



# Lark Engineering Company (India) Pvt. Ltd.

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

Form No. CNC/QA/FM/03

Rev. No. 01

## Final Inspection (Pellet Dies) after Hardening & Finishing

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	9741	31/07/13
2.	Visual Inspection	OK - 6.0 mm CM (Jumbo)	Done by 377 A-11
3.	Pellet Die No.	10478	07-OK
4.	Hardened by	Kanishk Vaccum	Relief - OK
5.	Received by after hardening (Name)	Jaijir	Φ 6.5 ± 40 mm
6.	Hardness achieved on 1 <sup>st</sup> side	51.5 - 52.0 HR	Φ 7.3 ± 30 mm
7.	Hardness achieved on 2 <sup>nd</sup> side	51.4 - 52.1 HR	Counter - OK 30°
8.	Ovality after hardening 1 <sup>st</sup> side	(.5) mm	PCD - 618 mm
9.	Ovality after hardening 2 <sup>nd</sup> side	(.9) mm	Tapping M16
10.	Outside Diameter	688 mm	Step - 30.6 mm
11.	Inside Diameter	(548.3 ± .00 +.30 +.10 +.35 mm) ⊕	Tapping Hoop
12.	Width of die	215 mm	Holes - 2
Inspected By (Sign) & Date		Jaijir 31/7/13	
1.	Finish Fitting size 1 <sup>st</sup> side	694.8 ± .12 ± .12 mm Taper 5°	
2.	Finish Fitting size 2 <sup>nd</sup> side	694.8 ± .12 ± .12 mm Taper 5°	
3.	Finish size made by		
Inspected By (Sign) & Date		Jaijir 31/7/13	
1.	Supplied to (Customer Name)	Benjamin Industries, Gujarat	
2.	Dispatch Date		
Reported By (Sign) & Date		Jaijir 31/7/13	

Reviewed by (Engineer-CNC)

Manager-CNC