

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		19093	30/40
3	Pallet Die No.		V.T.L M/C Shop	Drg No - LSD-335
4	Die Category		11837 (30mm)	(ReVoo)
5	Out Side Diameter	Drg. No.	500mm Senior	
6	Inside Diameter	Drg. No.	Step OD - 491mm	Step length - 17.5mm
7	Width of Pellet Die	Drg. No.	420.12mm	
8	Grooves as per Drawing	Drg. No.	158.1mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3mm / 12x8x3mm	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 8 Both Side]
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		454mm	
14	Tapping On Second Side	Half pitch of 1st side	3/4" Check by 3/4" Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 18.5mm Tapping Depth - 16.6mm	
17	Visual Inspection Before Gun Drilling		Yes	
			ok	

Inspected By (Sign) & Date Ramanpreet Singh 05/6/24

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter - 60°

1	Counter Sinking Depth & Finish	ok								Row - 25
2	External Relief Dia	3.5mm	outside (R-2)	INNER						
3	External Relief Depth		13mm	10mm						
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		05	6	24					

Inspected By (Sign) & Date Ramanpreet Singh 05/6/24

Satya
 5/6/24
 Reviewed by (Engineer-CNC)

Manager-QA