

15824

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|----------------------------------------------------------------------------------|--|-----------------------------------------------|--|-----------------------------------|--|---------------------------|---|
|  |  | <b>LARK ENGINEERING CO. (INDIA) PVT. LTD.</b> |  |                                   |  | Format. No.: CNC/QC/FM/03 |   |
| <b>Pellet Die Final Inspection Report</b>                                        |  |                                               |  |                                   |  |                           |   |
| Machine Name:- <b>LM-7</b>                                                       |  |                                               |  | WON :- <b>16372</b>               |  | JUDGEMENT SYMBOLS         |   |
| Drawing No./Rev.:- <b>1074 / Rev 00</b>                                          |  |                                               |  | Blank NO.:- <b>15885</b>          |  | OK                        | ✓ |
| Part Mfg. Date :- <b>31/10/25</b>                                                |  |                                               |  | Hole Size:- <b>4.0 / 28/40/45</b> |  | REJECT                    | X |
| Inspector Name:- <b>Sanjay</b>                                                   |  |                                               |  | Category :- <b>Senior</b>         |  | REWORK                    | □ |
| Inspection Date:- <b>11/11/25</b>                                                |  |                                               |  | Customer Name:-                   |  | CONDITIONALLY ACCEPTED    | △ |

| 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                                                                                  | 510                                       | +/-0.1                            |               | 510             | ✓         |        |
| 3       | Inside Diameter                  | VC                                                        | mm                                                                                  | 420                                       | +/-0.1                            |               | 420             | ✓         |        |
| 4       | Width of die                     | VC                                                        | mm                                                                                  | 158                                       | +/-0.2                            |               | 158             | ✓         |        |
| 5       | Hardened By                      | Inhouse/Outsource                                         |                                                                                     |                                           |                                   |               | Lark Purvey     | ✓         |        |
| 6       | Hardness Achieved on 1st Face    | Hardness Tester                                           | HRC                                                                                 | 50-55 HRC                                 |                                   |               | 50.3 - 50.7     | ✓         |        |
| 7       | Hardness Achieved on 2nd Face    | Hardness Tester                                           | HRC                                                                                 | 50-55 HRC                                 |                                   |               | 49.3 - 49.5     | ✓         |        |
| 8       | Ovality After Hardening 1st Side | VC                                                        | mm                                                                                  | Upto 700 OD-0.7 max, Above 700 OD-1mm max |                                   |               | .03             | ✓         |        |
| 9       | Ovality After Hardening 2nd Side | VC                                                        | mm                                                                                  |                                           |                                   |               | .01             | ✓         |        |
| 10      | OD Fitting Size 1st Side         | MM                                                        | mm                                                                                  | 489                                       | +1.02<br>-1.05                    | *             | 489 +1.05 +1.05 | ✓         |        |
| 11      | OD Fitting Size 2nd Side         | MM                                                        | mm                                                                                  | 489                                       | +1.02<br>-1.05                    | *             | 489 +1.05 +1.05 | ✓         |        |
| 12      | ID Fitting Size 1st Side         | IMM                                                       | mm                                                                                  |                                           |                                   | *             | —               |           |        |
| 13      | ID Fitting Size 2nd Side         | IMM                                                       | mm                                                                                  |                                           |                                   | *             | —               |           |        |
| 14      | Tapper/Straight Fit              | Visual                                                    |                                                                                     |                                           |                                   |               | Straight        | ✓         |        |
| 15      | Tapper Angle                     | Bevel Protector                                           | Degree                                                                              |                                           |                                   | *             | —               |           |        |
| 16      | Total Step Length                | VC                                                        | mm                                                                                  |                                           | +/-0.1                            |               | 18mm            | ✓         |        |
| 17      | Tapper Step Length               | HG/VC                                                     | mm                                                                                  |                                           | +/-0.1                            |               | —               |           |        |
| 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      | Slot Size (WxD)                  | VC                                                        | mm                                                                                  |                                           | +/-0.1                            |               | —               |           |        |
| 21      | Recounter Quality if applicable  | Visual                                                    |                                                                                     | Check For Finishing                       |                                   |               | —               |           |        |
| 22      | Surface Finish On Fitting Size   | Surface Roughness Tester                                  | Ra                                                                                  | 1 Ra max                                  |                                   |               | ok              | ✓         |        |
| 23      | ⊥ on Fitting size W.R.T Face     | Dial and HG                                               | mm                                                                                  | 0.05 Max                                  |                                   |               | —               |           |        |
| 24      | Marking Pattern                  | Visual                                                    |  | Blank No                                  | Category                          | Hole Size     | Relief Ratio    |           |        |
|         |                                  |                                                           | LARK                                                                                | 15885                                     | Senior                            | 4.0           | 28/40/45        | ✓         |        |

Remarks :-

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

|                                        |                                                |                |                                |
|----------------------------------------|------------------------------------------------|----------------|--------------------------------|
| VC- Vernier Calliper                   | IMM- Internal Micrometer                       | MM-Micro Meter | HG- Height Gauge               |
| Checked By :- <b>Sanjay</b><br>3/11/25 | Verified By Quality:- <b>Sanjay</b><br>3/11/25 | Approved By:-  | RN NO. :-<br>File In Record :- |