



# VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED GROUP OF COMPANIES

## SURFACE PREPARATION & PRIMER PAINTING INSPECTION OFFER

<b>CLIENT</b>	GFCL EV Products Limited	<b>PROJECT</b>	HH-2700 TPA	<b>REPORT NO.</b>	VE/HH-2700 TPA/STR/SP/OFFER/1
<b>WO/PO NO</b>	9252100056	<b>PROCEDURE NO.</b>	VEPL/GFCL/HH-2700 TPA/ITP/001	<b>OFFER DATE</b>	01/06/2025

### WEATHER CONDITION

<b>ACTIVITY</b>	<b>DATE PERFORMED</b>	START TIME - 14:30				FINISH TIME- 19:45			
		<b>SURFACE OR METAL TEMP °C</b>	<b>DEW POINT °C</b>	<b>RELATIVE HUMIDITY %</b>	<b>AMBIENT TEMP °C</b>	<b>SURFACE OR METAL TEMP °C</b>	<b>DEW POINT °C</b>	<b>RELATIVE HUMIDITY %</b>	<b>AMBIENT TEMP °C</b>
Blasting / Surf. Prep.	31/05/2025	33	29	56.4	38.9	32	28.2	61.7	36.5
Primer Application	31/05/2025	32	28.2	61.7	36.5	33	27.1	73.5	32.3

### SURFACE CONDITION

<b>ORIGINAL STATUS</b>	NON COATED	<b>METAL CONDITION</b>	NON COATED	<b>METAL RUST GRADE</b>	B
<b>PAINT SYSTEM NO.</b>	GFL STRUCTURAL			<b>BLASTING DATE</b>	31/05/2025

### SURFACE PREPARATION

<b>BLASTING METHOD</b>	CU-SLG	<b>PREP. STANDARD</b>	SA 2 1/2	<b>ABRASIVE TYPE</b>	GU-SLG
<b>SURFACE PROFILE REQUIREMENT</b>	40 - 70 Microns				
<b>DUST LEVEL</b>	01	<b>SALT TEST REQUIRED</b>	Maximum 80 mg/m <sup>2</sup>		

### PRIMER COATING

<b>PRIMER PAINT/SHADE</b>	SIGMACOVER 620	<b>APP. METHOD</b>	SPRAY	<b>PRIMER DATE</b>	31/05/2025
<b>PAINT MANUFACTURER</b>	ASIAN PPG	<b>DFT RANGE</b>	150 Micron	<b>HARD DRY TIME</b>	6
<b>PAINT BATCH NO. (BASE)</b>	'0537500151	<b>MANUFACTURE DATE</b>	26/04/2025	<b>SHELF LIFE</b>	36 MONTHS
<b>PAINT BATCH NO. (HARDNER)</b>	'0537500151				

<b>SR. NO.</b>	<b>DRAWING NO.</b>	<b>REV</b>	<b>ASSEMBLY NUMBER</b>	<b>GRID NUMBER</b>	<b>GRID QTY</b>	<b>REMARKS</b>
1	1619-CS-STR-504-FD-1C15	0	1C15	E-4	1	--
2	1619-CS-STR-504-FD-2C14	0	2C14	E-3	1	--

<b>NOTE</b>	--
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	<b>OFFERED BY</b>
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<b>SIGN</b>	
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<b>NAME</b>	BIRENDRA KUMAR
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<b>DATE</b>	01/06/2025
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VE-DOC-23 REV.00



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<b>WO/PO NO</b>	9252100056	<b>PROCEDURE NO.</b>	VEPL/GFCL/HH-2700 TPA/ITP/001	<b>OFFER DATE</b>	01/06/2025		
SR. NO.	DRAWING NO.	REV	ASSEMBLY NUMBER	GRID NUMBER	GRID QTY	REMARKS	
3	1619-CS-STR-504-FD-2C15	0	2C15	E-4	1	--	
4	1619-CS-STR-504-FD-1C14	0	1C14	E-3	1	--	
5	1619-CS-STR-504-FD-1C35	0	1C35	C-2	1	--	
6	1619-CS-STR-504-FD-2C13	0	2C13	E-2	1	--	
7	1619-CS-STR-504-FD-2C35	0	2C35	C-2	1	--	
<b>NOTE</b>	--						
	<b>OFFERED BY</b>						
<b>SIGN</b>							
<b>NAME</b>	BIRENDRA KUMAR						
<b>DATE</b>	01/06/2025						

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