

CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 439

WEIGHT: Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm					
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm					
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm					
RCS 355	20 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm					
RCS 355	30 mm					

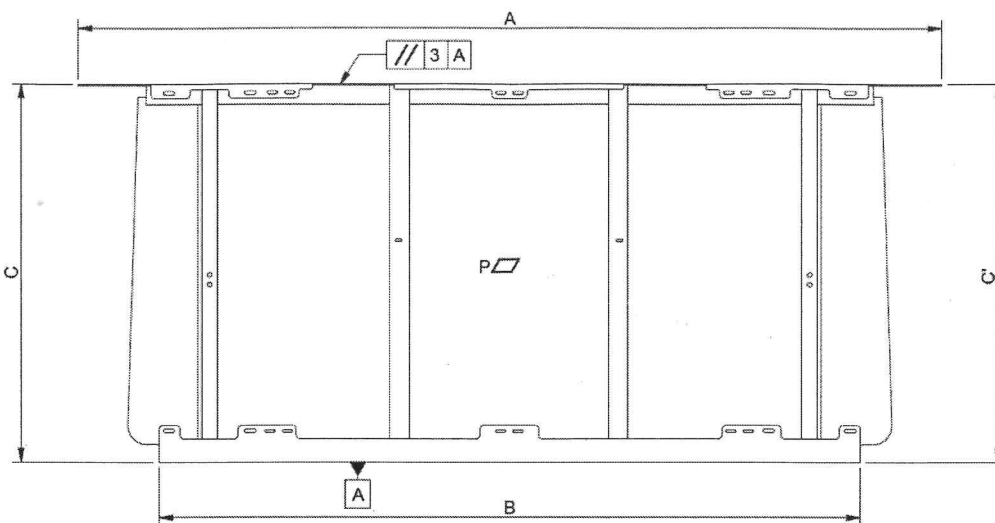
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					



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

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

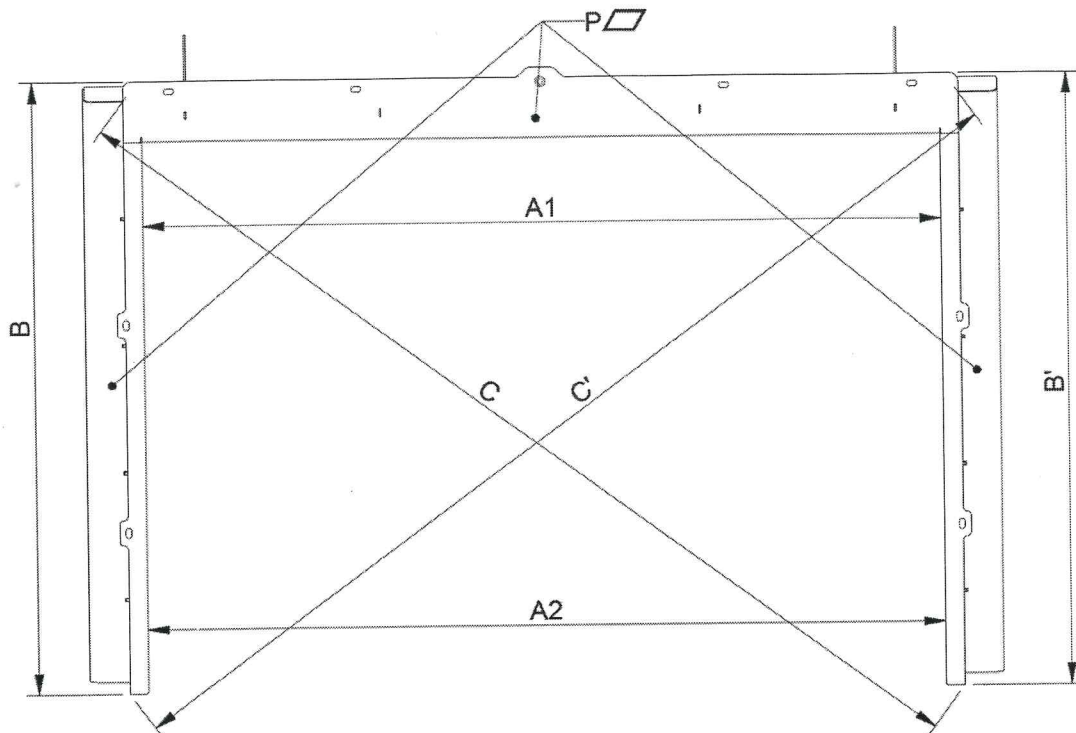
Cabin Roof Assembly: GN002839

Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<u>DYLAN DAVIDS</u>	Assembly Date:	20 <u>24</u> / <u>01</u> / <u>18</u>			
Sign:		Wire Batch No.:	<u>107238201</u>			



Welding Control						
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042				Confirmed	Yes	<input checked="" type="checkbox"/>
QC Inspector:	<u>Leon</u>	Sign:		Date:	20 <u>24</u> / <u>01</u> / <u>18</u>	
Dimensional Control						
Rep		Toler.	Dimension measured		Measuring Equipment	Observations
A	2216	+5/-0	<u>2216</u>		Tape Measure	<u>Acceptable</u>
B	1800	± 4	<u>1800</u>			<u>Acceptable</u>
C	976	+2/-3	<u>976</u>	<u>976</u>		<u>Acceptable</u>
QC Inspector:		Sign:		Date:	20 <u>24</u> / <u>01</u> / <u>18</u>	
Geometrical Control						
Nature of Checks		Dimension Measured		Measuring Equipment	Observations	
Planarity P		6 mm		Ruler		
//	3	A		Set Square	<u>Acceptable</u>	
QC Inspector:	<u>Leon</u>	Sign:		Date:	20 <u>24</u> / <u>01</u> / <u>18</u>	

Cabin Front Frame Assembly: GN002840					
Assembly Completed as per WI/SOS MD_0047			Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	Bambato Gungu	Assembly Date:		20/01/18	
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:	20/01/18	
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension Measured		Observations	
A1	1910	± 2	1912		Tape Measure Acceptable	
A2	1910		1910			
B	1475	± 1	1475	1475		Acceptable
C	Diagonals C - C' ≤ 3		2476	2476		Acceptable
QC Inspector:	LEON	Sign:		Date:	20/01/18	
Geometrical Control						
Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P : Planeity		4 mm		Ruler	Acceptable	
QC Inspector:	LEON	Sign:		Date:	20/01/18	

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:	<i>Xander</i>	Assembly Date:	20 <u>24</u> / <u>01</u> / <u>09</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	<u>2202152</u>			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

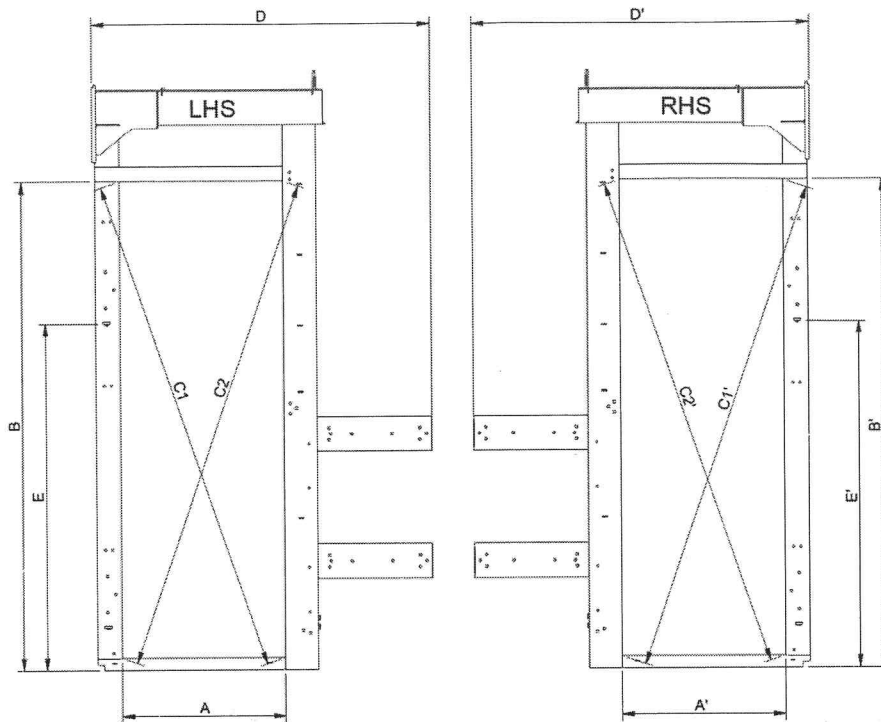
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>Glenn</i>	Assembly Date:	20 <u>24</u> / <u>01</u> / <u>09</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	<u>2202152</u>			

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:	<i>Glenn</i>	Assembly Date:	20 <u>24</u> / <u>01</u> / <u>09</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	<u>2202152</u>			

Cabin LHS/RHS Door Frame Assembly: GN002839

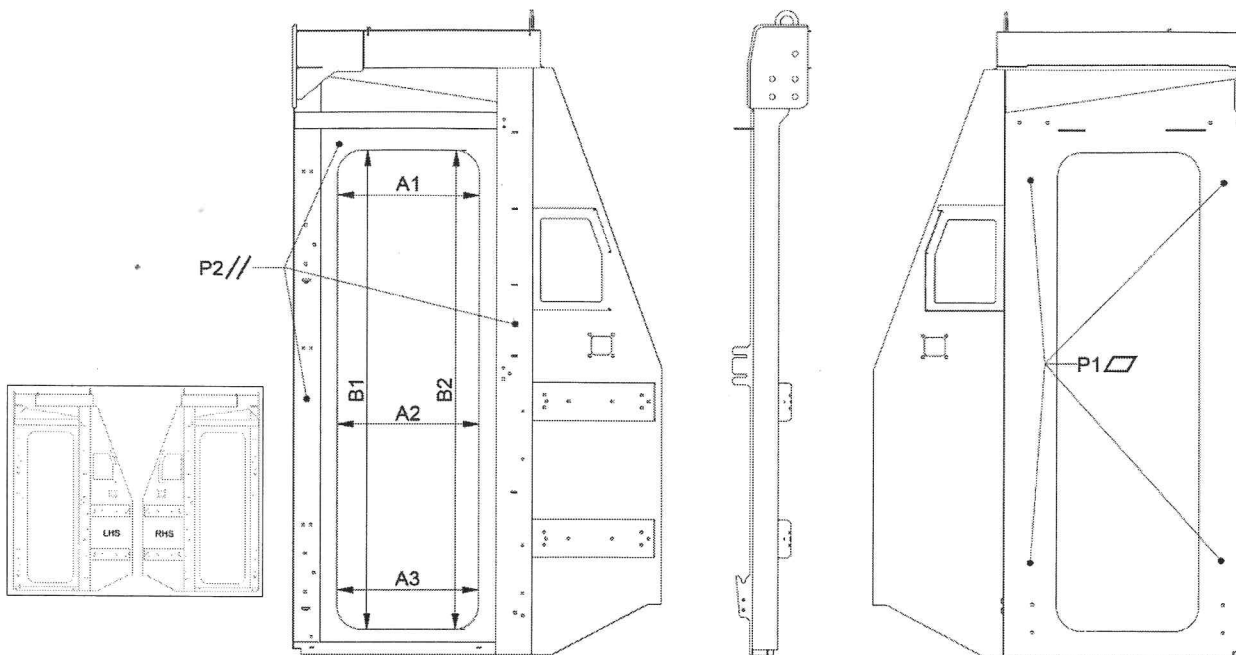
Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Glenn	Assembly Date:	2024/01/09			
Sign:	<i>Glenn</i>	Wire Batch No.:	2202152			



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>[Signature]</i>	Date:	2024/01/17
Dimensional Control							
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	695	± 2	696	695	Tape Measure	Acceptable	
B	2086	+1/-3	2085	2086		Acceptable	
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2150	2152		Acceptable	
C1 - C2			2151	2152		Acceptable	
D	1438	+2/-3	1440	1438		Acceptable	
E			1484	1485		Acceptable	
QC Inspector:		<i>Leon</i>		Sign:	<i>[Signature]</i>	Date:	2024/01/17
Geometrical Control							
Nature of checks			Dimension Measured		Measuring Equipment	Observations	
P1 : planeity of 2 edges		4 mm	Passed		Ruler	Acceptable	
QC Inspector:		<i>Leon</i>		Sign:	<i>[Signature]</i>	Date:	2024/01/17

Cabin LHS/RHS Side Assembly: GN002838/GN002837

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Xander</i>	Assembly Date:	2024/01/11			
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	<input type="checkbox"/>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/01/18	

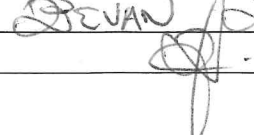
Dimensional Control

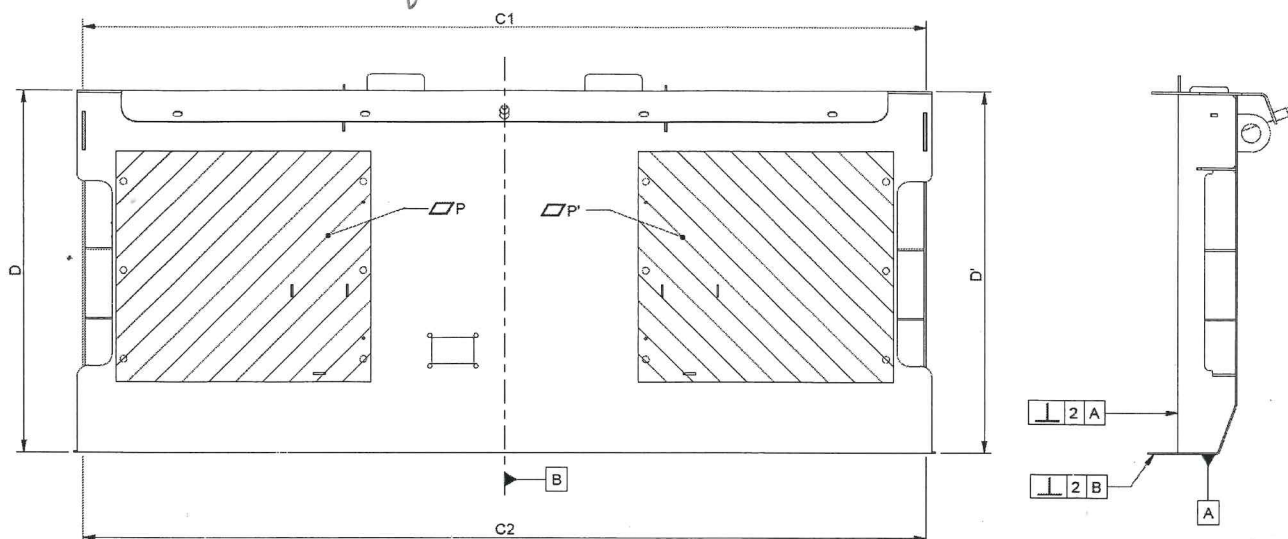
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	558	558	Tape Measure	<i>[Handwritten]</i>
A2			559	558		<i>[Handwritten]</i>
A3			1898	559		<i>[Handwritten]</i>
B1	1900	± 2	1898	1898		<i>[Handwritten]</i>
B2			1898	1898		<i>[Handwritten]</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/01/18	

Geometrical Control


Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P1 : Planeity	4 mm	<i>Passe</i>		Ruler	<i>Pass</i>	
P2 : Planeity	2 mm	<i>Passe</i>		Ruler	<i>Pass</i>	
QC Inspector:	<i>Leon</i>		Sign:	<i>[Signature]</i>	Date:	20 <i>24</i> / <i>01</i> / <i>2024</i>

Cabin Shield Assembly: GN002836


Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	STEVEN JAVENHILL	Assembly Date:	20 27/01/18			
Sign:		Wire Batch No.:	2202165			




Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	LEON	Sign:		Date:	20 24 / 01 / 18	


Dimensional Control

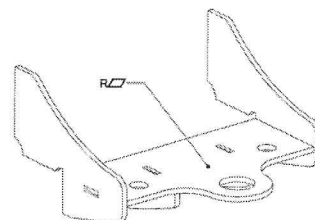
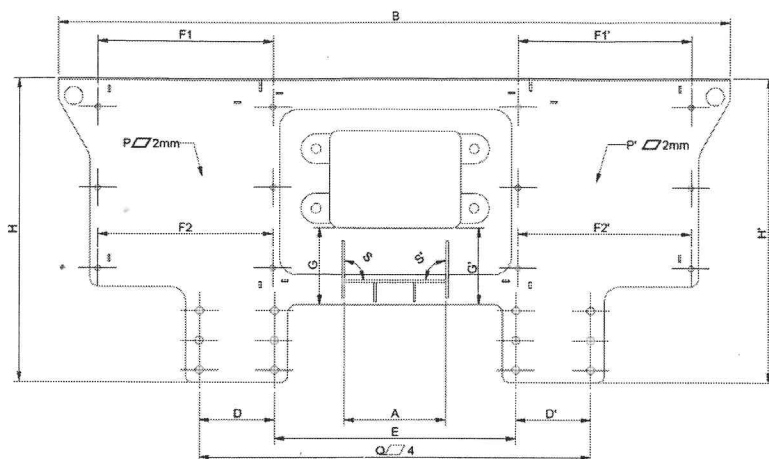
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2213	2212	Tape Measure	Acceptable
D / D'	956	± 2	955	955		Acceptable
QC Inspector:	LEON		Sign:		Date:	20 24 / 01 / 18

Geometrical Control


Nature of Checks				Dimension Measured	Measuring Equipment	Observations
Planeity P / P'			2 mm	Passed	Ruler	Acceptable
Perpendicularity		2	A	Passed	Set Square	Acceptable
		2	B	Passed	Set Square	Acceptable
QC Inspector:			Sign:		Date:	20 24 / 01 / 18

Cabin Front Headstock Assembly: GN002841


Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	TK BOGCH	Assembly Date:	20/01/15			
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	<input type="checkbox"/>
QC Inspector:	LEON	Sign:		Date:	20/01/15	

Dimensional Control

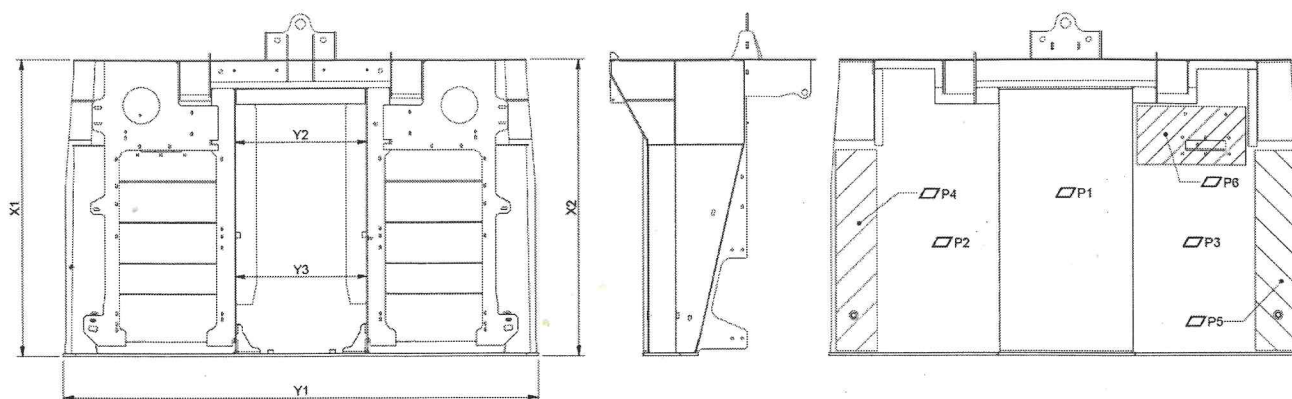
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	340	± 1	340		Tape Measure	Acceptable	
B	2240	± 4	2244			Acceptable	
D / D'	250	± 1	251	251		Acceptable	
E	808	± 2	808			Acceptable	
F1 / F1'	580	± 1	581	581		Acceptable	
F2 / F2'			581	581		Acceptable	
G / G'	258	± 1	258	258		Acceptable	
H / H'	1019	± 2	1020	1020		Acceptable	
QC Inspector:		LEON		Sign:		Date:	2024/01/15

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_01/15


Cabin Underframe Assembly: GN002835

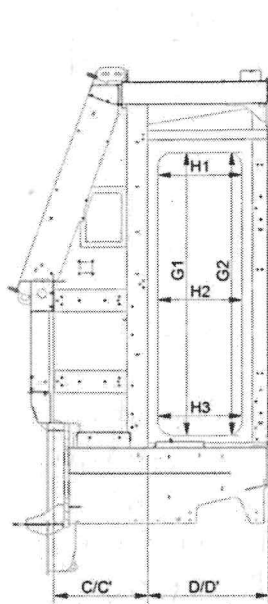
Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	20 <u>24</u> / <u>01</u> / <u>18</u>	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202165	



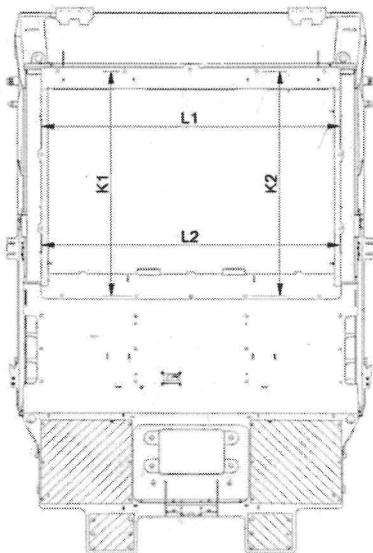
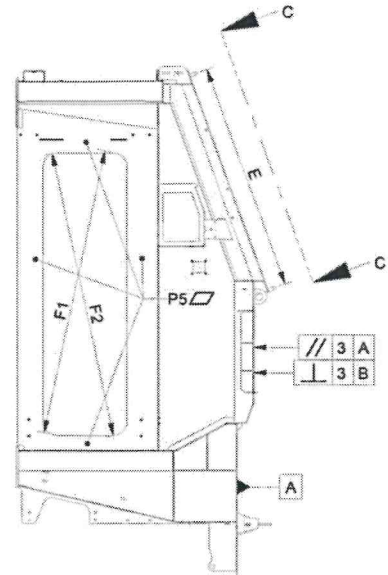
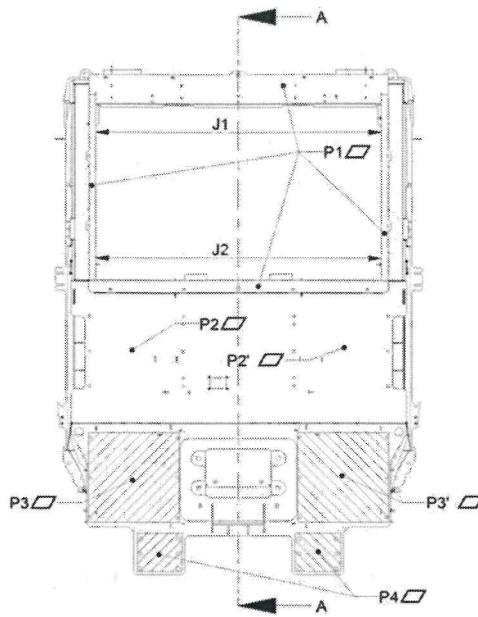
Welding Control						
Assembly Completed as per WI/SOS MD_0042			Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>01</u> / <u>18</u>	
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	<i>1485</i>	<i>1485</i>	Tape Measure	<i>Acceptable</i>
Y1	2354	± 3	<i>2352</i>			<i>Acceptable</i>
Y2 / Y3	666	± 1	<i>666</i>	<i>667</i>		<i>Acceptable</i>
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>01</u> / <u>18</u>	
Geometrical Control						
Nature of checks			Dimension Measured	Measuring Equipment	Observations	
P1 : Planeity	4 mm		<i>PASS GO</i>	Ruler	<i>Acceptable</i>	
P2 / P3 : Planeity	4 mm		<i>PASS GO</i>	Ruler	<i>Acceptable</i>	
P4 / P5 : Planeity	2 mm		<i>PASS GO</i>	Ruler	<i>Acceptable</i>	
P6 : Planeity	2 mm		<i>PASS GO</i>	Ruler	<i>Acceptable</i>	
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>01</u> / <u>18</u>	

Cabin Structure Assembly: GN002834

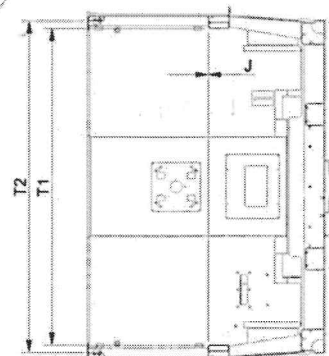
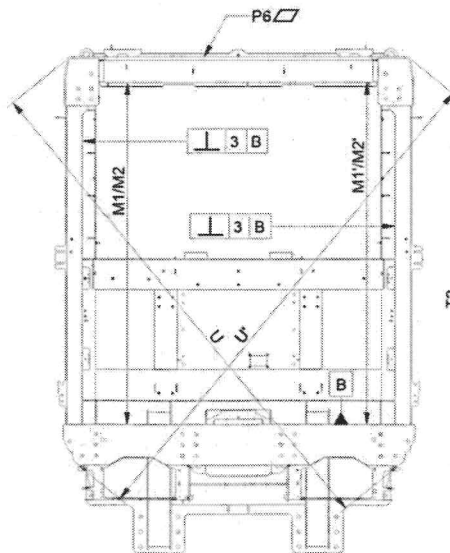
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLOEN	Assembly Date:	2024/01/18			
Sign:		Wire Batch No.:	2202152			






SECTION A-A




AUX VIEW: C



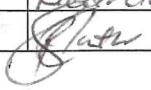
SECTION B-B

Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed		Yes		No
QC Inspector:		LEON			Sign:				Date: 20 <u>24</u> / <u>01</u> / <u>22</u>
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	625	624	Acceptable				
D / D'	813	± 2,5	812	811	Acceptable				
E	1531.5	± 3	1531		Acceptable				
G1 / G'1	Height 1900	+1	1899	1898	Acceptable				
G2 / G'2		-3	1899	1898	Acceptable				
H1' / H'1	Width 560	+1	557	557	Acceptable				
H2 / H'2		-3	558	558	Acceptable				
H3 / H'3			557	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	1		Acceptable				
K1 / K2	1515	± 3	1514	1514	Acceptable				
L1 / L2	1996	± 3	1999	1996	Acceptable				
M1 / M'1	2306	± 3	2466	2466	Acceptable				
M2 / M'2			2477	2477	Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2127	2127	Acceptable				
T2 / T'2	2230 Top/Bottom		2229	2229	Acceptable				
Difference	U - U' (3522)	≤ 4mm	3520	3518	Acceptable				
QC Inspector:		LEON			Sign:				Date: 20 <u>24</u> / <u>01</u> / <u>22</u>
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 <u>24</u> / <u>01</u> / <u>22</u>

Cabin Bracket Assembly: GN002833


Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	CHARL BLOEM	Assembly Date:	20 24/01/21			
Sign:		Wire Batch No.:	2202152			

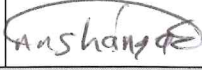

Cabin Rivnut Assembly: GN002832



Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes		No	
Operator:	Regis do	Assembly Date:	20 24/02/20			
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:		TD [Signature]	
Date:	2024/02/08				
Record of Shot Blasting					
Operator:		Date:	2024/02/08		
Start Time:	07 H35	End Time:	17 H15		
Temperature ($\geq 15^\circ$):	21-03 $^\circ\text{C}$	Humidity ($\leq 75\%$):	66-05 %		
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:		TD [Signature]	
Date:	2024/02/08				
Shot Blasting Cleaning					
Cabin free of all sand		Confirmed	Yes	<input type="checkbox"/>	No
Operator:		Sign:		TD [Signature]	
Date:	2024/02/08				
Shot Blasting Control					
Temperature $\geq 15^\circ$:	19-01 $^\circ\text{C}$	Humidity $\leq 75\%$:	61-02 %		
Internal Roughness $3.2 \leq Ra \leq 12.5$	9.7 Ra	External Roughness $3.2 \leq Ra \leq 12.5$	11.7 Ra		
QC Inspector:	[Signature]	Sign:		[Signature]	
Date:	8/02/24				

Record of Priming									
Start Time:				End Time:					
Temperature $\geq 15^{\circ}$:				Humidity $\leq 75\%$:					
Paint Batch No.:				Paint Expiry Date:					
Hardener Batch No.:				Hardener Expiry Date:					
Desolvation Start Time:				Desolvation End Time:					
Stoving Start Time:				Stoving End Time:					
Stoving Temp:									
Operator:				Sign:					
Date: 20 __/__/__									
Priming Control									
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front			
1: 43	5: 31	1: 79	5: 31	1: 55	5: 62	1: 41	5: 49		
2: 66	6: 56	2: 59	6: 68	2: 79	6: 75	2: 47	6: 66		
3: 38	7: 70	3: 64	7: 84	3: 89	7: 33	3: 48	7: 54		
4: 42	8: 44	4: 38	8: 66	4: 56	8: 52	4: 80	8: 49		
Min:	31	Min:	31	Min:	33	Min:	41		
Max:	70	Max:	84	Max:	89	Max:	80		
Average:	48	Average:	61	Average:	62	Average:	54		
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside			
1: 53	5: 80	1: 73	5: 56	1: 40	5: 82	1: 51	5: 71		
2: 68	6: 47	2: 89	6: 73	2: 81	6: 47	2: 78	6: 60		
3: 51	7: 38	3: 68	7: 50	3: 88	7: 65	3: 34	7: 32		
4: 40	8: 36	4: 75	8: 44	4: 55	8: 74	4: 67	8: 73		
Min:	36	Min:	44	Min:	40	Min:	32		
Max:	86	Max:	89	Max:	88	Max:	78		
Average:	52	Average:	66	Average:	66.5	Average:	58		
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS			
1: 49	5: 65	1: 61	5: 73	1: 40	5: 84	1: 48	5: 46		
2: 57	6: 72	2: 55	6: 82	2: 63	6: 59	2: 57	6: 32		
3: 49	7: 62	3: 59	7: 78	3: 41	7: 60	3: 64	7: 70		
4: 65	8: 86	4: 79	8: 46	4: 73	8: 51	4: 31	8: 77		
Min:	49	Min:	46	Min:	41	Min:	31		
Max:	86	Max:	82	Max:	73	Max:	77		
Average:	63	Average:	66.5	Average:	58	Average:	53		
Primer has been inspected and is free of defects				Confirmed		Yes		No	
QC Inspector:		Cee-J		Sign:					
Date:		16.02.24							

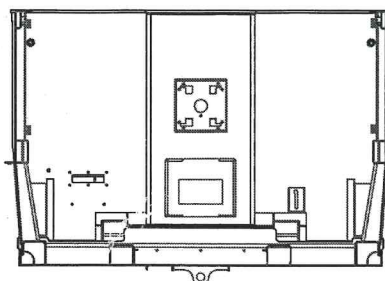
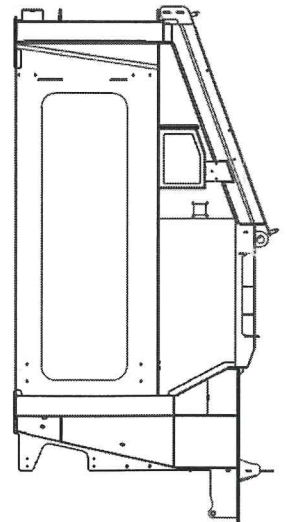
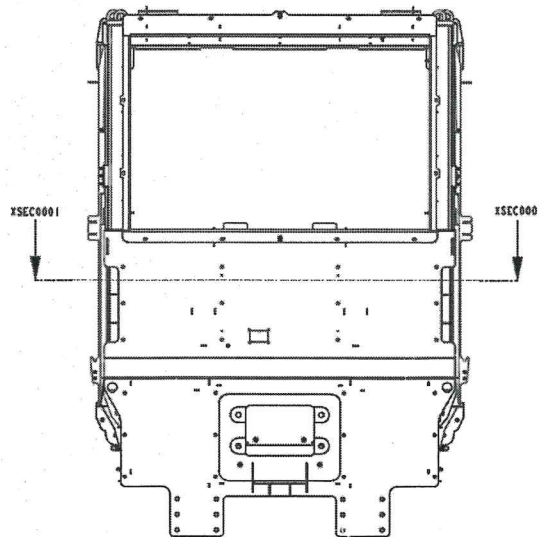
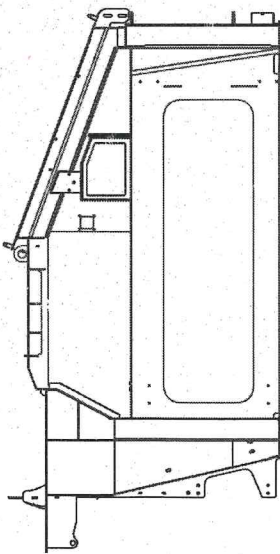
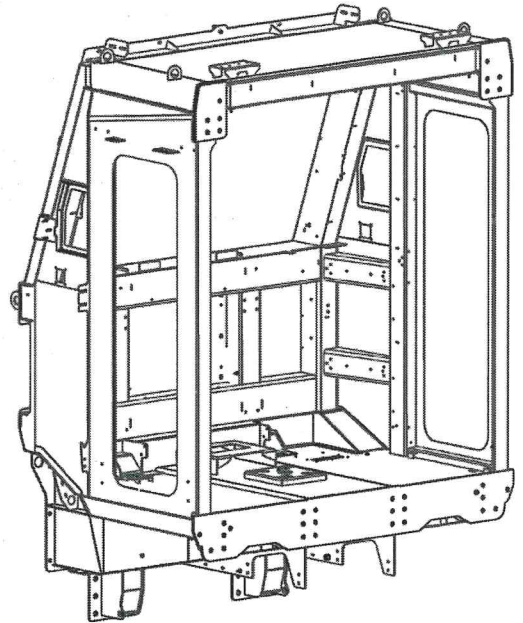
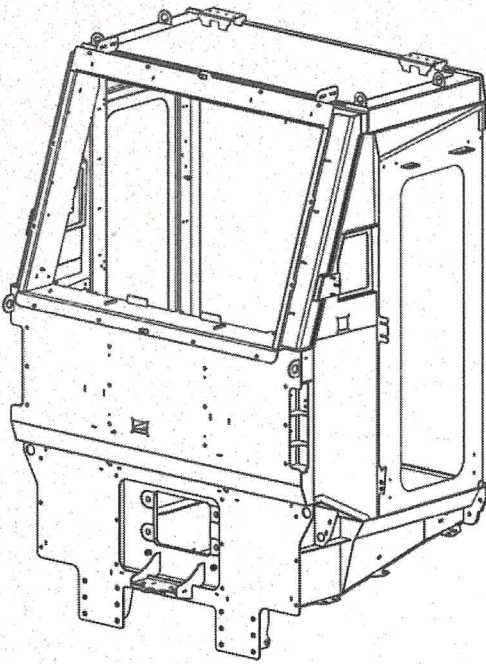
Record of Painting NCSS3010 R90B					
Start Time:				End Time:	
Temperature $\geq 15^{\circ}$:				Humidity $\leq 75\%$:	
Paint Batch No.:				Paint Expiry Date:	
Hardener Batch No.:				Hardener Expiry Date:	
Desolvation Start Time:				Desolvation End Time:	
Stoving Start Time:				Stoving End Time:	
Stoving Temp:					
Operator:				Sign:	
Date: 20__/__/__					
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: 118	5: 104	1: 96.3	5: 128		
2: 141	6: 113	2: 126	6: 105		
3: 128	7: 127	3: 111	7: 113		
4: 139	8: 122	4: 127	8: 121		
Min: 104		Min: 96.3			
Max: 139		Max: 128			
Average: 124		Average: 115			
Painting NCSS3010 R90B has been inspected and is free of defects					
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	
QC Inspector: Zothule				Sign:	
Date: 16.02.2024					

Record of Painting Blue NCSS1565 B					
Start Time:		20300		End Time:	
Temperature $\geq 15^{\circ}$:		28°C		Humidity $\leq 75\%$:	
Paint Batch No.:		8076541		Paint Expiry Date:	
Hardener Batch No.:		7250479041		Hardener Expiry Date:	
Desolvation Start Time:		21:00		Desolvation End Time:	
Stoving Start Time:		21:15		Stoving End Time:	
Stoving Temp:		60°C			
Operator:		Nervthuko		Sign: 	
Date:		2024/02/13			
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: 104	5: 98.6	1: 108	5: 96.5		
2: 103	6: 126	2: 114	6: 129		
3: 123	7: 117	3: 132	7: 112		
4: 127	8: 133	4: 131	8: 100		
Min:	98.6	Min:	96.5		
Max:	133	Max:	132		
Average:	116	Average:	115		
Painting NCSS3010 R90B has been inspected and is free of defects					
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	
QC Inspector:		Cee-J		Sign: 	
Date:		16/02/24			

Record of RAL 7012							
Start Time:		06:30		End Time:		08:30	
Temperature $\geq 15^{\circ}$:		28°C		Humidity $\leq 75\%$:		33%	
Paint Batch No.:		8096599		Paint Expiry Date:		21-09-2024	
Hardener Batch No.:		7280479041		Hardener Expiry Date:		04-24	
Desolvation Start Time:		08:30		Desolvation End Time:		08:45	
Stoving Start Time:		08:45		Stoving End Time:		09:45	
Stoving Temp:		60°C					
Operator:		N. T. U. H. V. K. O.		Sign:			
Date:		20/02/24					
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 113	5: 83	1: 124	5: 85	1: 136	5: 135	1: 145	5: 124
2: 161	6: 102	2: 112	6: 150	2: 94	6: 140	2: 94	6: 113
3: 111	7: 102	3: 103	7: 121	3: 135	7: 132	3: 125	7: 154
4: 90	8: 80	4: 101	8: 96	4: 140	8: 123	4: 86	8: 106
Min:	80	Min:	85	Min:	94	Min:	86
Max:	161	Max:	150	Max:	140	Max:	154
Average:	105	Average:	115	Average:	103.5	Average:	118
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 122	5: 127	1: 110	5: 122	1: 114	5: 93	1: 126	5: 161
2: 100	6: 95	2: 103	6: 114	2: 155	6: 114	2: 160	6: 134
3: 113	7: 108	3: 126	7: 106	3: 155	7: 123	3: 111	7: 162
4: 135	8: 116	4: 81	8: 149	4: 145	8: 125	4: 102	8: 103
Min:	95	Min:	81	Min:	93	Min:	102
Max:	135	Max:	149	Max:	155	Max:	161
Average:	114	Average:	116	Average:	128	Average:	124
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 163	5: 98.7	1: 143	5: 121				
2: 93.0	6: 91.5	2: 100	6: 131				
3: 89.6	7: 146	3: 126	7: 91.7				
4: 152	8: 101	4: 124	8: 108				
Min:	89.6	Min:	100				
Max:	163	Max:	143				
Average:	116	Average:	118				
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			
QC Inspector:		Cee-J		Sign:			
Date:		16/02/24					
SEALING OF CABIN							
All areas where there is no welding has been sealed with SIKA				Confirmed		YES	<input type="checkbox"/> NO
All sealants have been neatly applied along joints				Confirmed		YES	<input type="checkbox"/> NO
SIGN OFF							
CLOCK No:		OPERATOR SIGN:		DATE:			

REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)



FAULT TRACKING

[illegible]

REMINDERS / COMMENTS

[illegible]