



Lark Engineering Company (India) Pvt. Ltd.

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

14917

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.		
2.	Visual Inspection	15072 to 15158	66/66
3.	Pellet Die No.	OK - 12-0 mm (M. Surp)	208 320 HB
4.	Hardened by	15161	UT-OK
5.	Received by after hardening (Name)	Work Person	Relief - OK
6.	Hardness achieved on 1 st side	49.2 - 49.7 HR	2 HIL
7.	Hardness achieved on 2 nd side	49.2 - 49.6 HR	3 HIL
8.	Ovality after hardening 1 st side	(0.7) mm	Counter - OK
9.	Ovality after hardening 2 nd side	(0.5) mm	PCD - 61.9 mm
10.	Outside Diameter	680.1 mm	Tapping M16
11.	Inside Diameter	548.1 $\pm$ 0.15 $\pm$ 0.14 - 548.1 $\pm$ 0.10 $\pm$ 0.12 mm	Depth - 31.6 mm
12.	Width of die	195 mm	Tapping No of Holes - 2
Inspected By (Sign) & Date		Janji 13/6/15	
1.	Finish Fitting size 1 st side	690.1 $\pm$ 0.7 - 690.1 $\pm$ 0.8 Tapper 8°	
2.	Finish Fitting size 2 nd side	690.1 $\pm$ 1.0 - 690.1 $\pm$ 1.1 Tapper 18°	
3.	Finish size made by		
Inspected By (Sign) & Date		Janji 13/6/15	
1.	Supplied to (Customer Name)	Yulong, HR to Global Mandhori	PB
2.	Dispatch Date		
Reported By (Sign) & Date		Janji 13/6/15	

13/6/15

Reviewed by (Engineer-CNC)

Manager-CNC