

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

Before plating

Part No:- 571269640.

C.P.O:-

Order Date:-

Order Qty:-

Vendor Name:- Welltech

S.P.O: SQPO2526

Order Date:-

Order Qty:-

Buyer name:- Zappas romanly 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 [mangnees Phosphating]

SR NO	SAMPLE PARAMETER	1	2	3	4	5	6	7	8	9	10	REMARK
1	CH 24 ^{-0.130}	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	15 ^{+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 5/7R/310 Nogo										OK
8	20.955 (-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	12.5 ^{+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	Checked with slip 2.90 Go / 3.10 Nogo										OK
13	Phosphate, manganese	Visually checked After Plating										OK
14	8 TO 15 micron	Report attached with										OK
15	After treatment G 1/2"	G 1/2" DIN SPM 6464 Go / (B) 8/7R/310 Nogo										OK
16	12.5 ^{+0.1}	Checked with pin 12.50 Go / 12.60 Nogo										OK
17												
18												
19												
20												

CHECKED BY :-

Abhay P. Chavan

SIGN & Dt:- 25/11/25

APPROVED BY :-

DDX

DATE:- 25-11-25

PREVIOUS DATE :

PREVIOUS REPORT NO : 25/477

RECEIVED QTY

853

LOT 1

: 280

nos. 16/11/25

LOT 2

:

nos.

LOT 3

:

nos.

LOT 4

:

nos.

REMARK : 1)

Hex Side face observed rusty in term to visual team, need to polish hex before phosphating

2)

3)

4)

5)



FSI **FOUR STAR**
INDUSTRIES
Pioneers in Differential Spiders

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	Mangnese 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 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
- 2 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

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

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

1 MICRON INCREASE IS EQUAL TO 1.42 gm/m²

Remark : Coating Meets specification.

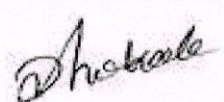
for **FOUR STAR INDUSTRIES**

Checked by : Nitin G.

Approved by : Rajesh D.

FORMAT NO.FSI/804/F03

REV.NO : 00


Authorized Signatory