

8199



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.		11581	45170
2.	Visual Inspection		ok - 3.2 mm (SS4W)	Ph 00 Dmg 16 - 406 A/P
3.	Pellet Die No.		11986	07-OK
4.	Hardened by		Lark Finney	Relief - ok
5.	Received by after hardening (Name)		Jayjw	(3.3) → 12 mm
6.	Hardness achieved on 1 st side		49.8 - 49.9 HRC	Relief 3.8 3 5 mm
7.	Hardness achieved on 2 nd side		49.4 - 49.5 HRC	Counts - ok
8.	Ovality after hardening 1 st side		(0.6) mm	PCD - 565 mm
9.	Ovality after hardening 2 nd side		(0.4) mm	Tapping M20
10.	Outside Diameter		620 mm	Deep - 18.8 mm
11.	Inside Diameter		520 mm	Tapping Holes
12.	Width of die		222 mm	Holes - 12

Inspected By (Sign) & Date

Jayjw 10/4/24

1. Finish Fitting size 1st side

621 φ 10 φ 12 mm Tapper 15°

Under cut = 0.8 mm

2. Finish Fitting size 2nd side

621 φ 11 φ 12 mm Tapper 12°

3. Finish size made by

Inspected By (Sign) & Date

Jayjw 10/4/24

1. Supplied to (Customer Name)

Ryan Tech, Tamil Nadu

2. Dispatch Date

Reported By (Sign) & Date

Jayjw 10/4/24

Satya 10/4/24

Reviewed by (Engineer-CNC)

Manager-CNC