



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 (Pollet Dies) after Hardening & Finishing

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	15229	33138
2.	Visual Inspection	OK - 3.0 mm (MJEW)	Depth - 935 A
3.	Pellet Die No.	14609	U7-OK
4.	Hardened by	hark. Pinner	Relief - OK
5.	Received by after hardening (Name)	J. J. J.	(3-3) 2 15 m
6.	Hardness achieved on 1 st side	49.5 - 55.2 HRC	Relief 3-5 3 HRC
7.	Hardness achieved on 2 nd side	49.7 - 49.8 HRC	Re-counter - OK
8.	Ovality after hardening 1 st side	(0.8) mm	die is Re-counter
9.	Ovality after hardening 2 nd side	(1.5) mm	due to ovality.
10.	Outside Diameter	676 mm	PCD - 640 mm
11.	Inside Diameter	600 mm	Tapping H2O
12.	Width of die	265 mm	Deep - 18.5 mm
Inspected By (Sign) & Date		J. J. J. 15/3/12	Tapping H2O
1.	Finish Fitting size 1 st side	690 ± 0.5 - 690 ± 0.5 mm	Under ut. 7 mm
2.	Finish Fitting size 2 nd side	690 ± 0.4 - 690 ± 0.5 mm	
3.	Finish size made by		
Inspected By (Sign) & Date		J. J. J. 15/3/12	
1.	Supplied to (Customer Name)	Sager fresh, Nepal	
2.	Dispatch Date		
Reported By (Sign) & Date		J. J. J. 15/3/12	

Satbir
15/7/13

Reviewed by (Engineer-CNC)

Manager-CNC

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