



Lark Engineering Company (India) Pvt. Ltd.

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

6762

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.		7901	
2.	Visual Inspection		OK - 8.0 mm CS45C	44/15
3.	Pellet Die No.		9411	Relief - 639 ATB
4.	Hardened by		hark pernu	WT - OK
5.	Received by after hardening (Name)		Jaujan	Relief - OK
6.	Hardness achieved on 1 st side		50.4 - 50.8 HR	(3-3) > 19mm
7.	Hardness achieved on 2 nd side		50.3 - 50.4 HR	Relief ϕ - 8.5 > 11mm
8.	Ovality after hardening 1 st side		(0.3) mm	Counter - OK
9.	Ovality after hardening 2 nd side		(0.1) mm	PCD - 585 mm
10.	Outside Diameter		630 mm	Tapping M20
11.	Inside Diameter		520 mm	Deep - 18.8mm
12.	Width of die		222 mm	Tapping Mandrel

Inspected By (Sign) & Date

Jaujan 19/7/13

1.	Finish Fitting size 1 st side	621 ϕ 1.10 ϕ 1.10 mm Tapper 12°
2.	Finish Fitting size 2 nd side	621 ϕ 1.09 ϕ 1.10 mm Tapper 12°
3.	Finish size made by	

Inspected By (Sign) & Date

Jaujan 19/7/13

1.	Supplied to (Customer Name)	Archant Fertilizers & Chemical, M.P.
2.	Dispatch Date	

Reported By (Sign) & Date

Jaujan 19/7/13

Reviewed by (Engineer-CNC)

 20/7/13

Manager-CNC