✓
Inspected By (Sign) & Date		Jain 26/5/15	
1.	Finish Fitting size 1 st side	610 ± 0.05 → 610 ± 0.05 mm	
2.	Finish Fitting size 2 nd side	610 ± 0.04 → 610 ± 0.05 mm	
3.	Finish size made by		
Inspected By (Sign) & Date		Jain 26/5/15	
1.	Supplied to (Customer Name)	Sampurna Tech, Haryana	
2.	Dispatch Date		
Reported By (Sign) & Date		Jain 26/5/15	

100K2 - CW/PINK

Sain 26/5/15

Reviewed by (Engineer-CNC)

Manager-CNC