



# 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.                               | 10910                             | 50155                          |
| 2.                         | Visual Inspection                            | OK - 5.0 mm (SSAW)                | Photo<br>Drawing No - 14951A/B |
| 3.                         | Pellet Die No.                               | 11363                             | UT-OK                          |
| 4.                         | Hardened by                                  | heek Perme                        | Relief - OK                    |
| 5.                         | Received by after hardening (Name)           | Jayji                             | (3-3) * 10 mm                  |
| 6.                         | Hardness achieved on 1 <sup>st</sup> side    | 50.0 - 50.1 HRC                   | Relief 5.5 3 5 mm              |
| 7.                         | Hardness achieved on 2 <sup>nd</sup> side    | 49.9 - 49.5 HRC                   | Comper - OK                    |
| 8.                         | Ovality after hardening 1 <sup>st</sup> side | (0.4) mm                          | PCD - 565 mm                   |
| 9.                         | Ovality after hardening 2 <sup>nd</sup> side | (0.3) mm                          | Tapping 120                    |
| 10.                        | Outside Diameter                             | 630 mm                            | Scp - 19 mm                    |
| 11.                        | Inside Diameter                              | 520 mm                            | Tapping Hoeff                  |
| 12.                        | Width of die                                 | 222 mm                            | Holes - 12                     |
| Inspected By (Sign) & Date |  | Jayji 28/12/13                    | /                              |
| 1.                         | Finish Fitting size 1 <sup>st</sup> side     | 618.5 ± 0.03 ± 0.04 mm Tapper 12° |                                |
| 2.                         | Finish Fitting size 2 <sup>nd</sup> side     | 618.5 ± 0.04 ± 0.05 mm Tapper 12° |                                |
| 3.                         | Finish size made by                          |                                   |                                |
| Inspected By (Sign) & Date |  | Jayji 28/12/13                    |                                |
| 1.                         | Supplied to (Customer Name)                  | SRC <del>Country</del> Tamil Nadu |                                |
| 2.                         | Dispatch Date                                |                                   |                                |
| Reported By (Sign) & Date  |  | Jayji 28/12/13                    |                                |

Reviewed by (Engineer-CNC)

Manager-CNC