



Lark Engineering Company (India) Pvt. Ltd.

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

15227

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.	15214 to 15332 + 15561	50/66
2.	Visual Inspection	OK - 8.0 mm (M-Subs)	208
3.	Pellet Die No.	15326	Longer 320 A+B
4.	Hardened by	Lark Furnace	UT-OK
5.	Received by after hardening (Name)	Janji	Relief-OK
6.	Hardness achieved on 1 st side	51.9 - 52.3 HRC	Ø 90 ± 16 mm
7.	Hardness achieved on 2 nd side	50.1 - 50.2 HRC	All
8.	Ovality after hardening 1 st side	(0.2) mm	Gauge-OK
9.	Ovality after hardening 2 nd side	(0.5) mm	PCD - 619 mm
10.	Outside Diameter	680.1 mm	Tapping M16
11.	Inside Diameter	548.1 ± 0.8 ± 0.12 - 548.1 ± 0.8 ± 0.14 mm	Deep - 31.6 mm
12.	Width of die	195 mm	Tapping No. of Holes = 2
Inspected By (Sign) & Date		Janji 28/7/15	
1.	Finish Fitting size 1 st side	690.1 ± 0.9 - 690.1 ± 1.0 Tapper 8°	
2.	Finish Fitting size 2 nd side	690.1 ± 1.0 - 690.1 ± 1.2 Tapper 8°	
3.	Finish size made by		
Inspected By (Sign) & Date		Janji 28/7/15	
1.	Supplied to (Customer Name)	Yulong, HR to Bhushya, Rajasthan to Provey, Rajasthan	
2.	Dispatch Date		
Reported By (Sign) & Date		Janji 28/7/15	

Satish 28/7/15

Reviewed by (Engineer-CNC)

Manager-CNC

1002 - CHF/PK