



PRASA PROJECT
APPLICABLE FROM TRAINSET 190+ AS PER BASELINE 10.4

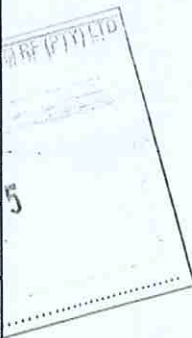
SELF INSPECTION SHEET


CONFIDENTIAL INFORMATION

This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE							WORK INSTRUCTION	SAFETY ? 	
				TC1	M4	M1	M2	M3	TC2				
<input type="checkbox"/>	DTR30225487/3	AAD0001278566	CARBODYSHELL M3,M4 ASSEMBLY	CB2210		X				(X)		PRA.CB2210.DTR30225 487/3.V30	YES
<input type="checkbox"/>													
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		Itumeleng 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		Itumeleng 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		Itumeleng 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		06/08/2020				
					CHECKER		Bongane Masina						
					REVISED BY		Bongane Masina						
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	19/02/2022	New Baseline change 10.3.1			APPROVER		Mbhombi collins		19/02/2022				
					CHECKER		Andani Muthelo						
					REVISED BY		Andani Muthelo						
26	14/04/2023	Addition of welding consumable traceability			APPROVER		Ntuli Vanessa		14/04/2023				
					CHECKER		Mohlampe Amogelang						
					REVISED BY		Mohlampe Amogelang						
30	20/07/2023	New Baseline change 10.4			APPROVER		Ngobeni Tyson		28/07/2023				
					CHECKER		Mohlampe Amogelang						
					REVISED BY		Mohlampe Amogelang						
31	07/11/2023	Added traceability for welding sections			APPROVER		Ngobeni Tyson		07/11/2023				
					CHECKER		Mohlampe Amogelang						
					REVISED BY		Ntokozo Zwane						
TRAINSET	CAR	OPERATOR NAME& ALPS NO		DATE	SELF INSPECTION NUMBER		PAGES						
214	M3	WINGA 471497		25/02/24	SI.CB2210.254.V30		17						

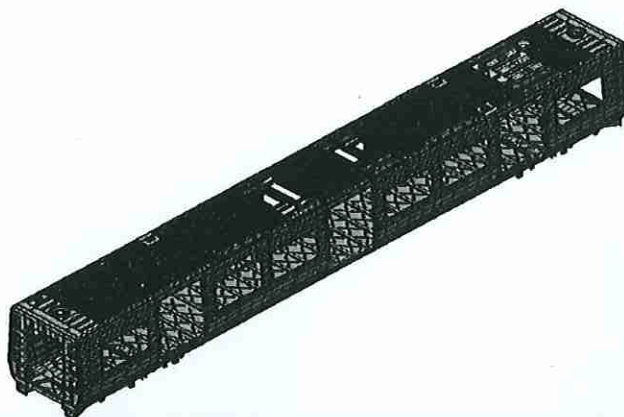


	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	

Car: M3 & M4	NCR:	Work station: CB2210
--------------	------	----------------------


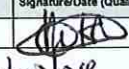


Safety Related







I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	TC1	M1	M2	M3	M4	TC2					
DTR30225487/3				X					✓		 23/02/24




I.2 - Instruments Control

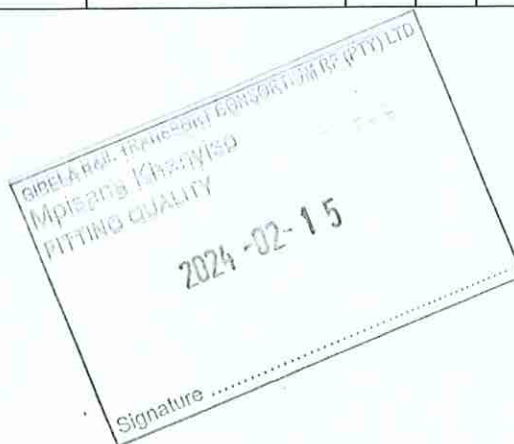
Monitoring and Measuring Instrument Control - Used for Special Process


Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULAR	22713	04/10/23	✓	 25/02/24	
30 M TAPE	6187P0084	23/03/21	✓	 25/02/24	
LASER TAPE	125425924	08/01/24	✓	 25/02/24	25/02/24

1.3 Consumables

Welding Consumable Control - Used for Special Process










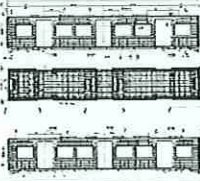





Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
AUTROD 308 LSI	E221880	MIG	✓	 25/02/24	
ETL 309 LSI	318394	MIG	✓	 25/02/24	 25/02/24

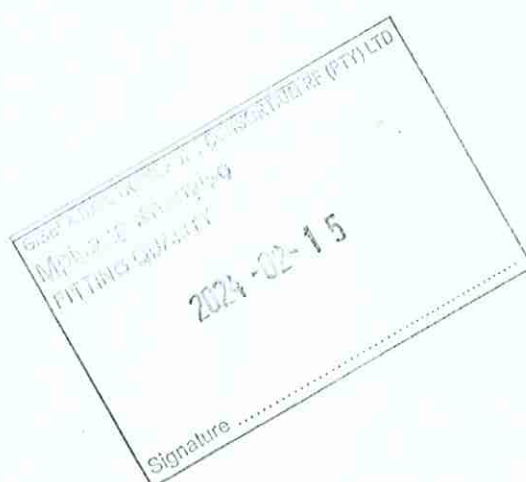


	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31	Project: PRASA SI.CB2210.254.V30
		Date	
		07/11/2023	

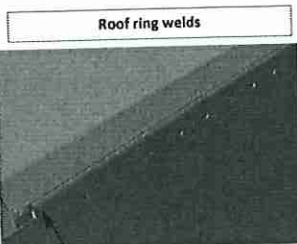
II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		 25/02/24	 25/02/24
02	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓		 25/02/24	 25/02/24
03	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 25/02/24	 25/02/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 25/02/24	 25/02/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓		 25/02/24	 25/02/24
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.	✓		 25/02/24	 25/02/24



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



Boiler maker (Name & Sign): Tuniso Pbs ^{LHS} Welder (Name & Sign): BOBBI Bess

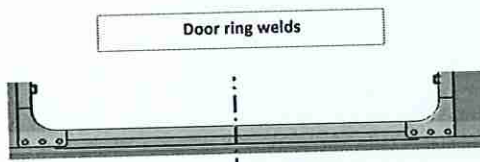
END 1

Boiler maker (Name & Sign): Tuniso Pbs ^{RHS} Welder (Name & Sign): Ketu K. Nair

Boiler maker (Name & Sign): Tuniso Pbs ^{LHS} Welder (Name & Sign): BOBBI Bess

END 2

Boiler maker (Name & Sign): Tuniso Pbs ^{RHS} Welder (Name & Sign): Ketu K. Nair

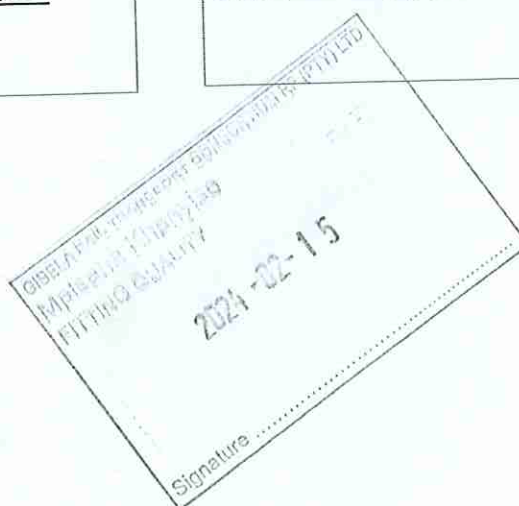


Boiler maker (Name & Sign): GERALD P. Mub ^{LHS}

Welder (Name & Sign): Thabang

Boiler maker (Name & Sign): GERALD P. Mub ^{RHS}

Welder (Name & Sign): Thabang



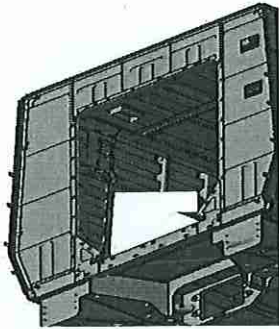
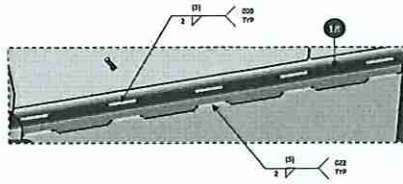


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.
31
Date
07/11/2023

Project: PRASA
SI.CB2210.254.V30

EUF Reinforcement Plates



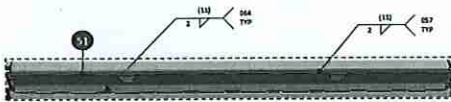
END 1

Boiler maker (Name & Sign):

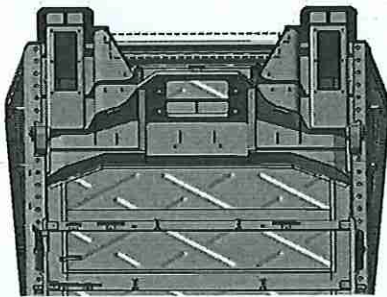
SEAN B

Welder (Name & Sign):

Kenny K. K.



END 2



Underneath the CAR

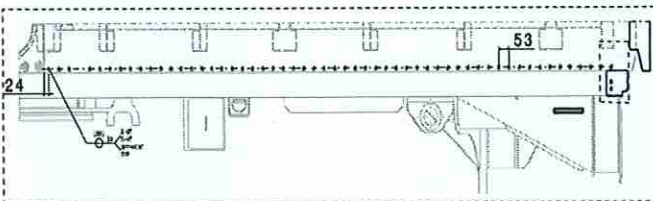
END 2

Boiler maker (Name & Sign):

TUMILO

Welder (Name & Sign):


Thabang

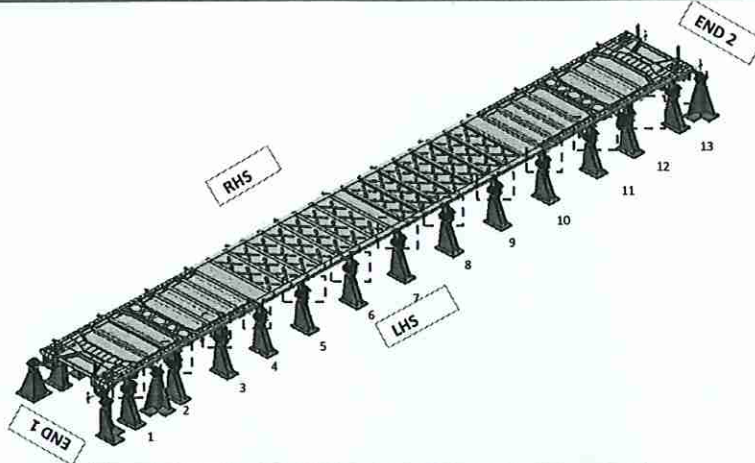


FEDOLI

Operator:

Jobogo Masalane

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

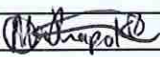
	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side						NA							
Right Hand Side													

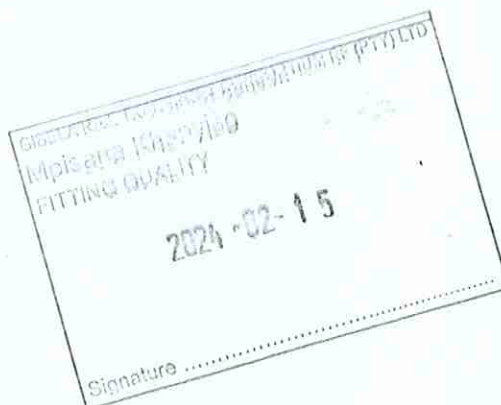
Signature Operations:  Date: 25/02/24

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						NA							
Right Hand Side													

Signature Industrial Quality:  Date: 25/02/24



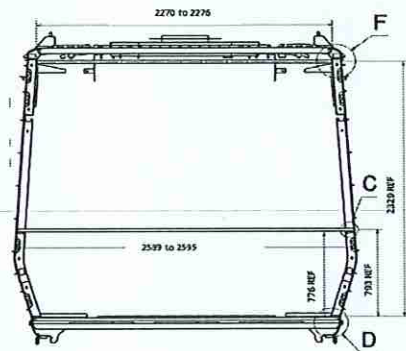
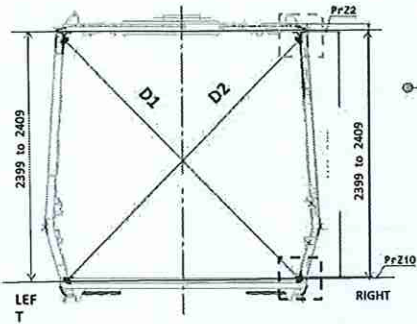
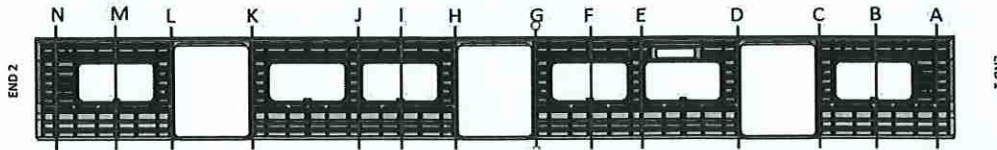


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.
31
Date
07/11/2023

Project: PRASA
SI.CB2210.254.V30

Specifications of Details for CBS measurement



Measurement positions on roof rail and side sill corner.



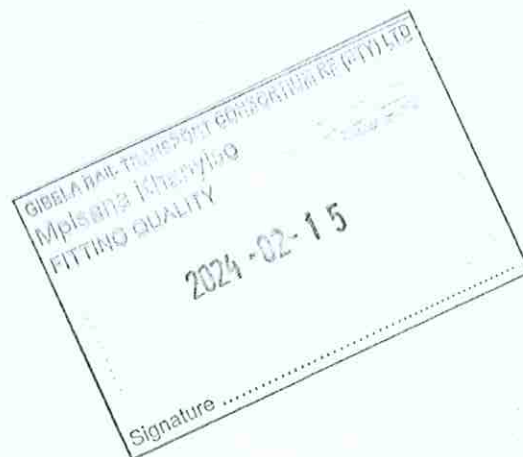
Measurement positions on side sill and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.



Detail P
Don't consider the corner

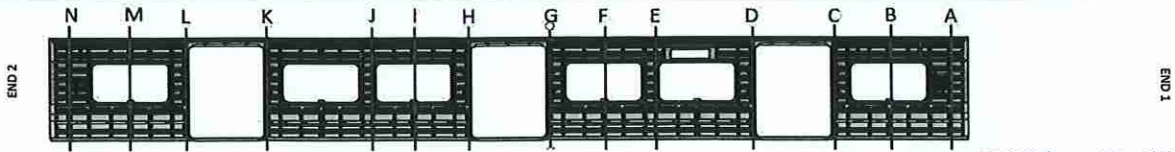




CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.
31
Date
07/11/2023Project: PRASA
SI.CB2210.254.V30

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	3269	3271	2	2406	2408	2
B	3268	3265	3	2405	2406	1
C	3269	3267	2	2405	2405	0
D	3268	3268	0	2407	2406	1
E	3265	3265	0	2404	2405	1
F	3266	3265	1	2406	2406	0
G	3268	3269	1	2405	2404	1
H	3270	3270	0	2406	2405	1
I	3264	3265	1	2405	2405	0
J	3266	3266	0	2404	2406	2
K	3270	3268	2	2407	2405	2
L	3268	3269	1	2405	2406	1
M	3265	3268	3	2408	2407	1
N	3268	3267	1	2407	2407	0

25/02/24





CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.

31

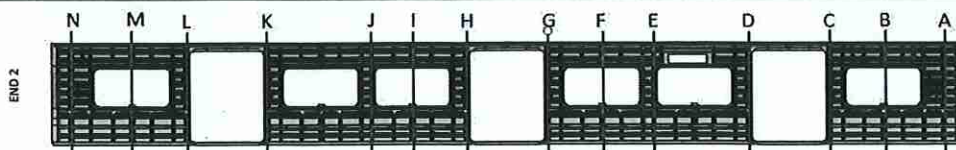
Project: PRASA

SI.CB2210.254.V30

Date

07/11/2023

Specifications of Details for CBS measurement

PME Column LHS - RHS should be $\leq 2\text{MM}$ on each point.

AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3296	3296	0			
B	3268	3265	3			
C	3294	3296	2			
D	3296	3296	0			
E	3265	3266	1			
F	3266	3264	2			
G	3295	3294	1			
H	3296	3295	1			
I	3264	3265	1			
J	3266	3266	0			
K	3295	3295	0			
L	3294	3295	1			
M	3265	3269	4			
N	3296	3298	2			





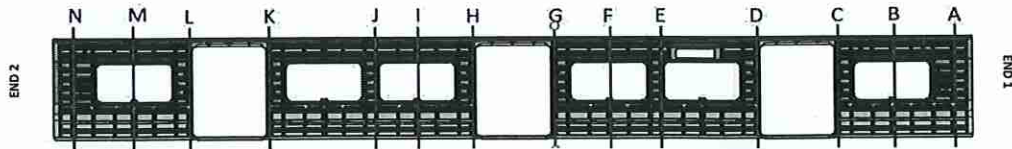
CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.
31
Date
07/11/2023

Project: PRASA
SI.CB2210.254.V30

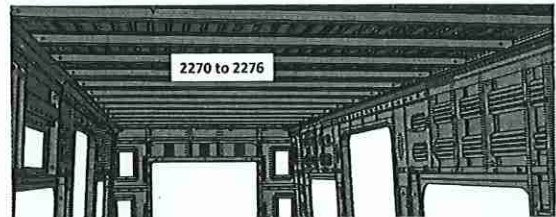
CBS measurement

BEFORE WELDING

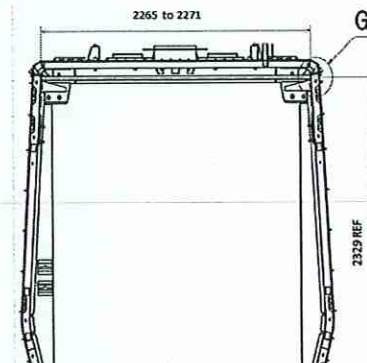


2270 to 2276

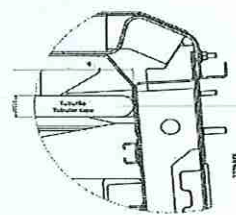
A	2271
B	2271
C	2274
D	2272
E	2276
F	2275
G	2273
H	2273
I	2275
J	2277
K	2274
L	2273
M	2274
N	2272



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



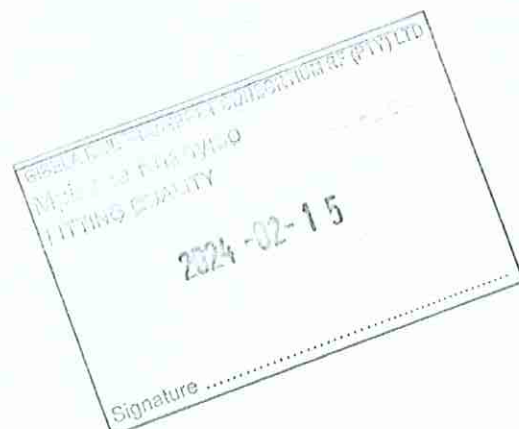
2265 to 2271



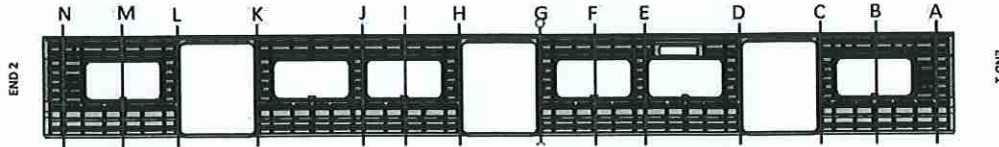
Detail G

Considering the
reinforcement plate

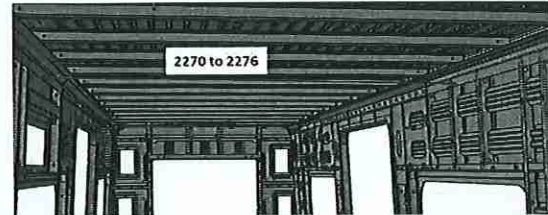
25/02/24



AFTER WELDING



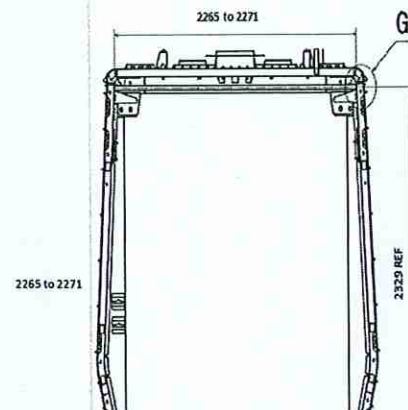
	2265 to 2271	2270 to 2276
A	2269	
B		2274
C	2269	
D	2268	
E		2276
F		2274
G	2271	
H	2270	
I		2275
J		2276
K	2269	
L	2266	
M		2273
N	2268	



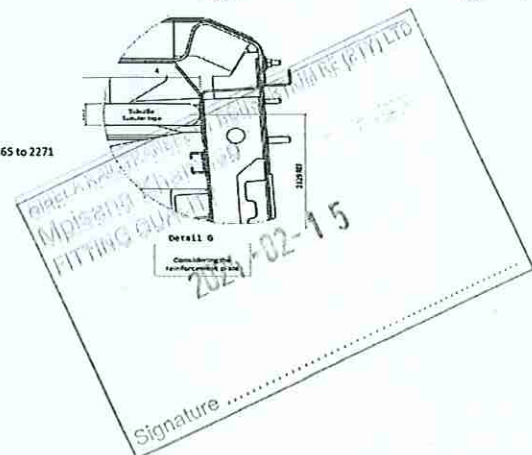
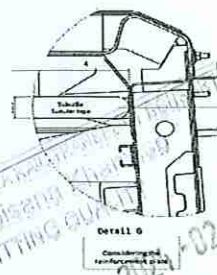
Do not consider reinforcement (Take measurements top area of zee profile



Take measurement close to radius (considering reinforcement)



2265 to 2271



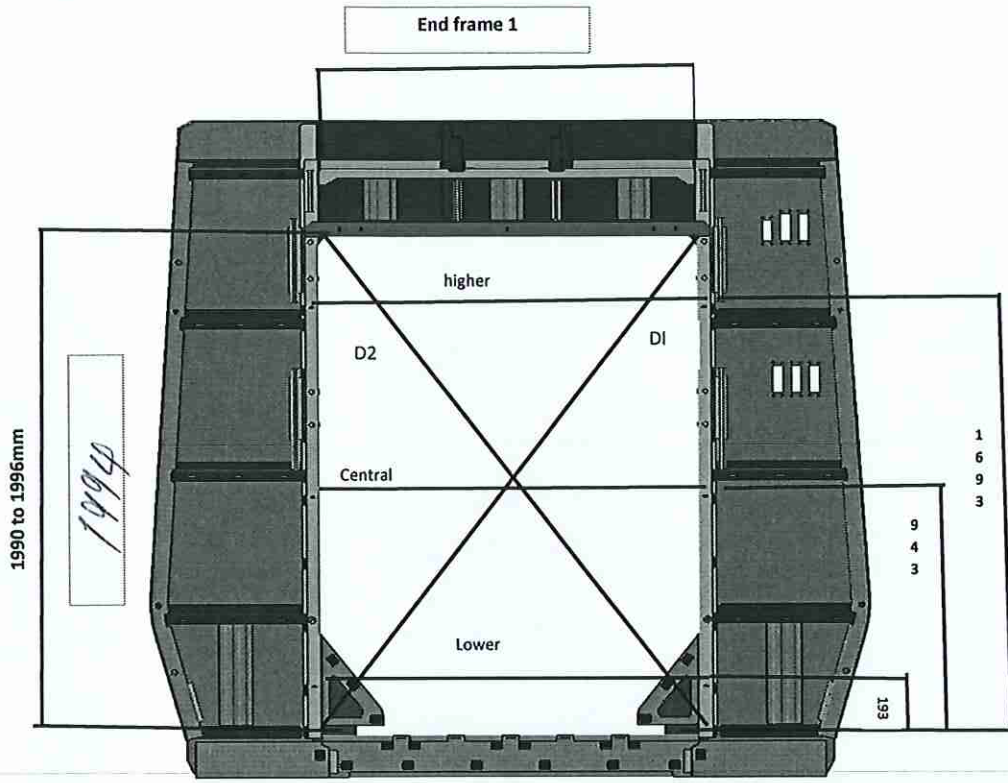


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.
31
Date
07/11/2023

Project: PRASA
SI.CB2210.254.V30

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3mm$

Higher Dimension

1382

D1

2414

Central Dimension

1382

D2

2415

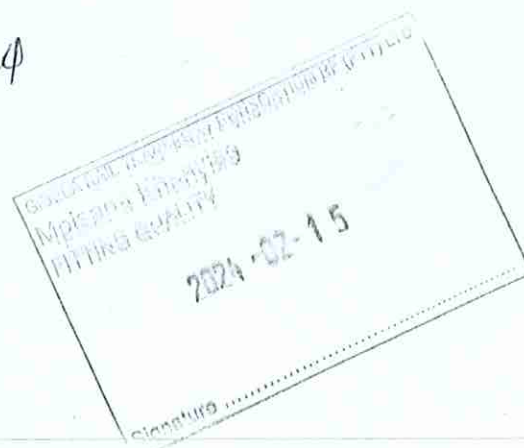
Lower Dimension

1381

D1-D2

1

25/02/24



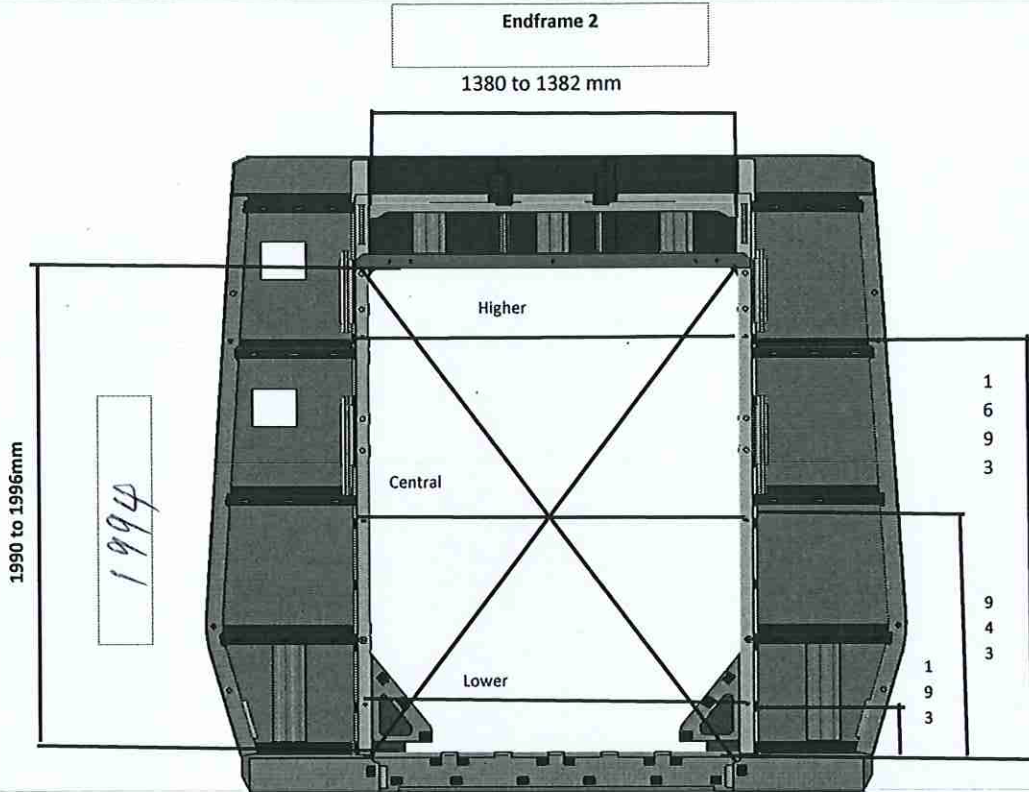


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.
31
Date
07/11/2023

Project: PRASA
SI.CB2210.254.V30

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1381

D1

2414

Central Dimension

1381

D2

2414

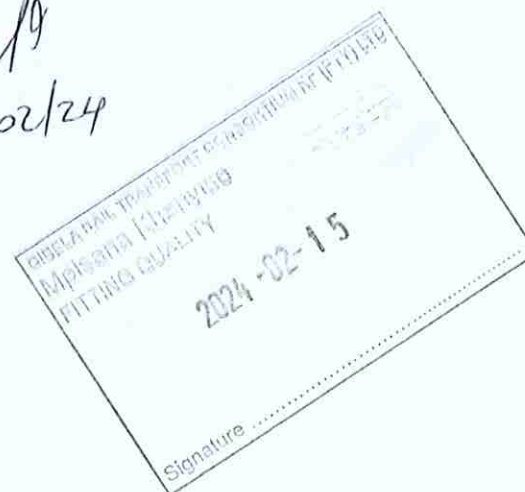
Lower Dimension

1381

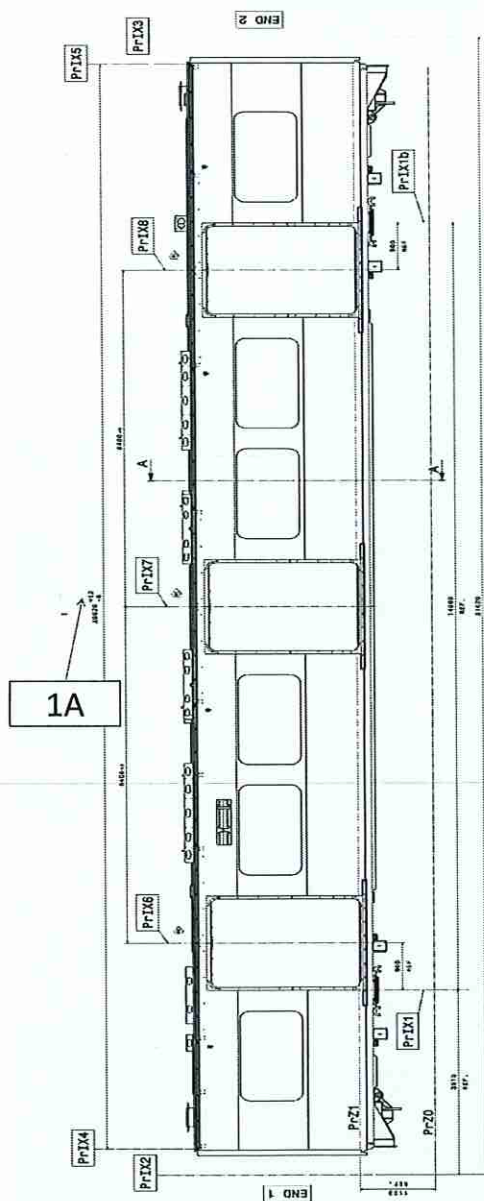
D1-D2

0

19
25/02/24



Specifications of Details for CBS measurement




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

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

Dye penetrant test

Dye-penetration test to be performed by quality personnel






		CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3		Rev. 31		Project: PRASA SI.CB2210.254.V30			
				Date 07/11/2023					
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	NG	Accused	Signature/Date (Manufacturing)	Signature/Date (Quality)	
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX						

GIBELG - Inspection and Control Department (PQCL)

Mplana Khanyig
FITTING QUALITY

2024-02-15

Signature

		CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3		Rev. 31	Project: PRASA SI.CB2210.254.V30	
				Date 07/11/2023		
Self Inspection - Final Result						
				DATE	NAME	SIGNATURE
HOLD POINT		GO	(If activities are not complete, the missing activities must not impact the next stage)	25/02/24	WINGA Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	25/02/24	Richardson 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)			
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			

2024-02-15
Signature






APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1


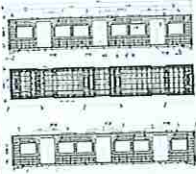


SELF INSPECTION SHEET

CONFIDENTIAL INFORMATION
 This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.


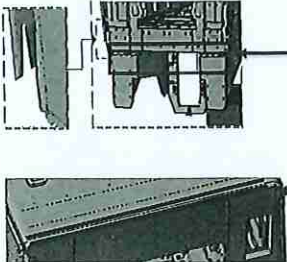


APPLICATION REFERENCE												
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?	
				TC1	M4	M1	M2	M3	TC2			
<input type="checkbox"/>	DTR30225487/2	AAD0003278566	CARBODY SHELL M1,M3,M4 ASSEMBLY	CB1220		X	X		X		PRA CB2220.DTR3022548 7/2.V21	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
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 Mathagu	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 Motama	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 Motama	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 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	19/04/2021					
					REVISED BY	Bongane Masina	19/04/2021					
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING			APPROVER	Mbhombi Collins	17/08/2021					
					CHECKER	Mpho Mulaudzi	17/08/2021					
					REVISED BY	Mpho Mulaudzi	17/08/2021					
25	20/02/2022	New Baseline change 10.3.1			APPROVER	Collins Mbombhi	19/02/2022					
					CHECKER	Andani Muthelo	19/02/2022					
					REVISED BY	Andani Muthelo	19/02/2022					
26	14/06/2022	Update minimum temperature requirement for sealant application			APPROVER	Collins Mbombhi	14/06/2022					
					CHECKER	Andani Muthelo	14/06/2022					
					REVISED BY	Andani Muthelo	14/06/2022					
27	19/10/2022	Addition of traceability for sealant application & welding			APPROVER	Collins Mbombhi	19/10/2022					
					CHECKER	Ntokozo Zwane	19/10/2022					
					REVISED BY	Amogelang Mohlampe	19/10/2022					
28	14/04/2023	Added sealant batch number & welding consumables traceability			APPROVER	Vanessa Ntuli	14/04/2023					
					CHECKER	Ntokozo Zwane	14/04/2023					
					REVISED BY	Amogelang Mohlampe	14/04/2023					
29	28/10/2023	Addition of bracket quantity			APPROVER	Ngobeni Tyson	28/10/2023					
					CHECKER	Ntokozo Zwane	28/10/2023					
					REVISED BY	Amogelang Mohlampe	28/10/2023					
TRAINSET	CAR	OPERATOR NAME & ALPS NO		DATE	SELF INSPECTION NUMBER		PAGES					
214	M3	Moshale 410041		26/02/24	SI.CB2220.250.V29		13					

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB2220.250.V29																												
		29																													
		Date																													
		28/10/2023																													
Car: M1,M3&M4	NCR:	Work station:		CB2220																											
<div style="display: flex; align-items: center;"> Safety Related </div>																															
I - Documentation and Instruments Control																															
I.1 - Documentation Control																															
Document	<table border="1" style="width:100%; border-collapse: collapse; font-size: 8px;"> <tr> <th colspan="5">Type of car</th> <th rowspan="2">Revision</th> <th rowspan="2">Observation</th> <th rowspan="2">OK</th> <th rowspan="2">N/A</th> <th rowspan="2">Signature/Date (Manufacturing)</th> <th rowspan="2">Signature/Date (Quality)</th> </tr> <tr> <th>TC1</th> <th>M1</th> <th>M2</th> <th>M3</th> <th>TC2</th> </tr> <tr> <td></td> <td></td> <td></td> <td style="text-align: center;">x</td> <td></td> <td style="text-align: center;">29</td> <td></td> <td style="text-align: center;">✓</td> <td></td> <td style="text-align: center;">N/A</td> <td style="text-align: center;"> <div style="display: flex; justify-content: space-between;"> <div> <i>[Signature]</i> 26/02/24 </div> <div> <i>[Signature]</i> 26/02/24 </div> </div> </td> </tr> </table>				Type of car					Revision	Observation	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)	TC1	M1	M2	M3	TC2				x		29		✓		N/A	<div style="display: flex; justify-content: space-between;"> <div> <i>[Signature]</i> 26/02/24 </div> <div> <i>[Signature]</i> 26/02/24 </div> </div>
Type of car					Revision	Observation	OK	N/A	Signature/Date (Manufacturing)							Signature/Date (Quality)															
TC1	M1	M2	M3	TC2																											
			x		29		✓		N/A	<div style="display: flex; justify-content: space-between;"> <div> <i>[Signature]</i> 26/02/24 </div> <div> <i>[Signature]</i> 26/02/24 </div> </div>																					
I.2 - Instruments Control																															
Monitoring and Measuring Instrument Control - Used for Special Process																															
Instruments	Serial number	Calibration or Verification Validation Date	OK	<table border="1" style="width:100%; border-collapse: collapse; font-size: 8px;"> <tr> <th>Signature/Date (Manufacturing)</th> <th>Signature/Date (Quality)</th> </tr> <tr> <td colspan="2" style="text-align: center;"> <div style="display: flex; justify-content: space-between;"> <div> <i>[Signature]</i> 26/02/24 </div> <div> <i>[Signature]</i> 26/02/24 </div> </div> </td> </tr> </table>		Signature/Date (Manufacturing)	Signature/Date (Quality)	<div style="display: flex; justify-content: space-between;"> <div> <i>[Signature]</i> 26/02/24 </div> <div> <i>[Signature]</i> 26/02/24 </div> </div>																							
Signature/Date (Manufacturing)	Signature/Date (Quality)																														
<div style="display: flex; justify-content: space-between;"> <div> <i>[Signature]</i> 26/02/24 </div> <div> <i>[Signature]</i> 26/02/24 </div> </div>																															
Tubular Measuring tape	22713-1	29/11/2024	✓																												
1.3 Consumables																															
Welding Consumable Control - Used for Special Process																															
Filler Material	Heat Number	Welding Process	OK	<table border="1" style="width:100%; border-collapse: collapse; font-size: 8px;"> <tr> <th>Signature/Date (Manufacturing)</th> <th>Signature/Date (Quality)</th> </tr> <tr> <td colspan="2" style="text-align: center;"> <div style="display: flex; justify-content: space-between;"> <div> <i>[Signature]</i> 26/02/24 </div> <div> <i>[Signature]</i> 26/02/24 </div> </div> </td> </tr> </table>		Signature/Date (Manufacturing)	Signature/Date (Quality)	<div style="display: flex; justify-content: space-between;"> <div> <i>[Signature]</i> 26/02/24 </div> <div> <i>[Signature]</i> 26/02/24 </div> </div>																							
Signature/Date (Manufacturing)	Signature/Date (Quality)																														
<div style="display: flex; justify-content: space-between;"> <div> <i>[Signature]</i> 26/02/24 </div> <div> <i>[Signature]</i> 26/02/24 </div> </div>																															
308 1.0mm	231067	MIG	✓																												


2024-02-15
 Signature

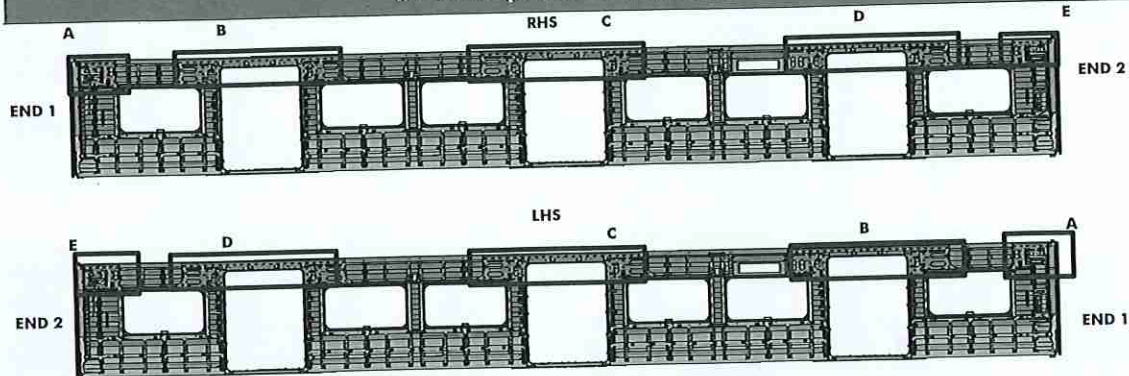
GIBELQ		CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2		Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29		
II - Self Inspection - Items to Check							
II.1 - Items to check							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOT OK	Signature/Date (Manufacturing)	Signature/Date (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	/		Muskhur 26/02/24	[Signature] 26/02/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	/		Muskhur 26/02/24	[Signature] 26/02/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	/		Muskhur 26/02/24	[Signature] 26/02/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	/		Muskhur 26/02/24	[Signature] 26/02/24
05		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	/		Muskhur 26/02/24	[Signature] 26/02/24
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.	/		Muskhur 26/02/24	[Signature] 26/02/24
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 (°C) Min-Max 10°C - 35°C Relative humidity Min - Max (%) Min-Max 25% - 80%	Sealant Batch No: _____ Exp Date: 10/05/24 Actuals Temperature: 21°C Humidity: 58%	/		[Signature] 26/02/24	[Signature] 26/02/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278565	/		[Signature] 26/02/24	[Signature] 26/02/24
09		Verification of safety welds	Approved according to DTD0000210658 reference and Self inspection	/		Muskhur 26/02/24	[Signature] 26/02/24

Signature

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA
		29	
		Date	
		28/10/2023	
		SI.CB2220.250.V29	
II - Self Inspection - Items to Check			
<div style="text-align: center;">SEALANT APPLICATION</div> <div style="display: flex; align-items: center;">  <div style="margin-left: 20px;"> <div style="border: 1px solid black; padding: 5px; margin-bottom: 10px;"> AREA 1 & 2 END 1 Operator (Name & sign): Lerato  </div> <div style="border: 1px solid black; padding: 5px;"> Operator (Name & sign): Lerato  </div> </div> </div>			

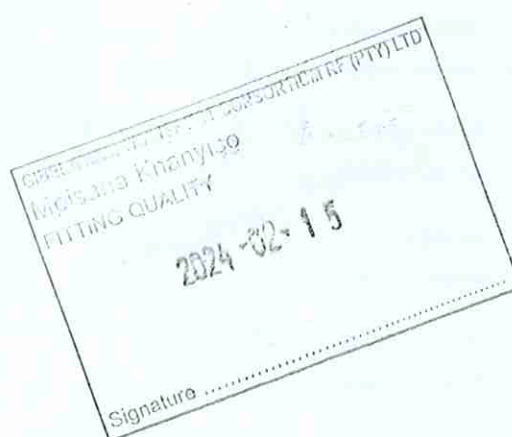
GIBELA HEALTH AND SAFETY CONSORTIUM RF (PTY) LTD
Mpisani Khanyiso
FITTING QUALITY
2024-02-15
Signature


	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29	Project: PRASA SI.CB2220.250.V29
		Date 28/10/2023	
		II - Self Inspection - Items to Check	

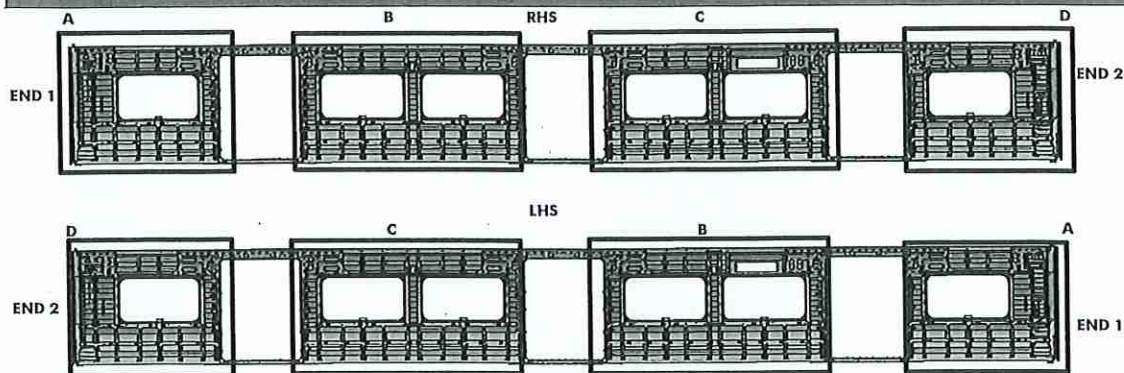


REINFORCEMENT WELDING


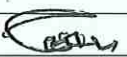



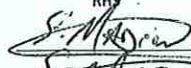

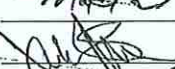
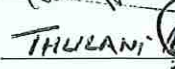
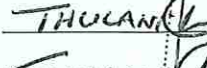
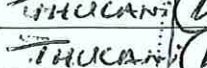
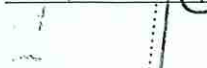


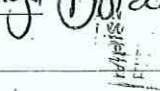
AREA	LHS	RHS
A	Operator (Name&sign): <u>LINDO MRP</u>	<u>LINDO MRP</u>
B	Operator (Name&sign): <u>LINDO MRP</u>	<u>LINDO MRP</u>
C	Operator (Name&sign): <u>Mmasikulu MRP</u>	<u>Mmasikulu MRP</u>
D	Operator (Name&sign): <u>Johannes D</u>	<u>Johannes D</u>
E	Operator (Name&sign): <u>Johannes D</u>	<u>Johannes D</u>




	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29	Project: PRASA SI.CB2220.250.V29
		Date 28/10/2023	
		II - Self Inspection - Items to Check	

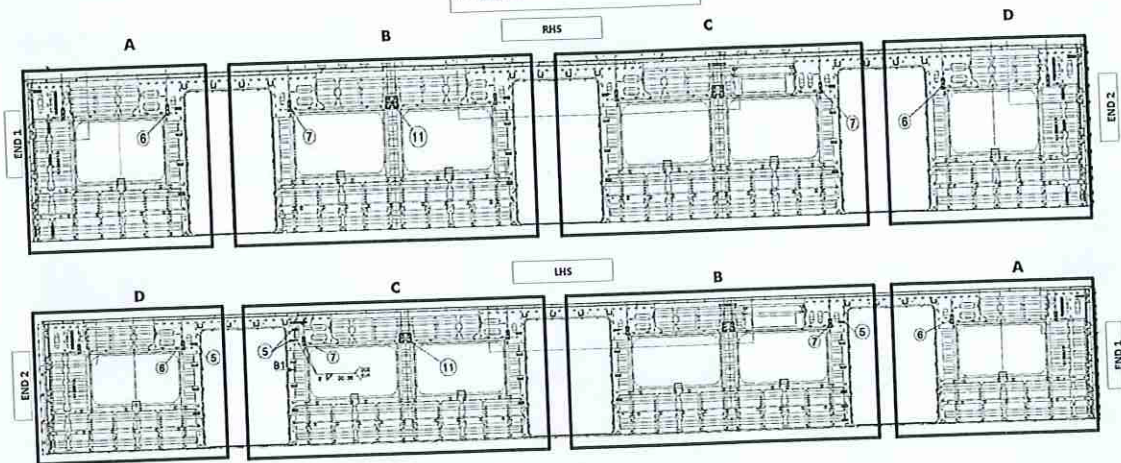


BRACKETING

		INSTALLATION	
C-RAILS:	Operator:	Lewi	
	Operator:		
DOOR MECHANISMS:	Operator:	Priscilla	
	Operator:		
TAPPING PADS	Operator:	Priscilla	
	Operator:		
		INSTALLATION & VERIFICATION	
SEAT & LUGGAGE BRACKETS:	Operator:	THULANI	
	Operator:		
SEAT BRACKETS VERIFICATION:	Operator:		
	Operator:		
WELDING			
AREA	LHS		RHS
A (Seat brackets)	: Operator (Name&sign):	Mashadi	
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	Mashadi	
B (Seat brackets)	: Operator (Name&sign):	Mashadi	
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	Mashadi	
C (Seat brackets)	: Operator (Name&sign):	THULANI	
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	THULANI	
D (Seat brackets)	: Operator (Name&sign):	THULANI	
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	THULANI	
ENDS			
END 1 TAPPING PADS WELDING:	Operator (Name&sign):	Nkomo	
END 1 TAPPING PADS WELDING:	Operator (Name&sign):	Nkomo	

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA
		29	
		Date	SI.CB2220.250.V29
		28/10/2023	
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	6	✓	
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: Mashudh

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: Mashudh

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: _____

LHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	10		
	C	11		
	D	6		
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: _____

Signature _____

2024-02-15

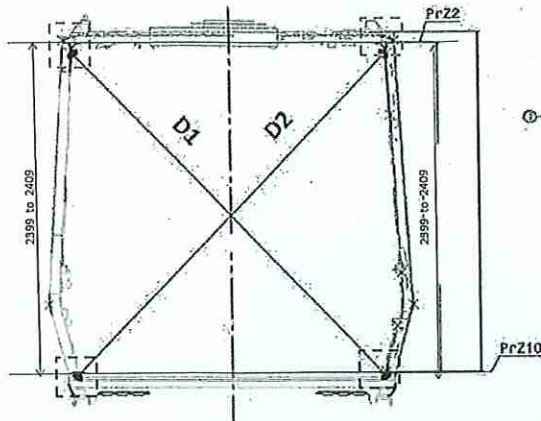


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

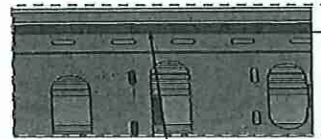
Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB2220.250.V29

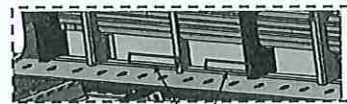
Specifications of Details for CBS measurement



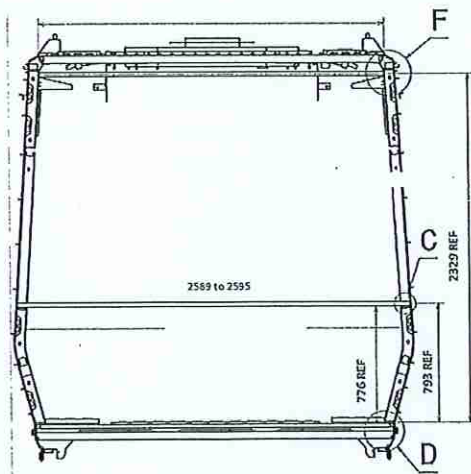
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



GIBELA RAIL TRANSPORT PONDOROTHUM RE (PTY) LTD
Mpisane Khanyiso
FITTING QUALITY
2024-02-15
Signature



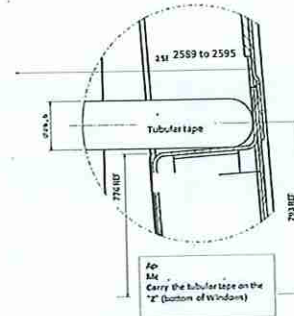
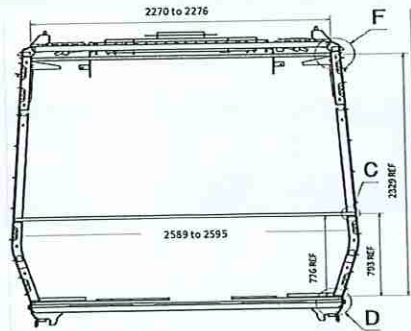
CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

Rev.	29
Date	28/10/2023

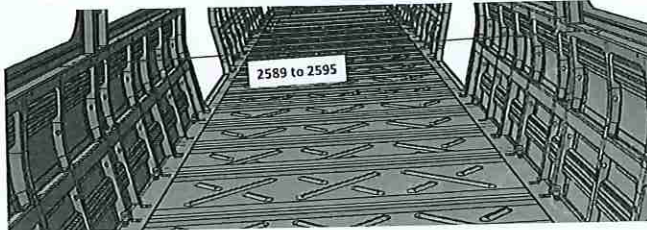
Project: PRASA

SI.CB2220.250.V29

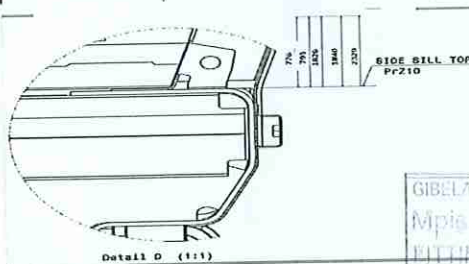
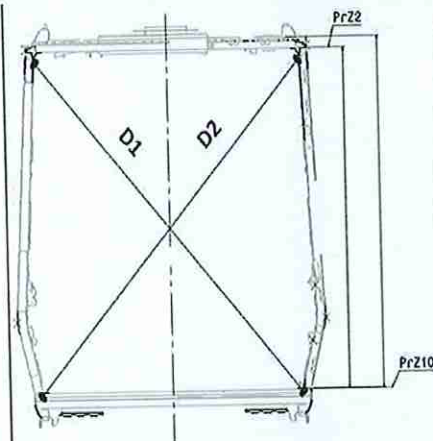
CBS measurement



Detail C



Take measurement close to radius




Detail D (1:1)

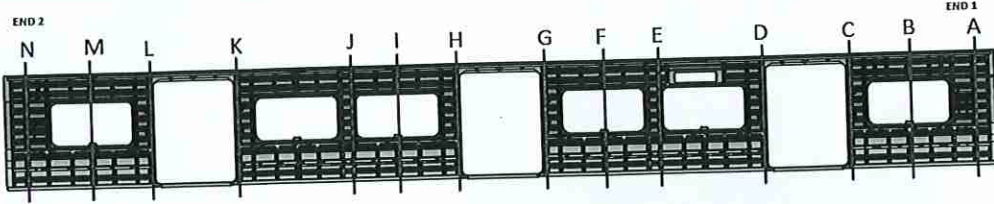
GIBELA RAIL TRANSPORT CORPORATION PVT LTD
Mpiasana Khanyisa
FITTING QUALITY

2024-02-15

Signature

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

CBS measurement

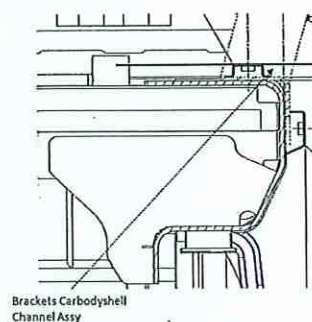
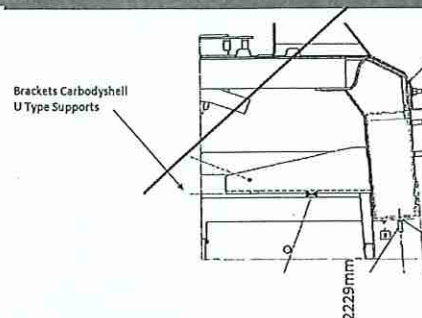
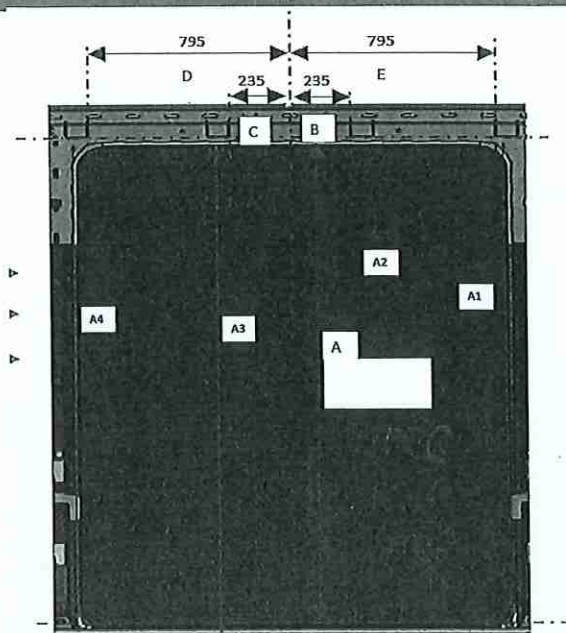


AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3300	0	2593
B	3268	3270	2	2591
C	3297	3297	0	2589
D	3298	3299	1	2593
E	3266	3268	2	2593
F	3265	3267	2	2592
G	3296	3299	3	2591
H	3297	3299	2	2593
I	3266	3268	2	2593
J	3269	3267	2	2593
K	3299	3298	1	2594
L	3298	3296	2	2592
M	3270	3267	3	2593
N	3300	3299	1	2594

GIBELA - KARABODYSHELL (PTY) LTD
 FOR BEST QUALITY
 2024-02-15
 Signature

Specifications of Details for CBS measurement CB1220



	DOOR 1 - LHS		DOOR 1 - RHS
A1	2230 to 2232		2233
A2	2230 to 2232		2232
A3	2230 to 2232		2232
A4	2230 to 2232		2233
B	234 to 236		235
C	234 to 236		235
D	794 to 796		795
E	794 to 796		795

DOOR 2 - LHS		
	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2232
A3	2230 to 2232	2232
A4	2230 to 2232	2232
B	234 to 236	2235
C	234 to 236	2235
D	794 to 796	796
E	794 to 796	795

DOOR 2 - LHS		
	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2231
A3	2230 to 2232	2231
A4	2230 to 2232	2232
B	234 to 236	235
C	234 to 236	235
D	794 to 796	796
E	794 to 796	795

DOOR 1 - RHIS		
	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2232
A3	2230 to 2232	2232
A4	2230 to 2232	2232
B	234 to 236	235
C	234 to 236	235
D	794 to 796	795
E	794 to 796	796

	DOOR 2 - RHS	
	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2231
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	795

DOOR 3 - RHS		
	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2231
A3	2230 to 2232	2231
A4	2230 to 2232	2232
B	234 to 236	225
C	234 to 236	235
D	794 to 796	795
E	794 to 796	796

Signature

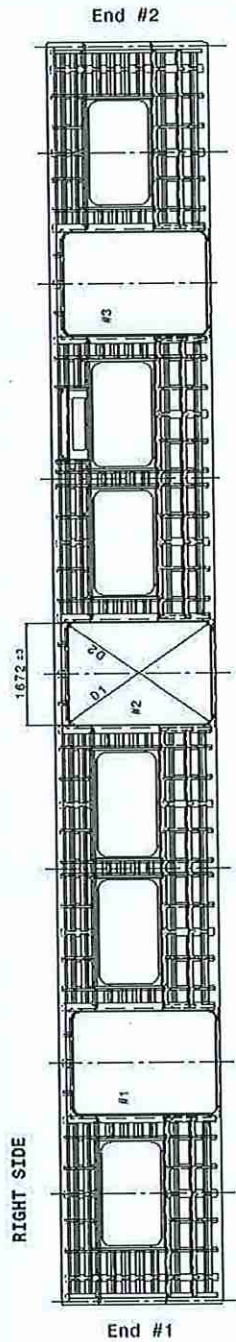


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB2220.250.V29

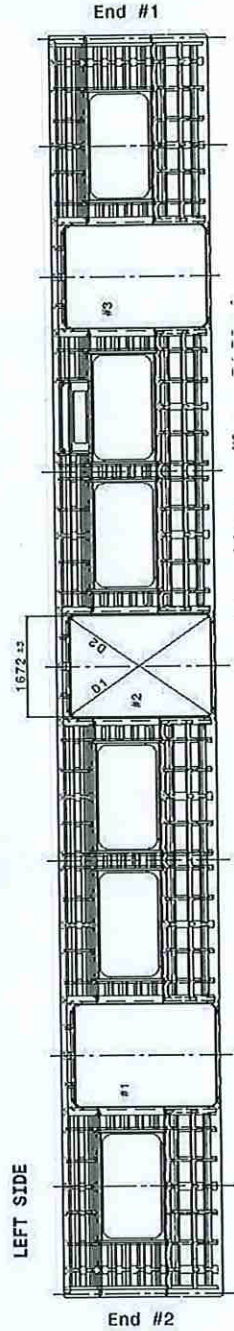
Specifications of Details for CBS measurement CB1220



Doors diagonal D1-D2 maximum difference $\leq 4\text{mm}$

	#1	#2	#3
D1	2749	2750	2749
D2	2747	2747	2748
D1-D2	2	3	1

Doors Length - 1672 $\pm 3\text{mm}$			
	#1	#2	#3
HIGHER DIMENSION	1671	1672	1671
CENTRAL DIMENSION	1671	1671	1670
LOWER DIMENSION	1670	1671	1670


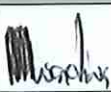



Doors diagonal D1-D2 maximum difference $\leq 4\text{mm}$

	#1	#2	#3
D1	2750	2748	2751
D2	2749	2749	2749
D1-D2	1	1	2

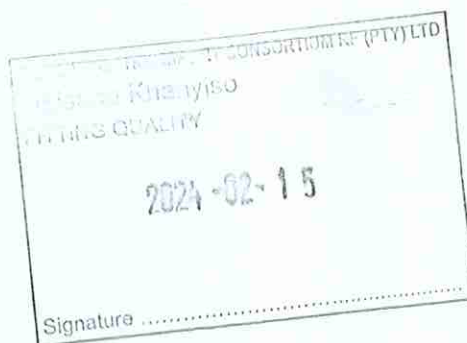
Doors Length - 1672 $\pm 3\text{mm}$			
	#1	#2	#3
HIGHER DIMENSION	1672	1672	1672
CENTRAL DIMENSION	1672	1673	1672
LOWER DIMENSION	1673	1673	1671

GIBELA TVL TRANSPORT CONSULTING
Mpelema Khanyiso
FITTING QUALITY
2024-02-15

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB2220.250.V29			
		29				
		Date				
		28/10/2023				
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 activities are not complete, the missing activities must not impact the next stage!)	26/02/2024	Mashudu Operations		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party	26/02/2024	Mashudu Industrial Quality		
	NO GO	There are activities pending 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




APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

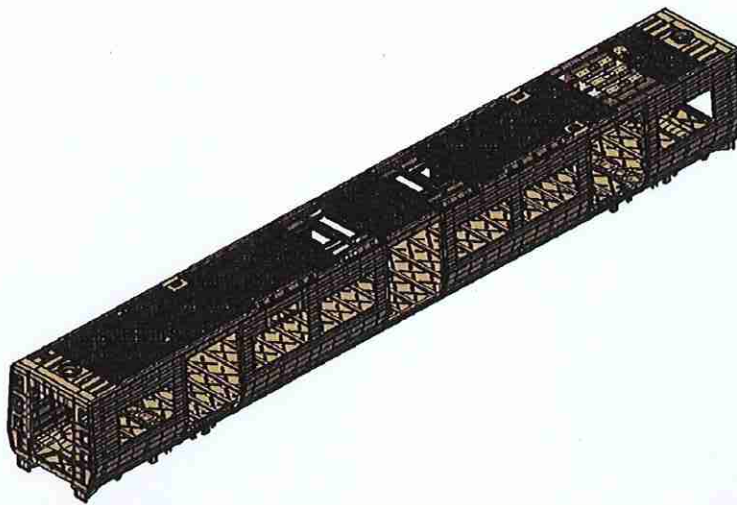
SELF INSPECTION SHEET

CONFIDENTIAL INFORMATION

This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

APPLICATION REFERENCE


MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE							WORK INSTRUCTION	SAFETY ? 
				TC1	M4	M1	M2	M3	TC2			
<input type="checkbox"/>	DT00000225487	AAD0001278556	CARBODY SHELL M1,M3,M4 ASSEMBLY	CB2230		X	X		X		PRA.CB2230.DT000002 25487.V20	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE							
	2018/08/02	GIBELA NEW CREATION	APPROVER	Philippe 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	06/08/2020							
			CHECKER	Bongane Masina								
			REVISED BY	Bongane Masina								
	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021							
			CHECKER	Bongane Masina								
			REVISED BY	Bongane Masina								
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	20/02/2022							
			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	26/07/2022	Threshold measurements addition	APPROVER	Collins Mbhombhi	26/07/2022							
			CHECKER	Andani Muthelo								
			REVISED BY	Andani Muthelo								
28	17/10/2022	Added traceability of sealant application	APPROVER	Collins Mbhombhi	17/10/2022							
			CHECKER	Ntokozo Zwane								
			REVISED BY	Amogelang Mohlampe								
29	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023							
			CHECKER	Ntokozo Zwane								
			REVISED BY	Amogelang Mohlampe								
30	06/11/2023	Added threshold traceability for boiler makers and welders	APPROVER	Ngobeni Tyson	06/11/2023							
			CHECKER	Andani Muthelo								
			REVISED BY	Ntokozo Zwane								
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES							
214	M3	Zanele 4877	27/02/24	SI.CB2230.256.V29	12							



1.1 - Documentation Control

1.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
Tubular	22015	2024/03/05	X		27/02/24	 27/02/24
Combination square	913TA034	2024/09/05	X		27/02/24	
Tape measurement	918CS 0131	2024/10/11	X		27/02/24	

1.3 Consumables







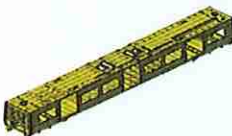


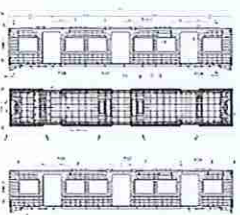


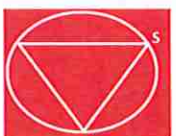








Welding Consumable Control - Used for Special Process

[illegible]

888-847-7468
 1-800-847-7468
 FITTING QUALITY
 2024-02-15
 Signature

II - Self Inspection - Items to Check

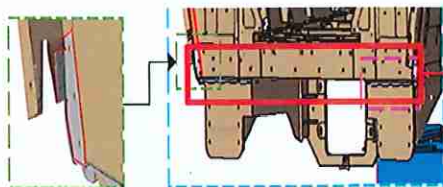
II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOK	Rework	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.DT00000225487 Verification of fillet for all brackets.	PRA.CB1230.DT00000225487	X			 27/02/24	 27/02/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	X			 27/02/24	 27/02/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	X			 27/02/24	 27/02/24
		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	X			 27/02/24	 27/02/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	X			 27/02/24	 27/02/24
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.	X			 27/02/24	 27/02/24
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 (I) Min-Max 10°C - 35°C Relative humidity Min - Max (I) Min-Max 25% - 80%	Sealant Batch No: <u>334440</u> Exp Date: <u>27/02/24</u> Actuals Temperature: <u>16°C</u> Humidity: <u>78%</u>	X			 27/02/24	 27/02/24
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	X			 27/02/24	 27/02/24
09	N/A	Verification of sealant application in certain regions in the drawing.	AAD0001278566	X			 27/02/24	 27/02/24

Signature

II - Self Inspection - Items to Check

AREA 1



END 2 SEALANT

OPERATOR
(Name & sign):

Leroy

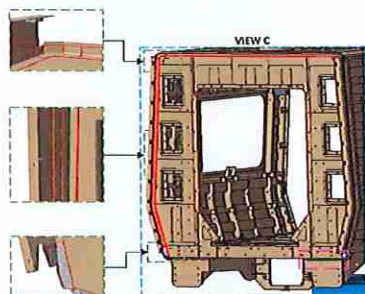
OPERATOR
(Name & sign):

Leroy

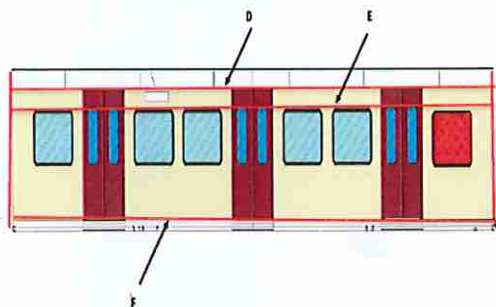
OPERATOR
(Name & sign):

Leroy

AREA 2 (VIEW C)



H



Area D,E,F,G,H,I

Operator (Name & sign):

LHS

RHS

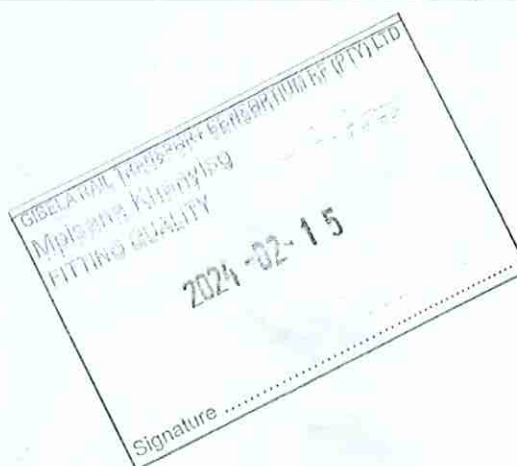
Operator (Name & sign):

Operator (Name & sign):

Operator (Name & sign):

Operator (Name & sign):

Operator (Name & sign):





CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

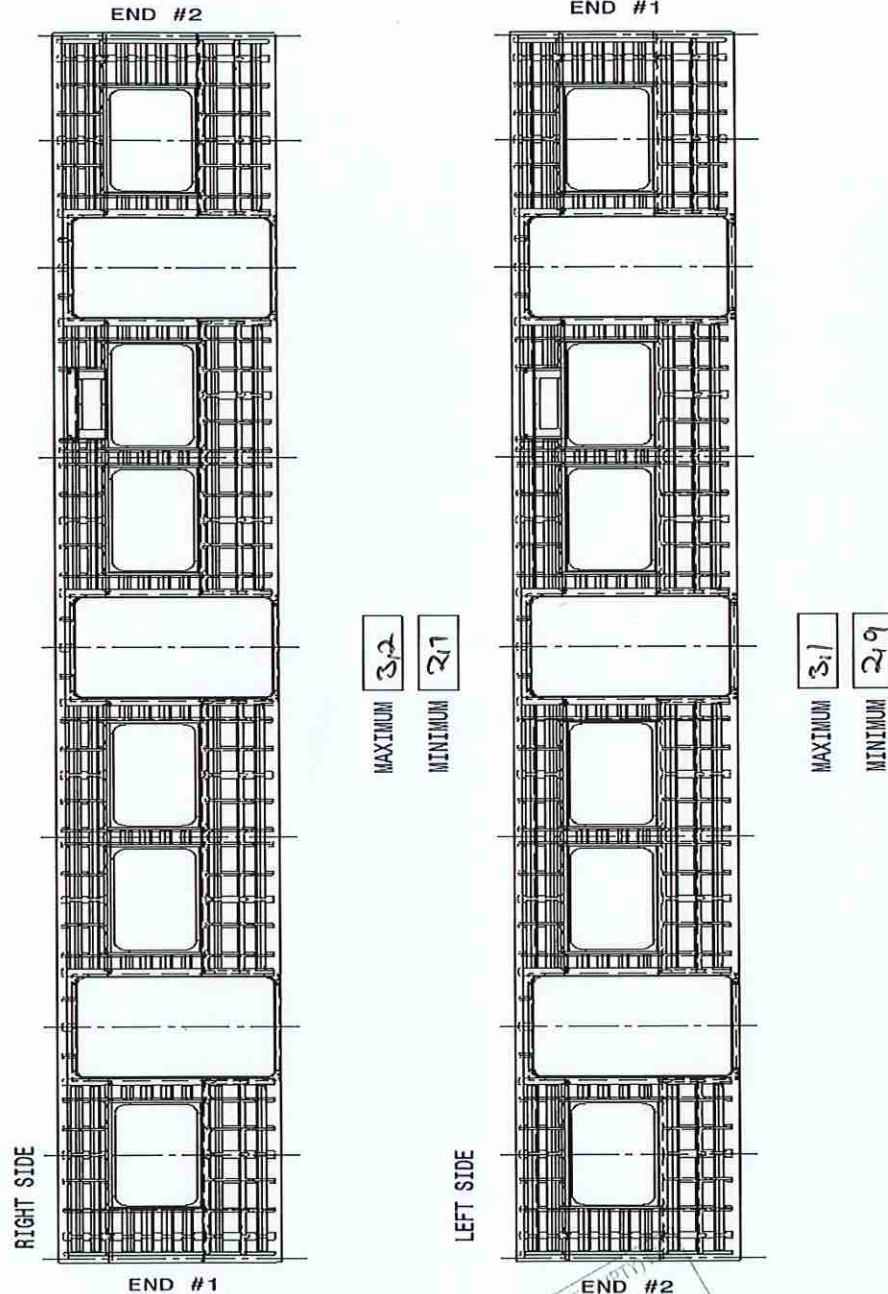
Rev.
30
Date
06/11/2023

Project: PRASA

SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230

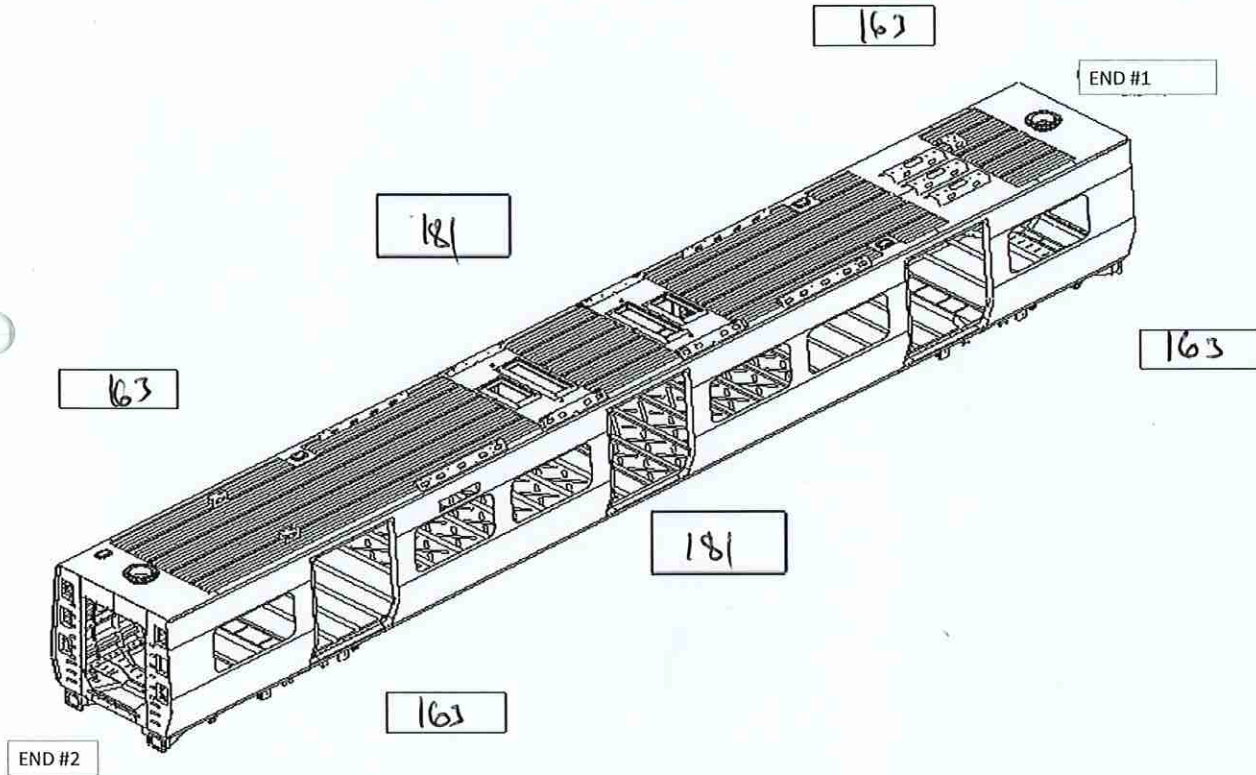
Flatness side left and right maximum of 2mm in the valley to peak measured in 900mm. Recod the maximum and minimum value found and indicate the corresponding region.



Signature
2024-02-15
Gibela Khemiso
Quality

Specifications of Details for CBS measurement CB1230

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



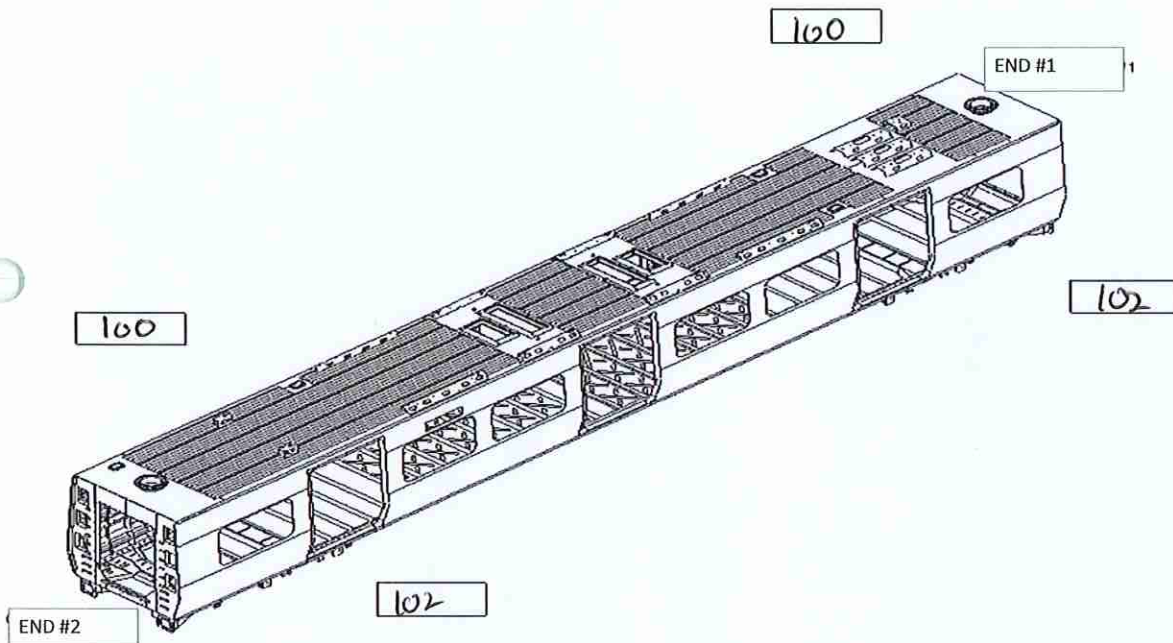
MEASURED CAMBER VALUES

RIGHT	11	18
LEFT	1a1	18

GIBELQ - L. 10.10.2019 - 10.10.2019 - 10.10.2019
Mpsens Ktary ISO
FITTING QUALITY
2024-02-15
Signature

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 following twist measurement document.



TWIST FOUND ON END 1

TRANVERSE

2

LONGITUDINAL

0

TWIST FOUND ON END 2

TRANVERSE

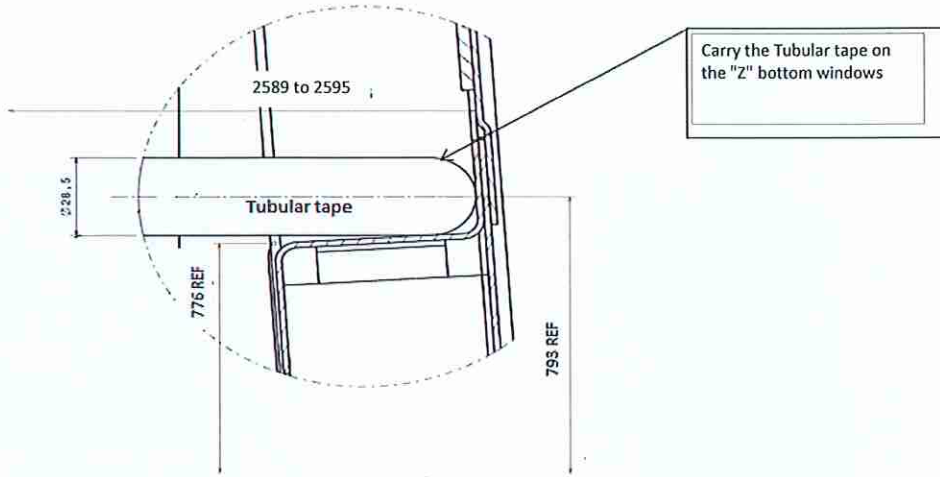
2

LONGITUDINAL

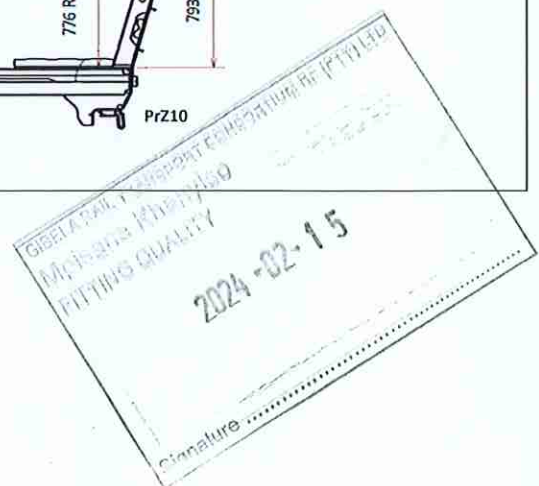
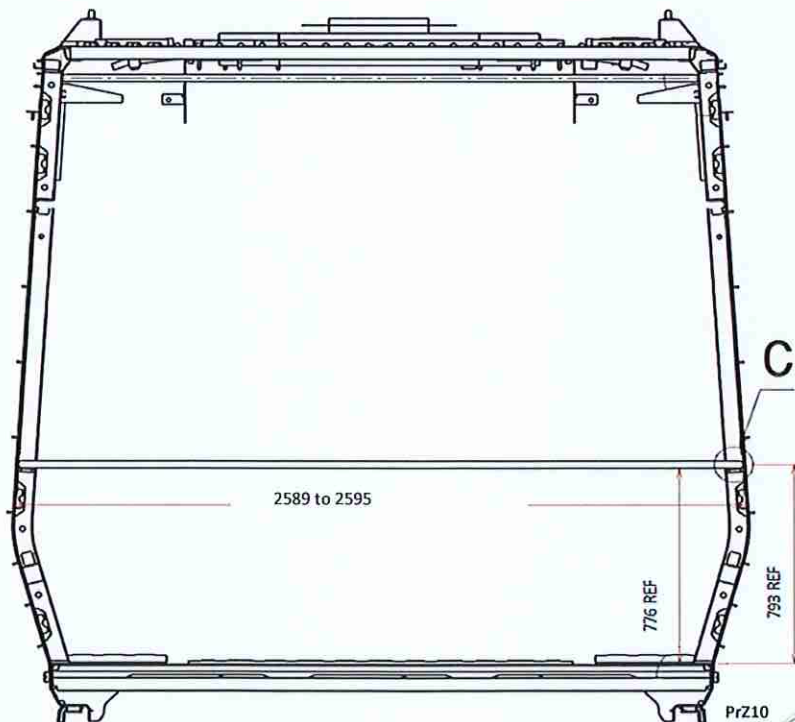
0

GIBELQ TO REPORT PERFORMANCE (PTY) LTD
Mpisane I. Mphahlele
FITTING QUALITY
2024-02-15
Signature

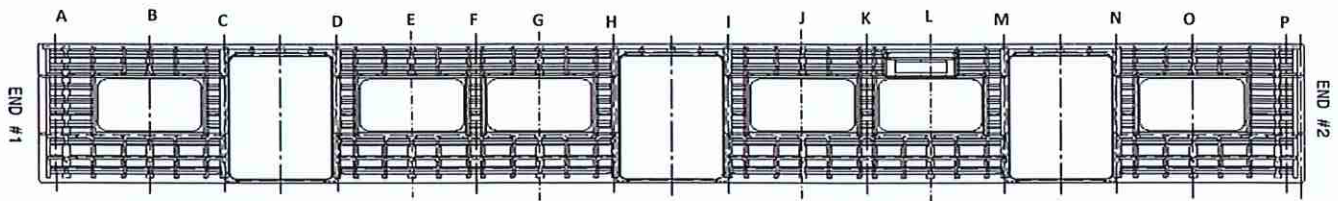
Specifications of Details for CBS measurement CB1230



Detail C



Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	2595
B	2593
C	2595
D	2595
E	2594
F	2593
G	2592
H	2595
I	2595
J	2593
K	2594
L	2592
M	2593
N	2592
O	2592
P	2591



Threshold verification

Nominal value :38

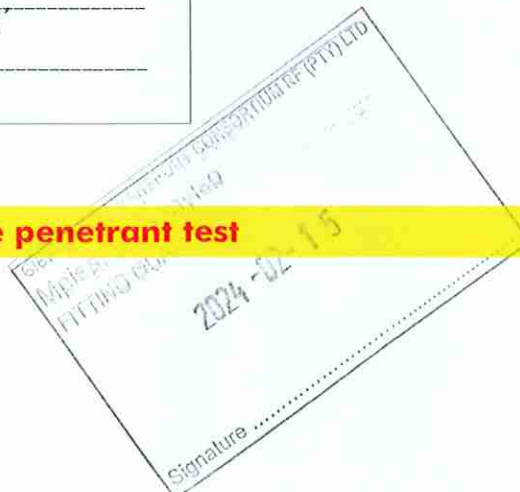
Door 1		Door 2		Door 3	
L	R	L	R	L	R
38	39	38	39	38	39
Door 4		Door 5		Door 6	
L	R	L	R	L	R
38	39	38	39	38	37


BOILER MAKER: Bobbert

WELDER: Kertumelse

Dye penetrant test

Dye-penetration test to be performed by quality personnel



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

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	Rework	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX					



GIBELQ Sdn Bhd
Mpisara Kumyilag
FITTING QUALITY

2024-02-15

Signature

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

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 activities are not complete, the missing activities must not impact the next stage!)	27/02/24	Zanelo Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	27/02/24	Richmond 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

