



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.		14926 ✓	45/50 ✓
2	Machined By		V.T.L. n/c Shop	Dry H. 13.0. 442
3	Pallet Die No.		15116 (8.0) ✓	Recoo
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 ✓ Step OD: 491.9 ✓	Step length 13.5
6	Inside Diameter	Drg. No.	420.12 ✓	
7	Width of Pellet Die	Drg. No.	159 ✓	
8	Grooves as per Drawing	Drg. No.	7x7x5 mm / 7x7x5 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		45.5 mm ✓	
13	Tapping Hole Diameter		03/4" 2 Cuts by 03/4" Drill	[Tapping Holes of Holes 08 Both Side]
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 22.7 mm ✓	Tapping Depth 20.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

81/5/25

251.4

1	As per programme no.			20.1.14.12.14.14
2	Gun Drilling Work Completed On			7.14.14.14.14
3	Hole Finish In Gun Drilling	Marked	OK	Back Side
4	Defective Holes (If Any)		Nil	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter, Bo

1	Counter Sinking Depth & Finish	OK						Row = 12
2	External Relief Dia	8.5 mm	80 Side (2-2)		Inner			
3	External Relief Depth		13 mm		5 mm			
4	Inspection Done Before Hardening By (Name)	Ravi						
5	Material Sent For Hardening By (Name)	Lank Ramesh						
6	Material Sent For Hardening On Date	01	5	25				

Inspected By (Sign) & Date

Row: 21/5/25

Reviewed by (Engineer-CNC)

Manager-QA