



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/3
WO/PO NO	9252100056	PROCEDURE NO.	VEPL/GFCL/HH-2700 TPA/ITP/001	OFFER DATE	03/06/2025

WEATHER CONDITION

ACTIVITY	DATE PERFORMED	START TIME - 09:30				FINISH TIME- 11:45			
		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.	03/06/2025	33.8	28	72.6	33.5	35	26.7	56.9	36.5
Primer Application	03/06/2025	35	26.7	56.9	36.5	38.2	28.8	57.5	38.4

SURFACE CONDITION

ORIGINAL STATUS	NON COATED	METAL CONDITION	NON COATED	METAL RUST GRADE	B
PAINT SYSTEM NO.	GFL STRUCTURAL			BLASTING DATE	03/06/2025

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	31/05/2025
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	Average DFT	ACC/REJ
					PRIMER	
1	1619-CS-STR-504-FD-1C13	0	1C13	E-2	1	150-165
NOTE			--			
	VISHAL QC			CLIENT / TPIA		
SIGN						
NAME	BIRENDRA KUMAR					
DATE	03/06/2025					

VE-DOC-24 REV.00