

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

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14680 ✓	36/40/2175
3	Pallet Die No.		V.T.L. H/c Shop	Dry No. 1012
4	Die Category	Drg. No.	14522(3.0) H/c ✓ Senior	
5	Out Side Diameter	Drg. No.	499.9 H/c ✓	Step on - 490.8 H/c ✓
6	Inside Diameter	Drg. No.	420.12 H/c ✓	Step length 17.5 ✓
7	Width of Pellet Die	Drg. No.	158 H/c ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H/c ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		454 H/c ✓	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 H/c ✓	Tapping Depth 18.5 H/c ✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rowi 15/4/25

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

Coontenz 60'

Note : Mark the defective holes/missed holes and mark them									
1	Counter Sinking Depth & Finish	OK							24
2	External Relief Dia	3.344	Outside (2.2)		Inner				
3	External Relief Depth		1.044		4.44				
4	Inspection Done Before Hardening By (Name)		Paul						
5	Material Sent For Hardening By (Name)		Lark Lawrence						
6	Material Sent For Hardening On Date		15	4	25				
			D. 15/1/25						

Inspected By (Sign) & Date

Sem: 15/4/25

Reviewed by (Engineer-CNC)

Manager-QA