

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		12042	40/52
3	Pallet Die No.		V.T.L M/C Shop	Drg No - LSD-1063
4	Die Category	Drg. No.	12291 (80mm)	(REV00)
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	419mm - Step od-388mm	Step Length-9.5mm
7	Width of Pellet Die	Drg. No.	315.14mm (B)	
8	Grooves as per Drawing	Drg. No.	145mm	
9	Fitting Sizes on CNC Plate	Drg. No.	8X8X3mm / 8X8X3mm	
10	Drilling Area Surface Smoothness		OK	[Tapping No. of Holes 8 Both Side]
11	Tapping Operator		M/C Shop	
12	Tapping PCD		360mm / 355mm	
13	Tapping Hole Diameter		M12 / 3/4 Check by M12 / 3/4 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 21mm Tapping Depth - 18.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet Singh 13/06/24

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 - 600

1	Counter Sinking Depth & Finish	OK						Row-11
2	External Relief Dia	8.5mm	outside (R-R)	Inner				
3	External Relief Depth		20mm	12mm				
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		13	06	24			

Inspected By (Sign) & Date Ramanpreet Singh 13/06/24

Reviewed by (Engineer-CNC) Satya 13/06/24

Manager-QA