

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.		14779	5/66
2	Machined By		V. T. L. n/c Shop	Dry H. 12.2.6-9
3	Pallet Die No.		14985(2.0) H-3	Revs 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm Step off. 693 mm	Tap H. 8"
6	Inside Diameter	Drg. No.	546.12 mm Bar 25548.4 mm	Step length. 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Extension. 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 mm 32 x 7 x 9.2 mm (4 x 9) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 mm Deep Probe
11	Tapping Operator		n/c Shop	Side
12	Tapping PCD		619 mm	Tapping H.
13	Tapping Hole Diameter		H16 - Check by H16 Ball	of Holes = 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth. 33.4 mm	Tapping Depth. 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Prei 5/5/25

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

Counter, 30'

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	9.0mm	All Rows					
3	External Relief Depth		16mm					
4	Inspection Done Before Hardening By (Name)		Paul					
5	Material Sent For Hardening By (Name)		Lank Furnace					
6	Material Sent For Hardening On Date		5	5	25			

Inspected By (Sign) & Date

Ques: 5/5/25

Reviewed by (Engineer-CNC)

Manager-QA