

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		12178	38/50
3	Pallet Die No.		V.T.L Mic Shop	Drg No-LSD 493
4	Die Category	Drg. No.	12416 (4.0mm)	(Rev 00) ✓
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	700mm, Step od-693mm	Step Length-20mm
7	Width of Pellet Die	Drg. No.	600.14mm Ø	Taper-1°
8	Grooves as per Drawing	Drg. No.	222mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x10x7.5mm / 12x10x7.5mm	
10	Drilling Area Surface Smoothness		OK	[Tapping No. of Holes 12 Both Side]
11	Tapping Operator		OK	
12	Tapping PCD		Mic Shop	
13	Tapping Hole Diameter		640mm	
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 - 20.4mm Tapping Depth - 18.6mm	
17	Visual Inspection Before Gun Drilling		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date		Ramanpreet Singh 14/06/24		
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-68
Row-31

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.5mm	outside (3-3)	Inner			
3	External Relief Depth		16mm	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		14	06	24		

Inspected By (Sign) & Date	Ramanpreet Singh 14/06/24						
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Satya 14/06/24

Reviewed by (Engineer-CNC)

Manager-QA