



VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED GROUP OF COMPANIES

SURFACE PREPARATION & PRIMER PAINT INSPECTION REPORT

CLIENT	GFCL EV Products Limited	PROJECT	HH-2700 TPA	REPORT NO.	VE/HH-2700 TPA/STR/SP/2
WO/PO NO	9252100056	PROCEDURE NO.	VEPL/GFCL/HH-2700 TPA/ITP/001	OFFER DATE	02/06/2025

WEATHER CONDITION

ACTIVITY	DATE PERFORMED	START TIME - 10:00				FINISH TIME- 16:00			
		SURFACE OR METAL TEMP °C	DEW POINT °C	RELATIVE HUMIDITY %	AMBIENT TEMP °C	SURFACE OR METAL TEMP °C	DEW POINT °C	RELATIVE HUMIDITY %	AMBIENT TEMP °C
Blasting / Surf. Prep.	02/06/2025	33.8	28	72.6	33.5	38.2	28.8	57.5	38.4
Primer Application	02/06/2025	37.4	27.7	64.1	35.6	36.2	26.5	66.3	33.6

SURFACE CONDITION

ORIGINAL STATUS	NON COATED	METAL CONDITION	NON COATED	METAL RUST GRADE	B
PAINT SYSTEM NO.	GFL STRUCTURAL			BLASTING DATE	02/06/2025

SURFACE PREPARATION

BLASTING METHOD	CU-SLG	PREP. STANDARD	SA 2 1/2	ABRASIVE TYPE	GU-SLG
SURFACE PROFILE REQUIREMENT	40 - 70 Microns	ACTUAL SURFACE PROFILE	50-60		
DUST LEVEL	01	SALT TEST REQUIRED	Maximum 80 mg/m2	SALT TEST READING	22.4mg/m2

PRIMER COATING

PRIMER PAINT/SHADE	SIGMACOVER 620	APP. METHOD	SPRAY	PRIMER DATE	02/06/2025
PAINT MANUFACTURER	ASIAN PPG	DFT RANGE	150 Micron	HARD DRY TIME	6 HOURS
PAINT BATCH NO. (BASE)	'0537500151	MANUFACTURE DATE	26/04/2025	SHELF LIFE	36 MONTHS
PAINT BATCH NO. (HARDNER)	'0537500151				

SR. NO.	DRAWING NO.	REV	ASSEMBLY NUMBER	GRID NUMBER	GRID QTY	Average DFT	ACC/REJ
						PRIMER	
1	1619-CS-STR-504-FD-1C24	0	1C24	D-2	1	150-165	ACC
2	1619-CS-STR-504-FD-1C25	0	1C25	D-3	1	165-170	ACC

NOTE	--
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	VISHAL QC	CLIENT / TPIA
SIGN		
NAME	BIRENDRA KUMAR	
DATE	02/06/2025	

VE-DOC-24 REV.00



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3	1619-CS-STR-504-FD-1C26	0	1C26	D-4	1	155-165	ACC
4	1619-CS-STR-504-FD-1C37	0	1C37	C-4	1	165-170	ACC
5	1619-CS-STR-504-FD-2C24	0	2C24	D-2	1	165-175	ACC
6	1619-CS-STR-504-FD-2C25	0	2C25	D-3	1	155-162	ACC
7	1619-CS-STR-504-FD-2C26	0	2C26	D-4	1	155-175	ACC
8	1619-CS-STR-504-FD-2C37	0	2C37	C-4	1	165-170	ACC
NOTE	--						
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