



Lark Engineering Company (India) Pvt. Ltd.

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

14956

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.	15189	45/10
2.	Visual Inspection	OK - 5.0 mm (Scan)	Drill - 9980
3.	Pellet Die No.	14238	UT-OK
4.	Hardened by	Work Order	Relief - OK
5.	Received by after hardening (Name)	Janji	(3-3) 2 10mm
6.	Hardness achieved on 1 st side	49.0 - 49.3 HRc	5 5mm
7.	Hardness achieved on 2 nd side	48.1 - 49.0 HRc	Center - OK
8.	Ovality after hardening 1 st side	(0.2) mm	ROD - 565 mm
9.	Ovality after hardening 2 nd side	(0.2) mm	Tapping M20
10.	Outside Diameter	620 mm	Deep - 18.6 mm
11.	Inside Diameter	520 mm	Tapping 10 af
12.	Width of die	222 mm	Hole - 8 12
Inspected By (Sign) & Date		Janji 19/6/15	
1.	Finish Fitting size 1 st side	618.5 ± 0.05 - 618.5 ± 0.05 Tapper 12°	
2.	Finish Fitting size 2 nd side	618.5 ± 0.04 - 618.5 ± 0.05 Tapper 12°	
3.	Finish size made by		
Inspected By (Sign) & Date		Janji 19/6/15	
1.	Supplied to (Customer Name)	Esman Industries, PO	
2.	Dispatch Date		
Reported By (Sign) & Date		Janji 19/6/15	

Satya 19/6/15

Reviewed by (Engineer-CNC)

Manager-CNC

100x2 - CW/PHK