GIBELA

PRASA PROJECT

APPLICABLE FROM TRAINSET 190+ AS PER BASELINE 10.4

SELF INSPECTION SHEET

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE TC1	M4	M1	M2	M3	TC2	WORK INSTRUCTION	SAFETY ?
DTR30225487/3	AAD0001278566	CARBODYSHELL M3,M4 ASSEMBLY	CB2210		X			X		PRA.CB2210.DTR30225 487/3.V30	YES

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018
			CHECKER	Nosizo Pindela	10/01/2018
			COMPILER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motama	2018/05/18
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230	APPROVER	Itumeleng Modiba	2018/07/04
			CHECKER	Nosizo Pindela	2018/07/04
			REVISED BY	Ramokone Motama	2018/07/04
3	2018/12/12	Added dimensional check points to CB2210	APPROVER	Itumeleng Modiba	2018/12/12
			CHECKER	Nosizo Pindela	2018/12/12
			REVISED BY	Ramokone Motama	2018/12/12
5	22/01/2019	As per Baseline 10.2	APPROVER	tumeleng Modiba	22/01/2019
			CHECKER	Nosizo Pindela	22/01/2019
			REVISED BY	Vanessa Ntuli	22/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection	APPROVER	tumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	21/08/2019	New Baseline 10.2.5	APPROVER	tumeleng Modiba	21/08/2019
			CHECKER	Nosizo Pindela	21/08/2019
			REVISED BY	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	
			CHECKER	Bongane Masina	19/04/2021
			REVISED BY	Bongane Masina	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISED BY	Mpho Mulaudzi	
25	19/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	
			CHECKER	Andani Muthelo	19/02/2022
			REVISED BY	Andani Muthelo	
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	
			CHECKER	Mohlampe Amogelang	14/04/2023
			REVISED BY	Mohlampe Amogelang	
30	20/07/2023	New Baseline change 10.4	APPROVER	Ngobeni Tyson	
			CHECKER	Mohlampe Amogelang	28/07/2023
			REVISED BY	Mohlampe Amogelang	
31	07/11/2023	Added traceability for welding sections	APPROVER	Ngobeni Tyson	
			CHECKER	Mohlampe Amogelang	07/11/2023
			REVISED BY	Ntokozo Zwane	

TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
213	M4	WINGA 471497	20/02/24	SI.CB2210.254.V30	17

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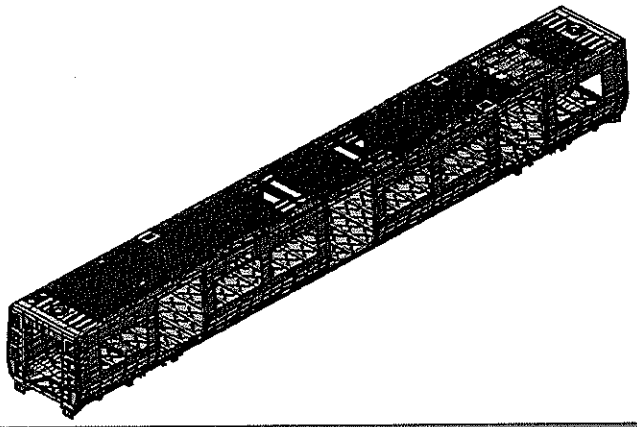
		Date 07/11/2023	

Car: M3 & M4	NCR:	Work station: CB2210

Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car: TC1	M1	M2	M3	M4	TC2	Revision	Observation	OK	N/A	Non OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
DTR30225487/3					X				✓				

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULAR	22713	04/10/23	✓		20/02/24	
30M TAPE	GIBTP0056	23/03/31	✓		20/02/24	
LASER TAPE	125475924	08/01/24	✓		20/02/24	

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)
AWS ROD 308LSI	E231067	MIG	✓		20/02/24	
ER 309 LSI	318394	MIG	✓		20/02/24	

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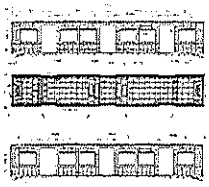
II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Not OK	Remarks	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	✓		20/02/24	
02	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	**IND-SAL-WMS-016 e DTD0000210675**	✓			20/02/24	20/02/24
03	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	**IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000**	✓			20/02/24	20/02/24
04		Cleaning of all Stainless Steel Surface	**According TO GIB-WEL - PROC-0002**	✓	✓		20/02/24	20/02/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.				20/02/24	20/02/24
06	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓			20/02/24	20/02/24

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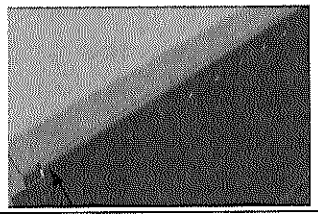
Welding Traceability

Roof ring welds



END 1

LHS

Boiler maker (Name & Sign): GERALD Welder (Name & Sign): BOBBY

RHS

Boiler maker (Name & Sign): LAWRENCE Welder (Name & Sign): M THOLOCIS

END 2

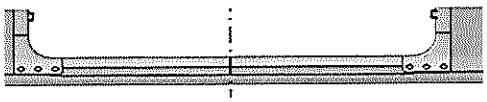
LHS

Boiler maker (Name & Sign): GERALD Welder (Name & Sign): BOBBY

RHS

Boiler maker (Name & Sign): LAWRENCE Welder (Name & Sign): M THOLOCIS

Door ring welds



LHS

Boiler maker (Name & Sign): TIMOTHY

Welder (Name & Sign): MTHOLOCIS

RHS

Boiler maker (Name & Sign): GERALD

Welder (Name & Sign): MTHOLOCIS

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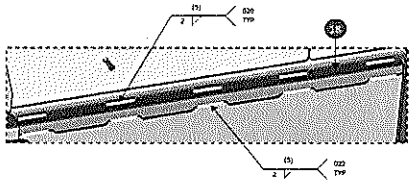
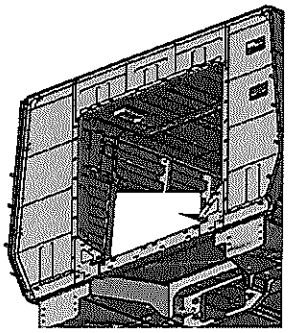
EUF Reinforcement Plates

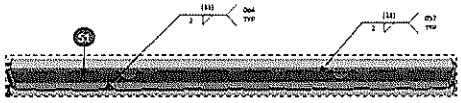




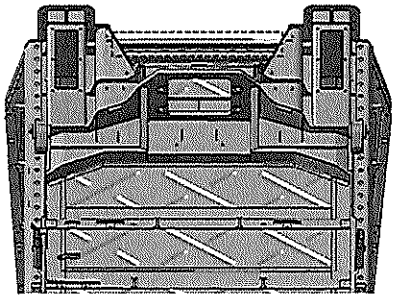
END 1

Boiler maker (Name & Sign): Timothy -

Welder (Name & Sign): Mthokozisi



END 2

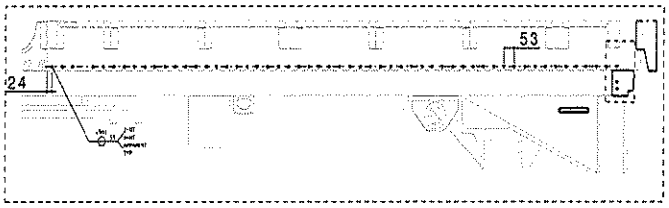


Underneath the CAR

END 2

Boiler maker (Name & Sign): Ebogo

Welder (Name & Sign): 21/02/24



FEDOLI

Operator: Ebogo

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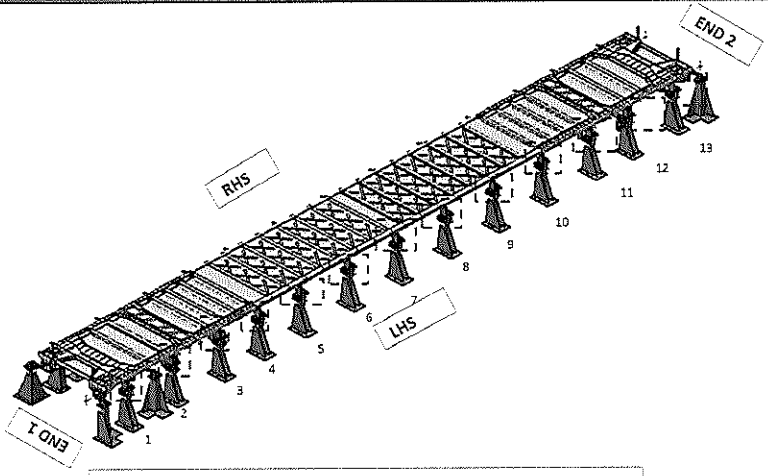
Specifications of Details for CBS measurement



Measure gap between jig pillar / chair and underframe = 0mm. No gap.

After loading and clamping

Fill in the gap foundon each jig pillars / chair and underframe should be 0mm.

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side													
Right Hand Side													

Signature Operations: Date: 20/02/24

After Welding.

Fill in the gap found each jig pillars / chair and underframe should be 0mm.

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side													
Right Hand Side													

Signature Industrial Quality: Date:

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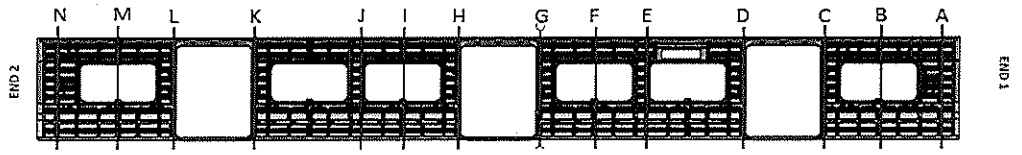
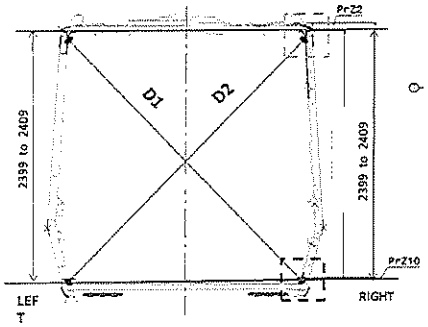
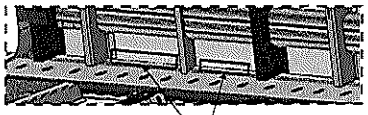
Specifications of Details for CBS measurement

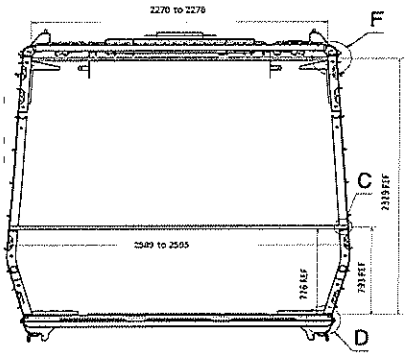


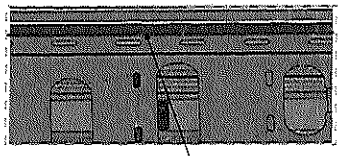


Measurement positions on roof rail and sidewall omega corner.

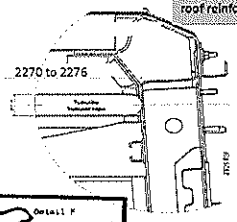


Measurement positions on sidewall and side sill corner.





Reinforcement area measurement positions on roof reinforcement area.



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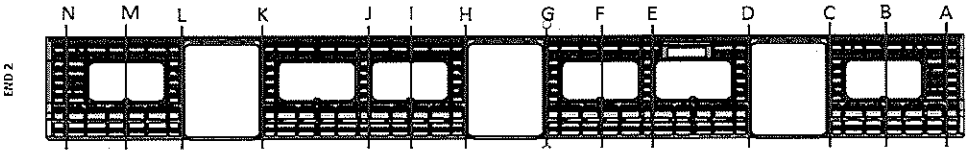
Specifications of Details for CBS measurement



PME Column LHS - RHS should be ≤2MM on each point.

BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3268	3268	0	2404	2406	2
B	3266	3269	3	2405	2405	0
C	3268	3268	0	2406	2404	2
D	3269	3267	2	2405	2403	2
E	3266	3266	0	2404	2403	1
F	3264	3265	1	2406	2404	2
G	3267	3267	0	2405	2406	1
H	3269	3268	1	2406	2406	0
I	3265	3266	1	2405	2404	1
J	3266	3267	1	2405	2407	2
K	3268	3268	0	2406	2405	1
L	3270	3269	1	2405	2407	2
M	3268	3266	2	2406	2406	0
N	3265	3267	2	2408	2407	1

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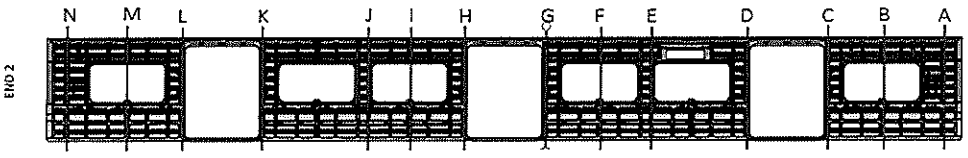
Specifications of Details for CBS measurement



PME Column LHS - RHS should be ≤2MM on each point.

AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3298	3297	1	2406	2405	1
B	3266	3267	1	2405	2407	2
C	3297	3298	1	2406	2404	2
D	3296	3295	2	2405	2405	0
E	3265	3265	0	2405	2405	0
F	3266	3265	1	2404	2403	1
G	3296	3295	1	2405	2406	1
H	3295	3297	2	2404	2405	1
I	3264	3265	1	2406	2406	0
J	3266	3266	0	2403	2405	2
K	3296	3296	0	2406	2406	0
L	3297	3296	1	2405	2404	1
M	3266	3269	3	2406	2406	0
N	3294	3295	1	2405	2407	1

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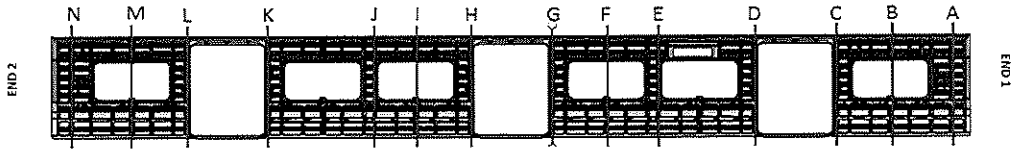
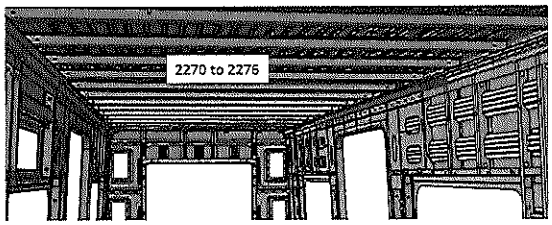
CBS measurement

BEFORE WELDING

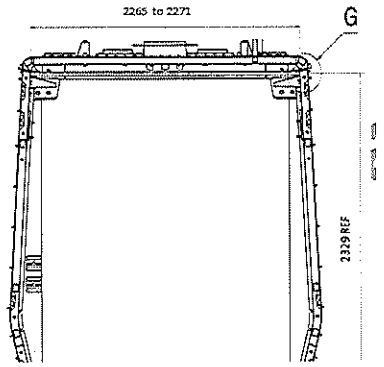


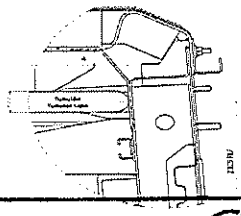


Do not consider reinforcement (Take measurements top area of zee profile

2270 to 2276

A	2272
B	2275
C	2272
D	2274
E	2278
F	2275
G	2276
H	2273
I	2275
J	2277
K	2271
L	2273
M	2274
N	2273





2265 to 2271

21/02/24

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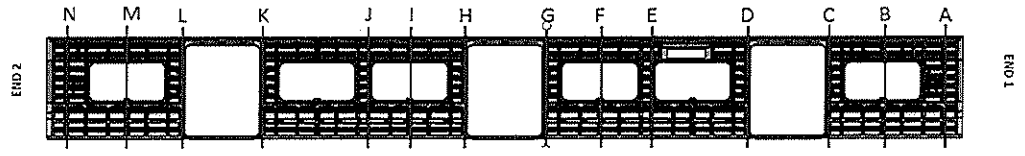
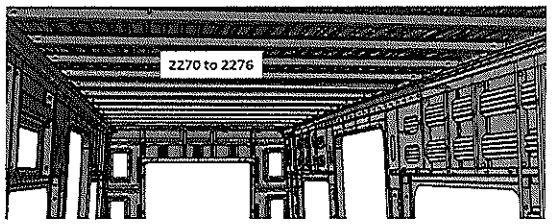
CBS measurement

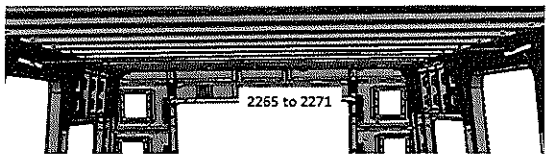
AFTER WELDING



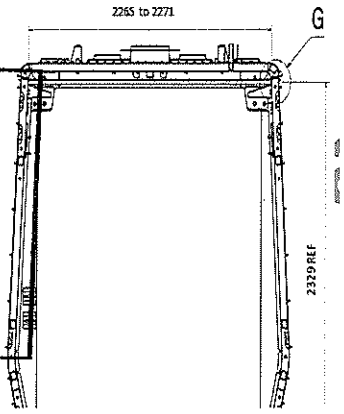
	2265 to 2271	2270 to 2276
A	2268	
B		2274
C	2268	
D	2270	
E		2275
F		2274
G	2265	
H	2266	
I		2276
J		2276
K	2269	
L	2265	
M		2273
N	2268	



Do not consider reinforcement (Take measurements top area of zee profile



Take measurement close to radius (considering reinforcement)



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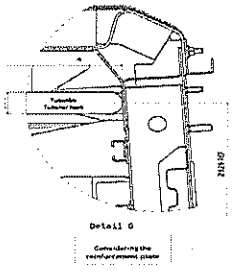

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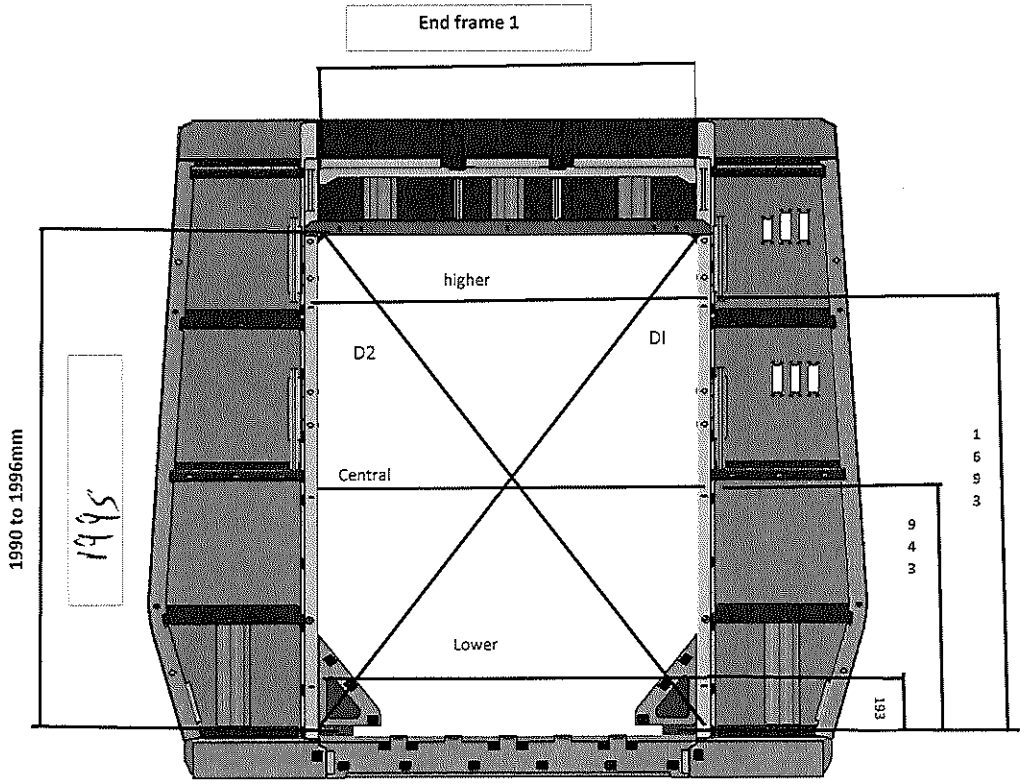
Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE **D1-D2** ≤ 3mm

Higher Dimension	1382	D1	2414
Central Dimension	1382	D2	2415
Lower Dimension	1381	D1-D2	1

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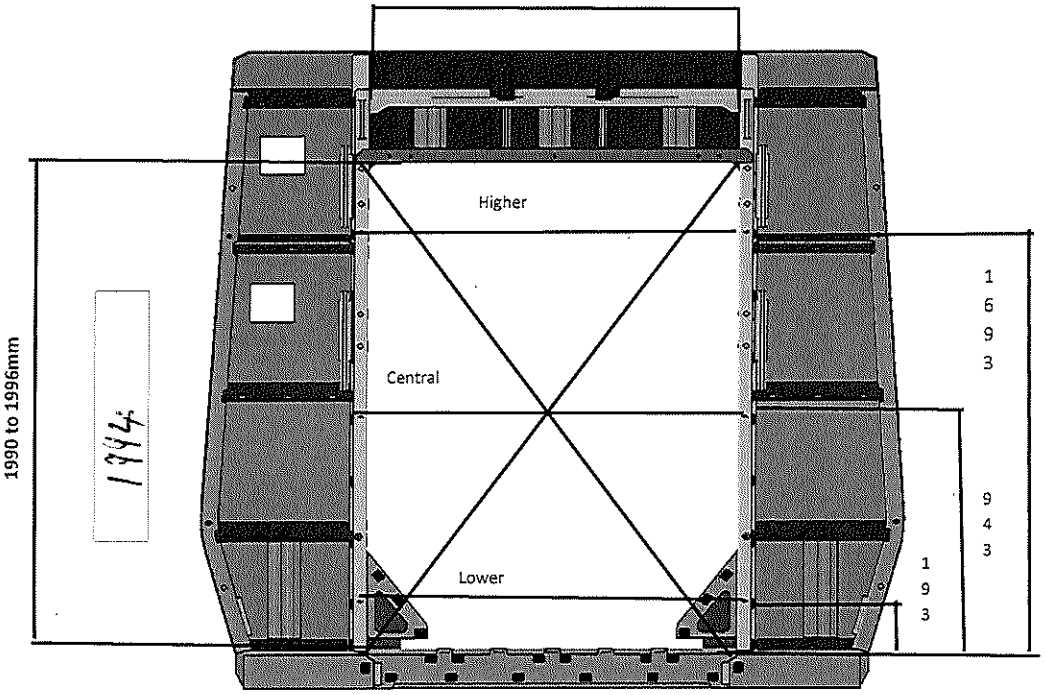
Specifications of Details for CBS measurement

Endframe 2

1380 to 1382 mm



1380 to 1382 mm

DIAGONAL DIFFERENCE **D1-D2** ≤ 3mm

Higher Dimension	1382	D1	2414
Central Dimension	1381	D2	2414
Lower Dimension	1381	D1-D2	0

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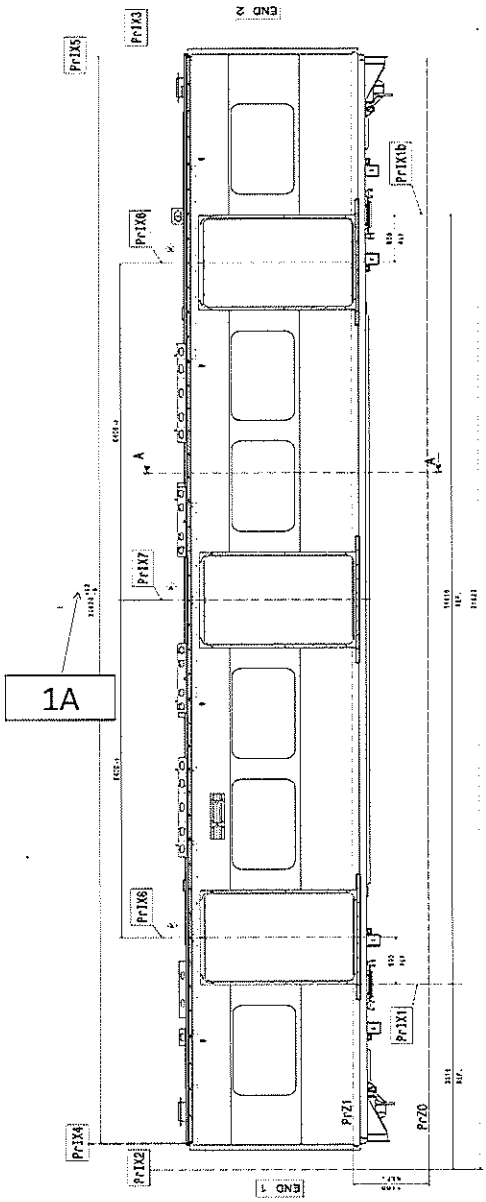
20/02/24

	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	

Specifications of Details for CBS measurement



	LEFT SIDE	
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20616

	RIGHT SIDE	
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20615

Dye penetrant test

Dye-penetration test to be performed by quality personnel

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INDUSTRIAL QUALITY
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GIBELO	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31 Date 07/11/2023	Project: PRASA SI.CB2210.254.V30

Item	Description of the issue	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)

II.2 - Check List REX

Check List Items

Item	Picture/Drawing	Description	Criteria /Record	OK	NOK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX					

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GIBELA	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31 Date 07/11/2023	Project: PRASA SI.CB2210.254.V30

Self Inspection - Final Result

				DATE	NAME	SIGNATURE
HOLD POINT		GO	(If activities are not complete, the missing activities must not impact the next stage)	20/02/24	LUNGA Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party)		Industrial Quality	
		NO GO	There are activities pendings that impact/stop the activities of the next process Obs. (To describe problems below)		Operations	
			There are non-conformities impact the quality of the product and there is no corrective action defined yet)		Industrial Quality	

In case of "NO GO", describe blocking problems

In case of "NO GO", the operations manager must define below action plan to ensure "GO":

Item	Description		Responsible	Due date	Status

Operations

Quality

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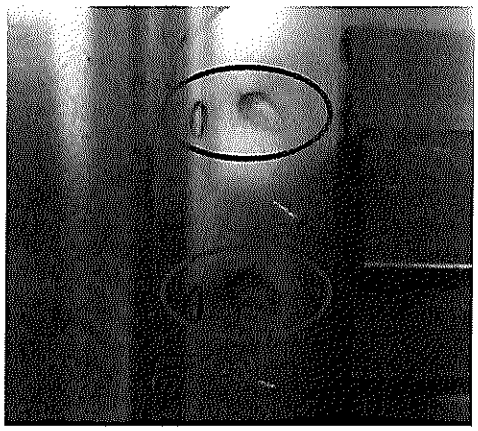
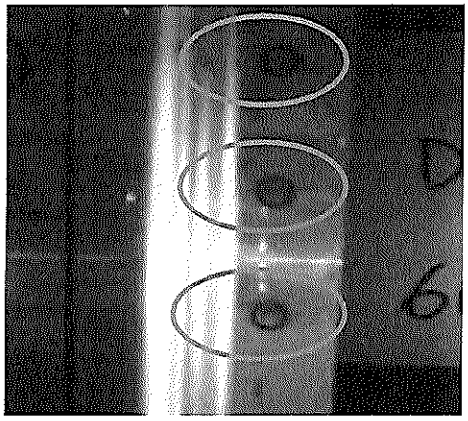
ANNEXURE A: Spot Welding Quality Acceptance Standard





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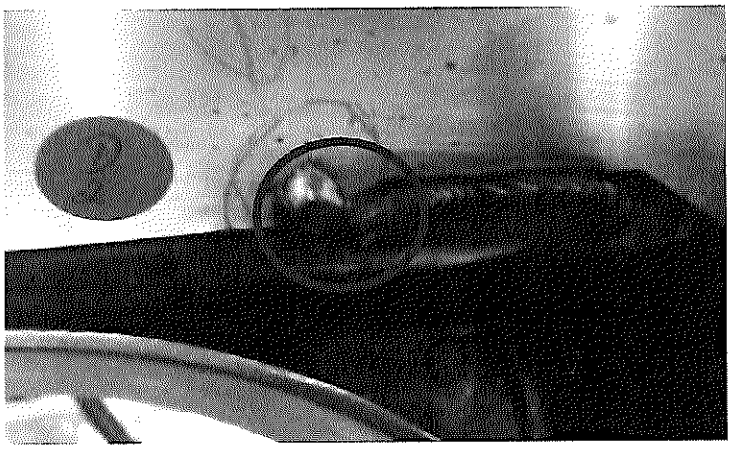
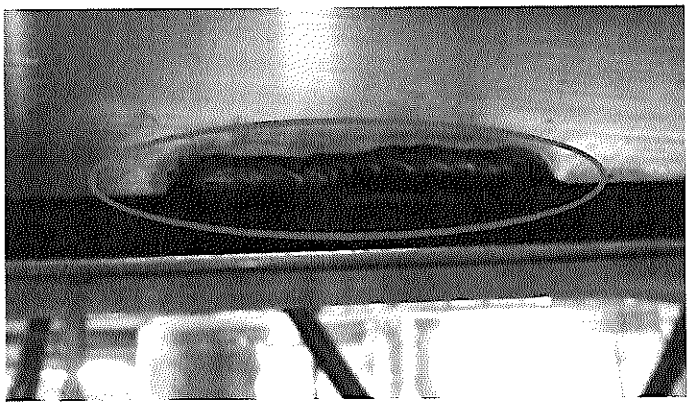
ANNEXURE B: Arc Welding Quality Acceptance Standard





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PRASA PROJECT

GIBELA

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

APPLICATION REFERENCE

	MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE TC1	M4	M1	M2	M3	TC2	WORK INSTRUCTION	SAFETY?
☐	DTR3022548?/2	AAD0001278566	CARBODYSHELL M1,M3,M4 ASSEMBLY	CB2220		X	X		X		PRA.CB2220.DTR3022548 7/2.V21	YES
☐												
☐												
☐												
☐												
☐												
☐												

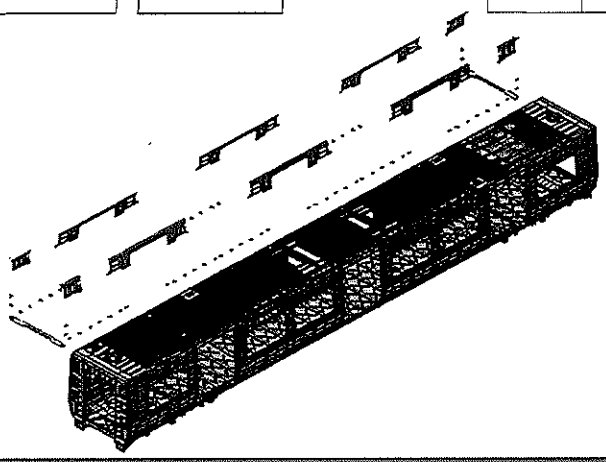
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	01/02/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	01/02/2018
			CHECKER	Nosizo Pindela	01/02/2018
			COMPILER	Thanyani Mathegu	01/02/2018
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	18/05/2018
			CHECKER	Nosizo Pindela	18/05/2018
			REVISED BY	Ramokone Matama	18/05/2018
2	2018/07/05	Certain dimensional checks added and others moved to CB1210	APPROVER	Itumeleng Modiba	2018/07/05
			CHECKER	Nosizo Pindela	2018/07/05
			REVISED BY	Ramokone Matama	2018/07/05
3	2018/06/12	Width tolerance as per DT0000336600	APPROVER	Itumeleng Modiba	2018/06/12
			CHECKER	Nosizo Pindela	2018/06/12
			REVISED BY	Nosizo Pindela	2018/06/12
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			REVISED BY	Vanessa Ntuli	24/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection Remove length measurements	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	22/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	22/08/2019
			CHECKER	Nosizo Pindela	22/08/2019
			REVISED BY	Nosizo Pindela	22/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021
			CHECKER	Mpho Mulaudzi	
			REVISED BY	Mpho Mulaudzi	
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	19/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbhombhi	14/06/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
27	19/10/2022	Addition of traceability for sealant application & welding	APPROVER	Collins Mbhombhi	19/10/2022
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
29	28/10/2023	Addition of bracket quantity	APPROVER	Ngobeni Tyson	28/10/2023
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	

TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
TS 213	MC4	[illegible]	21-02-24	SI.CB2220.250.V29	13

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 26/10/2023	Project: PRASA SI.CB2220.250.V29

Car: M1,M3&M4	NCR:	Work station:	CB2220

Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car TC1	M1	M2	M3	M4	TC2	Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
DTR30225487/2				X			29	28-10-2023	X		N/A 21-02-24	21/02/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
Tubular	231062		X		21-02-24	
measuring tape			X		21-02-24	21/02/24
Tubular	22713	03/08/2024	X		21-02-24	

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
308	231067	MIG	X		21-02-24	21/02/

GIBELA
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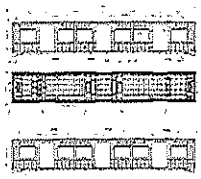
GIBELO	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK			Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB2220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB2220.DTR30225487/2	✓			21-02-24	21/02/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓			21-02-24	21/02/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	**IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000**	✓			21-02-24	21/02/24
04		Cleaning of all Stainless Steel Surface	**According TO GIB-WEL - PROC-0002**	✓			21-02-24	21/02/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			21-02-24	21/02/24
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-016. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-016 and DTD0000210658.	✓			21-02-24	21/02/24
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: Temperature Min - Max (1) Min-Max 10°C - 35°C Relative humidity Min – Max (1) Min-Max 25% - 80%	Sealant Batch No: BR 10-03 Exp Date: ___/03/24 Actuals Temparature: 20°C Humidity: 60%	✓			21-02-24	21/02/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓			21-02-24	21/02/24
09		Verfication of safety welds	Approved according to DTD000210658 reference and Self inspection	✓			21-02-24	21/02/24

GIBELO
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INDUSTRIAL QUALITY
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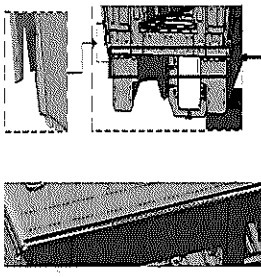
GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

II - Self Inspection - Items to Check

SEALANT APPLICATION



AREA 1 & 2 END 1

Operator (Name & sign): PRASAD

Operator (Name & sign): RAHUL

GIBELA

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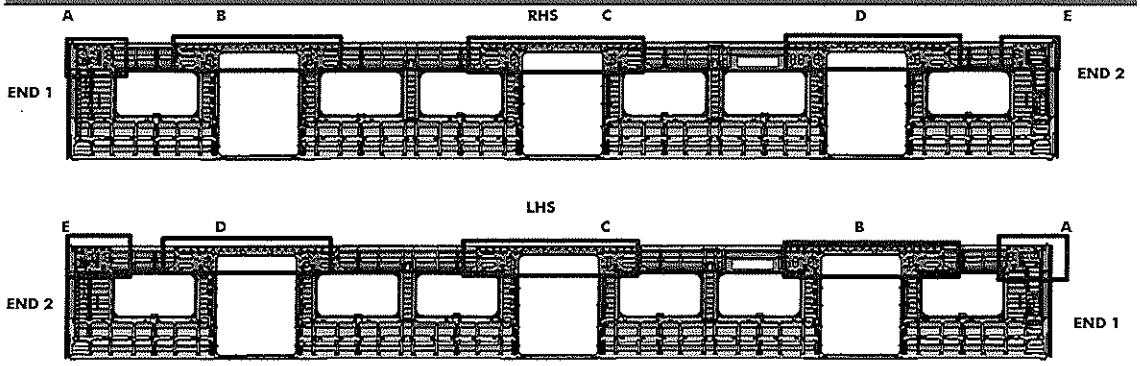
INDUSTRIAL QUALITY

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

II - Self Inspection - Items to Check



REINFORCEMENT WELDING

AREA		LHS	RHS
A	Operator (Name&sign):	LINDO	LINDO
B	Operator (Name&sign):	LINDO	LINDO
C	Operator (Name&sign):	KEITU K.	KEITU K.
D	Operator (Name&sign):		
E	Operator (Name&sign):		

GIBELA
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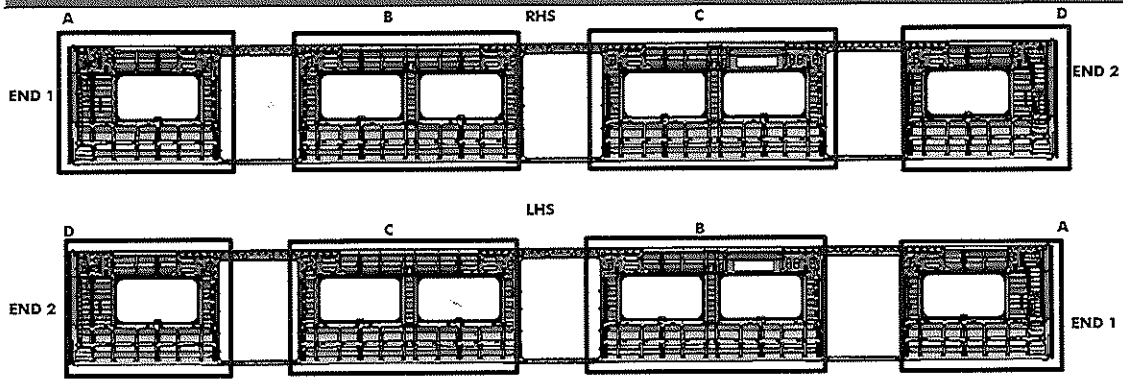
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

II - Self Inspection - Items to Check



BRACKETING

INSTALLATION

C-RAILS: Operator: Mthokozisi

Operator:

DOOR MECHANISMS: Operator: Mthokozisi

Operator:

TAPPING PADS Operator: LINDO END1

Operator: LINDO END2

INSTALLATION & VERIFICATION

SEAT & LUGGAGE BRACKETS: Operator: ASANDA. LOLO

Operator: John. Mkhize

SEAT BRACKETS VERIFICATION: Operator: ASANDA

Operator:

WELDING

AREA	LHS	RHS
A (Seat brackets)	: Operator (Name&sign): John	John
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	
B (Seat brackets)	: Operator (Name&sign): John Mkhize	John Mkhize
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	
C (Seat brackets)	: Operator (Name&sign): MATSHETO/MKHIZE	MATSHETO/MKHIZE
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	THULANI
D (Seat brackets)	Operator (Name&sign): MATSHETO	MATSHETO
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): Sibiya	THULANI

ENDS

END 1 TAPPING PADS WELDING: Operator (Name&sign): LINDO

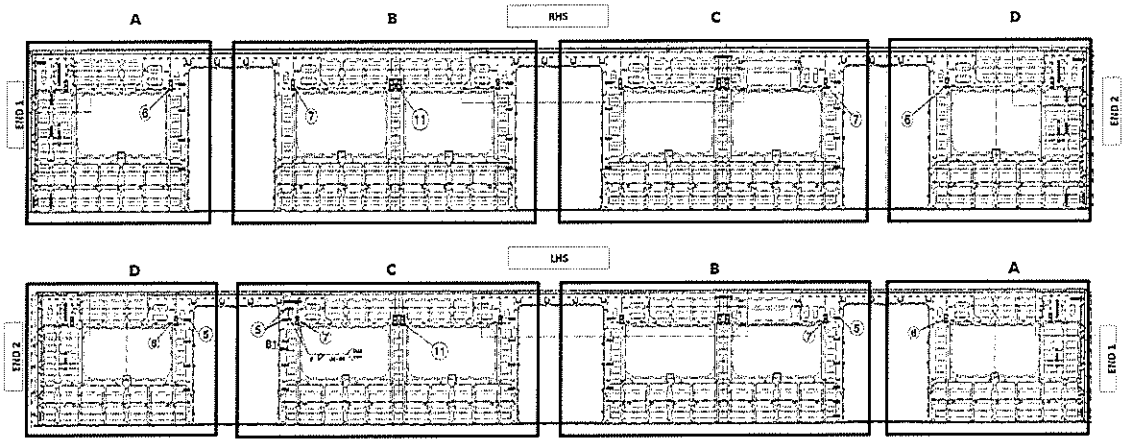
END 1 TAPPING PADS WELDING: Operator (Name&sign): LINDO

GIBELA
2024 -02- 01
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

II – Self Inspection - Items to Check

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

RHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7	✓	
	B	4	✓	
	C	8	✓	
	D	8	✓	
SEAT BRACKETS	A	13	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	3	✓	
	B	5	✓	
	C	4	✓	
	D	3	✓	

ROOF ENDS:

CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: Tebelo

LHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2	✓	
	B	8	✓	
	C	11	✓	
	D	8	✓	
SEAT BRACKETS	A	13	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	3	✓	
	B	5	✓	
	C	6	✓	
	D	2	✓	

ROOF ENDS:

CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: Tebelo

QUANTITIES (M1)

RHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7		
	B	8		
	C	8		
	D	8		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	2		
	B	4		
	C	5		
	D	3		

ROOF ENDS:

CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: N/A

LHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	10		
	C	11		
	D	8		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	7		
	C	6		
	D	2		

ROOF ENDS:

CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: N/A

GIBELA
2024 -02- 01
INDUSTRIAL QUALITY
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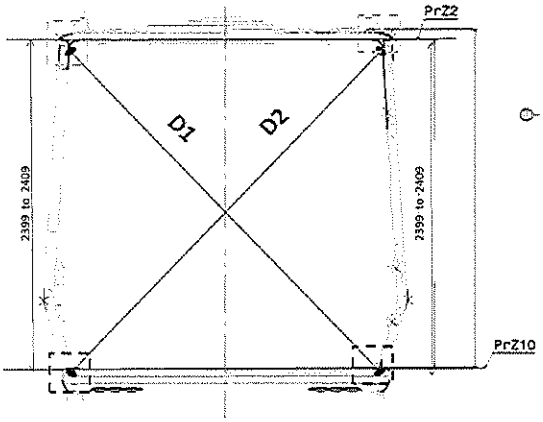
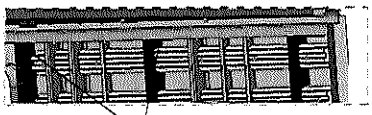
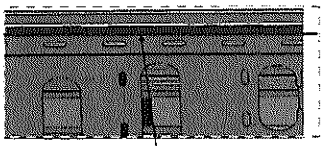
Specifications of Details for CBS measurement

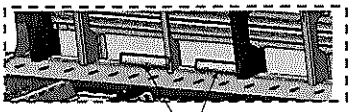




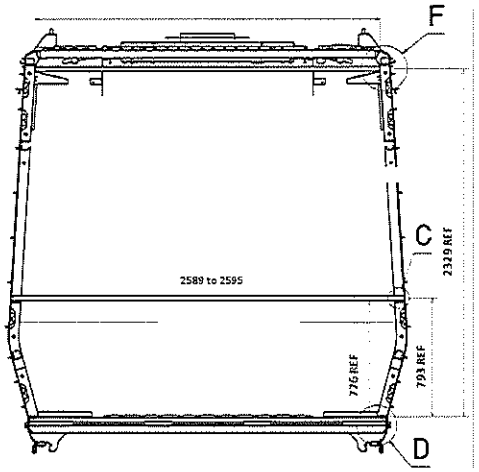
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.

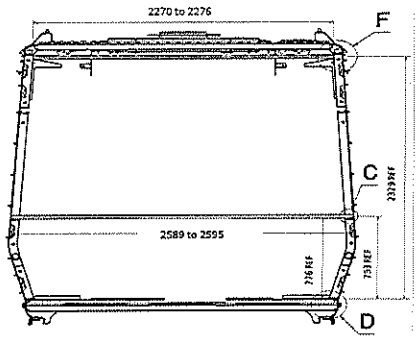


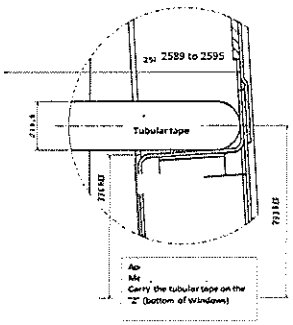
Measurement positions on sidewall and side sill corner.



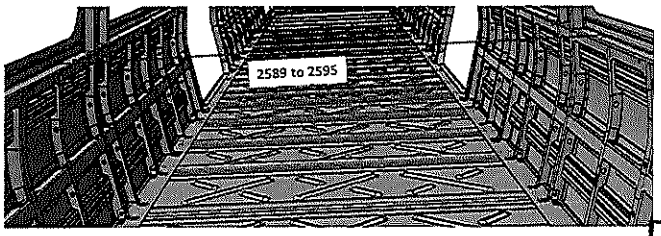
GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

CBS measurement

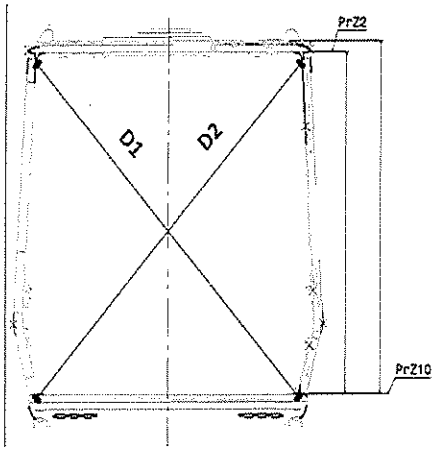


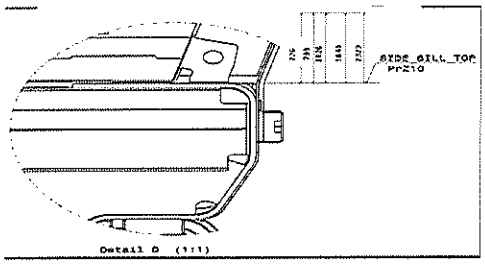


Detail C



Take measurement close to radius

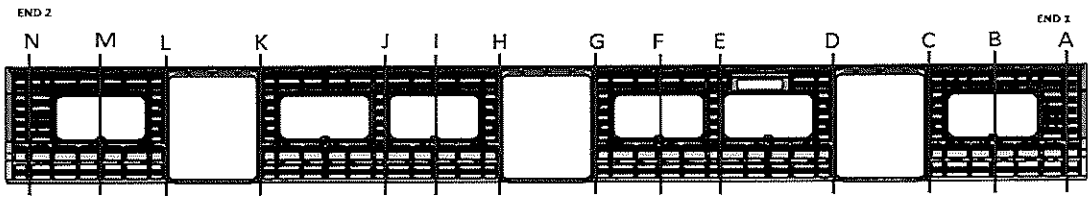




GIBELA
2024 -02- 01
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

CBS measurement



BEFORE WELDING

N/A

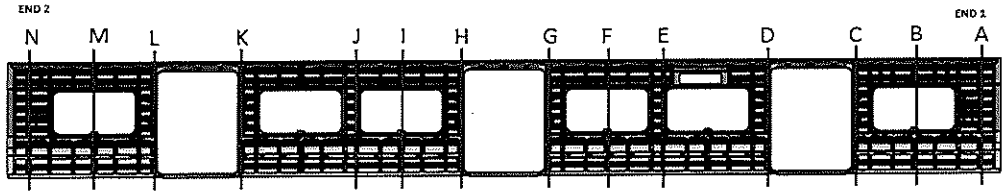
	ecord D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3297	3300	3	
B	3266	3270	4	
C	3296	3295	1	
D	3300	3295	5	
E	3270	3266	4	
F	3268	3270	2	
G	3300	3295	5	
H	3299	3293	6	
I	3269	3264	5	
J	3270	3270	0	
K	3300	3297	3	
L	3300	3294	6	
M	3270	3266	4	
N	3300	3300	0	

21-2-2024

GIBELA
2024 -02- 01
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

CBS measurement



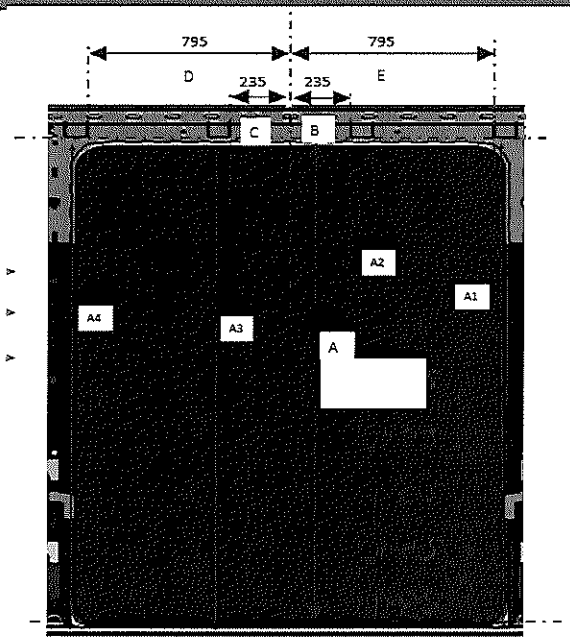
AFTER WELDING

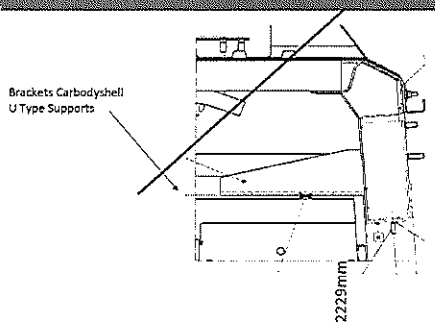
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3295	3297	2	2595
B	3296	3295	1	2590
C	3294	3297	3	2590
D	3295	3297	2	2590
E	3296	3298	2	2591
F	3297	3295	2	2590
G	3295	3297	2	2591
H	3299	3295	3	2589
I	3270	3269	1	2592
J	3270	3267	3	2591
K	3300	3297	3	2595
L	3300	3298	2	2589
M	3270	3297	3	2595
N	3295	3297	2	2589

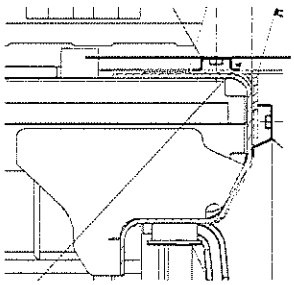
GIBELA
2024 -02- 01
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

Specifications of Details for CBS measurement CB1220







DOOR 1 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2232
A3	2230 to 2232	2231
A4	2230 to 2232	2232
B	234 to 236	234
C	234 to 236	235
D	794 to 796	796
E	794 to 796	794

DOOR 2 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2232
A3	2230 to 2232	2231
A4	2230 to 2232	2232
B	234 to 236	2235
C	234 to 236	235
D	794 to 796	794
E	794 to 796	795

DOOR 2 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2232
A3	2230 to 2232	2231
A4	2230 to 2232	2231
B	234 to 236	235
C	234 to 236	235
D	794 to 796	795
E	794 to 796	794

DOOR 1 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2232
A3	2230 to 2232	2231
A4	2230 to 2232	2232
B	234 to 236	235
C	234 to 236	234
D	794 to 796	796
E	794 to 796	794

DOOR 2 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2232
A3	2230 to 2232	2232
A4	2230 to 2232	2231
B	234 to 236	234
C	234 to 236	235
D	794 to 796	796
E	794 to 796	794

DOOR 3 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2232
A3	2230 to 2232	2232
A4	2230 to 2232	2231
B	234 to 236	234
C	234 to 236	235
D	794 to 796	796
E	794 to 796	795

GIBELA
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INDUSTRIAL QUALITY
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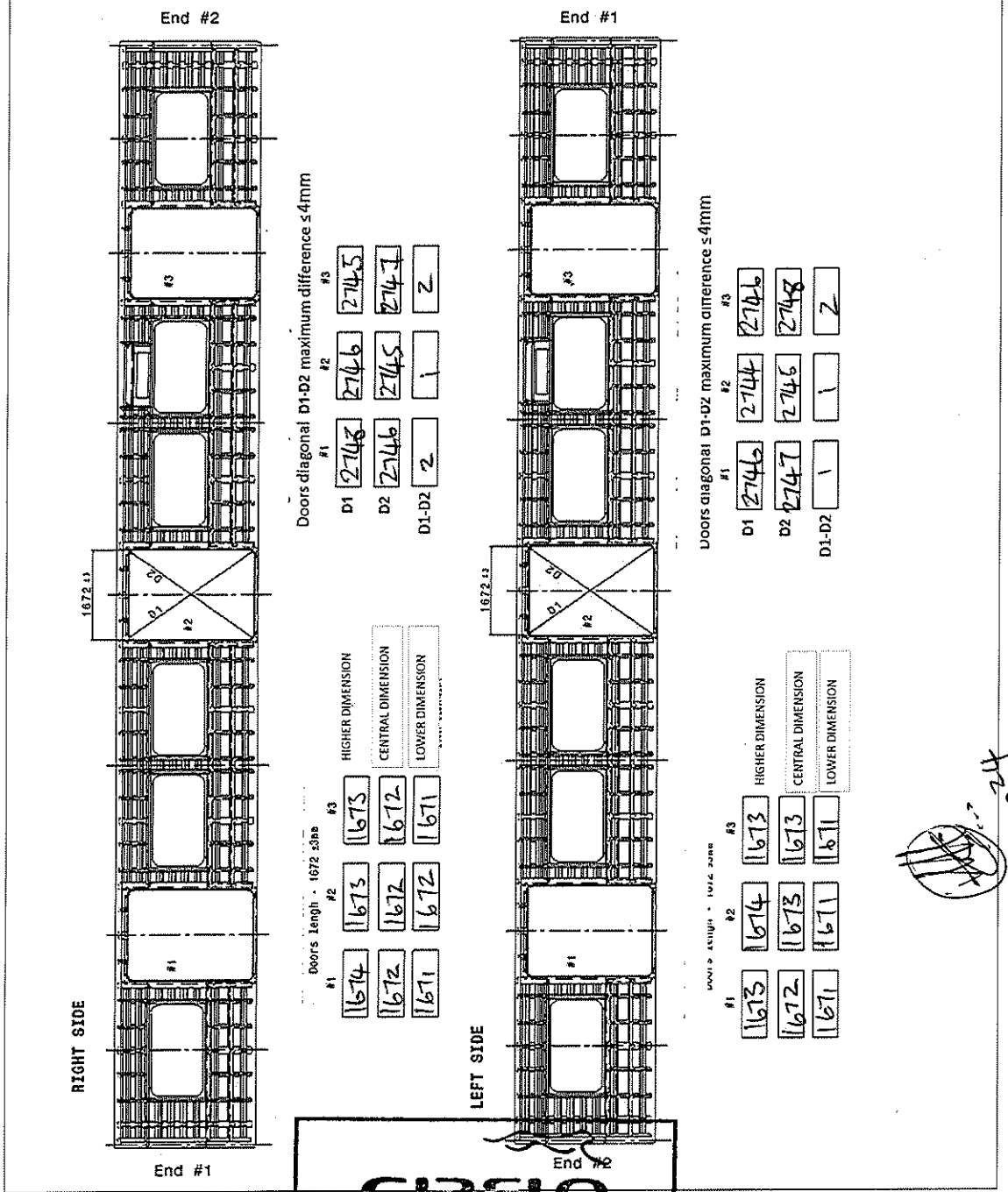
21-02-2024

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

Specifications of Details for CBS measurement CB1220



GIBELA

2024 -02- 01

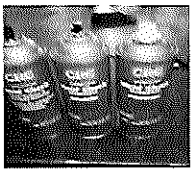
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

CBS measurement (Manufacturing)

Dye penetrant test

Dye-penetration test to be performed by quality personnel



Item	Description of the issue	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)

II.2 - Check List REX

Check List Items

Item	Picture/Drawing	Description	Criteria /Record	OK			Signature/Date (Manufacturing)	Signature/Date Quality
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX					

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2024 -02- 01
INDUSTRIAL QUALITY
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GIBELO	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

Self Inspection - Final Result

Is the car good to advance to the next workstation/process? (Approval of Operations Manager and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	✓	GO	(If f activities are not complete, the missing activities must not impact the next stage)	21/02/24	Tebelo Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	21/02/24	AMO Industrial Quality	
			There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)		Operations	
			There are non-conformities impact the quality of the product and there is no corrective action defined yet)		Industrial Quality	

In case of "NO GO", describe blocking problems

In case of "NO GO", the operations manager must define below action plan to ensure "GO":

Item	Description		Responsible	Due date	Status

Operations

Quality

GIBELO
2024 -02- 01
INDUSTRIAL QUALITY
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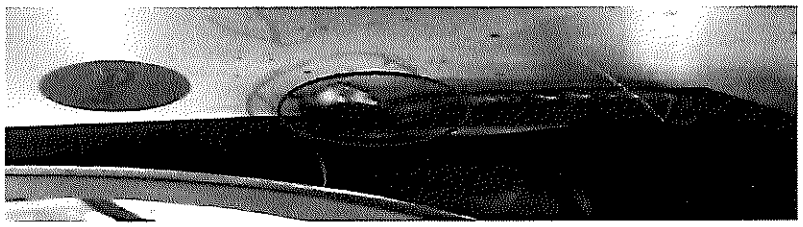
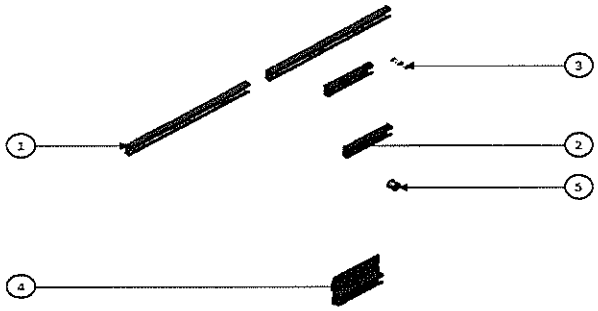
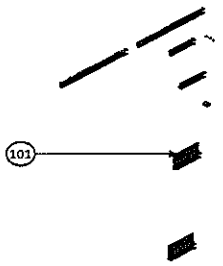
ANNEXURE A: Arc Welding Quality Acceptance Standard



Station: CB1220-004- U108 & U107



PART NO.	ITEM NO.	QTY	DESCRIPTION	MASS [KG]
DTR0220074083	5	6	EARTH STUD 6	0.036
AA00001201848	4	6	ASSEMBLY SUPPORT	0.271
DTR0000348305	3	12	WELDING STUD ISO13918 PT – M8X20 - SST	0.007
AA00001180424	2	12	ASSEMBLY SUPPORT	0.193
AA00001184418	1	14	ASSEMBLY SUPPORT	0.522
AA00001161080	101	6	CARBODYSHELL BRACKETS CARBODYSHELL M1/M3/M4 CAR[SIDE FRAME MODULE END – OPP]	12.132



GIBELA

2024 -02- 01

INDUSTRIAL QUALITY
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PRASA PROJECT

GIBELA

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE TC1	M4	M1	M2	M3	TC2	WORK INSTRUCTION	SAFETY?
☐ DT000002254B7	AAD0001278566	CARBODYSHELL M1,M3,M4 ASSEMBLY	CB2230		X	X		X		PRA.CB2230.DT000002 25487.V20	YES
☐											
☐											

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	2018/08/02	GIBELA NEW CREATION	APPROVER	Philipe Marques	2018/08/02
			CHECKER	Nosizo Pindela	2018/08/02
			COMPILER	Nosizo Pindela	2018/08/02
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	30/5/2018
			CHECKER	Nosizo Pindela	30/5/2018
			REVISED BY	Nosizo Pindela	30/5/2018
2	2018/05/07	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	2018/05/07
			CHECKER	Nosizo Pindela	2018/05/07
			REVISED BY	Ramokone Motama	2018/05/07
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			REVISED BY	Vanessa Ntuli	24/01/2019
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	23/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	23/08/2019
			CHECKER	Nosizo Pindela	23/08/2019
			REVISED BY	Nosizo Pindela	23/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	
			CHECKER	Bongane Masina	19/04/2021
			REVISED BY	Bongane Masina	
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	
			CHECKER	Andani Muthelo	20/02/2022
			REVISED BY	Andani Muthelo	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbhombhi	
			CHECKER	Andani Muthelo	14/06/2022
			REVISED BY	Andani Muthelo	
27	26/07/2022	Threashold measurements addition	APPROVER	Collins Mbhombhi	
			CHECKER	Andani Muthelo	26/07/2022
			REVISED BY	Andani Muthelo	
28	17/10/2022	Added traceability of sealant application	APPROVER	Collins Mbhombhi	
			CHECKER	Ntokozo Zwane	17/10/2022
			REVISED BY	Amogelang Mohlampe	
29	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	
			CHECKER	Ntokozo Zwane	14/04/2023
			REVISED BY	Amogelang Mohlampe	
30	06/11/2023	Added threashold traceability for boiler makers and welders	APPROVER	Ngobeni Tyson	
			CHECKER	Andani Muthelo	06/11/2023
			REVISED BY	Ntokozo Zwane	

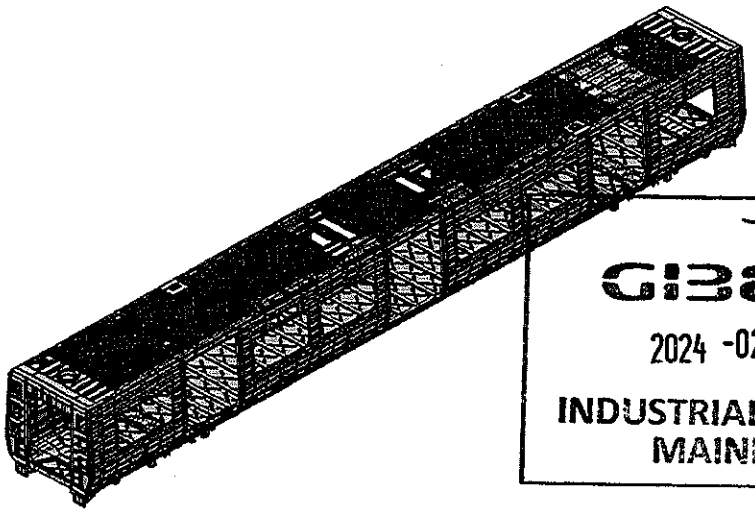
TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
213	M4	Levoy 426959	21/02/2024	SI.CB2230.256.V29	12

GIBELA
2024 -02- 01
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29

Car:	NCR:	Work station: CB2230

Safety Related



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INDUSTRIAL QUALITY
MAINLINE

I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car M1	M2	M3	M4	TC2	Revision	Obsevation	OK		N/A	Signature/Date (Operations)	Signature/Date (Quality)
PRA.CB2230.DT00000225487				X		30		✓		N/A	21/02/24	

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Operations)	Signature/Date (Quality)
Combination Square	GIB8906718	21/07/2024	✓		21/02/24	
Measuring Tape	GIBTA0898	2024/04/06	✓		21/02/24	
Tubular	22713-1	29/11/2023	✓		21/02/24	

1.3 Consumables

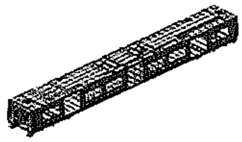
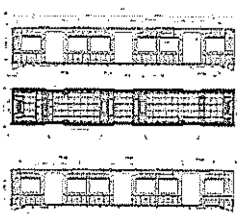
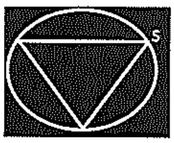
Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
WELDING WIRE	E22880	MIG	✓		21/02/24	

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30 Date 06/11/2023	Project: PRASA **SI.CB2230.256.V29**

II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOK	Remark	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering nº PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	OK			21/02/24	21/02/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	OK			21/02/24	21/02/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	**IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000**	OK			21/02/24	21/02/24
04		Cleaning of all Stainless Steel Surface	**According TO GIB-WEL - PROC-0002**	OK			21/02/24	21/02/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	OK			21/02/24	21/02/24
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	OK			21/02/24	21/02/24
07	N/A	Before appplication of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: Temperature Min - Max (1) Min-Max 10°C - 35°C Relative humidity Min - Max (1) Min-Max 25% - 80%	Sealant Batch No: PA23289303 Exp Date: __/03/24 Actuals Temparature: 25°C Humidity: 49%	OK			21/02/24	21/02/24
08	N/A	Verification of sealant application on the roof and sidewall finishers.	Sealant must be: -Applied straight and even -Free of gaps,cracks,damage and debris (flashes, dirt, dust) **Refer to Annexure B**	OK			21/02/24	21/02/24
09	N/A	Verification of sealant application in certain regions in the drawing.	AAD0001278566	OK				

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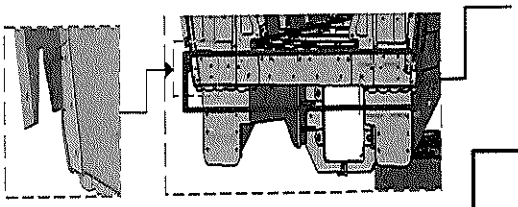
II - Self Inspection - Items to Check

END 2 SEALANT

AREA 1

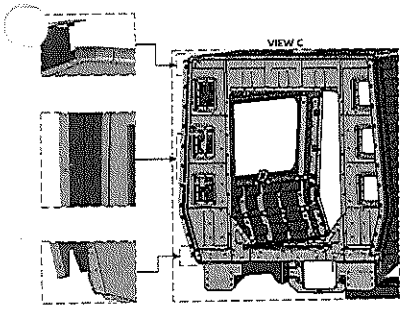


OPERATOR (Name & sign): Leroy

OPERATOR (Name & sign): Leroy

OPERATOR (Name & sign): Leroy

AREA 2 (VIEW C)



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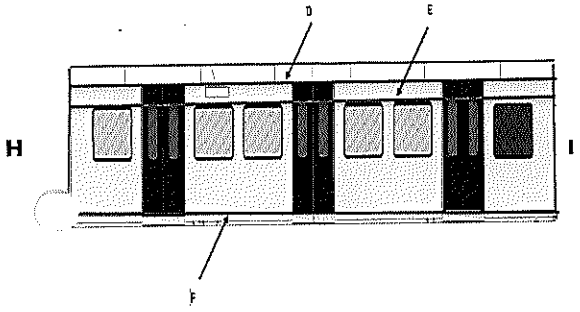
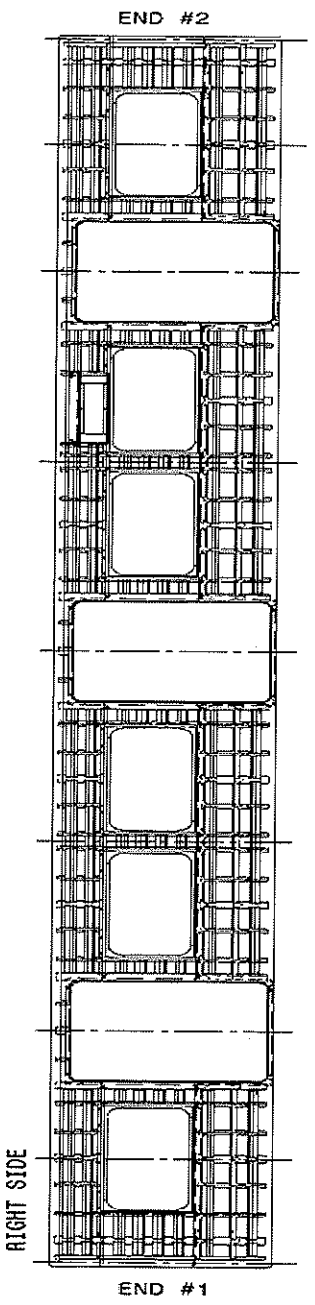
2024 -02- 01
INDUSTRIAL QUALITY
MAINLINE



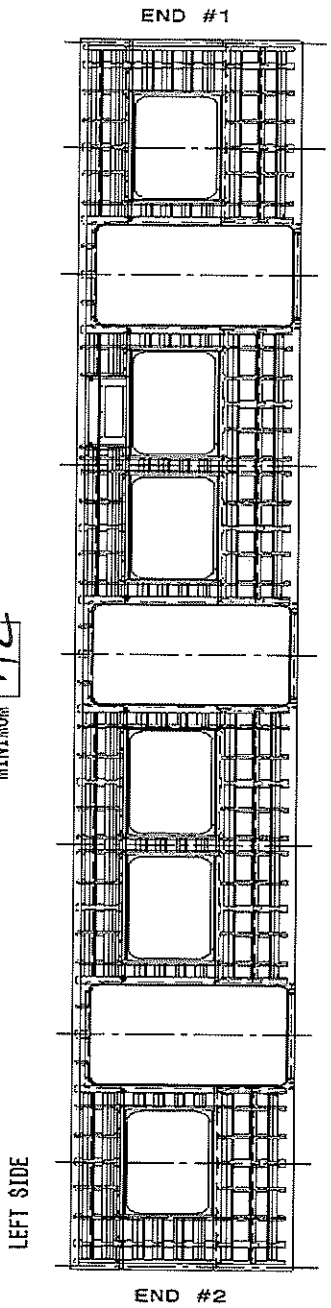
Area D,E,F,G,H,I	LHS	RHS (Bottom)
Operator (Name & sign) :	DE,F,G,H,I	E,H,I
Operator (Name & sign) :	Zuhle	Zuhle
Operator (Name & sign) :	Nonkanhla	Nonkanhla
Operator (Name & sign) :		D,E (H,I) top
Operator (Name & sign) :		Sine
Operator (Name & sign) :		Tshenuwo 1-10-24

Specifications of Details for CBS measurement CB1230

Flatness side left and right maximum of 2mm in the valley to peak measured in 900mm. Recod the maximum and minimum value foundand indicate the corresponding region.



MAXIMUM 1,8
MINIMUM 1,2



MAXIMUM 1,9
MINIMUM 1,4

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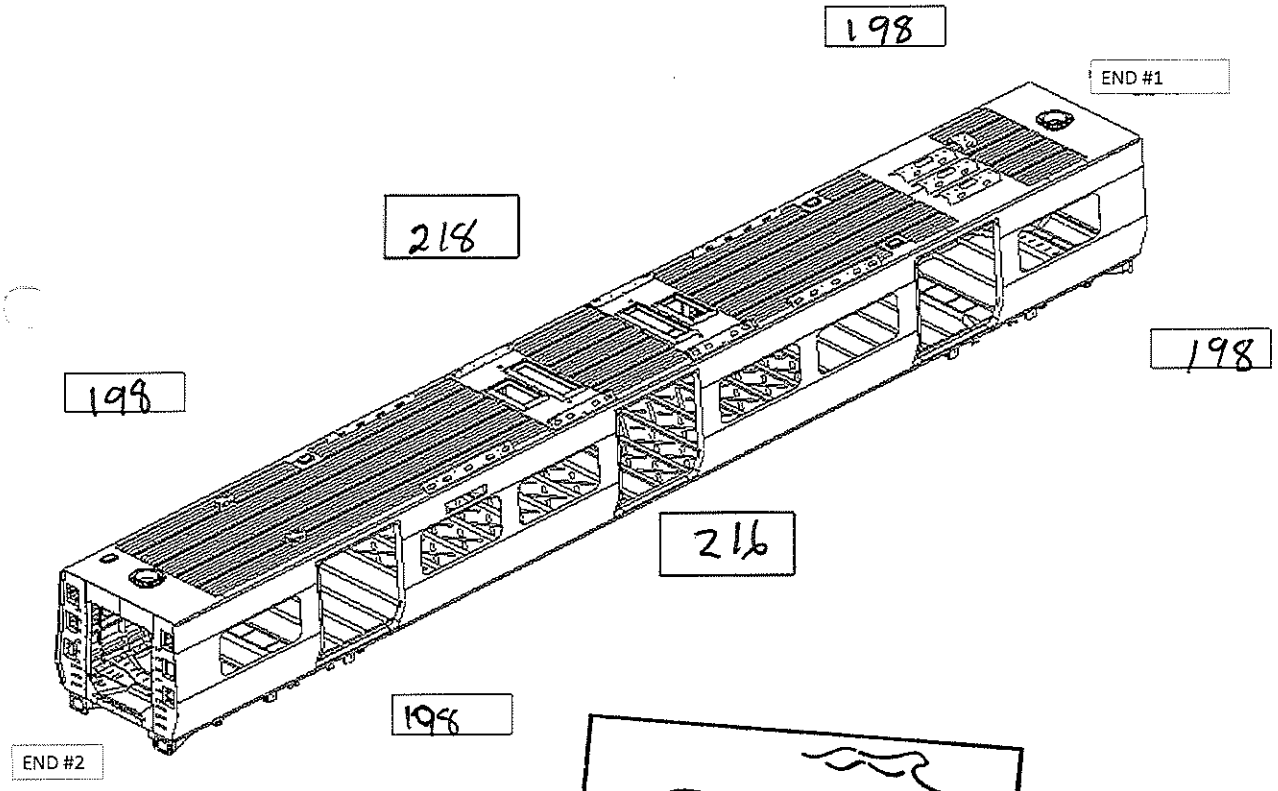
GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230

Specified Camber for car out of jig is 18mm(-0mm + 2mm)



MEASURED CAMBER VALUES	
RIGHT	18
LEFT	20

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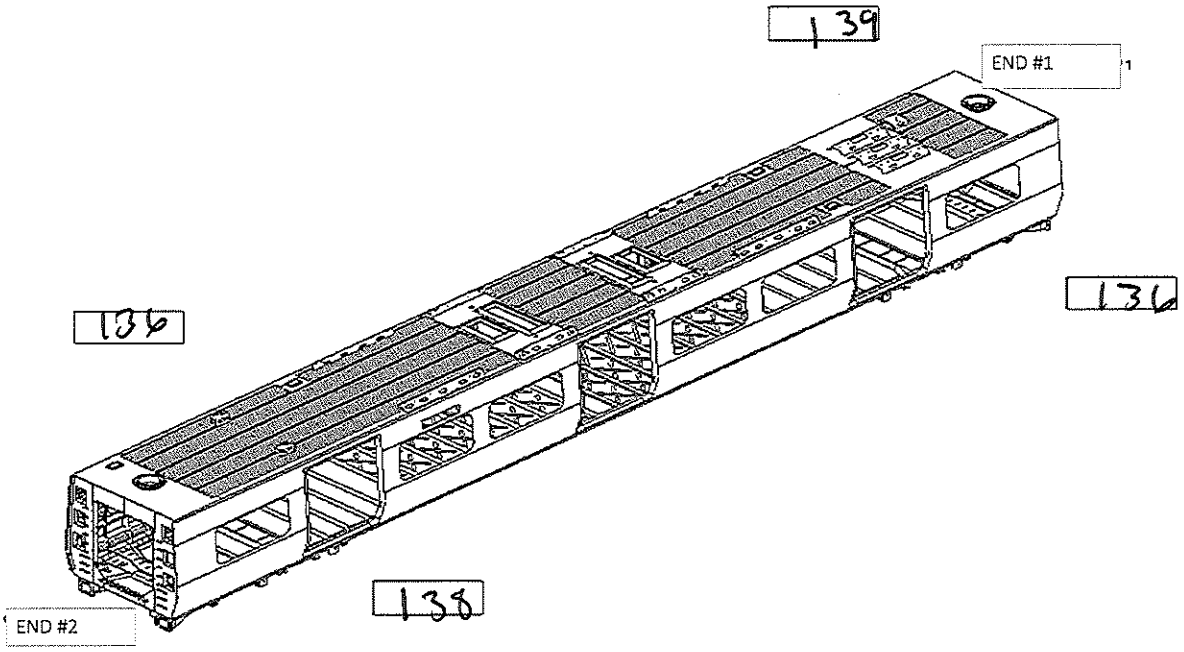
GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230

Twist measured in transversal and longitudinal = Maximum 3mm. Measure twist on air spring plates (LHS and RHS), both End 1 and End 2 folllowing twist measurement document.



TWIST FOUND ON END 1	
TRANVERSE	2
LONGITUDINAL	3

TWIST FOUND ON END 2	
TRANVERSE	3
LONGITUDINAL	2

GIBELA

2024 -02- 01

INDUSTRIAL QUALITY
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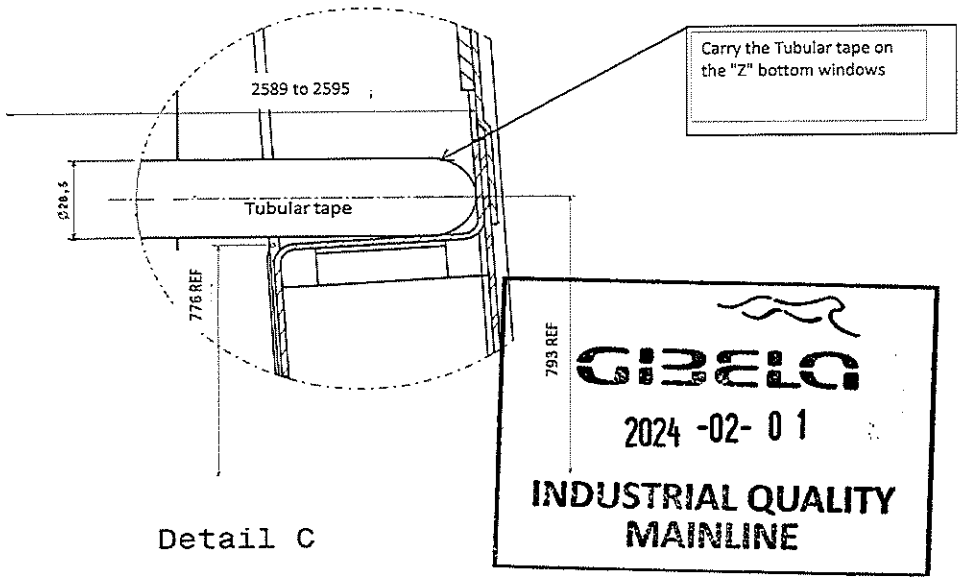
Specifications of Details for CBS measurement CB1230



Detail C

GIBELO
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INDUSTRIAL QUALITY
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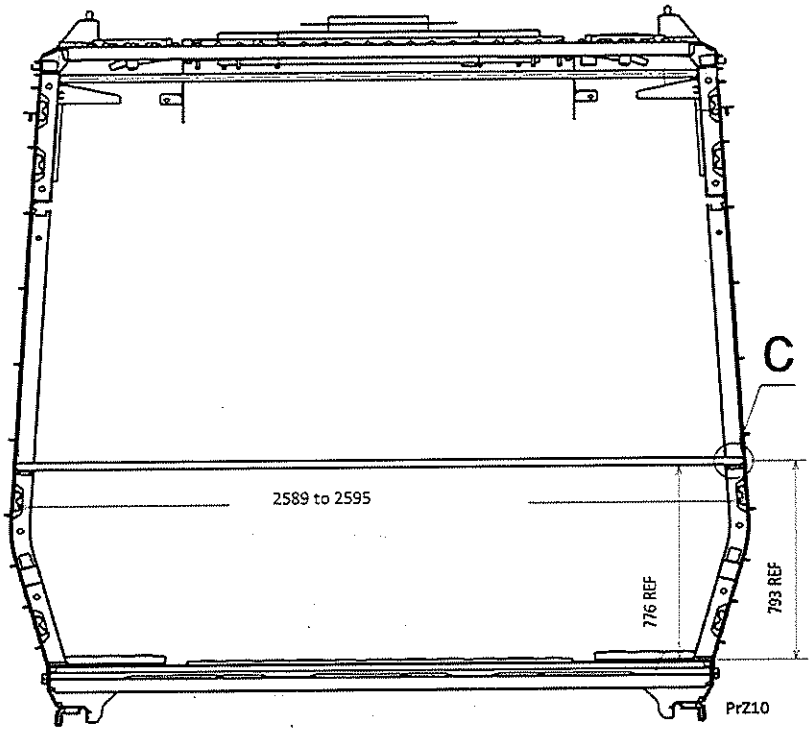
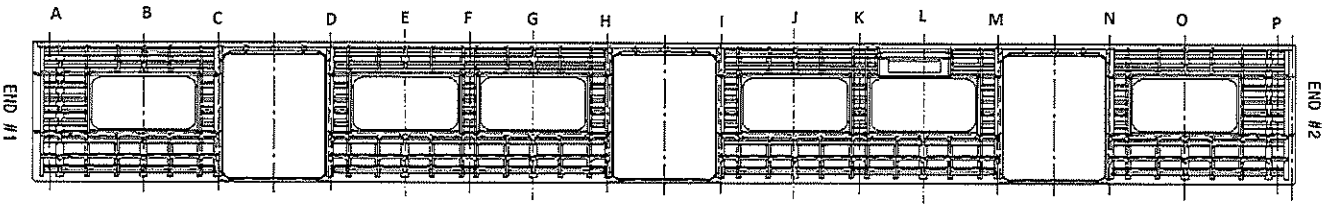


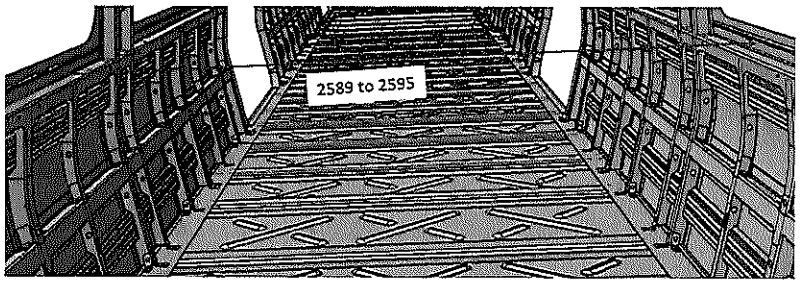
GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	25 92
B	25 89
C	25 89
D	25 93
E	25 90
F	25 91
G	25 91
H	25 90
I	25 91
J	25 89
K	25 93
L	25 91
M	25 90
N	25 92
O	25 89
P	2595



Threashold verification

Nominal value :38

Door 1		Door 2		Door 3	
L	R	L	R	L	R
38	38	39	37	37	39

Door 4		Door 5		Door 6	
L	R	L	R	L	R
38	37	38	38	39	38

BOILER MAKER: Mnothapelo

WELDER: Zonele

GIBELA
2024 -02- 01
INDUSTRIAL QUALITY
MAINLINE

Dye penetrant test

Dye-penetration test to be performed by quality personnel

	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29

Specifications of Details for CBS measurement

Item	Description of the issue	OK	Signature/Date (Operations)	Signature/Date (Quality)

II.2 - Check List REX

Check List Items

Item	Picture/Drawing	Description	Criteria /Record	OK	NOK	N/A	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX					

GIBELA
2024 -02- 01
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30 Date 06/11/2023	Project: PRASA **SI.CB2230.256.V29**

Self Inspection - Final Result

Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT		GO	(If f activities are not complete, the missing activities must not impact the next stage)	21/02/2024	Leroy Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	21/02/24	NTokozo Industrial Quality	
		NO GO	There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)		Operations	
			There are non-conformities impact the quality of the product and there is no corrective action defined yet)		Industrial Quality	

In case of "NO GO", describe blocking problems

In case of "NO GO", the operations manager must define below action plan to ensure "GO":

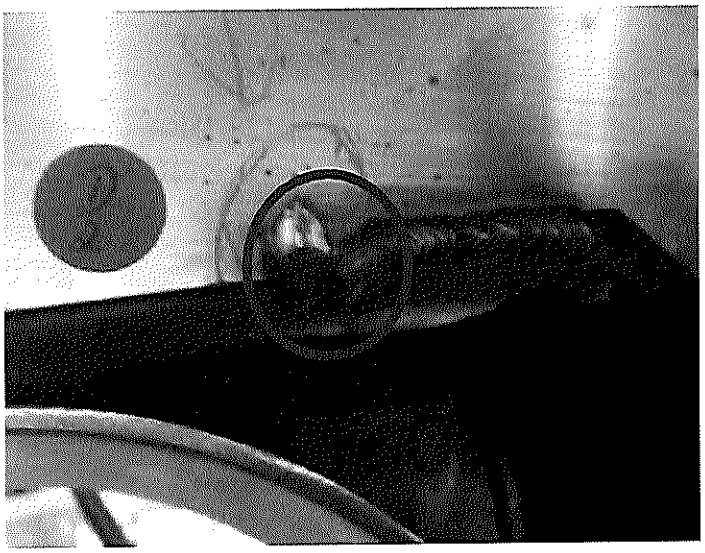
Item	Description		Responsible	Due date	Status

Operations

Quality

GIBELA
2024 -02- 01
INDUSTRIAL QUALITY
MAINLINE

ANNEXURE A: Arc Welding Quality Acceptance Standard



ANNEXURE B: Sealant