



Lark Engineering Company (India) Pvt. Ltd.

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

15379

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.	15892	25/8/13
2.	Visual Inspection	OK - 6-0 mm (81.4mm)	no 8
3.	Pellet Die No.	15568	Done at 320 A
4.	Hardened by	hark from	OT-06
5.	Received by after hardening (Name)	Janji	Relief - OK
6.	Hardness achieved on 1 st side	49.8 - 10.1 HRC	φ 7-0 > 41 mm
7.	Hardness achieved on 2 nd side	50.1 - 10.1 HRC	S. Ref
8.	Ovality after hardening 1 st side	0.5 mm	Counter - OK
9.	Ovality after hardening 2 nd side	0.87 mm	PM - 619 mm
10.	Outside Diameter	680.1 mm	Tapping M16
11.	Inside Diameter	548.1 ± 0.5 ± 0.6 - 548.1 ± 0.5 ± 0.7 mm	Deep - 31.2 mm
12.	Width of die	195 mm	Tapping M16 of
	Inspected By (Sign) & Date	Janji 22/8/13	Hole - 2
1.	Finish Fitting size 1 st side	690.1 ± 0.8 - 690.1 ± 0.9 Tappet 8°	
2.	Finish Fitting size 2 nd side	690.1 ± 0.9 - 690.1 ± 1.0 Tappet 8°	
3.	Finish size made by		
	Inspected By (Sign) & Date	Janji 22/8/13	
1.	Supplied to (Customer Name)	Ba-ga-Va Rifles, Keramatak	
2.	Dispatch Date		
	Reported By (Sign) & Date	Janji 22/8/13	

Satya
22/8/13

Reviewed by (Engineer-CNC)

Manager-CNC