



Lark Engineering Company (India) Pvt. Ltd.

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

6709

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.	9735	38170
2.	Visual Inspection	OK - 3.0 mm (SSCW)	Review Drawing No 9980A+B
3.	Pellet Die No.	10016	107-OK ✓
4.	Hardened by	lakshmi Vacuum	Relief - OK
5.	Received by after hardening (Name)	Jayjeem	(3-3) > 18 mm
6.	Hardness achieved on 1 st side	53.0 - 53.4 HRC	Relief - 0.35 3 D mm
7.	Hardness achieved on 2 nd side	52.8 - 53.3 HRC	Re-counter - OK
8.	Ovality after hardening 1 st side	(1.6) mm [die was Re-Counterd]	PCD - 565 mm
9.	Ovality after hardening 2 nd side	(1.3) mm [due to ovality]	Tapping M20
10.	Outside Diameter	620 mm	Deep - 18.8 mm
11.	Inside Diameter	520 mm	Tapping Ho of
12.	Width of die	222 mm	Holes - 12

Inspected By (Sign) & Date

Jayjeem 11/7/13

1. Finish Fitting size 1st side

618.5 ± .00 ± .05 mm Tapper 12°

2. Finish Fitting size 2nd side

618.5 ± .00 ± .05 mm Tapper 12°

3. Finish size made by

Inspected By (Sign) & Date

Jayjeem 11/7/13

1. Supplied to (Customer Name)

API agro, P.B

2. Dispatch Date

Reported By (Sign) & Date

Jayjeem 11/7/13

Reviewed by (Engineer-CNC)

Manager-CNC