



# Lark Engineering Company (India) Pvt. Ltd.

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

15086

Form No.

CNC/QA/FM/03

Rev. No.

01

Rev. Date

31-07-2013

## Final Inspection (Pellet Dies) after Hardening & Finishing

| S.No.                      | Check Paramotor                              | Specification<br>Observations   | Remarks                   |
|----------------------------|----------------------------------------------|---------------------------------|---------------------------|
| 1.                         | Work rder No.                                | 15356                           | 45/10                     |
| 2.                         | Visual Inspection                            | ok - 6.0 mm (Series)            | h                         |
| 3.                         | Pellet Die No.                               | 15308                           | Edg Ho - 13760 AB         |
| 4.                         | Hardened by                                  | Lark Finney                     | UT-OK                     |
| 5.                         | Received by after hardening (Name)           | Janji                           | Relief-OK                 |
| 6.                         | Hardness achieved on 1 <sup>st</sup> side    | 48.8 - 49.5 HR <sub>C</sub> (R) | (2-2) 3 11 mm             |
| 7.                         | Hardness achieved on 2 <sup>nd</sup> side    | 48.6 - 49.9 HR <sub>C</sub> (R) | Relief of 6.5 5 5 mm      |
| 8.                         | Ovality after hardening 1 <sup>st</sup> side | (0.2) mm                        | Counter-OK                |
| 9.                         | Ovality after hardening 2 <sup>nd</sup> side | (0.1) mm                        | PCD - 454 mm              |
| 10.                        | Outside Diameter                             | 520 mm                          | Tapping 120               |
| 11.                        | Inside Diameter                              | 420 mm                          | Deep - 16.6 mm            |
| 12.                        | Width of die                                 | 158 mm                          | Tapping Ho of Holes - 8 ✓ |
| Inspected By (Sign) & Date |                                              | Janji 21/7/15                   |                           |
| 1.                         | Finish Fitting size 1 <sup>st</sup> side     | 489 ± 0.03 - 489 ± 0.04 mm      |                           |
| 2.                         | Finish Fitting size 2 <sup>nd</sup> side     | 489 ± 0.03 - 489 ± 0.03 mm      |                           |
| 3.                         | Finish size made by                          |                                 |                           |
| Inspected By (Sign) & Date |                                              | Janji 21/7/15                   |                           |
| 1.                         | Supplied to (Customer Name)                  | ADZ Group, V.P.                 |                           |
| 2.                         | Dispatch Date                                |                                 |                           |
| Reported By (Sign) & Date  |                                              | Janji 21/7/15                   |                           |

Satish 21/7/15

Reviewed by (Engineer-CNC)

Manager-CNC

100x2 - CWP/PINK