

SUPRA QUALITY EXPORTS (I) PVT LTD

A-92,Road No. 16,
Wagle Industrial Estate
Thane west-400604
India

S/DIR/34 Rev.12 26/08/25
Phone : 45196493/94/95/96
Email:quality@supraexports.in

DIMENSIONAL INSPECTION REPORT

Part Description:- MS female

Part No:- 571269640.

C.P.O:-

Order Date:-

11-11-25

Order Qty:-

625

Vendor Name:- Welltech

S.P.O: SQPO2526 1726

Order Date:- 11-11-25

Order Qty: 1075

Buyer name:- Zappas romany DATE:- 16/11/25

Report No:-2526/0332

ZINC	<input type="checkbox"/>
COPPER	<input type="checkbox"/>
NICKEL	<input type="checkbox"/>
NICKEL CHROME	<input type="checkbox"/>
TIN	<input type="checkbox"/>
Un-plated	<input type="checkbox"/>

MATERIAL GRADE :- MS [mangneess Phospating]

SR NO	SAMPLE PARAMETER	1	2	3	4	5	6	7	8	9	10	REMARK
1	CH 24 ^{-0.10}	23.91 .95	23.95 .98	23.91 .94	23.97 .00	23.92 .93	23.96 .97	23.98 .00	23.98 .99	23.93 .94	23.96 .97	OK
2	26 ^{+0.2}	26.03	26.03	26.03	26.03	26.04	26.03	26.03	26.04	26.03	26.04	OK
3	10 ^{+0.2}	9.97	9.96	10.02	9.99	9.99	10.05	10.03	10.03	10.05	10.05	OK
4	8 ^{+0.2}	7.97	8.04	8.04	8.04	8.01	8.05	8.06	8.02	8.02	8.01	OK
5	Ø15 ^{+0.2}	15.01	15.01	15.02	15.02	15.01	15.02	15.01	15.02	15.01	15.01	OK
6	5 ^{+0.1}	5.01	5.02	5.02	5.02	5.01	5.00	5.00	5.01	5.01	5.02	OK
7	G 1/2"		G 1/2" DIN		SPM 6464 GO / B 8/1TR/310 Nogo							OK
8	20.95 (-0.282)	20.72	20.73	20.72	20.71	20.75	20.74	20.75	20.74	20.74	20.74	OK
9	19.793 (-0.282)	19.603	19.606	19.599	19.606	19.603	19.614	19.617	19.604	19.604	19.603	OK
10	Ø12.5 ^{+0.1}	Checked with pin			12.50 GO / 12.60 Nogo							OK
11	18.55 - 0.05	18.50	18.52	18.51	18.51	18.51	18.51	18.51	18.51	18.51	18.51	OK
12	3 ^{+0.10}											OK
13	groove width phosphate, manganese											OK
14	8T015 micron											OK
15	After treatment G 1/2"											OK
16	G 1/2" DIN SPM 6464 GO / B 8/1TR/310 Nogo											OK
17												
18												
19												
20												

CHECKED BY :-

Abhay P. Chavhan

SIGN & Dt:- 25/11/25

APPROVED BY :- DDCM

DATE:- 25-11-25

PREVIOUS DATE :

PREVIOUS REPORT NO : 25/477

RECEIVED QTY

853

LOT 1

: 820

nos. 16/11/25

LOT 2

: nos.

LOT 3

: nos.

LOT 4

: nos.

REMARK : 1) Hex side face observed rusty in term to visual term, need to polish hex before phosphating.
2)
3)
4) phosphating is accepted as per previous Report.
5)

PHOSPHATING REPORT

Report No.	PR-FSI-00056	Invoice No.	Invoice Date	INVOICE QTY	
Report Date	24-11-2025	LSTHN00005	24-11-2025	853	
Customer	Supra Quality Exports (I) Pvt Ltd,	Process	Manganese Phosphating 7 Tank Process		
Part No.	SS NIPPLE RACC. G 1/2	Product Description	ADJUSTING NUT		
Sr.No.	Parameter Checked	Degreasing	Activation	Phosphating	
		(Rang above 40)	(Rang 8 to 10)	Total Acidic (7 to 8) Free Acidic (1.1 to 1.4)	
1	Titration	43	9.5	7.3 1.3	
2	Temperature	50 - 60°C	60 - 70°C	85 - 95°C	
		56	67	94°C	
3	Process Cycle Time	2 - 3 Min	0 - 2 Min	3 - 8 Min	
		3 M	2 M	8 M	
4	Coating Weight (3.23 - 16.15 gm/m ²)	Insp Method	Observation		Remark
		Striping Method	6.715gm/m ²		OK
5	Phosphating Colour (Grey to Black)	Visually	OK	OK	OK

Coating Weight Procedure :

- 1 Take 1 No Popular panel size 69*150mm. Process for phosphating then dry and check coating weight.
Take Rotametal and glass beaker of 2 liter fill with solution made up of 1 liter water with 100 gram chromiumTrioxide . Heat upto 75 oC then insert panel and wait for 10 Minutes. Wash the panel properly under running water. Dry the panel and reweight
- 2 chromitum Trioxide . Heat upto 75 oC then insert panel and wait for 10 Minutes. Wash the panel properly under running water. Dry the panel and reweight

Example :

Calculations: For Standard Panel 69 x 150 mm

$$\text{Coating Weight (gm/m}^2\text{)} = \frac{\text{Wt. of Phosphate panel (gm)} - \text{Wt. after stripping (gms)}}{\text{Area of panel (mm}^2\text{)}}$$

$$\frac{80.344 - 80.205}{(69\text{mm} \times 150\text{mm}) \times 2 / 1000000 \text{ m}^2}$$

$$\frac{0.139}{0.0207}$$

$$= 6.715 \text{ gm/m}^2$$

Conversion parameter is 0.7

$$x \text{ gm/m}^2 * 0.7 = y \text{ micron}$$

1 MICRON INCREASE IS EQUAL TO 1.42 gm/m²

Remark : Coating Meets specification.

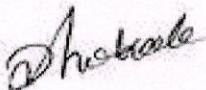
for **FOUR STAR INDUSTRIES**

Checked by : Nitin G.

Approved by : Rajesh D.

FORMAT NO.FSI/804/F03

REV. NO : 00


Authorized Signatory