

Report No	QIRI20253191	Select the Appropriate Inspection Stage / Process								
Date	27-06-2025	Inspection of Blanks (Punched)								
Production Order	PR025-0796	E FLATTENING COMMING E								
Item Code	MVR 20G-E	COINING								
Product Description	MVR-Lance 20G (RAJARATHNA)	CA CA CA								
DHR No	20251512									
Batch No	PU0185/2025									
Reference Drawing	NA									

SI.N			Instrument			Setup	Approva	I (Actual	Reading	s/Observ	ration)			Result (Complied / Not Complied)	
о.	Parameter	Requirement	Used	1	2	3	4	5	6	7	8	9	10		Remarks
А	Wire Diameter	0.90 ± 0.005 mm	DM	0.905	0.903	0,902	0.904	0.905	0.903	0.901	0.904	0.905	0.905	Compled	1
F(B)	Width of the flat	1.10 ± 0.10 mm	DVC	1.10	1.09	1.12	1:11	1.09	1.11	1.12	1.12	1.09	1.08	Complied	
F(E)	Thickness of the flat	0.63 ± 0.02 mm	DM	0.631	0,629	0.635	0.637	0.629	0.631	0.635	8.640	0:627	0,636	Complied	
C(B)	Width of the blank	1.40 ± 0.10 mm	DVC	1.39	1.242	1.216	1.43	1.38	1.42	1.212	1.242	1.41	1,43	Complied	
C(C)	Cutting length of the blank (LHS)	2.60 ± 0.10 mm	DVC	2.61	9.65	2,63	2.57	2.59	2.67	2.52	2,61			Compred	ď.
	Cutting length of the blank (RHS)	2.60 ± 0.10 mm	DVC		-									Complied	2
	Pre notch length	23.40 ± 0.50 mm	DVC	23.41	23,52	23,55	23.49	23,55	23.39	23,45	23.49	23,35	23,49	Compled	
C(E)	Flash land thickness	0.06 ± 0.01 mm	DM	0.061	0.065	0.069	0.066	0.070	0.063	0.061	0.067	0.066	0.063	Complied	
C(F)	Blank thickness	0.63 ± 0.02 mm	DM	0.631	0.635	0.637	0.640	0.633	0.637	0.638	0.639	0.631	0.637	Compled	
*	Surface Finish	Deffects Free	Microscope	OK	OK	OK	OK	OK	ok	ok	OK	OK	OK	Compled	
											1				
Insp	ected By (Name)		LAKSH	IMI			Si	gnature ((with dat	e)	(Contraction of the contraction	24-06-	2025.		

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SI.N o.			Instrument	In	orocess S	Samples Ir	rspection	n (Put "v'	- Comp	olied and	"X "- No	t Complie	ed)	Inspected by	Remarks		
	Parameter	Date and Time	Used	1	2	3	4	5	6	7	8	9	10	(Signature)	Remarks		
		27-06-2025	PHILIPPINA TO HAT DODGE	V	/	~	/			/			2	John Marie Control			
					~									10			
		01:10 PM												and the second			
					V				~		1	~		70			
		02110 PM					V						1	OCT.			
					~						1			10			
		03:10 PM		_				~	V	~	-	~	-	Pak			
1.	Width of the flat		DVC	~	~	~		4	~	~	~		1	(Sale)			
 3. 	Thickness of the flat Width of the blank	04:10 PM	DM DVC	~	V	/	~			_	~	-		(A)	Hode 2		
4.	Cutting length of the blank		DVC DVC DM VISUAL/MICRO SCOPE	-	V	V	~				V	Ú	~	- A			
5.	Pre notch length	05:10 PM						/		~	~	~		100			
6.	Blank Thickness			~		~	~							Contract of the contract of th			
7.	Visual Checks	06:00 PM		SCOPE	SCOPE			<u> </u>					~			Egy.	
	Tart -	28-06-2025			~	<u> </u>								Born			
	1	09130AM					~		~	<u> </u>		~	~				
		MA 02:01		V	~	V	V	~	~		V	-					
	y (k)	MA OEIII		~		~	~		V	~	~		~	(BOW)			
		M904161		~				~		~			~	1300			
		01/30 PM	-		~	~	~							100 P			
Man 2		02:30 PM							~			-		200			
	le Inspected Quantity	_		Accepted	Batch Qua	ntity		-		Remarks							
1000	ts Observed (Type)			PALIFFER LEG			10 (0)	•		LAVCUBA			- J D., (No.		IGESHAPPA R		
SPECIFICAL PROPERTY	Quality Inspection Result					Inspecte Signatur		me)	LAKSHMI			Signatur	ed By (Na	mej Muk	C/		
Batch conform to the requirement and approved Batch do not conform to the requirement and not approved									10	2.06-26		with dat		l l	128060		
<u> </u>	Annexure to be provided for addi					with dat		Amorea 1975	16/10	, C					2000		

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SI.N o.			Instrument Used	In	process :	Inspected by											
	Parameter	Date and Time		1	2	3	4	5	6	7	8	9	10	(Signature)	Remarks		
		28-06-2025.	4.	V	~		_							29			
		04170 PM	1									1		ROM			
		05:20 PM										0		60%			
		06100 PM	1											E CO			
		29 - 06-2025 09/HOAM				1,								30%			
		101 HO PM	1								×		1	Edin	Scratches		
		1/1/40 AM			. /	./								eson,	Sources		
1.	Width of the flat	12140 PM	DVC											(30)			
2.	Thickness of the flat Width of the blank Cutting length of the blank Pre notch length	OTHORM	DVC DVC DVC DVC											2017			
3.		02: 40PM												1300			
4. 5.		MACH! EO			1									(20)			
6.	Blank Thickness	041HOPM	DM										1	1803			
7.	Visual Checks	05: 20 PM	VISUAL/MICRO SCOPE			·			./	./						(600)	
		06:00 PM				SCOPE				X							CON
		OBIOOVI			10		-							190			
		30-06-2025 09/HOAM												(Color			
		10140PM							1		1 2			DOS			
- 1		MAGAIN					-	-	1							Cal	
		12140 PM			•	~	~							1300			
		ON PM					-				1			1000			
mpl	e Inspected Quantity	-		Accepted	Batch Qua	ntity	_	-2		Remarks		02 1	2'00	Deffect.			
efect	s Observed (Type)	Scrotches	Far W	antation	on.					Access to the same							
ost	Quality Inspection Result					Inspecte	d By (Na	me)		LAKSHM		Approve	ed By (Na	ame) MU	RIGESHAPPA R		
Batch conform to the requirement and approved							e		100 30-06-2025.			Signatur		11	1º		
	Batch do not conform to th	e requirement an	d not approve	ed		with dat	е		1	0-06-		with dat	te		30.06-2		

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SI.N o.	Parameter	Date and Time	Instrument	In	orocess :	Samples	Inspectio	n (Put "V	" - Comp	olied and	"X "- N	ot Compli	Complied)	Inspected by	
	raiailletei		Used	1	2	3	4	- 5	6	7	8	9	10	(Signature)	Remarks
		30-06-2025 02140 PM		1/	~	V		./			0			(ACC)	1
		03'HO PM		V				-		V	-	-		1300	
		MQ 04;40				V	v					-	_	COU	
		06:00 PM						~	~					1305	
		06:00 PM 01-07-2025 09:40 AM			V					2	1			BOU	
		10:40 to 11:40A	1		V				~	1	~	_		1000	
		12140 PM		V			~				~			800/	
1.	Width of the flat	1:40 to 2:40PM	DVC		~					~				Box	
2.	Thickness of the flat Width of the blank	MQ OHIZO	DM	~						~				(200	2
4.	Cutting length of the blank	05:00 PM.	DVC DVC	~	~	~				~	_	-	-	2001	
5.	Pre notch length		DVC									1		//	
6. 7.	Blank Thickness Visual Checks		DM VISUAL/MICRO									h I			
-	Visual Checks		SCOPE												
The second															
				-										1	
				-						NA	1 (11.				
							7								
														-	
										1		-		1	
ample	e Inspected Quantity	500 PCS.	×	Accepted B	atch Quar	ntity	11157	36 PC	S.	Remarks		_		1	
efect	s Observed (Type)	-		n Nilen (g. c. e. e. g.			7(-(-				7/4/ (= 1				
	Quality Inspection Result					Inspecte	ed By (Na	me)	1	LAKSHMI		Approve	d By (Na	me) MURI	GESHAPPA R
Batch conform to the requirement and approved						Signatu	'e		101-01-2025.			Signatur		.0	No.
VI.	Batch do not conform to the Annexure to be provided for addit			ed		with dat	te		10	-04-1		with dat	e		01-07-21

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