



Lark Engineering Company (India) Pvt. Ltd.

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

15862

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.	15817	36/55
2.	Visual Inspection	ok - 4.0 mm (Jumbo)	100
3.	Pellet Die No.	16386	Don't do - 1315/19
4.	Hardened by	hark permy	UT-OK
5.	Received by after hardening (Name)	Janji	Relief ok
6.	Hardness achieved on 1 st side	51.2 - 51.5 HRC	(3-3) 21 mm
7.	Hardness achieved on 2 nd side	50.1 - 50.2 HRC	Relief 4.5 1.9 mm
8.	Ovality after hardening 1 st side	(0.4) mm	Gumby - ok
9.	Ovality after hardening 2 nd side	(0.4) mm	PCD - 730 mm
10.	Outside Diameter	785 mm	Tapping M20
11.	Inside Diameter	675 mm	Deep - 37.8 mm
12.	Width of die	410 mm	Tapping 10 of Hole - 12
Inspected By (Sign) & Date		Janji 20/9/15	
1.	Finish Fitting size 1 st side	802.5 ± .10	Undercut - 14.5 mm
2.	Finish Fitting size 2 nd side	802.5 ± .10	2 slot both side
3.	Finish size made by		30X40 mm
Inspected By (Sign) & Date		Janji 20/9/15	Final size check
1.	Supplied to (Customer Name)	Paras Nutritionals, HR	by - Sandeep
2.	Dispatch Date		
Reported By (Sign) & Date		Janji 20/9/15	

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Reviewed by (Engineer-CNC)

Manager-CNC