



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

S.No.	Check Parameter	Specification Observations	Remarks
1.	Work order No.	12006	38150
2.	Visual Inspection	OK - 3.0 mm (M. Jumbo)	P.O. 12006/1A
3.	Pellet Die No.	12411	07-OK
4.	Hardened by	Work Benny	Relief - OK
5.	Received by after hardening (Name)	Janjar	(3-3) 2 20mm
6.	Hardness achieved on 1 st side	49.5 - 49.6 HRC	Relief 3-5 5 14mm
7.	Hardness achieved on 2 nd side	50.1 - 50.3 HRC	Counter - OK
8.	Ovality after hardening 1 st side	(0.2) mm	PCD - 640 mm
9.	Ovality after hardening 2 nd side	(0.5) mm	Tapping M20
10.	Outside Diameter	Ø 700 mm	Deep - 18.8 mm
11.	Inside Diameter	600 mm	Tapping Hoef
12.	Width of die	222 mm	Hobs - 12

Inspected By (Sign) & Date

Janjar 7/6/14

1.	Finish Fitting size 1 st side	690 ± .10 ± .11 mm Tapper 12°
2.	Finish Fitting size 2 nd side	690 ± .08 ± .10 mm Tapper 12°
3.	Finish size made by	_____

Inspected By (Sign) & Date

Janjar 7/6/14

1.	Supplied to (Customer Name)	Shakti feeds, HR
2.	Dispatch Date	_____

Reported By (Sign) & Date

Janjar 7/6/14

Satya 7/6/14

Reviewed by (Engineer-CNC)

Manager-CNC