



Lark Engineering Company (India) Pvt. Ltd.

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

Form No.

15647
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.	15924	28/55
2.	Visual Inspection	ok - 3.5 mm (SSCW)	14951/14
3.	Pellet Die No.	12391	UT-01
4.	Hardened by	Lark Penary	Relief - ok
5.	Received by after hardening (Name)	Jangir	(3-3) 30 mm
6.	Hardness achieved on 1 st side	51.7 - 52.2 HRC	Relief @ 4.0 27 mm
7.	Hardness achieved on 2 nd side	51.3 - 51.8 HRC	Assembly - ok
8.	Ovality after hardening 1 st side	(0.4) mm	PCD - 565 mm
9.	Ovality after hardening 2 nd side	(0.4) mm	Tapping M20
10.	Outside Diameter	630 mm	Depth - 18.4 mm
11.	Inside Diameter	520 mm	Tapping M10
12.	Width of die	222 mm	Holes - 12
Inspected By (Sign) & Date		Jangir 30/9/15	
1.	Finish Fitting size 1 st side	618.5 ± 0.4 - 618.5 ± 0.5 Tappet 12°	
2.	Finish Fitting size 2 nd side	618.5 ± 0.4 - 618.5 ± 0.5 Tappet 12°	
3.	Finish size made by		
Inspected By (Sign) & Date		Jangir 30/9/15	
1.	Supplied to (Customer Name)	Aakashdeep Feeds HR	
2.	Dispatch Date		
Reported By (Sign) & Date		Jangir 30/9/15	

Reviewed by (Engineer-CNC)

Manager-CNC