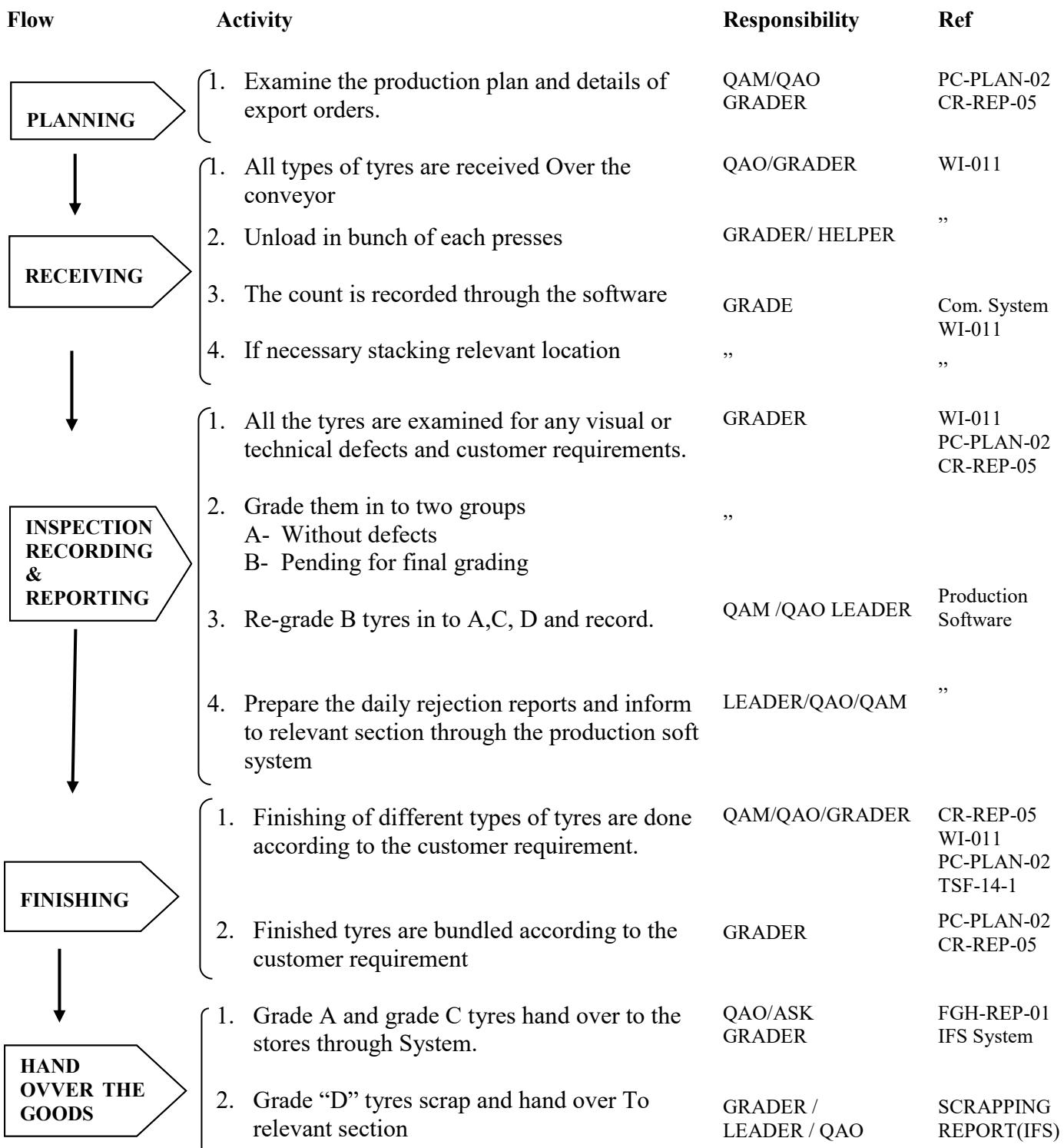


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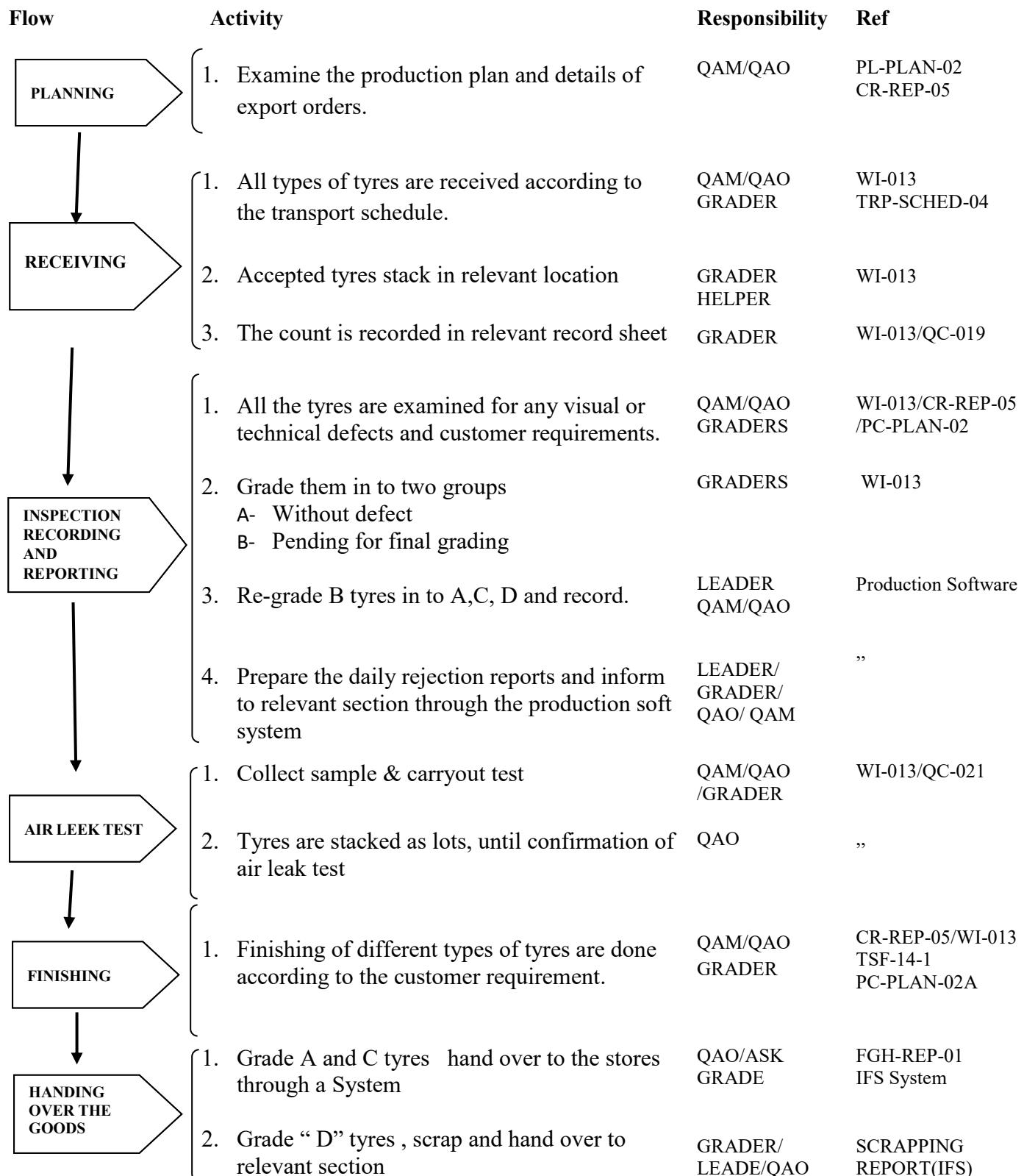
8.3 PROCEDURE FOR GRADING OF BICYCLE TYRES, MOTOR CYCLE TYRES, LAWN AND GARDEN TYRES, AIR BAG, RIM TAPE AND TUBE**8.3.1 Procedure for grading of bicycle tyres. (Export & Domestic)**

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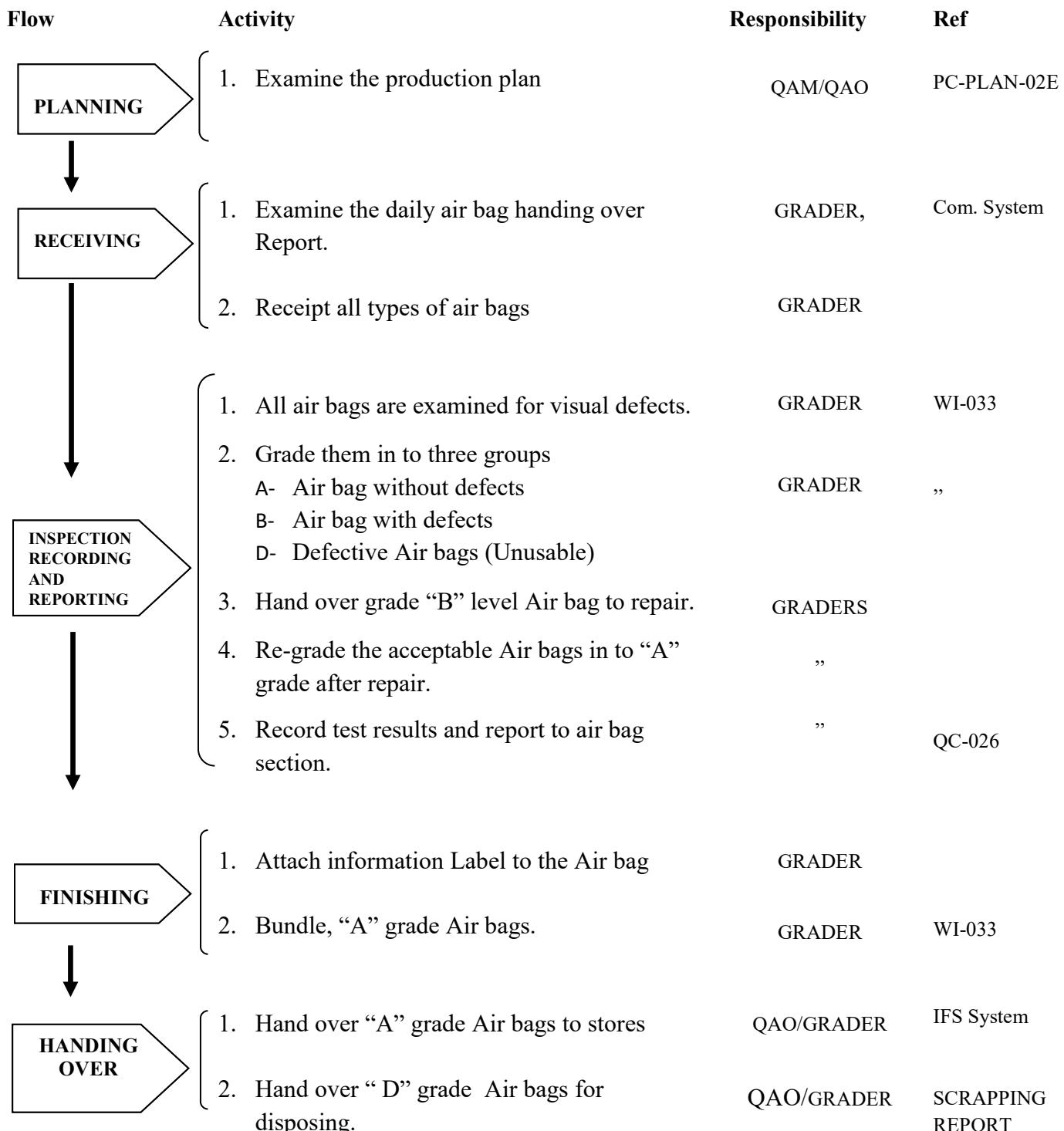
8.3.2 Procedure for grading of Lawn and garden tyres.

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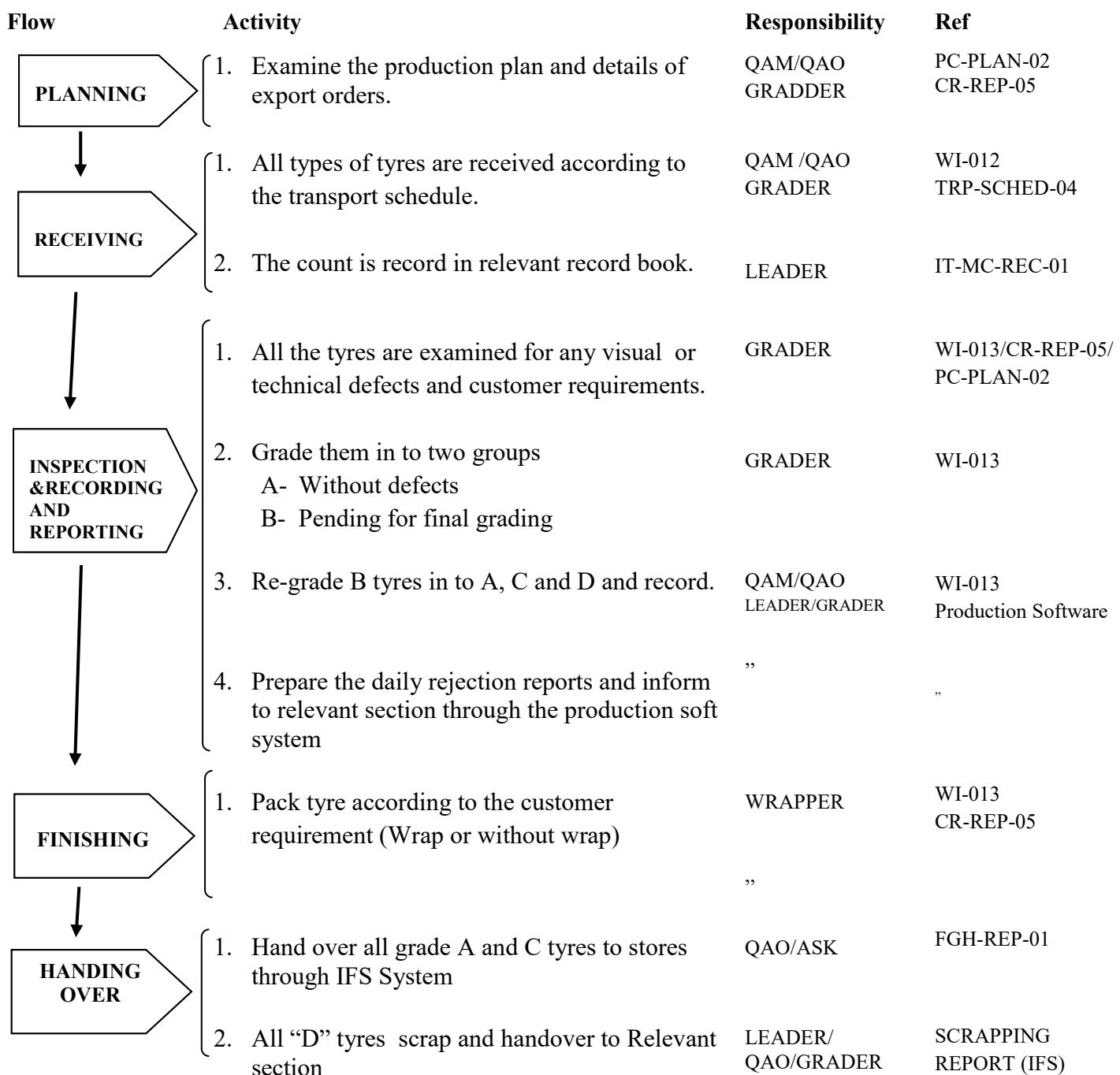
8.3.3 Procedure for Air bag grading.

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8.3.4 PROCEDURE FOR GRADING OF MOTOR CYCLE TYRES.

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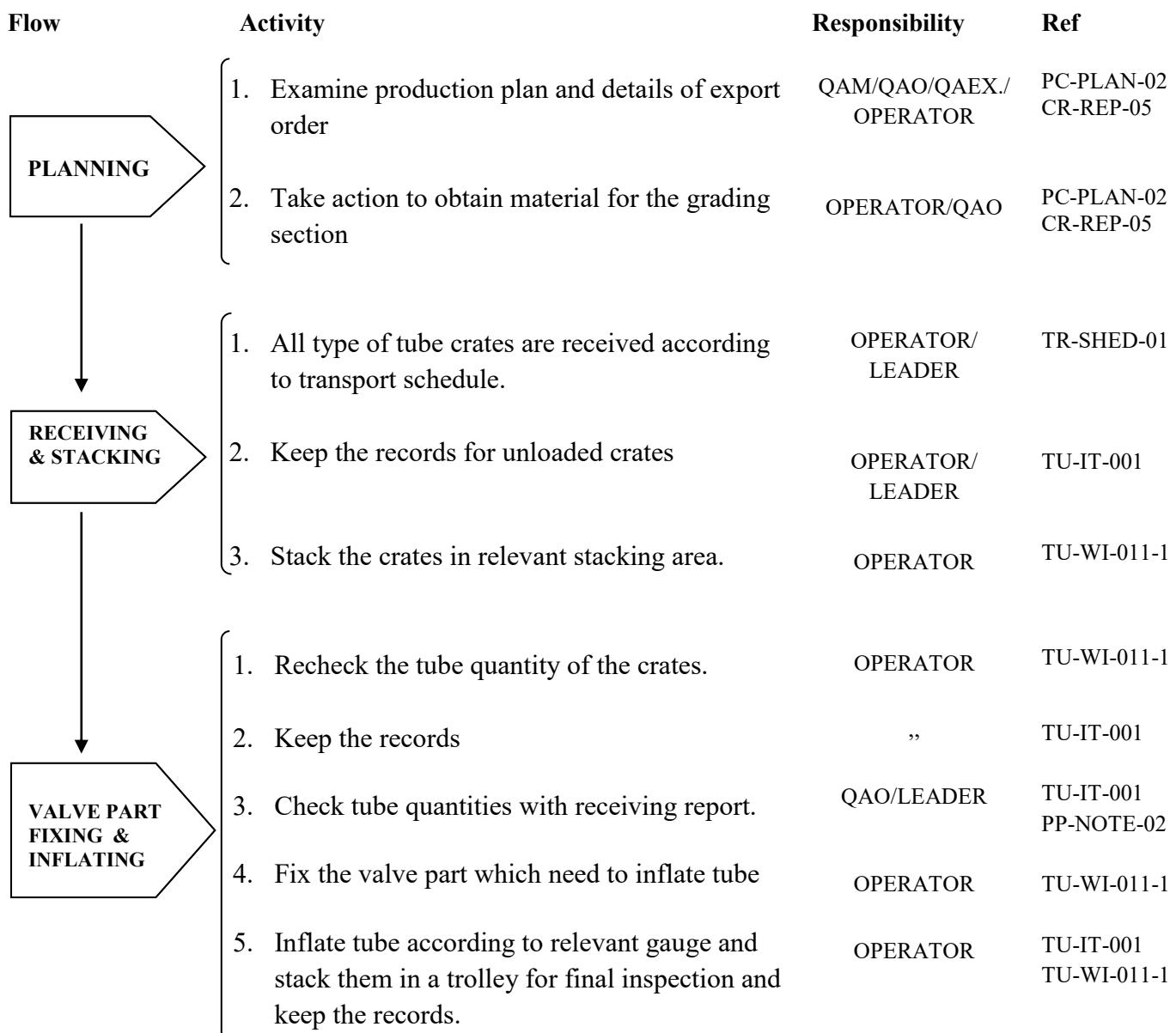
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Title : Procedure for Final Inspection and Finishing

8.3.5. Procedure for grading, finishing and final inspection of tubes

8.3.5.1.A Procedure for grading and finishing of tube (Moulded).



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Title : Procedure for Final Inspection and Finishing

Flow	Activity	Responsibility	Ref
INSPECTION & RECORDING	<ol style="list-style-type: none"> After relevant maturation period all tubes are examined for any visual or technical defects. (Maturation period, minimum 8hr) Grade them in two groups. <ul style="list-style-type: none"> A- Without Defect B- Pending for Final Inspection Re grade B tube either A, or D and record. Defects are entered to the software 	OPERATOR OPERATOR QAO/LEADER ,	TU-WI-011-2 TU-WI-011-2 TU-WI-0011-4 TUBE PRODUCTION SOFTWARE
DEFLAITING	<ol style="list-style-type: none"> Deflate the all A tube which are completed the relevant time period. (minimum 8 hr) Deflated tube during that time are sent for re inspection. 	OPERATOR OPERATOR	TU-WI-011-3 TU-WI-011-3
PRE PACKING	<ol style="list-style-type: none"> Do necessary thing (printing, filling sludge, sealant or latex...etc) according to customer requirements Pack tubes with polypropylene bag or rack for relevant market or customer with a relevant tag Maintain the record. 	OPERATOR OPERATOR OPERATOR	TU-WI-011-5/9/10 TU-WI-011-5 IT-TU-REC-01
HAND OVER	<ol style="list-style-type: none"> Grade A tube stack for packing Grade D tubes scrap and handover relevant section. 	OPERATOR OPERATOR	TU-WI-011-5 SCRAPING REPORT (IFS)

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Title : Procedure for Final Inspection and Finishing

8.3.5.1.B Procedure for grading and finishing of tube and Rim tape (Autoclave).

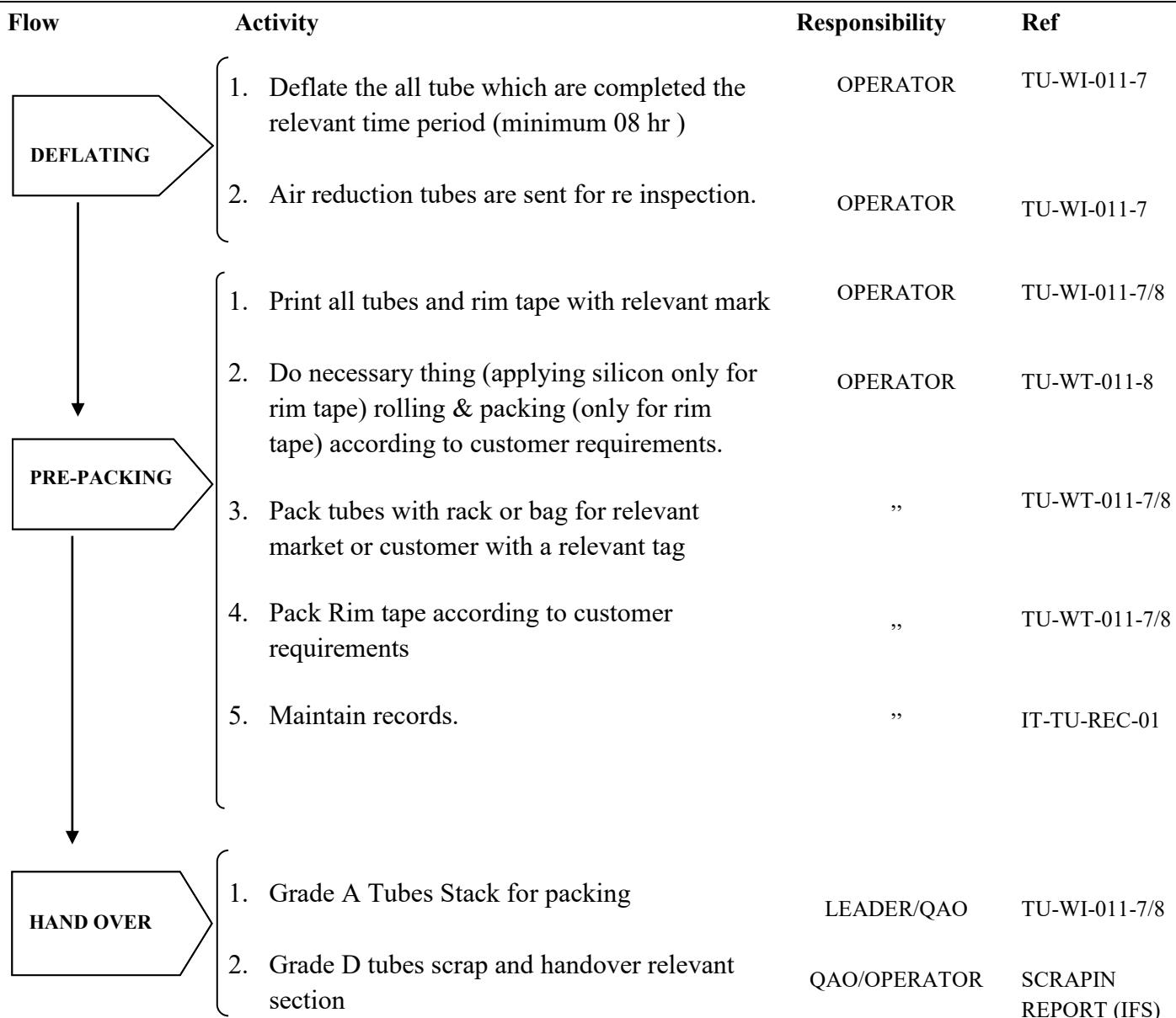
Flow	Activity	Responsibility	Ref
PLANING	<ul style="list-style-type: none"> 1. Examine production plan and details of export order 2. Take actions to obtain material for the grading section. 	QAM/QAO OPERATOR	PC-PLAN-02 CR-REP-05
RECEIVING & STACKING	<ul style="list-style-type: none"> 1. All type of tube and Rim tape crates are received according to transport schedule 2. Keep the records for unload crates 3. Stack the crates in relevant inspection line. 	OPERATOR/QAO OPERATOR/ LEADER OPERATOR	PC-PLAN-02 CR-REP-05 TR-SHED-01 TU-IT-001 TU-WI-011-7/8
INSPECTION of VALVE PARTS FIXING, INFLATING	<ul style="list-style-type: none"> 1. Recheck the tube and rim tape quantity of the crates. 2. Keep the records 3. Check the quantities with handover report 4. All tubes and Rim tape are examined for any visual or technical defects 5. Grade them in two group. <ul style="list-style-type: none"> A- Without defects B- Pending for final inspection 6. Fix relevant valve parts to A tubes and Rim tape where necessary 7. Inflate air (Tubes only) and record. 8. Re grade B tube and Rim tape in to A, D and record 9. Defects enter to the software 	OPERATOR " " " " " " " LEADER/QAO LEADER/QAO	TU-WI-011-7/8 TU-IT-001 PP-NOTE-02 TU-IT-001 TU-WI-011-7/8 TU-WI-011-7/8 TU-WI-011-7/8 TU-WI-011-7/8 TU-WI-011-7/8 TU-WI-011-7/8 TU-WI-011-7/8 TUBE PRODUCTION SOFTWARE

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Title : Procedure for Final Inspection and Finishing



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Title : Procedure for Final Inspection and Finishing

8.3.5.1.C Procedure for grading and finishing of tube (Jointed)

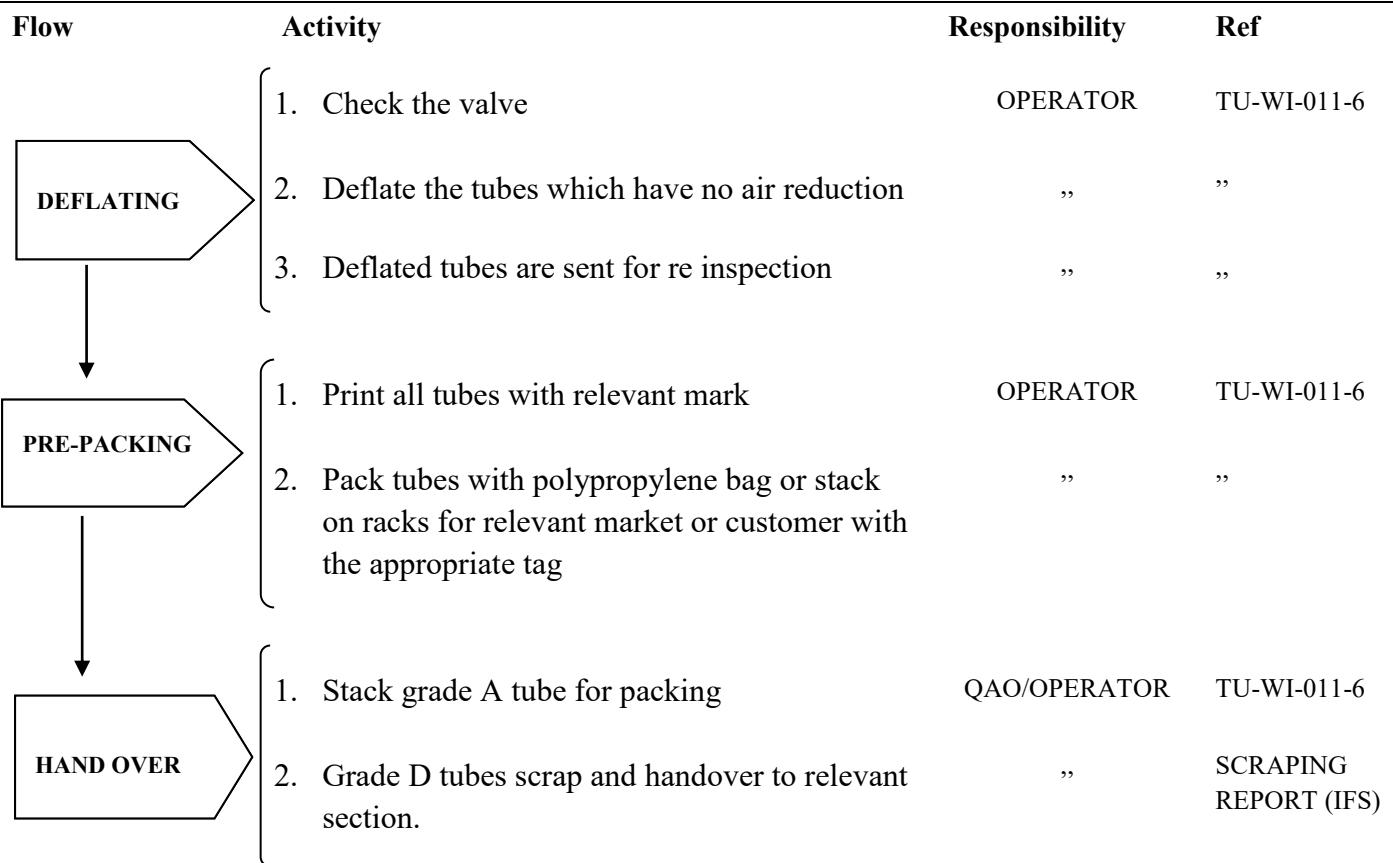
Flow	Activity	Responsibility	Ref
PLANNING	<ul style="list-style-type: none"> 1. Examine production plan and details of export order 2. Take actions to obtain material for the grading section 	QAM /QAEx/QAO OPERATOR	PC-PLAN-02 CR-REP-05
RECEIVING & STACKING	<ul style="list-style-type: none"> 1. All type of tube crates is received according to transport schedule 2. Keep the records for unload crates. 3. Stack the crates in relevant stacking area. 	OPERATOR	TR-SHED-01 ,, TU-WI-011-6
CHECKING & VALVE PART FIXING	<ul style="list-style-type: none"> 1. Recheck the tube quantity of crates and records 2. Examined all tubes for any visual or technical defects 3. Grade them in two group. <ul style="list-style-type: none"> A- Without defect B- Pending for final inspection 4. Fix relevant valve parts to A tubes and Inflate air and stack in trolleys and record. 5. Re grade B tube in to A and D. 6. Defects enter to the software 	OPERATOR OPERATOR ,, ,, TU-IT-001 TU-WI-011-6 TU-IT-001 LEADER/QAO LEADER/QAO	TU-IT-001 TU-WI-011-6 TU-IT-001 ,, TU-WI-011-6 TU-IT-001 TUBE PRODUCTION SOFTWARE

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Title : Procedure for Final Inspection and Finishing



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Document No: SRI-QPM 08 (3a) Date Issued: 01/12/2018 Revision date: 20/08/2025	DSI Tyres®	Revision No :04 Page No : 11 of 12

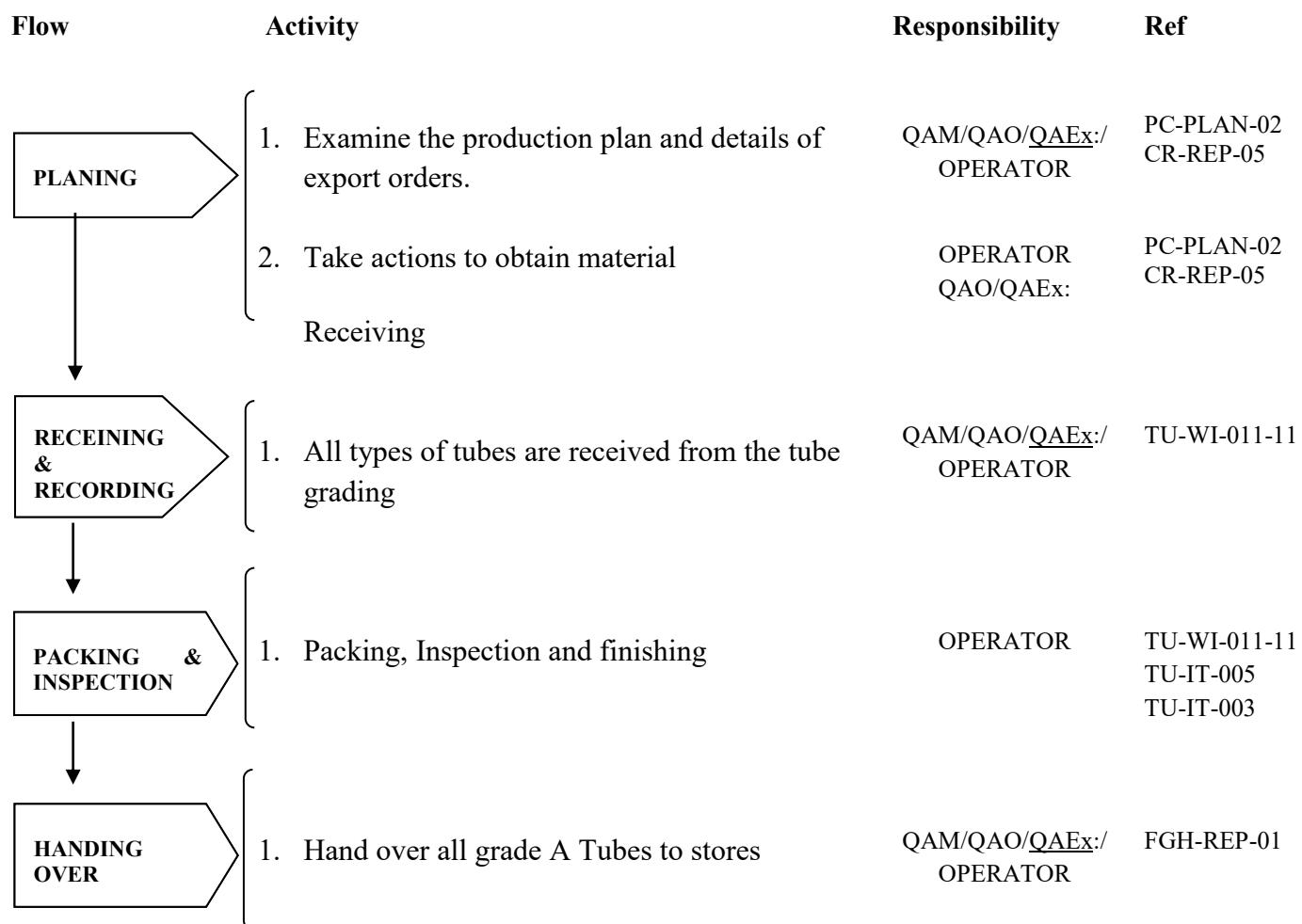
Title : Procedure for Final Inspection and Finishing

8.3.5.3 Procedure for final inspection of tubes

Flow	Activity	Responsibility	Ref
INSPECTION & NON DESTRUCTIVE TEST	1. Collect samples for testing according to sampling plan	OPERATOR	TU-TM-002
	2. Carryout non-destructive test	„	TU-TM-002 TU-TM-004
	3. Record test results	„	TU-IT-011
DESTRUCTIVE TEST	1. Collect samples for destructive test	OPERATOR	TU-TM-002
	2. Carryout destructive test	„	TU-TM-002 TU-TM-004
	3. Record test results	„	TU-IT-010 TU-IT-011

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	Date	

Title : Procedure for Final Inspection and Finishing

8.3.5.4 PROCEDURE FOR PACKING OF TUBES.

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