



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

CNC/QA/FM/02

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31-07-2013

Inprocess Inspection (Pellet Dies)

Pre-Process Inspection (Pellet Dies)				Rev. Date	31-07-2013
S.No.	Check Parameter	Specification	Observations	Remarks	
1	Work Order No.				
2	Machined By		15305	36/50	
3	Pallet Die No.		V.T.L. H/C Shop	Dry Holes 998	
4	Die Category	Drg. No.	14710 (3.0) mm	Renewed	
5	Out Side Diameter	Drg. No.	Extrude		
6	Inside Diameter	Drg. No.	619.9 mm, Step on	Tapper 12"	
7	Width of Pellet Die	Drg. No.	520.14 mm	Step length 18.5	
8	Grooves as per Drawing	Drg. No.	222 mm		
9	Fitting Sizes on CNC Plate	Drg. No.	13 x 8 x 5 mm / 13 x 8 x 5 mm		
10	Drilling Area Surface Smoothness		OK		
11	Tapping Operator		H/C Shop		
12	Tapping PCD		565 mm	Tapping H/C of Holes 12"	
13	Tapping Hole Diameter		H20, Check by H20 Ball	Ball Size	
14	Tapping On Second Side	Half pitch of 1st side	OK		
15	Tapping Hole Depth		Drill Depth 2.4 mm	Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		yes		
17	Visual Inspection Before Gun Drilling		OK		

Inspected By (Sign) & Date

Ques: 10/8/25

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 - 1 Hole Closed

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

Counter: 60	Row: 38
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Notes: 1. Mark the dimensions							
1	Counter Sinking Depth & Finish	OK					Row 138
2	External Relief Dia	3.5mm	Outer Side		Inner		
3	External Relief Depth		20mm		14mm		
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		10	7	25		

Inspected By (Sign) & Date

Seq: 10/7/25

Reviewed by (Engineer-CNC)

Manager-QA