

(Hold)



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
Rev. Date	31-07-2013

Final Inspection (Pellet Dies) after Hardening & Finishing

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	9776	45/5T
2.	Visual Inspection	OK - 3.5 mm (Jumbo)	Review Drg No - 839A/B
3.	Pellet Die No.	7994	UT-OK
4.	Hardened by	Lark Finney	Relief OK
5.	Received by after hardening (Name)	Janjan	Relief $\phi 4^{+0.00}$ (3-3) ≈ 17 mm
6.	Hardness achieved on 1 st side	50-4-10-6 HRC	Relief ≈ 10 mm
7.	Hardness achieved on 2 nd side	51.0-10-4 HRC	Re-center OK
8.	Ovality after hardening 1 st side	(1.0) mm [Die re-centered due to]	Rel. - 750 mm
9.	Ovality after hardening 2 nd side	(1.6) mm ovality	Chapping M20
10.	Outside Diameter	810 mm	Deep - 33-2m
11.	Inside Diameter	700 mm	Chapping Ho of
12.	Width of die	370 mm	Holes - 19

Inspected By (Sign) & Date

Janjan 27/7/23

1. Finish Fitting size 1st side

797.1 ϕ .12 ϕ .12 mm Tapper 4°

Final size check

2. Finish Fitting size 2nd side

797.1 ϕ .12 ϕ .12 mm Tapper 4°

5g - some deep some

3. Finish size made by

←

left - up

Inspected By (Sign) & Date

Janjan 27/7/23

Signature

1. Supplied to (Customer Name)

Srinivasa Routhy from Tamil Nadu

2. Dispatch Date

Reported By (Sign) & Date

Janjan 27/7/23

Reviewed by (Engineer-CNC)

Manager-CNC