



Lark Engineering Company (India) Pvt. Ltd.

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

15159

Form No. CNC/QA/FM/03

Rev. No. 01

Rev. Date 31-07-2013

Final Inspection (Pollot Dies) after Hardening & Finishing

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	15388	36145
2.	Visual Inspection	OK - 3.0 mm (SSC)	Rev 1
3.	Pellet Die No.	12904	579
4.	Hardened by	hark perma	UT-OK
5.	Received by after hardening (Name)	Janji	Relief - OK
6.	Hardness achieved on 1 st side	49-7 - 49-8 HRC	(3-3) 3 15mm
7.	Hardness achieved on 2 nd side	49-0 - 49-2 HRC	Relief 9.5 9mm
8.	Ovality after hardening 1 st side	(0.7) mm	Grinding - OK
9.	Ovality after hardening 2 nd side	(0.4) mm	Bed - 56mm
10.	Outside Diameter	610 mm	Tapping M20
11.	Inside Diameter	520 mm	Drill - 18-6 mm
12.	Width of die	222 mm	Tapping M16
Inspected By (Sign) & Date		Janji 18/7/15	Head - 12
1.	Finish Fitting size 1 st side	612.5 ± 0.12 - 612.5 ± 0.12 Taper 4°	Washer - 1.3mm
2.	Finish Fitting size 2 nd side	612.5 ± 0.10 - 612.5 ± 0.11 Taper 4°	
3.	Finish size made by		
Inspected By (Sign) & Date		Janji 18/7/15	
1.	Supplied to (Customer Name)	Suguna feed, WB	
2.	Dispatch Date		
Reported By (Sign) & Date		Janji 18/7/15	

Reviewed by (Engineer-CNC)

Manager-CNC