



VISHAL ENTERPRISE & VRISHAL ENGINEERING PRIVATE LIMITED GROUP OF COMPANIES

SURFACE PREPARATION & PRIMER PAINTING INSPECTION OFFER

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

WEATHER CONDITION

ACTIVITY	DATE PERFORMED	START TIME - 14:30				FINISH TIME- 19:45			
		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.	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

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

SURFACE PREPARATION

BLASTING METHOD	CU-SLG	PREP. STANDARD	SA 2 1/2	ABRASIVE TYPE	GU-SLG
SURFACE PROFILE REQUIREMENT	40 - 70 Microns				
DUST LEVEL	01	SALT TEST REQUIRED	Maximum 80 mg/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
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	REMARKS
1	1619-CS-STR-504-FD-1C15	0	1C15	E-4	1	--
2	1619-CS-STR-504-FD-2C14	0	2C14	E-3	1	--

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



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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	--
NOTE	--							
	OFFERED BY							
SIGN								
NAME	BIRENDRA KUMAR							
DATE	01/06/2025							

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