

16236

LARK ENGINEERING CO. (INDIA) PVT. LTD.

Pellet Die Final Inspection Report

Format. No.: CNC/QC/FM/03

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

JUDGEMENT SYMBOLS

OK ☒REJECT ☒REWORK ☐CONDITIONALLY ACCEPTED ☒

Machine Name:- LM-02

Drawing No./Rev.: 150-355A15 Rev

Part Affg. Date:- 16/12/25

Inspector Name:- Sanjeev

Inspection Date:- 17/12/25

WON :- 16824

Blank NO.: 16924

Hole Size:- 4.0

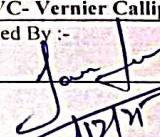
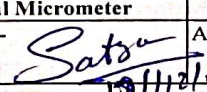
Category :- SSS1D

Customer Name:- Bongomali, Mahoraghat

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	630	+/-0.1		630	✓	
3	Inside Diameter	VC	mm	520	+/-0.1		520	✓	
4	Width of die	VC	mm	186	+/-0.2		186	✓	
5	Hardened By	Inhouse/Outsource					Lark firm	✓	
6	Hardness Achieved on 1st Face	Hardness Tester	HRC	50-55 HRC			47-4-48-1	⊙	
7	Hardness Achieved on 2nd Face	Hardness Tester	HRC	50-55 HRC			47-1-50.3	⊙	
8	Ovalty After Hardening 1st Side	VC	mm	Upto 700 OD-0.7 max, Above 700 OD-1mm max			.1	✓	
9	Ovalty After Hardening 2nd Side	VC	mm				.4	✓	
10	OD Fitting Size 1st Side	MM	mm	610	+0.7 -1.2	*	610 ± 1.0 ± 1.2	✓	
11	OD Fitting Size 2nd Side	MM	mm	610	+0.7 -1.2	*	610 ± 1.0 ± 1.1	✓	
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		20	✓	
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	Undercut	VC	mm				—		
21	Slot Size (WxD)	VC	mm		+/-0.1		—		
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	Dail and HG	mm	0.05 Max			—		
25	Marking Pattern	Visual			Blank No	Category	Hole Size	Relief Ratio	
				LARK	16924	SSS1D	4.0	42155	✓

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 :-