



Lark Engineering Company (India) Pvt. Ltd.

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

15490

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.	15870	32/45/55
2.	Visual Inspection	OK - 4.0 mm (M. Subbe)	Drill to 4.07 A to 4.07
3.	Pellet Die No.	15480	07-OK
4.	Hardened by	Lark Finny	Relief - OK
5.	Received by after hardening (Name)	Jayji	φ 4.6 ± 0.23 mm
6.	Hardness achieved on 1 st side	50.1 - 50.3 HRC	φ 5.0 1.0 mm
7.	Hardness achieved on 2 nd side	49.7 - 50.0 HRC	6.0 mm - OK
8.	Ovality after hardening 1 st side	(0.6) mm	PCD - 640 mm
9.	Ovality after hardening 2 nd side	(0.6) mm	Tapping 120
10.	Outside Diameter	710 mm	Deep - 18.4 mm
11.	Inside Diameter	600 mm	Tapping 10.5 mm
12.	Width of die	222 mm	Holes - 12
Inspected By (Sign) & Date		Jayji 11/9/15	
1.	Finish Fitting size 1 st side	690 ± 0.12 - 690 ± 0.12 Tapper 12°	Final size check
2.	Finish Fitting size 2 nd side	690 ± 0.12 - 690 ± 0.12 Tapper 12°	by - Sandeep Singh
3.	Finish size made by		Heeth - ap
Inspected By (Sign) & Date		Jayji 11/9/15	848 mm
1.	Supplied to (Customer Name)	Heritage Lubricant, A.P	
2.	Dispatch Date		
Reported By (Sign) & Date		Jayji 11/9/15	

Satya 11/9/15

Reviewed by (Engineer-CNC)

Manager-CNC

10002 - CWP/PHK