



Lark Engineering Company (India) Pvt. Ltd.

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

15280

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.	15623	62/66
2.	Visual Inspection	OK - 9.0 mm (M-dubbe)	Mo3 609A+H
3.	Pellet Die No.	15549	UT-06
4.	Hardened by	Lark Permy	Relief - OK
5.	Received by after hardening (Name)	Janji	Ø10.0 ± 0.05
6.	Hardness achieved on 1 st side	51.0 - 51.2 HRC	Self
7.	Hardness achieved on 2 nd side	60.5 - 60.7 HRC	Example - OK
8.	Ovality after hardening 1 st side	(0.3) mm	PCD - 619 mm
9.	Ovality after hardening 2 nd side	(0.4) mm	Tapping M16
10.	Outside Diameter	680 mm	Deep - 31.6 mm
11.	Inside Diameter	548.4 ± 0.4 ± 0.06 → 548.4 ± 0.4 ± 0.07	Tapping M16
12.	Width of die	195 mm	Hess - 2
Inspected By (Sign) & Date		Janji 22/8/15	
1.	Finish Fitting size 1 st side	690 ± 0.09 - 690 ± 0.10 Tapper 8°	Undercut - 1 mm
2.	Finish Fitting size 2 nd side	690 ± 0.09 - 690 ± 0.09 Tapper 8°	
3.	Finish size made by		
Inspected By (Sign) & Date		Janji 22/8/15	
1.	Supplied to (Customer Name)	Ssc Biomass Green Haryana	
2.	Dispatch Date		
Reported By (Sign) & Date		Janji 22/8/15	

Ssc
22/8/15

Reviewed by (Engineer-CNC)

Manager-CNC

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