



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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

| S.No.                      | Check Parameter                              | Specification<br>Observations          | Remarks         |
|----------------------------|----------------------------------------------|----------------------------------------|-----------------|
| 1.                         | Work order No.                               | 15995                                  | 30/10           |
| 2.                         | Visual Inspection                            | OK - 3.5 mm (SS&W)                     | 30/10           |
| 3.                         | Pellet Die No.                               | 15137                                  | U7-OK           |
| 4.                         | Hardened by                                  | Lark Finer                             | Relaf - OK      |
| 5.                         | Received by after hardening (Name)           | J. Singh                               | (3-3) 3 23 mm   |
| 6.                         | Hardness achieved on 1 <sup>st</sup> side    | 51.4 - 52.2 HR                         | Relaf 4.0 20 mm |
| 7.                         | Hardness achieved on 2 <sup>nd</sup> side    | 48.4 - 49.8 HR                         | Gumfu - OK      |
| 8.                         | Ovality after hardening 1 <sup>st</sup> side | (0.2) mm                               | Relaf - 565 mm  |
| 9.                         | Ovality after hardening 2 <sup>nd</sup> side | (0.5) mm                               | Tapping map     |
| 10.                        | Outside Diameter                             | 620 mm                                 | Deep - 18.5 mm  |
| 11.                        | Inside Diameter                              | 520 mm                                 | Tapping Hoef    |
| 12.                        | Width of die                                 | 992 mm                                 | Hals - 12 -     |
| Inspected By (Sign) & Date |                                              | J. Singh 25/9/15                       |                 |
| 1.                         | Finish Fitting size 1 <sup>st</sup> side     | 618.5 ± 0.05 - 618.5 ± 0.04 Tappin 12° |                 |
| 2.                         | Finish Fitting size 2 <sup>nd</sup> side     | 618.5 ± 0.04 - 618.5 ± 0.05 Tappin 12° |                 |
| 3.                         | Finish size made by                          |                                        |                 |
| Inspected By (Sign) & Date |                                              | J. Singh 25/9/15                       |                 |
| 1.                         | Supplied to (Customer Name)                  | Vaibhaw Poultry, HR                    |                 |
| 2.                         | Dispatch Date                                |                                        |                 |
| Reported By (Sign) & Date  |                                              | J. Singh 25/9/15                       |                 |

Reviewed by (Engineer-CNC)

Manager-CNC