



# 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 (Pellet Dies) after Hardening & Finishing

| S.No.                      | Check Parameter                              | Specification<br>Observations    | Remarks         |
|----------------------------|----------------------------------------------|----------------------------------|-----------------|
| 1.                         | Work order No.                               | 15447                            | 40/50           |
| 2.                         | Visual Inspection                            | ok - 3.5 mm (SS57D)              | Double - check  |
| 3.                         | Pellet Die No.                               | 14319                            | 127-OK          |
| 4.                         | Hardened by                                  | Work Party                       | Relief - OK     |
| 5.                         | Received by after hardening (Name)           | Jangin                           | (3-3) 8 17mm    |
| 6.                         | Hardness achieved on 1 <sup>st</sup> side    | 51.1 - 51.3 HRC                  | Relief 4-0 10mm |
| 7.                         | Hardness achieved on 2 <sup>nd</sup> side    | 51.1 - 51.6 HRC                  | Counter - OK    |
| 8.                         | Ovality after hardening 1 <sup>st</sup> side | (0.4) mm                         | PCD - 565mm     |
| 9.                         | Ovality after hardening 2 <sup>nd</sup> side | (0.2) mm                         | Tapping M20     |
| 10.                        | Outside Diameter                             | 620 mm                           | Deep - 18-4mm   |
| 11.                        | Inside Diameter                              | 520 mm                           | Tapping M10     |
| 12.                        | Width of die                                 | 186 mm                           | Hole - 12       |
| Inspected By (Sign) & Date |                                              | Jangin 6/8/15                    |                 |
| 1.                         | Finish Fitting size 1 <sup>st</sup> side     | 610 $\pm 0.3$ - 610 $\pm 0.3$ mm |                 |
| 2.                         | Finish Fitting size 2 <sup>nd</sup> side     | 610 $\pm 0.3$ - 610 $\pm 0.5$ mm |                 |
| 3.                         | Finish size made by                          |                                  |                 |
| Inspected By (Sign) & Date |                                              | Jangin 6/8/15                    |                 |
| 1.                         | Supplied to (Customer Name)                  | Sri Srinivasa Perum, A.P.        |                 |
| 2.                         | Dispatch Date                                |                                  |                 |
| Reported By (Sign) & Date  |                                              | Jangin 6/8/15                    |                 |

Satish  
6/8/15

Reviewed by (Engineer-CNC)

Manager-CNC