

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By			
3	Pallet Die No.		V-TL R837 ✓	36/46 ✓
4	Die Category		M/c Shop	Drg No - LEC 808P
5	Out Side Diameter	Drg. No.	11863 (3.0mm) ✓	(Revol) ✓
6	Inside Diameter	Drg. No.	SSSD	
7	Width of Pellet Die	Drg. No.	612 H-H ✓	Step 00 = 8.24 ✓
8	Grooves as per Drawing	Drg. No.	52.12 H-H ✓	Step length - 18mm
9	Fitting Sizes on CNC Plate	Drg. No.	186mm ✓	Tappet = 12
10	Drilling Area Surface Smoothness	Drg. No.	14x8x5mm / 14x8x5mm	Under cut = 6.4 ✓
11	Tapping Operator		ok	[Tapping No. of Holes 12]
12	Tapping PCD		M/c Shop	[Both Side]
13	Tapping Hole Diameter		5.65mm ✓	
14	Tapping On Second Side	Half pitch of 1st side	M to check by M to Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
17	Visual Inspection Before Gun Drilling		Yes	

Inspected By (Sign) & Date Ramanpreet Singh 16/09/24

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter - 60°
Row - 30

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5mm ✓	outside (3-3)	Inner			
3	External Relief Depth		16mm	10mm			
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh				
5	Material Sent For Hardening By (Name)		Laxk Furnace				
6	Material Sent For Hardening On Date		16	09	24		

Inspected By (Sign) & Date Ramanpreet Singh 16/09/24

Satya
16/09/24
Reviewed by (Engineer-CNC)

Manager-QA