



# Lark Engineering Company (India) Pvt. Ltd.

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

15191

Form No. CNC/QA/FM/03

Rev. No. 01

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

Rev. Date 31-07-2013

| S.No.                      | Check Parameter                              | Specification<br>Observations    | Remarks                      |
|----------------------------|----------------------------------------------|----------------------------------|------------------------------|
| 1.                         | Work order No.                               | 15189                            | 47/60                        |
| 2.                         | Visual Inspection                            | OK - 8.0 mm (Jumbo)              | me 1343 A                    |
| 3.                         | Pellet Die No.                               | 15941                            | 47-012                       |
| 4.                         | Hardened by                                  | h.c.s. ferris                    | Relief - ok                  |
| 5.                         | Received by after hardening (Name)           | Janji                            | (3) 23 mm                    |
| 6.                         | Hardness achieved on 1 <sup>st</sup> side    | 50.2 - 50.6 HRC                  | Relief 8.5 1.5 mm            |
| 7.                         | Hardness achieved on 2 <sup>nd</sup> side    | 50.7 - 50.8 HRC                  | Relief - Counter - ok        |
| 8.                         | Ovality after hardening 1 <sup>st</sup> side | (1.2) mm                         | Pd - 72 mm                   |
| 9.                         | Ovality after hardening 2 <sup>nd</sup> side | (1.1) mm                         | due to ovality. Tapping 1122 |
| 10.                        | Outside Diameter                             | 780 mm                           | Deep. 28.6 mm                |
| 11.                        | Inside Diameter                              | 660 mm                           | Tapping 1100                 |
| 12.                        | Width of die                                 | 324 mm                           | Hold 12                      |
| Inspected By (Sign) & Date |                                              | Janji 23/7/13                    |                              |
| 1.                         | Finish Fitting size 1 <sup>st</sup> side     | 795 ± 0.10 - 795 ± 0.12 Tappm 4' | Under ut - 8                 |
| 2.                         | Finish Fitting size 2 <sup>nd</sup> side     | 795 ± 0.10 - 795 ± 0.10 Tappm 4' | 7.8                          |
| 3.                         | Finish size made by                          |                                  | 2 slot both side             |
| Inspected By (Sign) & Date |                                              | Janji 23/7/13                    |                              |
| 1.                         | Supplied to (Customer Name)                  | Karnelhemu Cattle's W.P          |                              |
| 2.                         | Dispatch Date                                |                                  |                              |
| Reported By (Sign) & Date  |                                              | Janji 23/7/13                    |                              |

Satya 23/7/13

Reviewed by (Engineer-CNC)

Manager-CNC