



# 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

15472

| S.No. | Check Parameter                              | Specification Observations            | Remarks         |
|-------|----------------------------------------------|---------------------------------------|-----------------|
| 1.    | Work order No.                               | 15860                                 | 30140/66        |
| 2.    | Visual Inspection                            | ok - 6.0 mm (M-Jumbo)                 | no 3            |
| 3.    | Pellet Die No.                               | 15561                                 | Dog - 699A      |
| 4.    | Hardened by                                  | hank Penny                            | UT-OK           |
| 5.    | Received by after hardening (Name)           | Janji                                 | Reluf - ok      |
| 6.    | Hardness achieved on 1 <sup>st</sup> side    | 50.3 - 50.4 HRC                       | φ 6.5 S 36 mm   |
| 7.    | Hardness achieved on 2 <sup>nd</sup> side    | 50.0 - 50.6 HRC                       | φ 7.0 S 26 mm   |
| 8.    | Ovality after hardening 1 <sup>st</sup> side | (0.6) mm                              | Geometry - ok   |
| 9.    | Ovality after hardening 2 <sup>nd</sup> side | (0.4) mm                              | PCD - 619 mm    |
| 10.   | Outside Diameter                             | 680                                   | Tapping M16     |
| 11.   | Inside Diameter                              | 548.4 ± 0.7 ± 0.8 - 548.4 ± 0.8 ± 0.8 | Deep - 31.6 mm  |
| 12.   | Width of die                                 | 194.8 mm                              | Tapping No of   |
|       | Inspected By (Sign) & Date                   | Janji 8/9/15                          | Tool - 2        |
| 1.    | Finish Fitting size 1 <sup>st</sup> side     | 690 ± 0.7 - 690 ± 0.8 Tappet 8°       | Undercut - 1 mm |
| 2.    | Finish Fitting size 2 <sup>nd</sup> side     | 690 ± 0.5 - 690 ± 0.7 Tappet 8°       |                 |
| 3.    | Finish size made by                          |                                       |                 |
|       | Inspected By (Sign) & Date                   | Janji 8/9/15                          |                 |
| 1.    | Supplied to (Customer Name)                  | Mohit Ind. Rajasthan                  |                 |
| 2.    | Dispatch Date                                |                                       |                 |
|       | Reported By (Sign) & Date                    | Janji 8/9/15                          |                 |

1002 - CWP/PMK

Reviewed by (Engineer-CNC)

Manager-CNC