



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.		15920 ✓	38/55 ✓
2	Machined By		V. T. L. n/c Shop	Drg. No. 18.0.855
3	Pallet Die No.		15128 (4.0) n/c	Rev 20
4	Die Category	Drg. No.	58370	
5	Out Side Diameter	Drg. No.	629.9 mm ✓	Step on 611.9 mm
6	Inside Diameter	Drg. No.	520.14 mm ✓	Step length 20.15
7	Width of Pellet Die	Drg. No.	186 mm ✓	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 3 mm / 13 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c
12	Tapping PCD		565 mm ✓	of hole 12
13	Tapping Hole Diameter		M20, Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.5 mm	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

8-1 13/9/25

1	As per programme no.		100%	13/11/20
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		None	2 holes (2)

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

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.5mm	Outer Side 3-3.5		Inner				Row 2 85
3	External Relief Depth		2mm		17mm				
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lank Ruvane						
6	Material Sent For Hardening On Date		13	9	25				

Inspected By (Sign) & Date

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Manager-QA

Reviewed by (Engineer-CNC)