

## **Quality Inspection Report (Inprocess Inspection)**

Report #	QIRI20253105	Select the Appropriate Inspection Stage / Process					
Date	17-06-2025	In process Inspection of etched Blades					
Production Order#	ACUCUT SOPD2526-0002						
Item Code	MVR 20	\$ A *					
Product Description	MVR Lance 20G						
DHR#	20251378	×					
Batch #	EP0590/2025						
Reference Drawing	SECPL/MVR/07	d d					

						Setup A	pprova	l (Actual	Reading	gs/Obse	rvation)			Result (Complied / Not Complied)	
Sl.No.	Parameter	Requirement	Instrument Used	1	2	3	4	5	6	7	8	9	10		Remarks
1	Wire Diameter	0.81 ± 0.02mm	Micrometer	0.819	0.816	0.818	0.809	0.817	0.816	0.819	0.804	0.806	0.807	Complied	1
2	Width of the Blade	1.20 ± 0.1mm	Ocular/Microscope	1.20	1.10	1.20	1.20	1.20	1.20	1.20	120	1.20	1.20	Complied	
3	Thickness of the Blade	0.55 ± 0.02mm	Micrometer	0.548	0.546	0.549	0.551	0.549	0.541	0.556	0.558	0.558	1	Complied	1
4	Prenotch Length	25.00 ± 0.5mm	Digital calliper	24.91	24.88	24.98	2501	25.16	94.94	25.16	24.89	25.08	25.09	Complied	QN QN
5	Surface Finish	Matte Finish	Microscope	OK	OLL	OK	olc	OIL	OK	ok	de	OK		Complied	
6	Visual Inspection	Free from deffects	Microscope	OK	OR	ok	OK	014	ok	ok	OK	ok	Ole	Complied	
												-			1
Inspecte	ed By (Name)		SHIVANAND				Sig	gnature	(with da	te)	B	17-0	6-202	-5	

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Sl.No.	Parameter	Date and Time	Instrument Used	Inpro	cess San	nples Ins	pection	(Put "√	" - Com	plied and	d "X"-	Not Com	plied)	Inspected by	Remarks	
Jiii o				1	2	3	4	5	6	7	8	3 9 10	(Signature)			
		17-06-2015		~	~	~	~	V	-	~	_	~	-	8		
		02:30 PM		~	\ \ \	~	~	-	~	-	-	-	_	-8		
				V	-	-	~	~	-	~	-			8		
		03;30Рн		~	~	~	~	~	~	-	-	~	_	8		
				~	X	~	-	~	_	-	<u>_</u>	_		\$	No web	
		04:30PH	Ocular/Microscope Digital Micrometer Microscope	~	~	V	~	V	~	~	1	·	~	8		
				~	~	V	~	-	V	V	_	~	L	8		
		05:30PM		~	~	-	~	~	~	-	~	_	_	8		
	Width of the blade Thickness of the blade Surface Finish & Visual Checks	X / N		~	~	~	~	~	V	~	-	-	- L	8		
1		18-06-2024		~	-	~	-	~	-	~	-	i	_	8		
2 3		09:40AM		~	-	X	~	-	-	-			_	8	woshins	
		*		~	-	~	1	-	-	-	V	~	L	8		
		10:40 An		N.		~	-	-	~	-	~	-	L	-	1	8
		St						V	-			-		~	~	-
		11:40A7		~	-	1		1	1	1		-		8		
	,			~	~	1		_	-	L	_	- 1	X	\$	Burr	
		12:4077		~	-	-	~	~	-	-	-	-		8	1.700	
		OLLUPT			1	-	~	~	~	~	-	~	~	8		
		02:48PM		~	~	1	~	~	~	~	-	~	~	8		
		03:40PM			~			~	-	~	-	~	-	8		
Sample In	spected Quantity		-1	Accepted	Batch Qu	antity	-	_		Remarks				•		
Defects O	bserved (Type)	- E	-							Heral Local III on	CEDERAL MEDIL FEETS					
	ality Inspection Result					Inspect	ed By (N	lame)	SI	HVANAN	ND	Approv	ed By (N	Name) MU	RIGESHAPPA R	
- Landered	Batch conform to the requir					Signatu			8 . 1-2025			Signatu		. (	No ad	
	Batch do not conform to the	e requirement and not	approved			with da	te		Pu	3-06-2	7	with da	te	U	10 18 06,20	

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SI.No.	Parameter	Date and Time	Instrument Used	Inpro	Inprocess Samples Inspection (Put "v" - Complied and								plied)	Inspected by	Remarks
31.140.	I a dimeter			1	2	3	4	5	6	7	8 9 10	10	(Signature)		
	_	18-06-205		~	~	~	~	~	-	~	-	-	-	-8	
		04:4084		~	~	-	/	~	~	-		~	-	3	
				~	~	~	~	~	~	-	-	~	<u></u>	-	
				V	-	~	~	~	~	~	~	V	~	7	
		05:40 84		V	~	~	~	1	~			-	-	-8	Dent
				~	-	-	_		-	-	-		-	-\$	
		19-06-2025		V	~	~	~	~	~	-	-	c	~	8	
		09:40AM		V	-	-	-	~	-	-	-	L	-	-8	
				~	~	-	-	V	~	V	-	v	-	8	
1	Width of the blade Thickness of the blade Surface Finish & Visual		Ocular/Microscope Digital Micrometer Microscope	~	~	~	~	V	L	v	<u></u>	V	V	8	
2		10:40AM		~	~	~	V	V	-	~	-	~	-	-8	
	Checks		, maioscope	~	~	-	~	~						-\$	
													<u> </u>		
amole Ir	nspected Quantity	3151	Pre	Accepted	Batch Qu	antity	1.	04221	Pes	Remarks			04 4	Sos Defec	4
	Observed (Type)		vashing, Bu									1	572 101		
	iality Inspection Result	NO WED,	v 45hin 5, 150	001	OFD.	Inspect	ed By (N	lame)	S	HIVANA	ND	Approv	ed By (	Name) MUR	IGESHAPPA
	Batch conform to the requ					Signatu			ENAME			Signatu		101	19-06-2
	Batch do not conform to th		t approved			with da	te		7	\$19-06-20)5			ite	4	19-06-2

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## **Quality Test Report**

Report #	QIRI20253106	Type of Test	Penetration Force test		
Date.:	17-06-2025	Type of Test	renetration Force test		
Production Order #	ACUCUT SOPD2526-0002	Testing Work Instruction #	SECPL_WI_047		
Product Description	MVR LANCE 20G-PN 25MM	Testing Equipment Name	CHATILLON FORCE MEASUREMENT		
tem Code	MVR 20	Equipment ID #	SECPL/INS/ 146		
Batch #	EP0590/2025	DHR#	20251378		

SI.No	Sample #	Requirement				Actual	Readin	gs/Obse	ervation				Result (Complied / Not Complied)	Test Gr	aph/ Test Sample (Image)	
1	01-10		52.33	54.63	55.29	57.02	59.55	52.11	55.82	53.51	54.48	60.91	Complied	70.00 51 30 1 7	EP0590-2025 [Compression]	
2	11-20		66.54	60.73	57.52	56.50	62.90	60.63	62.67	59.76	63.37	65.60	Complied	*** ** • * * * * * * * * * * * * * * *		
3	21-30		60.66	64.37	59.30	58.05	63.39	61.95	65.15	63.76	62.95	63.72	Complied	6000		
4	31-40		63.25	66.48	55.72	55.29	53.50	56.70	57.19	52.04	59.71	52.66	Complied	5000		
5	41-50		65.08	61.22	60.82	60.12	59.46	62.14	60.22	64.30	64.93	59.60	Complied 5400	§ 4000 /		
6	51-60		60.86	60.69	60.51	59.35	61.50	63.88	62.07	65.86	53.16	54.88	Complied	3000		
7	61-70	61.00 ± 10gf	55.72	54.47	55.70	52.89	56.81	53.50	55.44	51.59	59.40	58.20	Complied	2000		
8	71-80		55.55	58.92	59.75	58.76	63.82	58.19	59.67	60.25	61.48	60.43	Complied	//		
9	81-90		53.67	53.63	59.83	53.70	56.70	53.57	57.04	56.55	53.94	55.92	Complied	10.00		
10	91-100		59.55	63.25	61.16	59.81	60.93	61.60	65.33	66.26	65.60	67.18	Complied	-0.00 10.00	2000 3000 4000	
11	101-110		55.64	57.12	60.93	55.06	57.31	57.04	57.83	57.38	56.05	54.03	Complied		Time [s]	
12	111-112		56.65	63.39									Complied	Pene	tration value - 52.33gf	
Inspect	ed By (Name)						SHI	VANAN	)					Signature (with date)		
Post Test Result										Approved By (Name)	MURIGESHAPPA R					
☑ B	atch conform to	the requirement	and ap	proved											, Cotto	
	atch do not con	form to the requir	ement	and not	approv	/ed								Signature (with date )	Up 1906-202	