

Engineering Company (India) Pvt. Ltd.

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

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.			
2	Machined By		11887	
3	Pallet Die No.		V.T.L M/C Shop	45/60
4	Die Category	Drg. No.	12404	Drg No - LSP 584
5	Out Side Diameter	Drg. No.	Jumbo (8.0mm)	(Revol)
6	Inside Diameter	Drg. No.	78.0mm, Step od-79.8mm	
7	Width of Pellet Die	Drg. No.	66.12mm	Tapper - 4°
8	Grooves as per Drawing	Drg. No.	324mm	Step length 25.5mm
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 10mm / 21.5 x 8 x 10mm	Under cut 9.0mm
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	[Tapping No. of
12	Tapping PCD		M/C Shop	Holes 12 Both
13	Tapping Hole Diameter		725mm	Side
14	Tapping On Second Side	Half pitch of 1st side	M20 Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth-31mm Tapping Depth-38.8mm	
17	Visual Inspection Before Gun Drilling		Yes	
Inspected By (Sign) & Date				

Inspected By (Sign) & Date			Ramanpreet Singh 22/5/24	
1	As per programme no.			[2 Slot
2	Gun Drilling Work Completed On			32.1 mm width
3	Hole Finish In Gun Drilling	Marked		8mm Deep
4	Defective Holes (If Any)		ok	Both Side
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				

1	Counter Sinking Depth & Finish	ok							Counter - 60°
2	External Relief Dia	8.5mm	outside (3-3)	Inner					Row-27
3	External Relief Depth		23mm	15mm					
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh						
5	Material Sent For Hardening By (Name)		Laxk Furnace						
6	Material Sent For Hardening On Date		22	5	24				

Inspected By (Sign) & Date Ramanpreet Singh 22/5/24

Reviewed by (Engineer-CNC) *Satyam* 22/5/24

Manager-QA