



Lark Engineering Company (India) Pvt. Ltd.

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

15239

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.	15478	96/10
2.	Visual Inspection	OK - 4.0 mm (SSSTO)	Length - 369 mm
3.	Pellet Die No.	14724	UT - OK
4.	Hardened by	work furnace	Relief - OK
5.	Received by after hardening (Name)	Jangir	(3-3) 3 18 mm
6.	Hardness achieved on 1 st side	50.0 - 10.1 HRC	Relief 4.5 14 mm
7.	Hardness achieved on 2 nd side	50.0 - 10.0 HRC	Grinding - OK
8.	Ovality after hardening 1 st side	(0.4) mm	ROD - 585 mm
9.	Ovality after hardening 2 nd side	(0.7) mm	Tapping M20
10.	Outside Diameter	620 mm	Deep - 23.4 mm
11.	Inside Diameter	520 mm	Tapping M10 - OK
12.	Width of die	190 mm	Hob - 12
Inspected By (Sign) & Date		Jangir 30/7/15	
1.	Finish Fitting size 1 st side	619.5 ± 0.09 - 619.5 ± 0.10 Tapping 12°	
2.	Finish Fitting size 2 nd side	619.5 ± 0.08 - 619.5 ± 0.08 Tapping 12°	
3.	Finish size made by		
Inspected By (Sign) & Date		Jangir 30/7/15	
1.	Supplied to (Customer Name)	Paras Nutritionals, PB	
2.	Dispatch Date		
Reported By (Sign) & Date		Jangir 30/7/15	

Satish
30/7/15

1002 - CWP/INK

Reviewed by (Engineer-CNC)

Manager-CNC