



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

CNC/QA/FM/02

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31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14924	30/66
2	Machined By		V.T.L. H/c Shop	Dy H/c 18.0
3	Pallet Die No.		15146 (G.O) H/c	Rev. 08
4	Die Category	Drg. No.	H. Jumbo	Group 4+3
5	Out Side Diameter	Drg. No.	680.1 H/c	Step on 693 H/c
6	Inside Diameter	Drg. No.	546.12 H/c	(Bor. 548.2) Step length 3
7	Width of Pellet Die	Drg. No.	195 H/c	Undercut, 2.8 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/c	32 x 7 x 9.1 H/c (4 x 8) H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side step
10	Drilling Area Surface Smoothness		OK	2 H/c Deep
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		619 H/c	Tapping H/c
13	Tapping Hole Diameter		H18	Check by H16 Bolt
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 H/c	Tapping Depth 31.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Drilling		OK	

Inspected By (Sign) & Date

Page: 98/5/25

1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		None	

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

Count en = 30

1	Counter Sinking Depth & Finish	OK						Page 12
2	External Relief Dia	7.0 mm	All Rows					
3	External Relief Depth		36 mm					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Purnore					
6	Material Sent For Hardening On Date		22	5	25			

Inspected By (Sign) & Date

Q. 29/5/25

Reviewed by (Engineer-CNC)

Manager-QA