

1819

LARK ENGINEERING CO. (INDIA) PVT. LTD.										Format. No.: CNC/QC/FM/03	
Pellet Die Final Inspection Report										Rev./Date: 02/15-05-25	
Machine Name:- 6M-07										WON :- 16/13	
Drawing No./Rev:- 1343 / Rev 0										Blank NO:- 15946	
Part Mfg. Date:- 21/10/25										Hole Size:- 4.0	
Inspector Name:- Samir										Category:- Jumbo	
Inspection Date:- 11/11/25										Customer Name:- Kamdhenu cattle, U.S.	
										JUDGEMENT SYMBOLS	
										OK	✓
										REJECT	X
										REWORK	□
										CONDITIONALLY ACCEPTED	Δ
Sl. No.	Check Parameters	Checking Method	Unit	Dimension	Tolerance	Critical Size	Observations	Judgement	Remark		
1	Visual Inspection	Visually Observe the Dents, Crack, Burr, Sharp Edges etc.					OK	✓			
2	Outer Diameter	VC	mm	780	+/-0.1		780	✓			
3	Inside Diameter	VC	mm	660	+/-0.1		660	✓			
4	Width of die	VC	mm	324	+/-0.2		324	✓			
5	Hardened By	Inhouse/Outsource					Lark	✓			
6	Hardness Achieved on 1st Face	Hardness Tester	HRC	50-55 HRC			51.5 - 51.8	✓			
7	Hardness Achieved on 2nd Face	Hardness Tester	HRC	50-55 HRC			50.9 - 51.3	✓			
8	Ovalty After Hardening 1st Side	VC	mm	Upto 700 OD-0.7 max, Above 700 OD-1mm max			.7	✓			
9	Ovalty After Hardening 2nd Side	VC	mm				.6	✓			
10	OD Fitting Size 1st Side	MM	mm	795	+0.7	*	795 +0.9 +1.0	✓			
11	OD Fitting Size 2nd Side	MM	mm	795	+0.7	*	795 +1.0 +1.2	✓			
12	ID Fitting Size 1st Side	IMM	mm			*					
13	ID Fitting Size 2nd Side	IMM	mm			*					
14	Tapper/Straight Fit	Visual					Tapper	✓			
15	Tapper Angle	Bevel Protector	Degree			*	4°	✓			
16	Total Step Length	VC	mm		+/-0.1		25.5	✓			
17	Tapper Step Length	HG/VC	mm		+/-0.1		21.5	✓			
18	Face Groove Depth	VC	mm		+/-0.1			✓			
19	Thread Quality	Thread Plug Gauge	Pass/Fail	Go Gauge Should be Qualify	NOGO Gauge Not more then 2 Thread	*	OK	✓			
20	Undercut	VC	mm				7.3, 7.5	✓			
21	Slot Size (WxD)	VC	mm		+/-0.1		32 x 8	✓			
22	Recounter Quality if applicable	Visual					Check For Finishing				
23	Surface Finish On Fitting Size	Surface Roughness Tester	Ra	1 Ra max			OK	✓			
24	⊥ on Fitting size W.R.T Face	Dial and HG	mm	0.05 Max				✓			
25	Marking Pattern	Visual		Blank No	Category	Hole Size	Relief Ratio				
				LARK	15946	Jumbo	4.0	40/60	✓		

Remarks :-

Note:- Critical Size Denoted by * Mark. Critical Dimension Mandatory to Be Check & Fill in the actual Size by Quality Inspector.

VC- Vernier Calliper	IMM- Internal Micrometer	MM-Micro Meter	HG- Height Gauge
Checked By :-	Verified By Quality:-	Approved By:-	RN NO. :-
			File In Record :-