

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

CNC/QA/FM/02

01

31-07-2013

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14656 ✓	25/66 ✓
3	Pallet Die No.		V.T.L. H/c. Shop	Drg. No. 18.0.330
4	Die Category	Drg. No.	14877 (6.0) H/c	Rev. 08 ✓
5	Out Side Diameter	Drg. No.	H. Jumbo	
6	Inside Diameter	Drg. No.	680.1 H/c, Step on 2 693 H/c	Tapping 8°
7	Width of Pellet Die	Drg. No.	548.12 H/c (Box 548.1 H/c)	Step length 31 H/c
8	Grooves as per Drawing	Drg. No.	195 H/c	Under cut 2.8 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	32.77.9.1 H/c 32.77.9.1 H/c (408) H/c	
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		H/c Shop	2 H/c Deep Bottom
12	Tapping PCD		619 H/c	Side
13	Tapping Hole Diameter		W16 = Check by W16 Bolt	Tapping H/c
14	Tapping On Second Side	Half pitch of 1st side	OK	of hole 2
15	Tapping Hole Depth		Drill Depth 33.4 H/c	Both Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth 31.6
17	Visual Inspection Before Gun Drilling		OK	

Page: 12/12

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	

Counter: 300
Corr: 12

1	Counter Sinking Depth & Finish	ok						Row 2/2
2	External Relief Dia	1.0111	All Rows					
3	External Relief Depth		41 mm					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lank Bunnace					
6	Material Sent For Hardening On Date		12	4	25			

Raoi 12/4/25

Sgt
12/4/25

Manager-QA