I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)  Rev. No. 01  Inprocess Inspection (Pellet Dies)  Rev. Date 31-07-2  S.No. Check Parameter Specification Observations Remarks  Work Order No. 9815 9763  Pallet Die No. 9815 9763  Pallet Die No. 9815 9763  Pallet Die No. 9816 0165  Out Side Diameter Drg. No. 9816 0165  Groves as per Drawing Drg. No. 9816 0165  Groves as per Drawing Drg. No. 9816 0165  Tapping PCD USU Tapping PCD USU Market Diaphone Side Diameter Drg. No. 9816 0165  Tapping PCD USU Market Diaphone Permanent Marker  Inspected By (Sign) & Date (Inspective holes/Missed holes with the help of Permanent Marker)  To Counter Sinking Co	1	Lark Eng	gineering Co	ompany (India) Pvt. Ltd.	Form	No.	CNC/QA/FM/02
S.No. Check Parameter Specification Observations Remarks  1 Work Order No. 2 Machined By 3 Pallet Die No. 4 Die Category Drg. No. 5 Out Side Diameter Drg. No. 6 Inside Diameter Drg. No. 7 Width of Pellet Die Drg. No. 9 Fitting Sizes on CNC Drg. No. 10 Drilling Area Surface Smoothness 11 Tapping Operator 12 Tapping PCD 13 Tapping Hole Diameter Marker 14 Tapping On Second Side Side Side Side Side Side Side Sid	I.T.I. Sasouli Road, Yamuna Nagar - 135 00			una Nagar - 135 001 (Haryana)	No. 20 (1994)		01
1 Work Order No. 2 Machined By 3 Pallet Die No. 4 Die Category 5 Out Side Diameter 6 Inside Diameter 7 Width of Pellet Die 8 Grooves as per Drawing 9 Fitting Sizes on CNC Plate 10 Drilling Area Surface 8 Smoothness 11 Tapping Operator 12 Tapping Hole Diameter 14 Tapping On Second 15 Side 15 Tapping Hole Diameter 16 Perpendicularity of Tapped Hole 17 Visual Inspection 18 Perpendicularity of Tapped Hole 17 Tapped Hole 18 Perpendicularity of Tapped Hole 19 Pitting Sizes on CNC 19 Pitting Sizes on CNC 10 Drilling Work 10 Drilling Work 11 Tapping Operator 12 Tapping Hole Depth 13 Tapping Hole Depth 14 Tapping On Second 15 Tapping Hole Depth 16 Perpendicularity of Tapped Hole 17 Visual Inspection 18 Perpendicularity of Tapped Hole 19 Tapped Hole 10 Perpendicularity of Tapped Hole 10 Perpendicularity of Tapped Hole 11 As per programme 12 Gun Drilling Work 13 Hole Finish In Gun 14 Difficitive Holes 15 (If Any) 16 Defective Holes 16 (If Any) 17 Wote: Mark the defective holes/Missed holes with the help of Permanent Marker			ocess Inspecti	on (Pellet Dies)	Rev. [	Date	31-07-2013
Machined By  Pallet Die No.  Pallet Die No.  Die Category  Drg. No.  Con Min and Stab Parlin Results  Tout Side Diameter  Drg. No.  Width of Pellet Die  Groves as per Drawing  Fitting Sizes on CNC  Plate  Drg. No.  Drg. No.  Plate  Tapping Operator  Tapping PCD  Tapping Hole Diameter  Tapping Hole Depth  Perpendicularity of Tapped Hole  Tapped Hole  Tapped Hole  Tout Side Diameter  Tapping Hole Depth  Perpendicularity of Tapped Hole  Tapped Hole  The Perpendicularity of Tapped Hole  Tapped Hole  The Perpendicularity of Tapped Hole  Tapped Hole  The Perpendicularity of Tapped Hole  The Perpendicularity of Tapped Hole  Tapping Hole Depth  Tapping Hole Depth  Drilling  Tapping Hole Depth  Tapping Hol	S.No.	Check Parameter	Specification	Observations			Remarks
3 Pallet Die No. 4 Die Category 5 Out Side Diameter 6 Inside Diameter 7 Width of Pellet Die 8 Grooves as per Drawing 9 Fitting Sizes on CNC Plate 10 Drilling Area Surface Smoothness 11 Tapping Operator 12 Tapping PCD 13 Tapping Hole Diameter 14 Tapping On Second Side 15 Tapping Hole Depth 16 Perpendicularity of Tapping Hole Depth 17 Visual Inspection 18 Grooves as per Drawing 19 Fitting Sizes on CNC Plate  M20 Cahcuk (120 fall)  M10 Perpendicularity of Tapping Hole Diameter 10 Visual Inspection 11 As per programme 12 No. 13 As per programme 13 No. 14 As per programme 15 Out Dilling Work Completed On 16 Perpendicularity of Tapping Hole Depth 17 Visual Inspection 18 Perpendicularity of Tapping Hole Depth 18 Perpendicularity of Tapping Hole Depth 19 Visual Inspection 10 Drilling 11 As per programme 12 Gun Drilling 13 Hole Finish In Gun Drilling 14 Defective Holes (It flavy) M4 Defective Holes (It flavy) M5 M6 M6 Work Completed On 18 Hole Finish In Gun Drilling M6 Defective Holes (It flavy) M10 Example Hole Permanent Marker	1	Work Order No.		9815 9763			
Pallet Die No.   Pallet Die Drg. No.   Pallet Drg. No.   Pallet Die Drg. No.   Pallet Die Drg. No.   Pallet	2	Machined By		1174 MKSLA			22/1.2
Die Category  Die Category  Drg. No.  Segan  Out Side Diameter  Drg. No.  Segan  Out Side Diameter  Drg. No.  Find Die Category  Drg. No.  Drg. No.  Pare  Fitting Sizes on CNC Plate  Plate  Drg. No.  Drg. No.  Drg. No.  Prilling Area Surface Smoothness  Drg. No.  Record Side  Tapping PCD  Tapping PCD  Tapping Hole Diameter  Mac Cahcak (120 fall)  Tapping Hole Depth  Drailling Area Surface  Drg. No.  As per programme no.  Drg. No.  Record Half pitch of 1st side  Ok  Inspected By (Sign) & Date  As per programme no.  Gun Drilling  As per programme no.  Gun Drilling  Marked  Drilling  Marked  Defective Holes  (if Any)  Note: Mark the defective holes/Missed holes with the help of Permanent Marker	3	Pallet Die No.	1	0 - 0 0	(		17190
5 Out Side Diameter Drg. No. 500 mm OO STD - 491 mm Step hearsh 6 Inside Diameter Drg. No. 420 mm OO STD - 491 mm Step hearsh 7 Width of Pellet Die Drg. No. 12x8x3 mm 8 Grooves as per Drawing Drg. No. 12x8x3 mm 9 Fitting Sizes on CNC Plate Drg. No. 12x8x3 mm 10 Drilling Area Surface Smoothness 11 Tapping Operator 11C Shalp 12 Tapping PCD 13 Tapping PCD 14S mm 14 Tapping On Second Side 15 Tapping Hole Diameter 14 Tapping On Second Side 15 Tapping Hole Depth 16 Perpendicularity of Tapped Hole Depth 17 Visual Inspection Before Gun Drilling 17 Usual Inspection Before Gun Drilling Marked On 18 As per programme no. 19 Gun Drilling Marked On 19 Defective Holes (If Any) Note: Mark the defective holes/Missed holes with the help of Permanent Marker 10 Counter Sinking 10 Co	4	Die Category	Drg. No.	The W		Dog	of herks
Inside Diameter   Drg. No.   12 Mode   12 Mode   12 Mode   12 Mode   13 Mode   14 Mode   14 Mode   14 Mode   15 Mo	5	Out Side Diameter	Drg. No.			- 1	1
Width of Pellet Die   Drg. No.   12 x 8 x 3	6	Inside Diameter	Drg. No.		ma	Step	height: 12.1
9 Fitting Sizes on CNC Plate Drilling Area Surface Smoothness Ok Tapping Operator 12 Tapping PCD 13 Tapping Hole Diameter 14 Tapping On Second Side 15 Tapping Hole Depth 16 Perpendicularity of Tapped Hole 17 Visual Inspection Before Gun Drilling  Inspected By (Sign) & Date 1 As per programme no. 2 Gun Drilling Work Completed On 3 Hole Finish In Gun Drilling Alark the defective holes/Missed holes with the help of Permanent Marker  Note: Mark the defective holes/Missed holes with the help of Permanent Marker	7	Width of Pellet Die	Drg. No.	168			
9 Plate Plate Drg. No.  Ok  Tapping Area Surface Smoothness  11 Tapping Operator  12 Tapping PCD  13 Tapping Hole Diameter  14 Tapping On Second Side  15 Tapping Hole Depth  Tappendicularity of Tapped Hole  17 Visual Inspection Before Gun Drilling  Inspected By (Sign) & Date  1 As per programme no.  2 Gun Drilling Work Completed On  3 Hole Finish In Gun Drilling  Marked  United Side  Mark the defective Holes (If Any)  Note: Mark the defective holes/Missed holes with the help of Permanent Marker	8	Grooves as per Drawing	Drg. No.	10 18 18			
10 Drilling Area Surface Smoothness  11 Tapping Operator  12 Tapping PCD  13 Tapping Hole Diameter  14 Tapping On Second Half pitch of 1st side of Side  15 Tapping Hole Depth  16 Perpendicularity of Tapped Hole  17 Visual Inspection Before Gun Drilling  18 Inspected By (Sign) & Date  1 As per programme no.  2 Gun Drilling Work Completed On  3 Hole Finish In Gun Drilling  4 Defective Holes (If Any)  Note: Mark the defective holes/Missed holes with the help of Permanent Marker	9	Fitting Sizes on CNC Plate	Drg. No.			7 11	2
Tapping Operator  Tapping PCD  Tapping Hole Diameter  Tapping On Second Side  Tapping Hole Depth  Tapping Hole Depth  Tapping Hole Depth  Perpendicularity of Tapped Hole  Tisped Hole  Tisped Hole  Tispected By (Sign) & Date  Tapping Mork Completed On  The Politing Marked  The Perpendicularity of Tapped Hole  The Perpendicularity of Tapped Hole  Tispected By (Sign) & Date  The Perpendicularity of Tapped Hole  Tispected By (Sign) & Date  The Perpendicularity of Tapped Hole  Tispected By (Sign) & Date  The Perpendicularity of Tapped Hole  The Perpendicularity of Tapped Hole  Tispected By (Sign) & Date  The Perpendicularity of Tapped Hole  Tispected By (Sign) & Date  The Perpendicularity of Tapped Hole  Tispected By (Sign) & Date  The Perpendicularity of Tapped Hole  Tispected By (Sign) & Date  The Perpendicularity of Tapped Hole  Tispected By (Sign) & Date  The Perpendicularity of Tapped Hole  Tispected By (Sign) & Date  Tispected By (Sign) &	10	Drilling Area Surface			-(	(or b)	ing Hoef
Tapping PCD  13 Tapping Hole Diameter  14 Tapping On Second Side  15 Tapping Hole Depth  16 Perpendicularity of Tapped Hole  17 Visual Inspection Before Gun Drilling  1 As per programme no.  2 Gun Drilling Work Completed On  3 Hole Finish In Gun Drilling  4 Defective Holes (If Any)  Note: Mark the defective holes/Missed holes with the help of Permanent Marker	11					toly	Both side
14 Tapping On Second Side 15 Tapping Hole Depth 16 Perpendicularity of Tapped Hole 17 Visual Inspection Before Gun Drilling 18 As per programme no. 2 Gun Drilling Work Completed On Drilling Work Completed On Drilling 3 Hole Finish In Gun Drilling 4 Defective Holes (If Any) Note: Mark the defective holes/Missed holes with the help of Permanent Marker	12	Tapping PCD		10.		8	)
14 Side Side Half pitch of 1st side Ak  Tapping Hole Depth Perpendicularity of Tapped Hole Tipped Hole	13	Tapping Hole Diameter					
Tapping Hole Depth  Perpendicularity of Tapped Hole  Visual Inspection Before Gun Drilling  As per programme no.  Gun Drilling Work Completed On  Hole Finish In Gun Drilling  Defective Holes (If Any)  Note: Mark the defective holes/Missed holes with the help of Permanent Marker	14		Half pitch of 1st side			-	
Perpendicularity of Tapped Hole  17 Visual Inspection Before Gun Drilling  Inspected By (Sign) & Date  1 As per programme no.  2 Gun Drilling Work Completed On  3 Hole Finish In Gun Drilling  4 Defective Holes (If Any)  Note: Mark the defective holes/Missed holes with the help of Permanent Marker  1 Counter Sinking	15			ak 100 m			
Inspected By (Sign) & Date  Inspected By (Sign) & Date  As per programme no.  Gun Drilling Work Completed On  Hole Finish In Gun Drilling Marked  Defective Holes (If Any)  Note: Mark the defective holes/Missed holes with the help of Permanent Marker	16	Perpendicularity of		Dorelling Depth-18.5 mm	appl	ing ?	sept- 16.8.
Inspected By (Sign) & Date  1    As per programme no. 2    Gun Drilling Work Completed On 3    Hole Finish In Gun Drilling 4    Defective Holes (If Any)  Note: Mark the defective holes/Missed holes with the help of Permanent Marker	17	Visual Inspection		705			
As per programme no.  2 Gun Drilling Work Completed On  3 Hole Finish In Gun Drilling  4 Defective Holes (If Any)  Note: Mark the defective holes/Missed holes with the help of Permanent Marker			d By (Sign) & Date				
2 Gun Drilling Work Completed On 3 Hole Finish In Gun Drilling 4 Defective Holes (If Any) Note: Mark the defective holes/Missed holes with the help of Permanent Marker	1	As per programme	7 ( - 3 - 7		_		
3 Hole Finish In Gun Drilling Marked 4 Defective Holes (If Any)  Note: Mark the defective holes/Missed holes with the help of Permanent Marker  1 Counter Sinking	2	Gun Drilling Work					
4 Defective Holes (If Any)  Note: Mark the defective holes/Missed holes with the help of Permanent Marker  1 Counter Sinking	3	Hole Finish In Gun	Marked				
Note : Mark the defective holes/Missed holes with the help of Permanent Marker  Counter Sinking	4	Defective Holes					
Counter Sinking			bles/Missed holes with	the help of Permanent Made			4
Depth & Finish	·   1	Counter Sinking Depth & Finish	@K	The Holp of Fernantent Marker			

Reviewed by (Engineer-CNC)

External Relief Dia

External Relief Depth

Inspection Done Before Hardening By (Name) Material Sent For Hardening By (Name)

Material Sent For Hardening On Date

3

5

Inspected By (Sign) & Date

aut side

(2-2)

26/6/23