

7618



# 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.	10867	35/50
2.	Visual Inspection	ok - 3.0 mm (SSCW)	Done + 406A/B
3.	Pellet Die No.	11243	WT-ak
4.	Hardened by	work firm	Relief-ak
5.	Received by after hardening (Name)	Jayjir	(3-3) $\approx$ 18 mm
6.	Hardness achieved on 1 <sup>st</sup> side	50.3 - 50.6 HRC	Relief $\phi$ 3.5 $\approx$ 15 mm
7.	Hardness achieved on 2 <sup>nd</sup> side	50.9 - 51.2 HRC	Counter-ak
8.	Ovality after hardening 1 <sup>st</sup> side	(0.9) mm $\odot$	RCD - 565 mm
9.	Ovality after hardening 2 <sup>nd</sup> side	(0.8) mm $\odot$	Tapping M20
10.	Outside Diameter	620 mm	Deep - 19 mm
11.	Inside Diameter	520 mm	Tapping M16
12.	Width of die	222 mm	Holds - 12

Inspected By (Sign) & Date

Jayjir 29/12/13

1.	Finish Fitting size 1 <sup>st</sup> side	621 $\pm$ 0.07 $\pm$ 0.08 mm Tapper 12°	Under cut = 1mm
2.	Finish Fitting size 2 <sup>nd</sup> side	621 $\pm$ 0.07 $\pm$ 0.07 mm Tapper 12°	
3.	Finish size made by		

Inspected By (Sign) & Date

Jayjir 29/12/13

1.	Supplied to (Customer Name)	R. N. feeds U.P.	
2.	Dispatch Date		

Reported By (Sign) & Date

Jayjir 29/12/13

Reviewed by (Engineer-CNC)  
30/12/13

Manager-CNC