



# 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.                               |                                       | 1229 to 7w         | 42150-             |
| 2.                         | Visual Inspection                            |                                       | OK - 4.0 mm (SSAW) | hake/br<br>Dongst  |
| 3.                         | Pellet Die No.                               |                                       | 11811              | 07-OK              |
| 4.                         | Hardened by                                  |                                       | hake/br            | Relief - OK        |
| 5.                         | Received by after hardening (Name)           |                                       | Jayjir             | (3-3) > 12 mm      |
| 6.                         | Hardness achieved on 1 <sup>st</sup> side    |                                       | 51.7 - 51.5 HRC    | Relief 4.5 S & mic |
| 7.                         | Hardness achieved on 2 <sup>nd</sup> side    |                                       | 51.0 - 50.5 HRC    | 6mm to - OK        |
| 8.                         | Ovality after hardening 1 <sup>st</sup> side |                                       | (0.2) mm           | PCD - 56.5 mm      |
| 9.                         | Ovality after hardening 2 <sup>nd</sup> side |                                       | (0.2) mm           | Tapping M20        |
| 10.                        | Outside Diameter                             |                                       | 620 mm             | Deep - 18.8 mm     |
| 11.                        | Inside Diameter                              |                                       | 520 mm             | Tapping M16        |
| 12.                        | Width of die                                 |                                       | 222 mm             | Holes - 12         |
| Inspected By (Sign) & Date |  | Jayjir 7/5/14                         |                    |                    |
| 1.                         | Finish Fitting size 1 <sup>st</sup> side     | 610 ± 0.05 - 0.05 mm                  |                    |                    |
| 2.                         | Finish Fitting size 2 <sup>nd</sup> side     | 610 ± 0.03 - 0.05 mm                  |                    |                    |
| 3.                         | Finish size made by                          | _____                                 |                    |                    |
| Inspected By (Sign) & Date |  | Jayjir 7/5/14                         |                    |                    |
| 1.                         | Supplied to (Customer Name)                  | Bhojraunath Poulky, Maharashtra to 7w |                    |                    |
| 2.                         | Dispatch Date                                | _____                                 |                    |                    |
| Reported By (Sign) & Date  |  | Jayjir 7/5/14                         |                    |                    |

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Reviewed by (Engineer-CNC)

Manager-CNC