



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

136

S.No.	Check Parameter	Specification	Observations	Remarks
1.	Work order No.		11890	40/60
2.	Visual Inspection		ok - 6.0 mm (Jumbo)	Part 1
3.	Pellet Die No.		12304	Degre 584 HB
4.	Hardened by		work Partner	UT-OK
5.	Received by after hardening (Name)		Jay	Relief - ok
6.	Hardness achieved on 1 st side		50.8 - 51.1 HRC	(3.3) = 2.6 mm
7.	Hardness achieved on 2 nd side		51.1 - 51.3 HRC	Relief 6.5 = 2.0 mm
8.	Ovality after hardening 1 st side		(0.8) mm	Counter - ok
9.	Ovality after hardening 2 nd side		(0.8) mm	PO - 725 mm
10.	Outside Diameter		780 mm	Tapping M20
11.	Inside Diameter		660 mm	Deep - 28.8 mm
12.	Width of die		324 mm	Tapping H.O. of

Inspected By (Sign) & Date

Jay 20/5/14

1. Finish Fitting size 1st side

795 \pm 0.10 \pm 0.10 mm Tappet 4°

Under cut = 7.8 mm
= 7.6 mm

2. Finish Fitting size 2nd side

795 \pm 0.10 \pm 0.10 mm Tappet 4°

3. Finish size made by

28 lot Both side

Inspected By (Sign) & Date

Jay 20/5/14

32x8 mm

1. Supplied to (Customer Name)

Karnalheru Cuttely U.P.

2. Dispatch Date

Reported By (Sign) & Date

Jay 20/5/14

1002 - CW/PNK

Jay 20/5/14

Reviewed by (Engineer-CNC)

Manager-CNC