

15817

LARK ENGINEERING CO. (INDIA) PVT. LTD.

Pellet Die Final Inspection Report

Format. No.: CNC/QC/FM/01

Rev./Date: 02/15-05-25

JUDGEMENT SYMBOLS

OK	✓
REJECT	X
REWORK	□
CONDITIONALLY ACCEPTED	Δ

Machine Name:-	L-M-07	WON :-	66133
Drawing No./Rev.:-	457 Rev 0	Blank NO.:-	15358
Part Mfg. Date :-	31/10/25	Hole Size :-	3.5
Inspector Name:-	Sanjay	Category :-	Jumbo
Inspection Date:-	1/11/25	Customer Name:-	Lotus Fern, Kornel

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	78.0	+/-0.1		77.0	✓	
3	Inside Diameter	VC	mm	66.0	+/-0.1		66.0	✓	
4	Width of die	VC	mm	31.6	+/-0.2		31.6	✓	
5	Hardened By	Inhouse/Outsource					hark fern	✓	
6	Hardness Achieved on 1st Face	Hardness Tester	HRC	50-55 HRC			51.6-52.0	✓	
7	Hardness Achieved on 2nd Face	Hardness Tester	HRC	50-55 HRC			50.1-50.4	✓	
8	Ovality After Hardening 1st Side	VC	mm	Upto 700 OD-0.7 max, Above 700 OD-1mm max			0.7	✓	
9	Ovality After Hardening 2nd Side	VC	mm				1.0	⊙	
10	OD Fitting Size 1st Side	MM	mm	79.8-6	+0.02	*	79.8-6 +0.06 +0.08	✓	
11	OD Fitting Size 2nd Side	MM	mm	79.8-6	+0.02	*	79.8-6 +0.07 +0.08	✓	
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	10.4°	10.4°	*	10.4°	✓	
16	Total Step Length	VC	mm	26	+/-0.1		26	✓	
17	Tapper Step Length	HG/VC	mm	23.5	+/-0.1		23.5	✓	
18	Face Groove Depth	VC	mm	NA	+/-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				13.3, 14.5	✓	
21	Slot Size (WxD)	VC	mm		+/-0.1			✓	
22	Recounter Quality if applicable	Visual		Check For Finishing			OK	✓	
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		
				15358	Jumbo	3.5	30/50	✓	

marks :-

:- 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 :-