

CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 4 2 1

WEIGHT: ~~1495~~ Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegapurus	19/12/13	F110326 VH1889171	179247 104825 01	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegapurus	19/12/13	V201257 VFK70756	176226 103023 01	
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegapurus	19/12/13	P206170 VFK97579	177332 103032 01	
RCS 355	20 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegapurus	19/12/13	P302091 VFK9784		
RCS 355	30 mm					

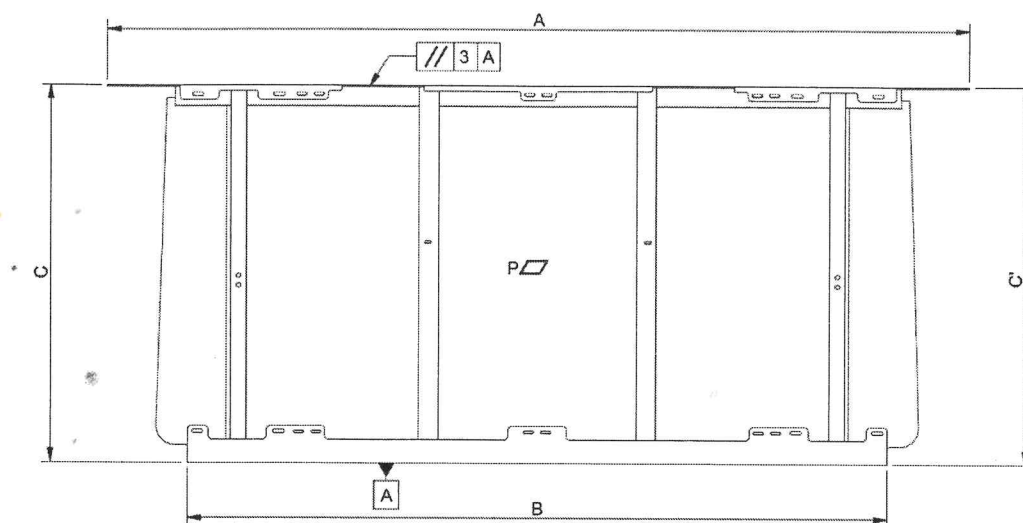
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegapurus	19/12/13	F207905 VH1651923	175252 102206 01	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm				171956 102206 01	
RCS 450	6 mm					
RCS 450	6 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegapurus	19/12/13	F201089 VH1555262	175869 102206 01	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

Cabin Roof Assembly: GN002839


Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	Dylan Davids	Assembly Date:	2023/12/04		
Sign:		Wire Batch No.:	107238201		




Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	Leon	Sign:		Date:	2023/12/04


Dimensional Control

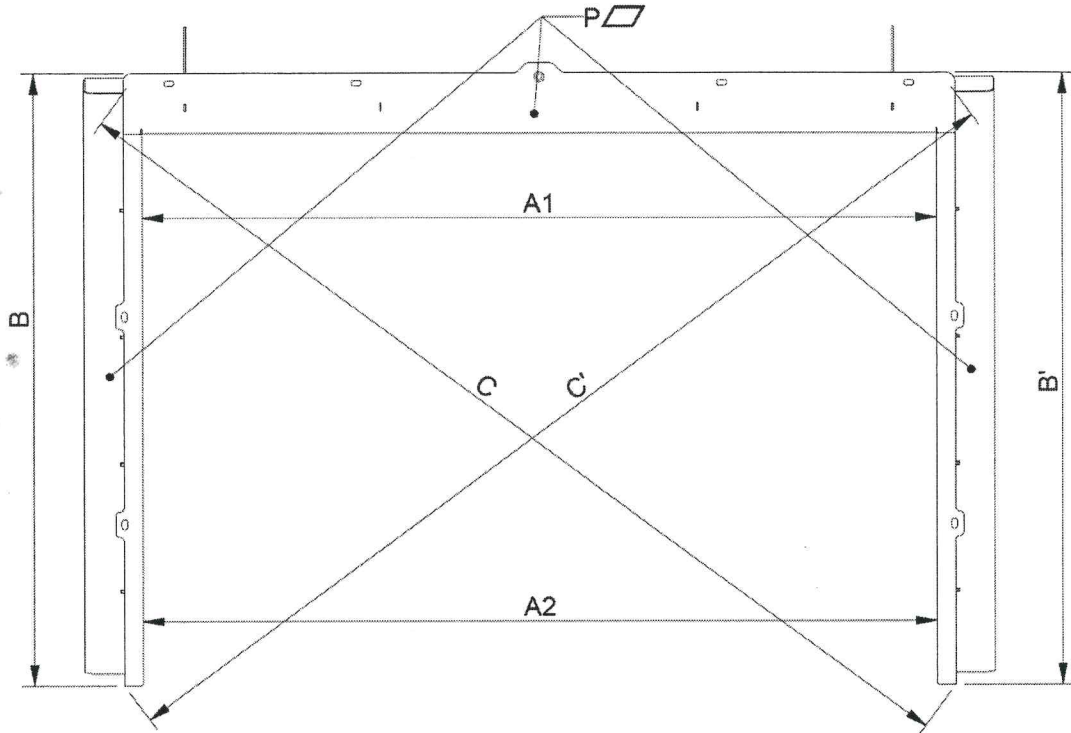
Rep		Toler.	Dimension measured		Measuring Equipment	Observations	
A	2216	+5/-0	2216		Tape Measure	Acceptable	
B	1800	± 4	1801			Acceptable	
C	976	+2/-3	976	976		Acceptable	
QC Inspector:		Leon		Sign:		Date:	20_28/_12/_04

Geometrical Control


Nature of Checks			Dimension Measured	Measuring Equipment	Observations
Planeity P		6 mm	Passed	Ruler	Acceptable
//	3	A	Passed	Set Square	Acceptable
QC Inspector:		Leon	Sign:		Date: 20 ²³ / 12 / 04

Cabin Front Frame Assembly: GN002840


Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Bambelo Gcuma	Assembly Date:	20 22/12/05			
Sign:		Wire Batch No.:	220752			




Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	LEON	Sign:		Date:	20 23/12/05	


Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	1910	± 2	1912		Tape Measure	Accepted
A2	1910		1910			Accepted
B	1475	± 1	1475	1475		Accepted
C	Diagonals C - C' ≤ 3		2478	2475		Accepted
QC Inspector:		Leon		Sign:		Date: 20_12/12/05

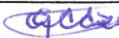
Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P : Planeity	4 mm	Passes	Ruler	Accepted
QC Inspector:		LEON		Sign:  Date: 20 23/12/05

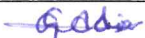
Cabin LHS/RHS Wing Mirror Plate Assembly: GN002846/GN002844

Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	TK Boote	Assembly Date:	20 <u>23</u> / <u>11</u> / <u>28</u>			
Sign:		Wire Batch No.:	2202152			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

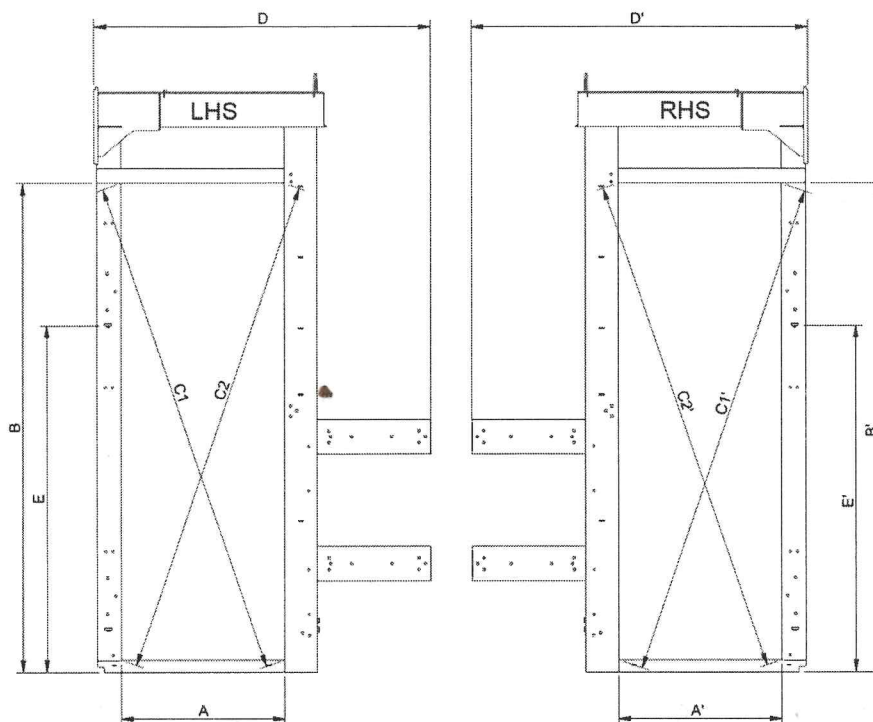
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	20 <u>23</u> / <u>11</u> / <u>28</u>			
Sign:		Wire Batch No.:	2202152			

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	20 <u>23</u> / <u>11</u> / <u>27</u>			
Sign:		Wire Batch No.:	2202152			

Cabin LHS/RHS Door Frame Assembly: GN002839

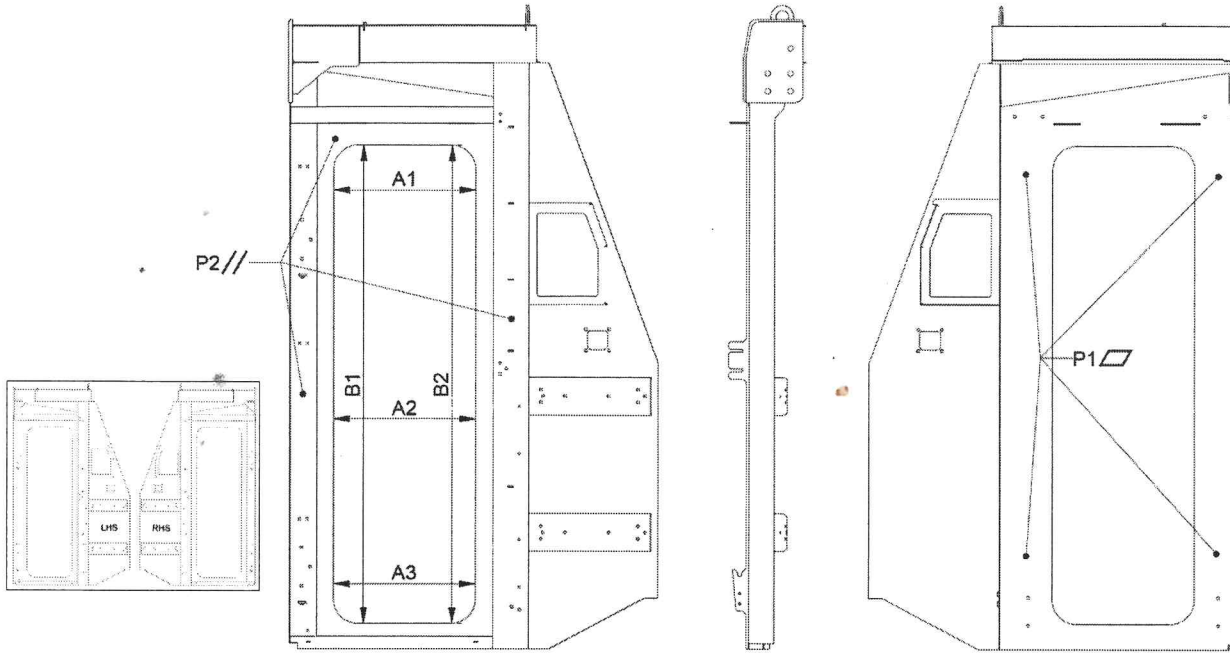
Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Glenn	Assembly Date:	2023/11/28			
Sign:	<i>Glenn</i>	Wire Batch No.:	2202152			



Welding Control							
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042				Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:		<i>Leon</i>		Sign:	<i>Leon</i>	Date:	2023/12/01
Dimensional Control							
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	695	± 2	695	696	Tape Measure	Acceptable	
B	2086	+1/-3	2087	2084		Acceptable	
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2153	2153		Acceptable	
C1 - C2			2151	2151		Acceptable	
D	1438	+2/-3	1440	1438		Acceptable	
E			1483	1482		Acceptable	
QC Inspector:		<i>Leon</i>		Sign:	<i>Leon</i>	Date:	2023/12/01
Geometrical Control							
Nature of checks		Dimension Measured		Measuring Equipment	Observations		
P1 : planeity of 2 edges		4 mm	Pass	Ruler	Acceptable		
QC Inspector:		<i>Leon</i>		Sign:	<i>Leon</i>	Date:	2023/12/01

Cabin LHS/RHS Side Assembly: GN002838/GN002837


Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	TK Rooth	Assembly Date:	2023/12/01			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			









Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
QC Inspector:	L. K. J.	Sign:	<i>[Signature]</i>	Date:	2023/12/04	

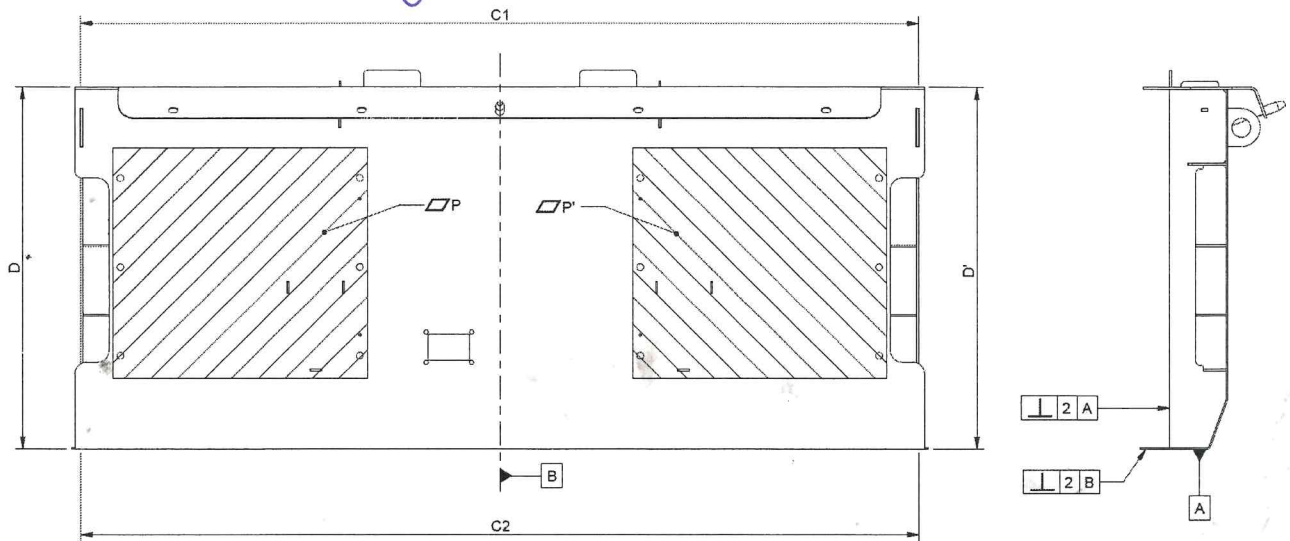
Dimensional Control

Rep	Theorical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	560	± 2	558	558	Tape Measure	Aug 11/11	
A2			559	560		Aug 11/11	
A3			560	560		Aug 11/11	
B1	1900	± 2	1898	1898		Aug 11/11	
B2			1898	1898		Aug 11/11	
QC Inspector:		L. K. J.		Sign:		Date:	20 02 / 12 / 04

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm		Ruler	
P2 : Planeity	2 mm		Ruler	
QC Inspector:		Sign:		Date: 20 <u>23</u> / <u>12</u> / <u>04</u>

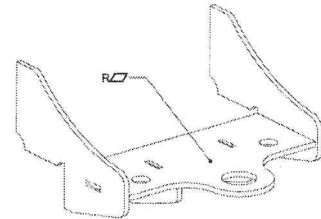
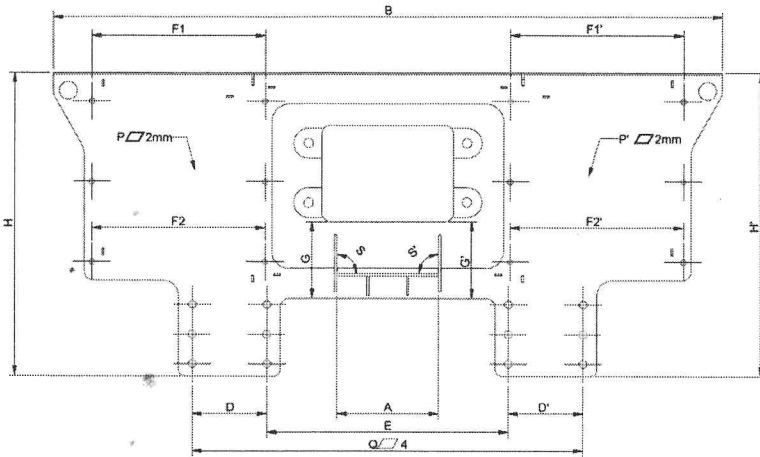
Cabin Shield Assembly: GN002836				
Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	SEVAN / DAUSNHILL	Assembly Date:	2023/12/04	
Sign:		Wire Batch No.:	2202152	



Welding Control						
Assembly Completed as per WI/SOS MD_0043		Confirmed		Yes	<input checked="" type="checkbox"/> No	
QC Inspector:	LEON	Sign:		Date:	2023 / 12 / 04	
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2213	2213	Tape Measure	Accepted
D / D'	956	± 2	955	955		Accepted
QC Inspector:	LEON	Sign:		Date:	2023 / 12 / 04	
Geometrical Control						
Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planeity P / P'		2 mm	PASSED		Ruler	Accepted
Perpendicularity	2	A	PASSED		Set Square	Accepted
	2	B	PASSED		Set Square	Accepted
QC Inspector:	LEON	Sign:		Date:	2023 / 12 / 04	

Cabin Front Headstock Assembly: GN002841


Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	TR Boorn	Assembly Date:	20 ²³ / ¹¹ / ²⁰			
Sign:		Wire Batch No.:	2202152			




Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
QC Inspector:	Leon	Sign:		Date:	20 ²³ / ¹¹ / ³⁰	

Dimensional Control

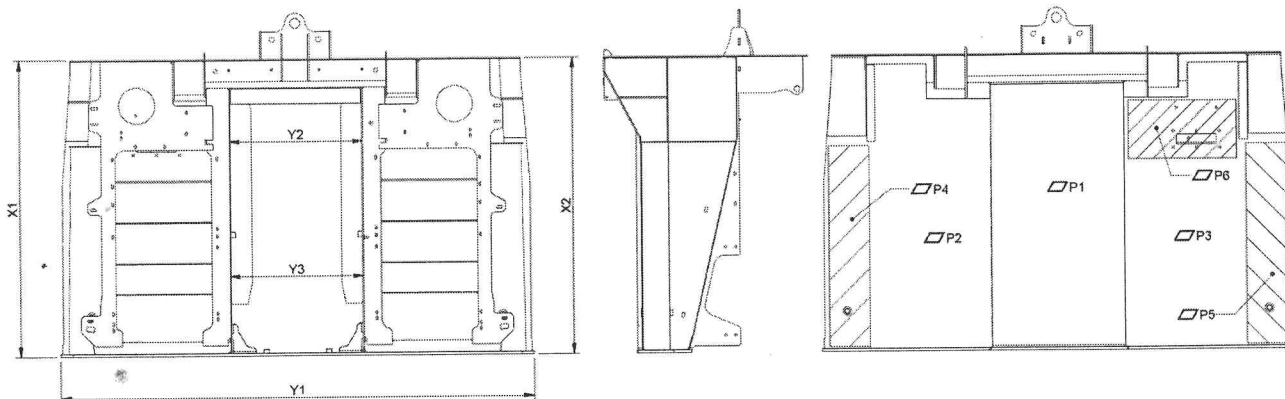
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	340	± 1	340		Tape Measure	Acceptable	
B	2240	± 4	2240			Acceptable	
D / D'	250	± 1	250.5	250.5		Acceptable	
E	808	± 2	808			Acceptable	
F1 / F1'	580	± 1	581	581		Acceptable	
F2 / F2'			581	581		Acceptable	
G / G'	258	± 1	259	260		Acceptable	
H / H'	1019	± 2	1020	1020		Acceptable	
QC Inspector:		Leon		Sign:		Date:	20 ²³ / ¹¹ / ³⁰

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
O: Planeity of global assembly	4 mm	Passed	Ruler	Acceptable
P / P': Planeity	2 mm	Passed	Ruler	Acceptable
Q: Planeity Surface of Supports	4 mm	Passed	Ruler	Acceptable
R: Planeity Coupler Support	2 mm	Passed	Ruler	Acceptable
S: Perpendicularity coupler	1mm	Passed	Square	Acceptable
QC Inspector:	Leon	Sign:		Date: 20_23_11_30


Cabin Underframe Assembly: GN002835

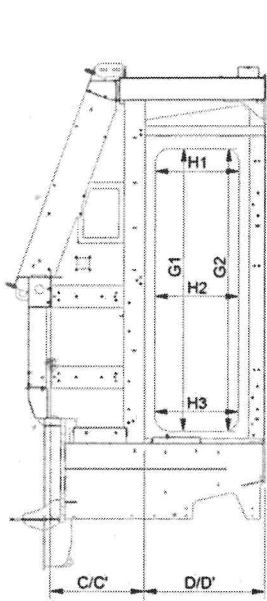
Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	20 <u>23</u> / <u>12</u> / <u>04</u>	
Sign:	<i>[Signature]</i>	Wire Batch No.:	<u>220 2167</u>	



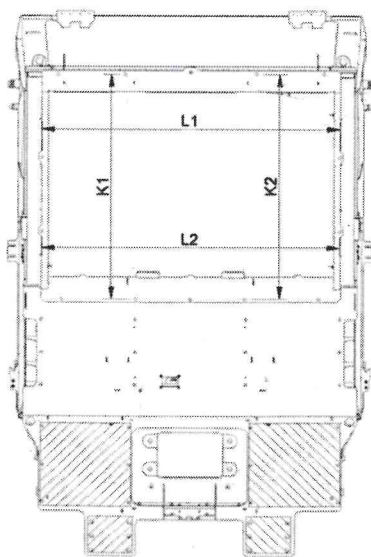
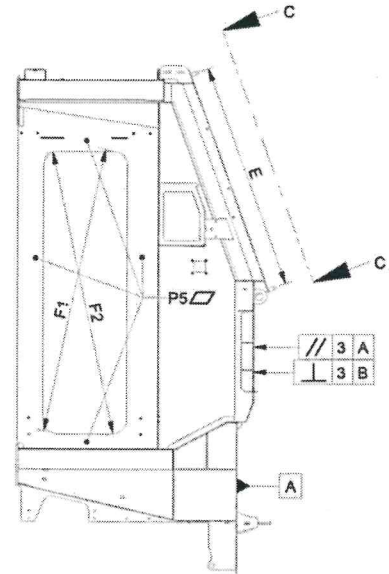
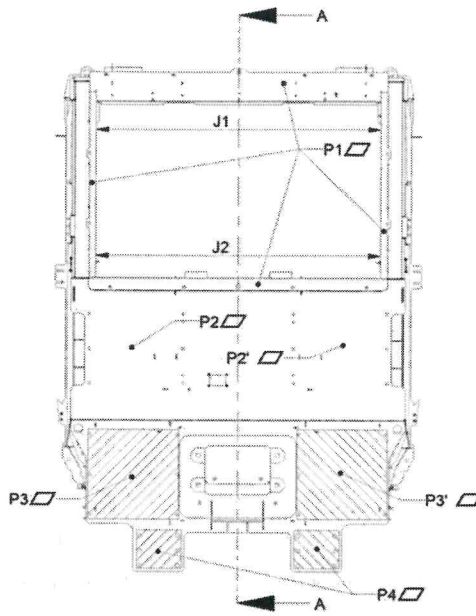
Welding Control						
Assembly Completed as per WI/SOS MD_0042			Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>23</u> / <u>12</u> / <u>04</u>	
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	<u>1486</u>	<u>1486</u>	Tape Measure	<i>Acceptable</i>
Y 1	2354	± 3	<u>2352</u>			<i>Acceptable</i>
Y2 / Y3	666	± 1	<u>667</u>	<u>667</u>		<i>Acceptable</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>23</u> / <u>12</u> / <u>04</u>	
Geometrical Control						
Nature of checks			Dimension Measured		Measuring Equipment	Observations
P1 : Planeity	4 mm	<u>PASSED</u>			Ruler	<i>Acceptable</i>
P2 / P3 : Planeity	4 mm	<u>PASSED</u>			Ruler	<i>Acceptable</i>
P4 / P5 : Planeity	2 mm	<u>PASSED</u>			Ruler	<i>Acceptable</i>
P6 : Planeity	2 mm	<u>PASSED</u>			Ruler	<i>Acceptable</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>23</u> / <u>12</u> / <u>04</u>	

Cabin Structure Assembly: GN002834

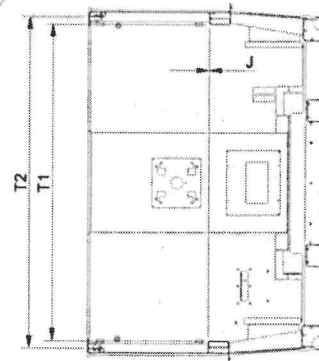
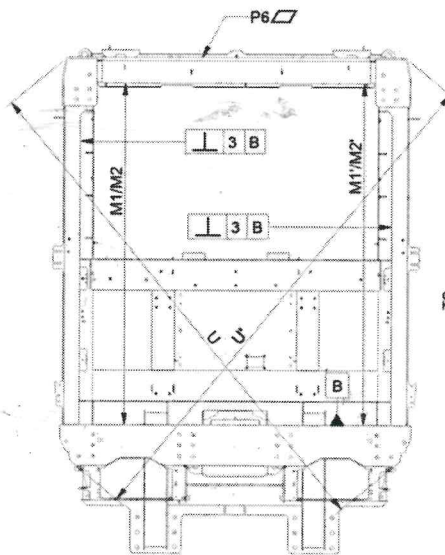
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BICEM	Assembly Date:	20 23 / 11 / 04			
Sign:		Wire Batch No.:	220222			






SECTION A-A




AUX VIEW: C



SECTION B-B

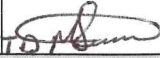



Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed		Yes		<input checked="" type="checkbox"/> No
QC Inspector:		LEON		Sign:				Date: 20 ²³ / 12 / 07	
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	626	625	Acceptable				
D / D'	813	± 2,5	812	812	Acceptable				
E	1531.5	± 3	1530		Acceptable				
G1 / G'1	Height 1900	+1	1897	1897	Acceptable				
G2 / G'2		-3	1898	1898	Acceptable				
H1 / H'1	Width 560	+1	557	557	Acceptable				
H2 / H'2		-3	558	558	Acceptable				
H3 / H'3			559	559	Acceptable				
F1 / F'1	Diagonals 1939		1935	1935	Acceptable				
F2 / F'2			1935	1935	Acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	0	0	Acceptable				
J	Gap of Doors	± 1,5	0		Acceptable				
K1 / K2	1515	± 3	1514	1514	Acceptable				
L1 / L2	1996	± 3	1999	1997	Acceptable				
M1 / M'1	2306	± 3	2467	2467	Acceptable				
M2 / M'2			2478	2477	Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2127	2128	Acceptable				
T2 / T'2	2230 Top/Bottom		2230	2229	Acceptable				
Difference	U - U' (3522)	≤ 4mm	3520	3520	Acceptable				
QC Inspector:		LEON		Sign:				Date: 20 ²³ / 12 / 07	
Geometrical Control									
Nature of checks				Toler.	LHS / Dimension Measured / RHS				
P1 / P'1	Planeity			2 mm	PASSED		Acceptable		
P2 / P'2	Planeity			2 mm	PASSED		Acceptable		
P3 / P'3	Planeity			4 mm	PASSED		Acceptable		
P4 / P'4	Planeity			4 mm	PASSED		Acceptable		
P5 / P'5	Planeity			4 mm	PASSED		Acceptable		
P6 Roof	Planeity			6 With 2m Ruler	PASSED		Acceptable		
Shield	//	3	A	3	PASSED		Acceptable		
Shield	⊥	3	A	3	PASSED		Acceptable		
Door Post	⊥	3	A	Front	PASSED		Acceptable		
				Back	PASSED		Acceptable		
QC Inspector:		LEON		Sign:				Date: 20 ²³ / 12 / 07	

Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLOEM	Assembly Date:	20 23 / 12 / 02			
Sign:		Wire Batch No.:	220222			


Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
Operator:		Assembly Date:	20 __ / __ / __			
Sign:		Wire Batch No.:				

Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Fasteners positioned in all Rivnuts and Bosses		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Masked as per GMS-SOS-GIBELA-CABIN-001		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:	DAVID	Sign:			
Date:	2024/01/20				
Record of Shot Blasting					
Operator:		Date:	2024/01/20		
Start Time:	07 H 13	End Time:	10 H 47		
Temperature ($\geq 15^\circ$):	19 - 09°C	Humidity ($\leq 75\%$):	63 - 02 %		
Shot Blasting Self Inspection					
Interior of Cabin: Sa 1 - Light Stripping		Confirmed	Yes	<input checked="" type="checkbox"/> No	
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping		Confirmed	Yes	<input checked="" type="checkbox"/> No	
		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:	DAVID	Sign:			
Date:	2024/01/20				
Shot Blasting Cleaning					
Cabin free of all sand		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:	DAVID	Sign:			
Date:	2024/01/20				
Shot Blasting Control					
Temperature $\geq 15^\circ$:	23 - 04°C	Humidity $\leq 75\%$:	65 - 07 %		
Internal Roughness $3.2 \leq Ra \leq 12.5$	As per Example	External Roughness $3.2 \leq Ra \leq 12.5$	As per Example		
QC Inspector:	Leon	Sign:			
Date:	24/01/24				

Record of Priming							
Start Time:		2:00		End Time:		4:00	
Temperature $\geq 15^{\circ}$:		28°C		Humidity $\leq 75\%$:		39%	
Paint Batch No.:		7296866		Paint Expiry Date:		6/5/2024	
Hardener Batch No.:		7287752		Hardener Expiry Date:		15/04/2024	
Desolvation Start Time:		4:00		Desolvation End Time:		4:15	
Stoving Start Time:		4:15		Stoving End Time:		5:15	
Stoving Temp:		600					
Operator:		Paul		Sign:		Paul	
Date:		20/01/2020					
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 42.1	5: 61.7	1: 54.1	5: 81.7	1: 77.4	5: 61.9	1: 63.4	5: 45.6
2: 59.8	6: 43.8	2: 63.8	6: 13.9	2: 71.4	6: 52.3	2: 45.0	6: 78.9
3: 54.2	7: 73.7	3: 44.7	7: 64.6	3: 63.0	7: 80.6	3: 59.5	7: 79.0
4: 50.1	8: 52.6	4: 51.6	8: 78.3	4: 41.8	8: 53.0	4: 51.3	8: 44.3
Min:	42.1	Min:	44.7	Min:	41.8	Min:	44.3
Max:	73.7	Max:	81.7	Max:	80.6	Max:	78.9
Average:	54.75	Average:	56.5	Average:	62.6	Average:	59
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 43.6	5: 40.1	1: 49.5	5: 56.5	1: 60.1	5: 67.2	1: 63.0	5: 79.6
2: 57.2	6: 60.3	2: 71.8	6: 65.8	2: 50.3	6: 63.5	2: 79.4	6: 45.1
3: 56.6	7: 72.2	3: 55.3	7: 45.1	3: 54.8	7: 62.7	3: 46.3	7: 77.8
4: 67.4	8: 44.1	4: 79.0	8: 74.0	4: 47.0	8: 56.1	4: 72.0	8: 87.7
Min:	40.1	Min:	45.1	Min:	47.0	Min:	45.1
Max:	72.2	Max:	79.0	Max:	67.2	Max:	79.6
Average:	55.1	Average:	62.1	Average:	57.7	Average:	68.8
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 41.4	5: 57.1	1: 59.3	5: 48.2	1: 77.6	5: 54.1	1: 75.3	5: 40.0
2: 78.5	6: 60.1	2: 53.3	6: 67.9	2: 41.1	6: 66.4	2: 55.4	6: 79.4
3: 80.6	7: 76.1	3: 43.0	7: 52.7	3: 53.9	7: 65.3	3: 46.1	7: 62.0
4: 60.3	8: 41.3	4: 70.1	8: 64.2	4: 46.9	8: 78.0	4: 45.1	8: 72.8
Min:	41.3	Min:	43.0	Min:	41.1	Min:	40.0
Max:	80.6	Max:	70.1	Max:	78.0	Max:	79.4
Average:	61.9	Average:	57.2	Average:	60.4	Average:	60.2
Primer has been inspected and is free of defects				Confirmed		Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>	
QC Inspector:		Zothile		Sign:		[Signature]	
Date:		20.01.2024					

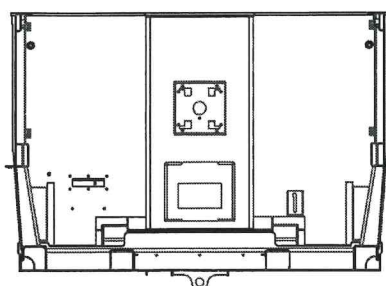
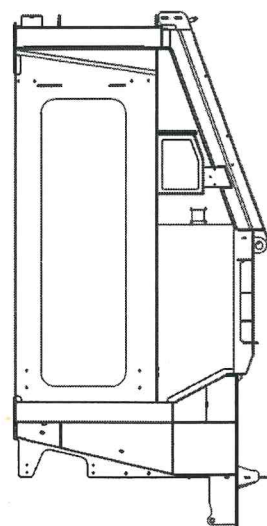
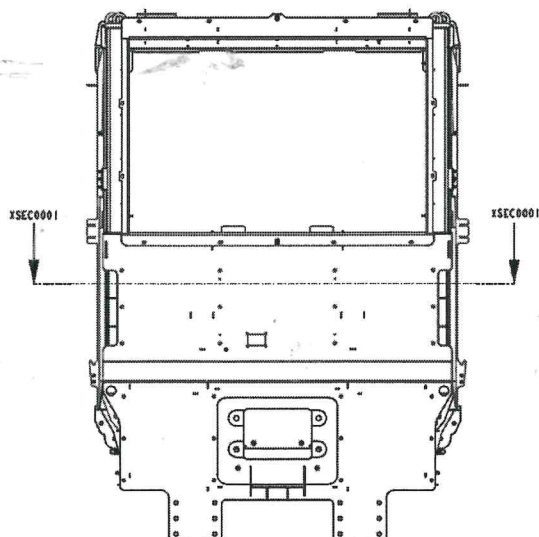
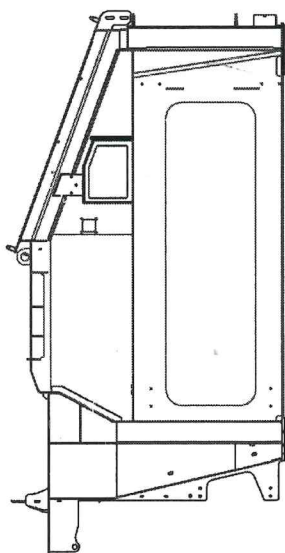
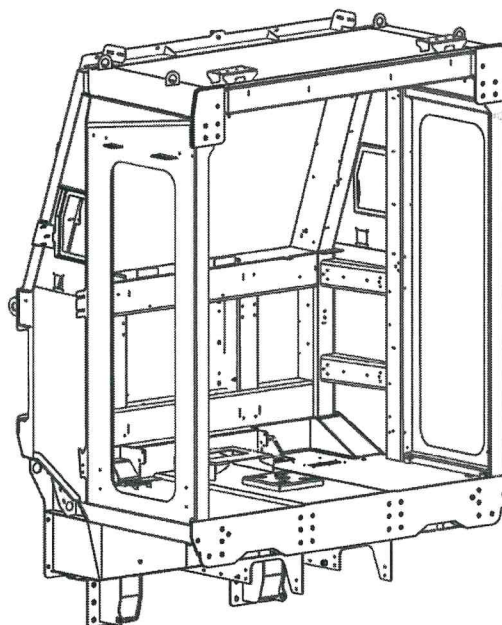
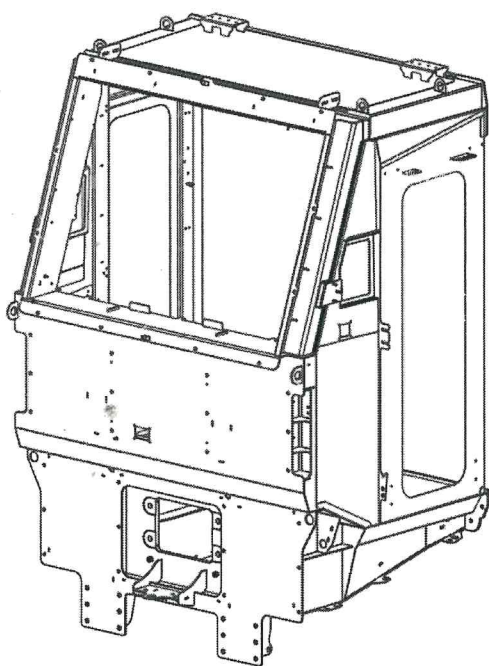
Record of Painting NCSS3010 R90B			
Start Time:	8:00	End Time:	9:50
Temperature $\geq 15^{\circ}$:	25 $^{\circ}$ C	Humidity $\leq 75\%$:	39%
Paint Batch No.:	8136210	Paint Expiry Date:	17/11/2024
Hardener Batch No.:	7250479041	Hardener Expiry Date:	04/2024
Desolvation Start Time:	9:00	Desolvation End Time:	9:15
Stoving Start Time:	9:15	Stoving End Time:	10:15
Stoving Temp:	60 $^{\circ}$ C		
Operator:	Colin	Sign:	Colin
Date:	20/01/21		
Painting NCSS3010 R90B Control			
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS	
GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)			
1: 109.2	5: 154.3	1: 96.9	5: 106.7
2: 90.8	6: 160.8	2: 99.2	6: 80.7
3: 76.9	7: 90.8	3: 150	7: 96.8
4: 113.4	8: 120.6	4: 113.6	8: 116.9
Min:	76.9	Min:	80.7
Max:	160.8	Max:	150
Average:	112	Average:	107
Painting NCSS3010 R90B has been inspected and is free of defects		Confirmed	Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	48.6
QC Inspector:	Reece	Sign:	PBell
Date:	26/01/24		

Record of Painting Blue NCSS1565 B			
Start Time:	2:00	End Time:	3:00
Temperature $\geq 15^{\circ}$:	25 $^{\circ}$	Humidity $\leq 75\%$:	38%
Paint Batch No.:	8032294	Paint Expiry Date:	13/06/2024
Hardener Batch No.:	7250479041	Hardener Expiry Date:	04/2024
Desolvation Start Time:	3:00	Desolvation End Time:	3:15
Stoving Start Time:	3:15	Stoving End Time:	4:15
Stoving Temp:	60 $^{\circ}$		
Operator:	Colin	Sign:	Colin
Date:	20 24/01/24		
Painting Blue NCSS1565 B Control			
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS	
GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)			
1: 131	5: 105	1: 161	5: 144
2: 108	6: 89.9	2: 136	6: 170
3: 122	7: 88.4	3: 114	7: 91.0
4: 121	8: 106	4: 150	8: 121
Min:	88.4	Min:	91.0
Max:	131	Max:	170
Average:	108	Average:	136
Painting NCSS3010 R90B has been inspected and is free of defects		Confirmed	Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	91.1
QC Inspector:	Zothile	Sign:	
Date:	24.01.2024		

Record of RAL 7012							
Start Time:		8:00		End Time:		10:00	
Temperature $\geq 15^{\circ}$:		25 $^{\circ}$		Humidity $\leq 75\%$:		54%	
Paint Batch No.:		8096599		Paint Expiry Date:		21/9/2024	
Hardener Batch No.:		7250479041		Hardener Expiry Date:		04/2024	
Desolvation Start Time:		10:00		Desolvation End Time:		10:15	
Stoving Start Time:		10:15		Stoving End Time:		11:15	
Stoving Temp:		60 $^{\circ}$					
Operator:		NTUTHUKO		Sign:		NTUTHUKO	
Date:		20/01/24					
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 173	5: 101	1: 127	5: 134	1: 129	5: 122	1: 91.4	5: 88.8
2: 134	6: 155	2: 156	6: 129	2: 106	6: 113	2: 128	6: 80.6
3: 175	7: 168	3: 108	7: 121	3: 92.7	7: 148	3: 81.4	7: 149
4: 118	8: 127	4: 136	8: 110	4: 118	8: 123	4: 127	8: 136
Min:	101	Min:	108	Min:	92.7	Min:	80.6
Max:	175	Max:	156	Max:	148	Max:	149
Average:	143	Average:	127	Average:	118	Average:	98
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 137	5: 145	1: 150	5: 123	1: 132	5: 138	1: 135	5: 143
2: 146	6: 126	2: 115	6: 97.0	2: 165	6: 141	2: 171	6: 159
3: 159	7: 125	3: 139	7: 135	3: 120	7: 130	3: 162	7: 162
4: 141	8: 156	4: 156	8: 119	4: 116	8: 126	4: 128	8: 131
Min:	125	Min:	97.0	Min:	120	Min:	128
Max:	159	Max:	156	Max:	165	Max:	171
Average:	141	Average:	129	Average:	133	Average:	148
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 158	5: 139	1: 137	5: 135				
2: 149	6: 146	2: 133	6: 105				
3: 144	7: 141	3: 159	7: 140				
4: 152	8: 163	4: 112	8: 122				
Min:	139	Min:	105				
Max:	163	Max:	159				
Average:	149	Average:	129				
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	35.8		
QC Inspector:		Zothule		Sign:			
Date:		24.01.2024					
SEALING OF CABIN							
All areas where there is no welding has been sealed with SIKA				Confirmed	YES	<input checked="" type="checkbox"/>	NO
All sealants have been neatly applied along joints				Confirmed	YES	<input checked="" type="checkbox"/>	NO
SIGN OFF							
CLOCK No:	2400	OPERATOR SIGN:		DATE:	24/01/24		

REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)

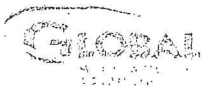


FAULT TRACKING

[illegible]

REMINDERS / COMMENTS

[illegible]



CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	421	Checks Updated:	2021/07/07

Disposition Key:	0	Pass
	X	Fail (Concession required)
	Δ	Rework required

No.	Description of inspection	Disposition	Validation after rework		Sign
			Repairer	Disposition	
1	WELDS ARE CLOSED	0			
2	NO PIN HOLES ON CAB STRUCTURE	0			
3	SEALANT IS APPLIED CORRECTLY <ul style="list-style-type: none">JOINTS ARE CLOSEDNO BREAKS IN THE SEALANTCORRECT BEAD	0			
4	RIVET NUTS ARE PROPERLY CRIMPED <ul style="list-style-type: none">RIVETS ARE MARKEDCORRECT GRIP RANGE USED	0			
5	NO MISS WELDS PRESENT AFTER SANDBLASTING	0			
6	NO VISUAL MISS WELDS (INSPECTION AFTER SEALING)	0			
7					
8					
9					
10					
11					
12					
13					
14					

Quality approval for release Signature	CO. NO:	DATE
ABett	2291	26/01/24