



Lark Engineering Company (India) Pvt. Ltd.

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

18640

Form No. CNC/QA/FM/03

Rev. No. 01

Rev. Date 31-07-2013

Final Inspection (Pellet Dies) after Hardening & Finishing

S.No.	Check Paramotor	Specification Observations	Remarks
1.	Work order No.		22/32/66
2.	Visual Inspection	16084	23/33/66
3.	Pellet Die No.	OK - 6-0 mm (Mid-throw)	new Dy No 802/16
4.	Hardened by	16260	07-OK
5.	Received by after hardening (Name)	hark funny	Relief - OK
6.	Hardness achieved on 1 st side	52-1-52-2 HRC	Q6.5 244, 43
7.	Hardness achieved on 2 nd side	51-2-51-6 HRC	Q7.0 34, 33
8.	Ovality after hardening 1 st side	(0.2) mm	Center - OK
9.	Ovality after hardening 2 nd side	(0.2) mm	BCD - 6.9 mm
10.	Outside Diameter	680 mm	Tapping M16
11.	Inside Diameter	548.1 ± 0.10 ± 0.10 - 548.1 ± 0.08 ± 0.10 mm	Deep - 30-6 mm
12.	Width of die	195 mm	Tapping No of Holes - 2
Inspected By (Sign) & Date		Jangin 30/9/15	
1.	Finish Fitting size 1 st side	690 ± 0.09 - 690 ± 0.10 Tappies 5°	Under at 1.5
2.	Finish Fitting size 2 nd side	690 ± 0.10 - 690 ± 0.10 Tappies 5°	
3.	Finish size made by		
Inspected By (Sign) & Date		Jangin 20/9/15	
1.	Supplied to (Customer Name)	Modern, Tamilnadu	
2.	Dispatch Date		
Reported By (Sign) & Date		Jangin 30/9/15	

Satyam
30/9/15

Reviewed by (Engineer-CNC)

Manager-CNC