

PRASA PROJECT

GIBELG

SELF INSPECTION SHEET

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

CONFIDENTIAL INFORMATION


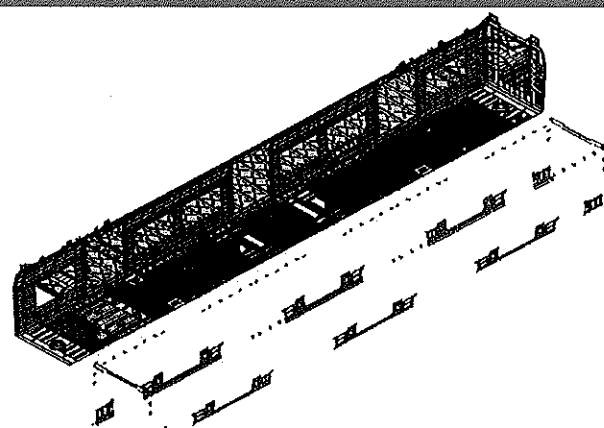
This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of clause 25 of the MSA, and treated as such.

APPLICATION REFERENCE



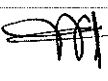
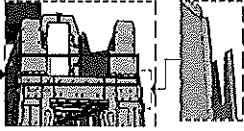

DRAWING	DESCRIPTION	STATION	CAR TYPE				TICK	M4	M2	M1	TICK	WORK INSTRUCTIONS	SAFETY ?
			CAR BODY SHELL	CAR 200	CAR 210	CAR 220							
07802251872	AD0000172555											PRACB2220.DIR3022548	YES

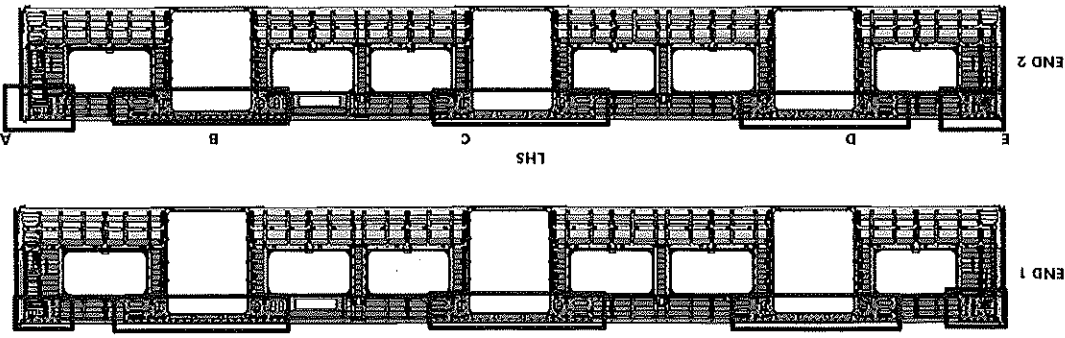
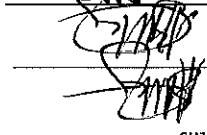
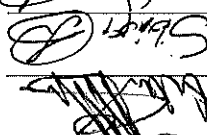
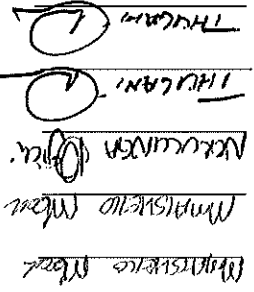
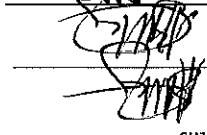
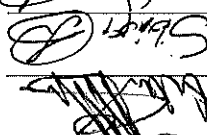
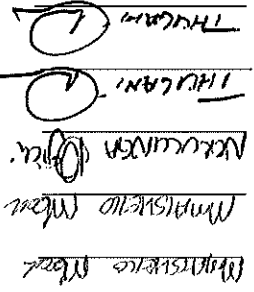
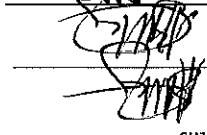
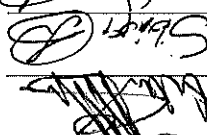
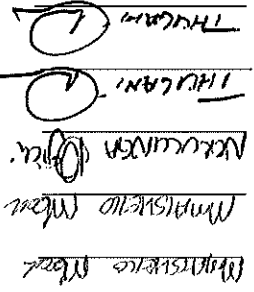
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0	01/02/2018	GIBELG NEW CREATION	APPROVER	Humeleng Modiba	01/02/2018
			CHECKER	Noszo Pindela	01/02/2018
			COMPLER	Thanyani Mathengu	01/02/2018
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PRC Manager to Quality manager	APPROVER	Humeleng Modiba	18/05/2018
			CHECKER	Noszo Pindela	18/05/2018
			REVISOR BY	Ramokone Motama	18/05/2018
2	2018/07/05	Certain dimensional checks added and others moved to CB120	APPROVER	Humeleng Modiba	2018/07/05
			CHECKER	Noszo Pindela	2018/07/05
			REVISOR BY	Ramokone Motama	2018/07/05
3	2018/06/12	Width tolerance as per DT0000336600	APPROVER	Humeleng Modiba	2018/06/12
			CHECKER	Noszo Pindela	2018/06/12
			REVISOR BY	Noszo Pindela	2018/06/12
5	24/01/2019	As per Baseline 10.2	APPROVER	Humeleng Modiba	24/01/2019
			CHECKER	Noszo Pindela	24/01/2019
			REVISOR BY	Vanessa Ntuli	24/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection Remove length measurements	APPROVER	Humeleng Modiba	13/03/2019
			CHECKER	Noszo Pindela	13/03/2019
			REVISOR BY	Noszo Pindela	13/03/2019
10	22/08/2019	New Baseline 10.2.5	APPROVER	Humeleng Modiba	22/08/2019
			CHECKER	Noszo Pindela	22/08/2019
			REVISOR BY	Noszo Pindela	22/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Mabele	06/08/2020
			CHECKER	Bongane Masina	06/08/2020
			REVISOR BY	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Mabele	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			REVISOR BY	Bongane Masina	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mpho Mulaudzi	17/08/2021
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISOR BY	Mpho Mulaudzi	17/08/2021
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mkhombathi	19/02/2022
			CHECKER	Andani Muthelo	19/02/2022
			REVISOR BY	Andani Muthelo	19/02/2022
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mkhombathi	14/06/2022
			CHECKER	Andani Muthelo	14/06/2022
			REVISOR BY	Andani Muthelo	14/06/2022
27	19/10/2022	Addition of traceability for sealant application & welding	APPROVER	Collins Mkhombathi	19/10/2022
			CHECKER	Nitoko Zwane	19/10/2022
			REVISOR BY	Amogelang Mkhamphe	19/10/2022
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Nitoko Zwane	14/04/2023
			REVISOR BY	Amogelang Mkhamphe	14/04/2023
29	28/10/2023	Addition of bracket quantity	APPROVER	Nyobeni Tyson	28/10/2023
			CHECKER	Nitoko Zwane	28/10/2023
			REVISOR BY	Amogelang Mkhamphe	28/10/2023

TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
209	293	293	29/10/23	SI.CB2220.250.V29	13


CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2		Rev. 29 Date 28/10/2023 Project: PRASA SI.CB2220.250.V29	Work station: CB2220	Safety Related 																
																				
I - Documentation and Instruments Control																				
L1 - Documentation Control																				
<table border="1"> <tr> <td colspan="2"> Document DTR30225487/2 </td> <td colspan="2"> Revision 29 </td> <td colspan="2"> Observation 28/10/2023 </td> <td colspan="2"> Signature Date (Quality) 07/02/2024 </td> </tr> <tr> <td colspan="2"> Type of car <input checked="" type="checkbox"/> TCR <input type="checkbox"/> MT <input type="checkbox"/> MS <input type="checkbox"/> MA <input type="checkbox"/> TC </td> <td colspan="2"> <input checked="" type="checkbox"/> OK <input type="checkbox"/> N/A </td> <td colspan="2"> Signature Date (Manufacturing) 07/02/2024 </td> <td colspan="2"> Signature Date (Quality) 07/02/2024 </td> </tr> </table>					Document DTR30225487/2		Revision 29		Observation 28/10/2023		Signature Date (Quality) 07/02/2024		Type of car <input checked="" type="checkbox"/> TCR <input type="checkbox"/> MT <input type="checkbox"/> MS <input type="checkbox"/> MA <input type="checkbox"/> TC		<input checked="" type="checkbox"/> OK <input type="checkbox"/> N/A		Signature Date (Manufacturing) 07/02/2024		Signature Date (Quality) 07/02/2024	
Document DTR30225487/2		Revision 29		Observation 28/10/2023		Signature Date (Quality) 07/02/2024														
Type of car <input checked="" type="checkbox"/> TCR <input type="checkbox"/> MT <input type="checkbox"/> MS <input type="checkbox"/> MA <input type="checkbox"/> TC		<input checked="" type="checkbox"/> OK <input type="checkbox"/> N/A		Signature Date (Manufacturing) 07/02/2024		Signature Date (Quality) 07/02/2024														
L2 - Instruments Control																				
<table border="1"> <tr> <td colspan="2"> Instruments 12/05/2023 04/05/2023 - 04/05/23 </td> <td colspan="2"> Validation or Verification 07/02/2024 </td> <td colspan="2"> Signature Date (Manufacturing) 07/02/2024 </td> <td colspan="2"> Signature Date (Quality) 07/02/2024 </td> </tr> <tr> <td colspan="2"> Serial number 22517 </td> <td colspan="2"> <input checked="" type="checkbox"/> OK <input type="checkbox"/> N/A </td> <td colspan="2"> Signature Date (Manufacturing) 07/02/2024 </td> <td colspan="2"> Signature Date (Quality) 07/02/2024 </td> </tr> </table>					Instruments 12/05/2023 04/05/2023 - 04/05/23		Validation or Verification 07/02/2024		Signature Date (Manufacturing) 07/02/2024		Signature Date (Quality) 07/02/2024		Serial number 22517		<input checked="" type="checkbox"/> OK <input type="checkbox"/> N/A		Signature Date (Manufacturing) 07/02/2024		Signature Date (Quality) 07/02/2024	
Instruments 12/05/2023 04/05/2023 - 04/05/23		Validation or Verification 07/02/2024		Signature Date (Manufacturing) 07/02/2024		Signature Date (Quality) 07/02/2024														
Serial number 22517		<input checked="" type="checkbox"/> OK <input type="checkbox"/> N/A		Signature Date (Manufacturing) 07/02/2024		Signature Date (Quality) 07/02/2024														
1.3 Consumables																				
<table border="1"> <tr> <td colspan="2"> Welding Consumable Control - Used for Special Process </td> <td colspan="2"> Signature Date (Manufacturing) 07/02/2024 </td> <td colspan="2"> Signature Date (Quality) 07/02/2024 </td> </tr> <tr> <td colspan="2"> Heat Number Welding 308451 022580 </td> <td colspan="2"> Welding Process MIG </td> <td colspan="2"> <input checked="" type="checkbox"/> OK <input type="checkbox"/> N/A </td> </tr> </table>					Welding Consumable Control - Used for Special Process		Signature Date (Manufacturing) 07/02/2024		Signature Date (Quality) 07/02/2024		Heat Number Welding 308451 022580		Welding Process MIG		<input checked="" type="checkbox"/> OK <input type="checkbox"/> N/A					
Welding Consumable Control - Used for Special Process		Signature Date (Manufacturing) 07/02/2024		Signature Date (Quality) 07/02/2024																
Heat Number Welding 308451 022580		Welding Process MIG		<input checked="" type="checkbox"/> OK <input type="checkbox"/> N/A																

II - Self Inspection - Items to Check		II.1 - Items to Check	
Rev.	Date	Signature/Date	Signature/Date (Quality)
29	20/10/2023	SI.CB2220.250.V29	
Project: PRSA			
CARBODYSHELL M1,M3,M4 ASSEMBLY			
DTR30226487/2			
Assembly according to			
Instruction Engineering n° PRA.CB2220.DTR30225487/2			
Verification of flange for all reinforcement brackets			
N/A			
Carshell free of significant flaws which compromise the appearance or functionality			
DTB00000210675			
N/A			
Arc Welding inspected and approved according procedure.			
IND-SAL-WMS-016 REFER TO GIB - TYPEDEF - ARC - 0000			
Cleaning of all Stainless Steel Surface			
According TO GIB-WEL - PROC-0002			
Functions dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document			
Approved according specified on pages below.			
Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-016. Fillet sampling as described in DTB00000210658.			
As the welding procedure IND-SAL-WMS-016 and DTB00000210658.			
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 35°C - 60°C			
Relative humidity: Min-Max 25% - 60%			
Max (t)			
Verification of sealant application in certain regions in the drawing.			
N/A			
Verification of safety welds			
Approved according to DTB0000210658 reference and Self inspection			
N/A			
AD0001272856			
Self inspection			

		CARBODYSHELL M1,M3,M4 ASSEMBLY DTR302226487/2		Rev. 29 Date 28/10/2023	Project: PRASA SI:CB2220.250.V29
II - Self Inspection - Items to Check					
SEALANT APPLICATION					
AREA 1 & 2 END 1					
Operator (Name & sign): 		Operator (Name & sign): 			
					

															
REINFORCEMENT WELDING															
<table border="1"><tr><td rowspan="3"> Operator (Name&sign):</td><td>A</td></tr><tr><td>B</td></tr><tr><td>C</td></tr><tr><td rowspan="3"> Operator (Name&sign):</td><td>D</td></tr><tr><td>E</td></tr><tr><td></td></tr><tr><td rowspan="5"> Operator (Name&sign):</td><td>RHS</td></tr><tr><td></td></tr><tr><td></td></tr><tr><td></td></tr><tr><td></td></tr></table>		 Operator (Name&sign):	A	B	C	 Operator (Name&sign):	D	E		 Operator (Name&sign):	RHS				
 Operator (Name&sign):	A														
	B														
	C														
 Operator (Name&sign):	D														
	E														
 Operator (Name&sign):	RHS														

Rev.	29	Project: PRASA
	Date	
	28/10/2023	
SI.CB2220.250.V29		

	CARBODYSHELL M1,M3,M4 ASSEMBLY	
	DTR30226487/2	

CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA
	Date	SI.CB2220.250.V29
	28/10/2023	

II - Self Inspection - Items to Check

END 1	A	B	C	D
RHS				
LHS				
END 2	A	B	C	D

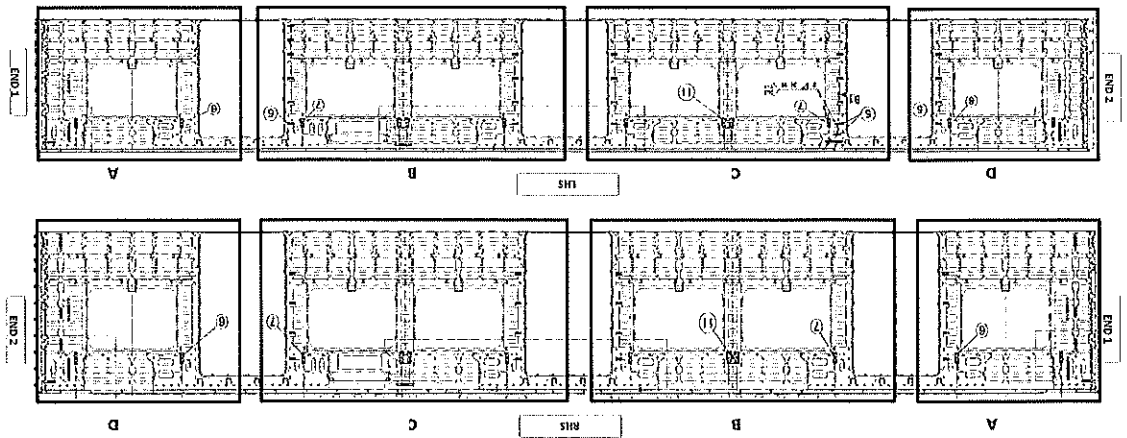
BRACKETING

C-RAILS:	Operator: <u>Lead LHS</u>
DOOR MECHANISMS:	Operator: <u>Tetelo</u>
TAPPING PADS	Operator: <u>Rosalia</u>
SEAT & LUGGAGE BRACKETS:	Operator: <u>Tetelo</u>
SEAT BRACKETS VERIFICATION:	Operator: <u>Tetelo</u>
WELDING	
AREA	
A (Seat brackets)	Operator (Name&sign): <u>S. V. 19</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>Xulio</u>
B (Seat brackets)	Operator (Name&sign): <u>Xulio</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>S. V. 19</u>
C (Seat brackets)	Operator (Name&sign): <u>S. V. 19</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>S. V. 19</u>
D (Seat brackets)	Operator (Name&sign): <u>S. V. 19</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>S. V. 19</u>
ENDS	
END 1 TAPPING PADS WELDING:	Operator (Name&sign): <u>Xulio</u>
END 1 TAPPING PADS WELDING:	Operator (Name&sign): <u>THUAM</u>

CIBELA CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	29
	Date	28/10/2023
	Project PRASA SI.CB2220.250.V29	

II - Self Inspection - Items to Check

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

VERIFICATION BY: *[Signature]*

GRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

ROOF ENDS:

SECTION	QUANTITY	OK	NOK
A	2		
B	6		
C	11		
D	8		
A	13		
B	21		
C	21		
D	13		
A	3		
B	5		
C	8		
D	2		

SEAT BRACKETS

EARTH BUSH

LHS

QUANTITIES (M1)

VERIFICATION BY: *[Signature]*

GRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

ROOF ENDS:

SECTION	QUANTITY	OK	NOK
A	7		
B	8		
C	8		
D	6		
A	13		
B	21		
C	21		
D	13		
A	3		
B	5		
C	8		
D	2		

SEAT BRACKETS

EARTH BUSH

RHS

VERIFICATION BY: *[Signature]*

GRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

ROOF ENDS:

SECTION	QUANTITY	OK	NOK
A	2		
B	10		
C	11		
D	6		
A	13		
B	21		
C	21		
D	13		
A	3		
B	5		
C	8		
D	2		

SEAT BRACKETS

EARTH BUSH

LHS

VERIFICATION BY: *[Signature]*

GRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END


ROOF ENDS:

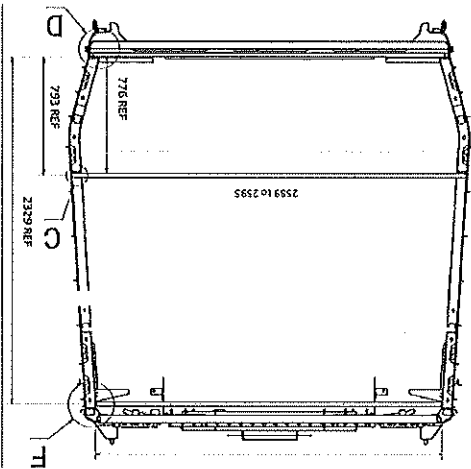
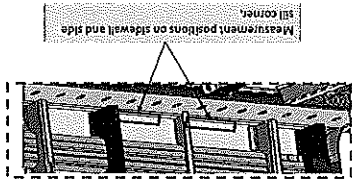
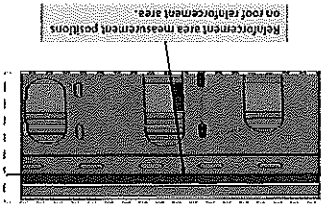
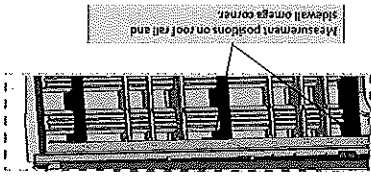
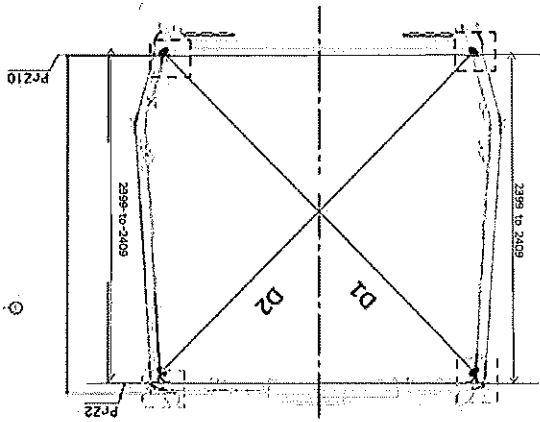
SECTION	QUANTITY	OK	NOK
A	7		
B	8		
C	8		
D	6		
A	13		
B	21		
C	21		
D	13		
A	3		
B	5		
C	8		
D	2		

SEAT BRACKETS

EARTH BUSH

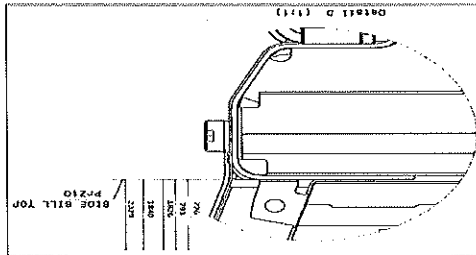
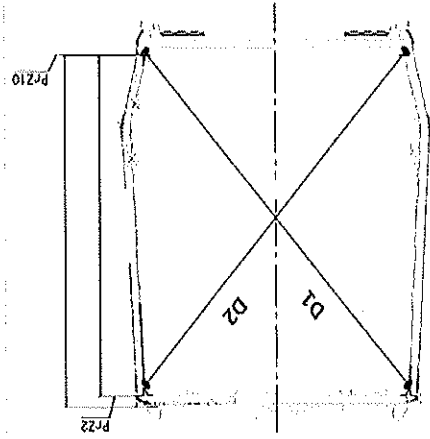
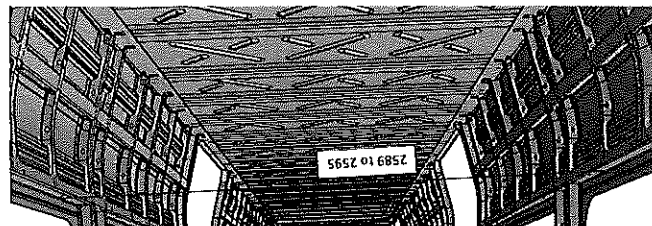
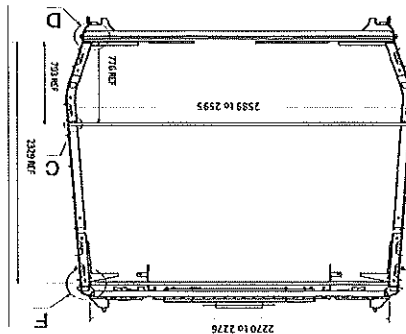
RHS

 CIBEL	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	29	Project: PRASA	SI.CB2220.250.V29	Specifications of Details for CBS measurement
		Date	28/10/2023			

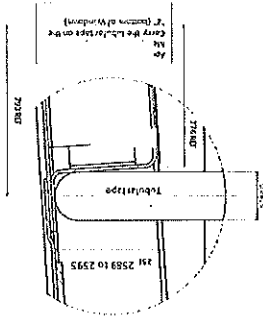


CIBELA		CARBODYSHELL M1,M3,M4 ASSEMBLY	Rev.
		DTR30226487/2	29
		28/10/2023	Date
SI.CB2220.250.V29		28/10/2023	Rev.
Project: PRASA			


CBS measurement

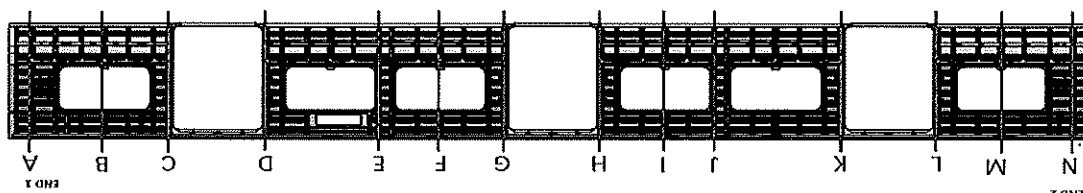


Detail C



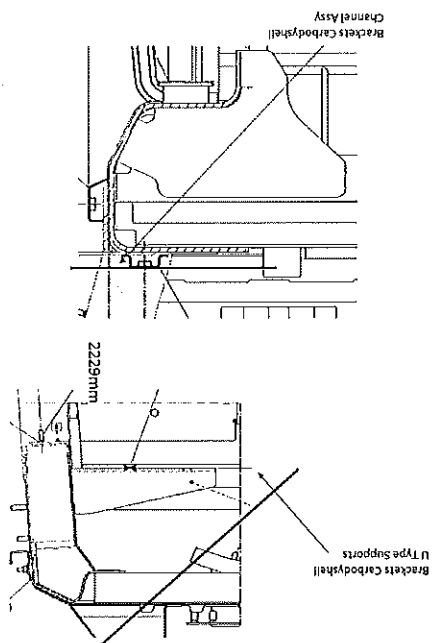
Take measurement close to
radius

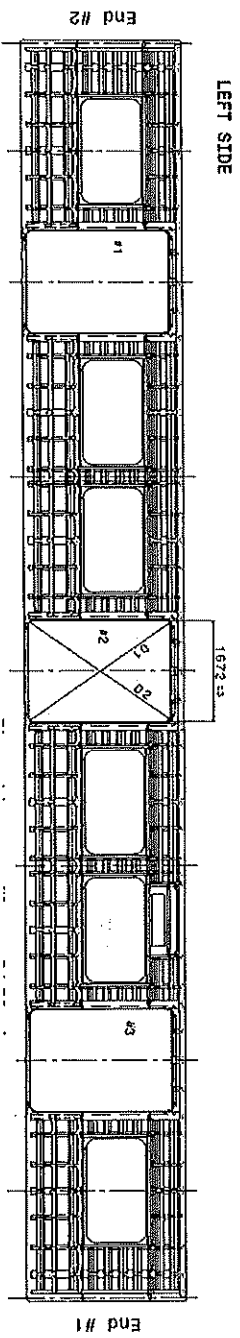
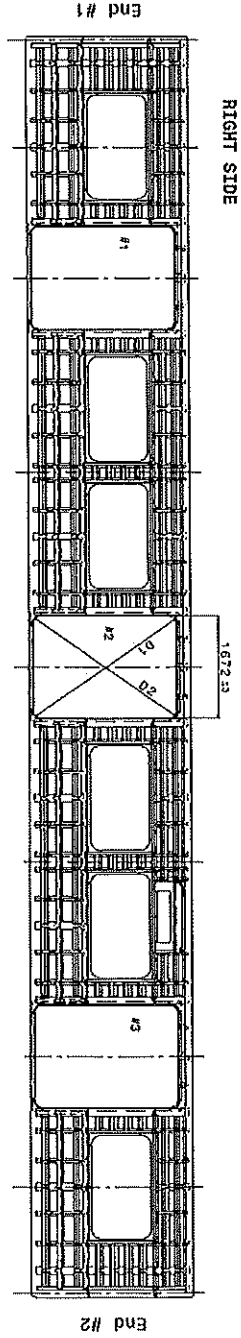
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR302254872	Date	SI.CB2220.250.V29
		Rev.	Project: PRASA
		29	28/10/2023





BEFORE WELDING

Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
3298	3298	0	
3265	3265	0	
3296	3293	3	
3295	3295	0	
3265	3265	0	
3267	3265	2	
3297	3296	1	
3295	3297	2	
3265	3265	0	
3264	3264	0	
3299	3298	1	
3297	3296	1	
3264	3265	1	
3297	3298	1	

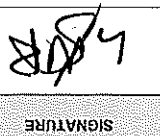

[illegible]



CARBODYSHELL M1,M3,M4 ASSEMBLY		DTR3022648712		Rev.	29	Date	28/10/2023	Project: PRASA		SI.CB2220.250.V29		CBS measurement (Manufacturing)	
Dye penetrant test													
Eye penetration test to be performed by quality personnel													
													
Dye penetrant test													
Item	Description of the issue			OK	Signature/Date (Manufacturing)	Signature/Date (Quality)							
II.2 - Check List REX							Check List Items						
Item	Picture/Drawing	Description	Criteria/Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)							
01	N/A	To comply REX	Refer to REX. New defects must be added on REX										

CIBELG 	CARBODYSHELL M1.M3.M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA
		Date	SI.CB2220.250.V29
		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)					
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)	DATE: 07/06/24	NAME: L. J.	SIGNATURE: 
		Every also inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.	DATE: 07/06/24	NAME: J. J.	SIGNATURE: 
		There are activities pending that impact the activities of the next process Obs: (To describe the problems below)		NAME:	SIGNATURE:
		There are non-conformities impact the quality of the product and there is no corrective action desired yet)		NAME:	SIGNATURE:

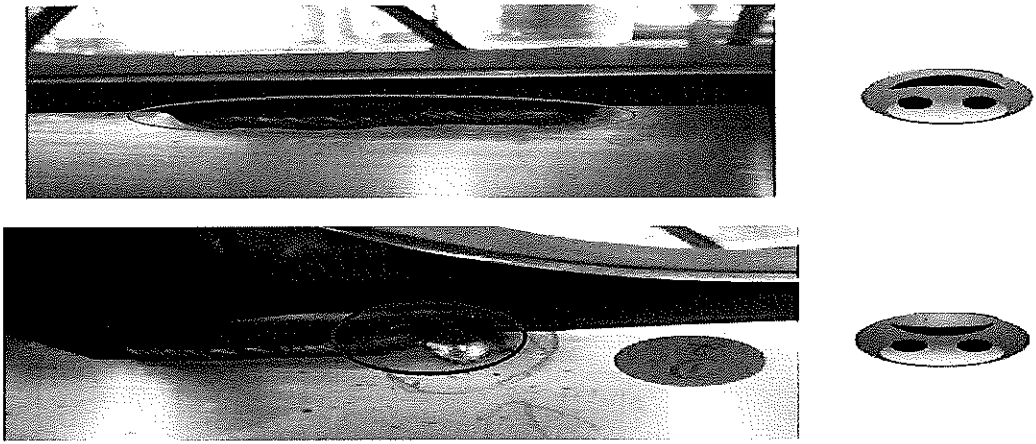
In case of "NO GO", the operations manager must define below action plan to ensure "GO":					
Item	Description	Responsible	Due date	Status	

Operations

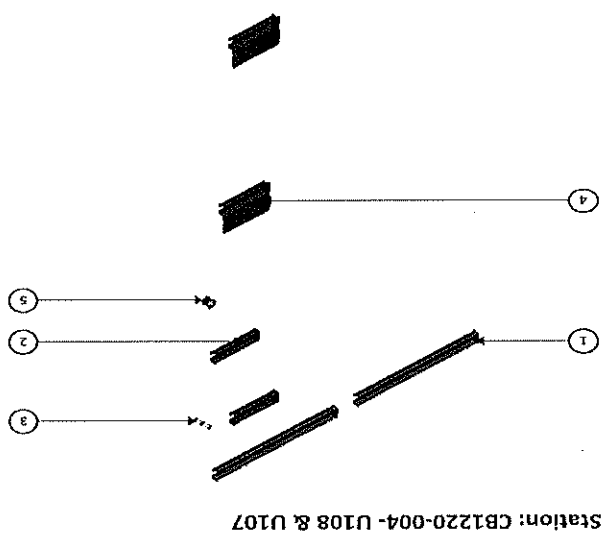
Quality

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA
		Date	SI.CB2220.250.V29
		28/10/2023	

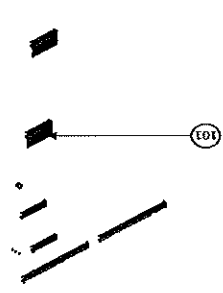
ANNEXURE A: Arc Welding Quality Acceptance Standard



MASS	(KG)	0.05	0.27	0.07	0.19	0.12	12.132
DESCRIPTION	QTY	ITEM NO.	ITEM	QTY	ITEM NO.	DESCRIPTION	MASS
FRAMING MODULE BDM - 0595	1	101	101	1	101	FRAMING MODULE BDM - 0595	12.132
CARBODYSHELL BRACKETS	6	14	14	6	14	CARBODYSHELL BRACKETS	0.122
ASSEMBLY SUPPORT	1	12	12	1	12	ASSEMBLY SUPPORT	0.198
WELDING STUD 603318 PT - 1/2X20 - 55T	3	4	4	3	4	WELDING STUD 603318 PT - 1/2X20 - 55T	0.007
ASSEMBLY SUPPORT	6	5	5	6	5	ASSEMBLY SUPPORT	0.271
EARTH STUD 6	6	6	6	6	6	EARTH STUD 6	0.058



Station: CB1220-004- U108 & U107



PRASA PROJECT

GIBBLQ


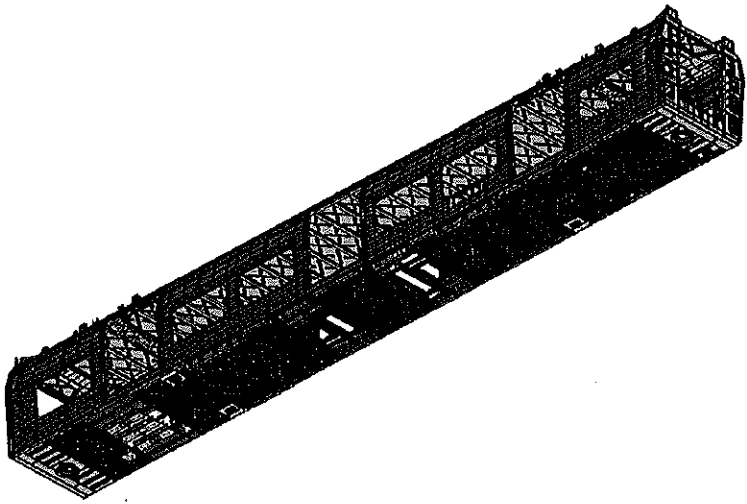
SELF INSPECTION SHEET

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

CONFIDENTIAL INFORMATION

THIS DOCUMENT AND THE INFORMATION CONTAINED THEREIN HAVE TO BE CONSIDERED AS CONFIDENTIAL INFORMATION PURSUANT TO THE PROVISIONS OF CLAUSE 25 OF THE MSA, AND TREATED AS SUCH.

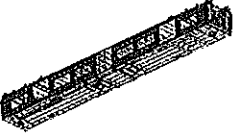
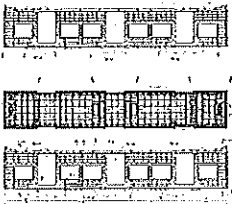

APPLICATION REFERENCE


		CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487		Rev. 29 Date 14/04/2023	Project: PRASA SI.CB2230.256.V29	
Cat:		NCR:		Work station: CB2230		
						
I - Documentation and Instruments Control						
I.1 - Documentation Control						
Type of car						
Document		Revision		Observation		
PRA.CB2230.DT00000225487		29		OK		
M1		M2		M3		
M4		TC2		N/A		
Signature/Date (Operations)		Signature/Date (Quality)		Signature/Date (Quality)		
08/02/24		08/02/24		08/02/24		
I.2 - Instruments Control						
Monitoring and Measuring Instrument Control - Used for Special Process						
Instruments		Serial number		Calibration or Verification		
Tubular		02713		03/08/24		
Combination Gauge		61850000		07/07/24		
Measuring tape		618740396		04/05/24		
1.3 Consumables		Welding Consumable Control - Used for Special Process				
Filler Material		Heat Number		Welding Process		
306 L01		033168		MIG welding		
Signature/Date (Quality)		Signature/Date (Manufacturing)		Signature/Date (Quality)		
08/02/24		08/02/24		08/02/24		

Rev. 29 Date 14/04/2023 Project: PRASA SI.CB2230.256.V29	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	GIBELQ

II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Copies)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering ne PRA.CB1230.DT00000225487	Verification of fitment for all brackets.	✓	(LM) 08/02/24	(LM) 08/02/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	(LM) 08/02/24	(LM) 08/02/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	(LM) 08/02/24	(LM) 08/02/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	(LM) 08/02/24	(LM) 08/02/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓	(LM) 08/02/24	(LM) 08/02/24
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 as (weld ring) and fillet sampling as described in DT00000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓	(LM) 08/02/24	(LM) 08/02/24
07	N/A	Before application of sealant record the room temperature and humidity are within specified values as per Works Instructions	Specified: Temperature Min - Max (T) Min-Max Relative humidity Min - Max (H) Min-Max Humidity: 10°C - 35°C - 25% - 60% Actuals Temperature: 18°C Humidity: 56% Sealant Batch No: 158-70-03 Exp Date: 1/05/24	✓	(LM) 08/02/24	(LM) 08/02/24
08	N/A	Verification of sealant application on the roof and sidewall finishers.	Sealant must be: -Applied straight and even -Free of gops,cracks,damage and debris (flashes, dirt, dust)	✓	(LM) 08/02/24	(LM) 08/02/24
09	N/A	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓	(LM) 08/02/24	(LM) 08/02/24

	CARBODYSHELL M1,M3,M4 ASSEMBLY DT000000226487	Rev. 29	Date 14/04/2023	Project: PRASA SI.CB2230.256.V29

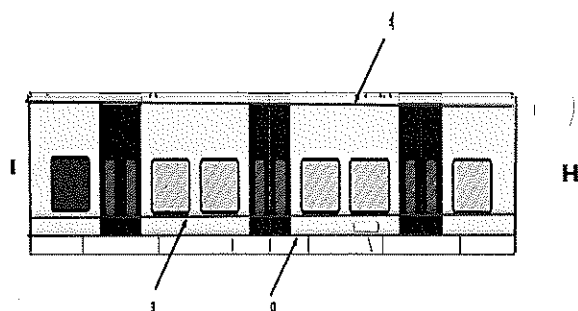
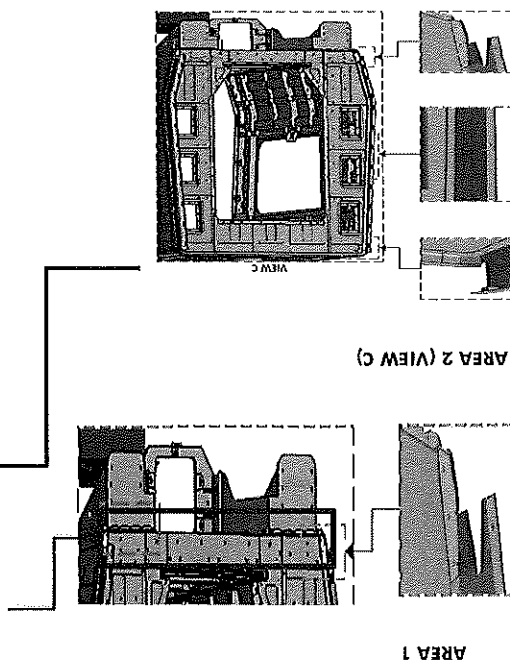
II - Self Inspection - Items to Check

END 2 SEALANT

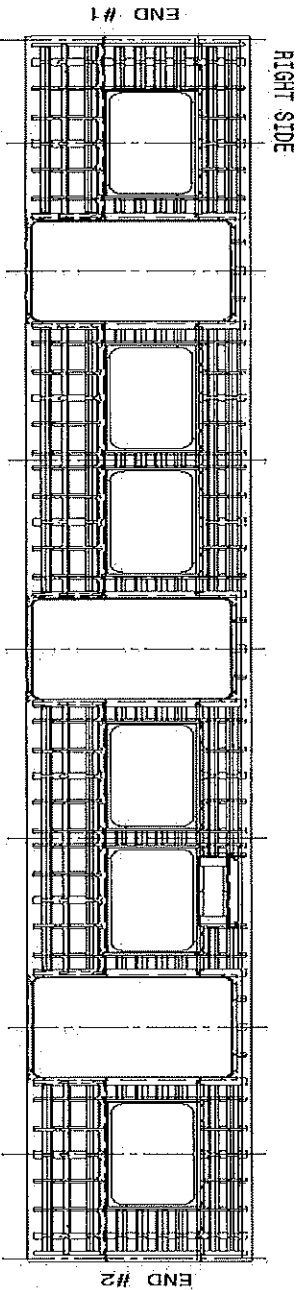
OPERATOR (Name & sign):

OPERATOR (Name & sign):

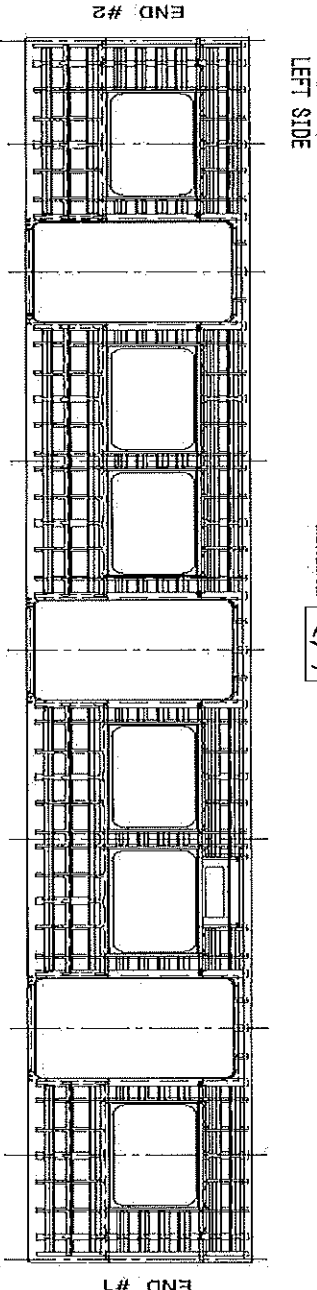
OPERATOR (Name & sign):

[illegible]


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



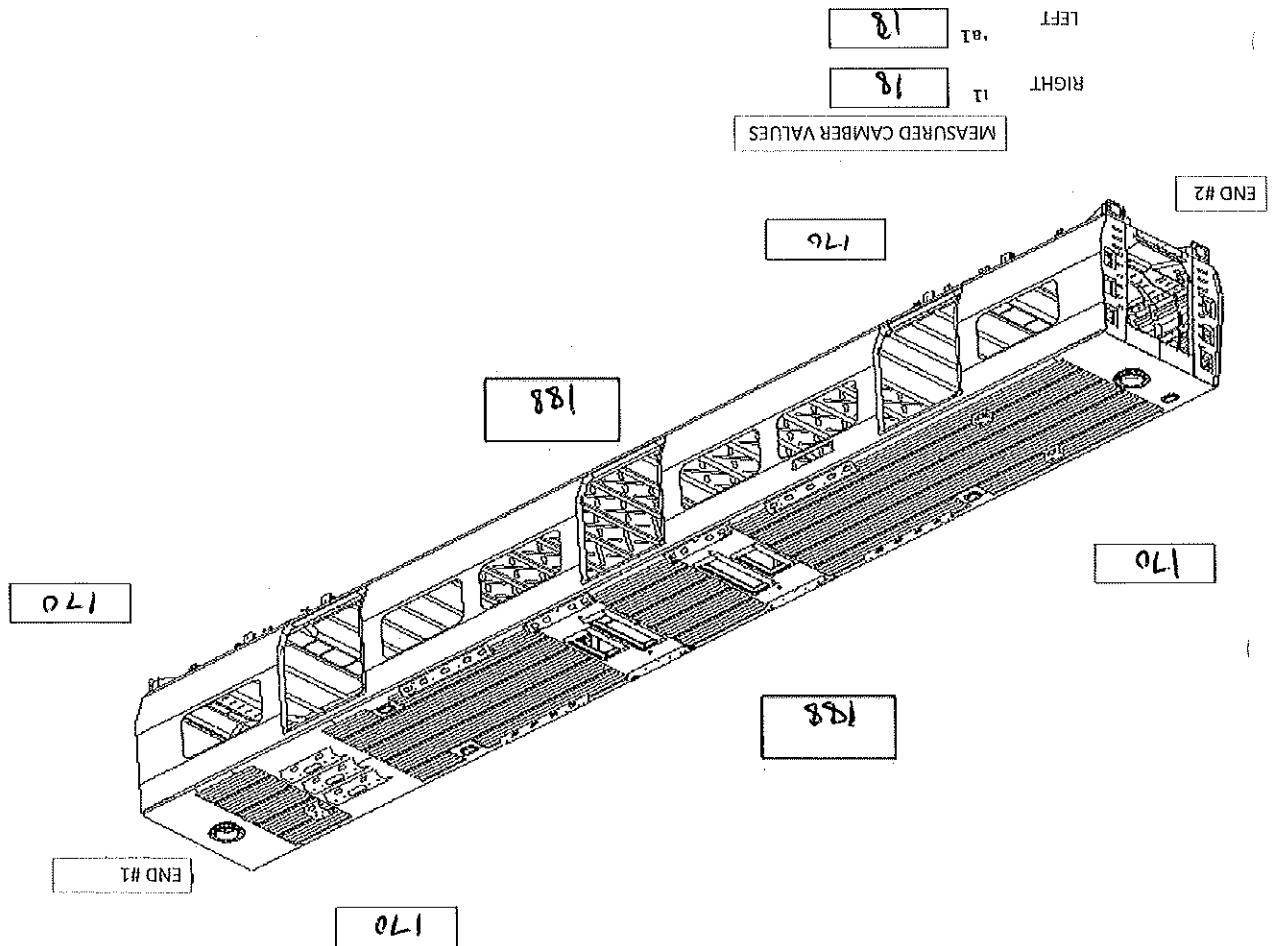
MAXIMUM 2,6
MINIMUM 2,4




MAXIMUM 2,5
MINIMUM 2,4

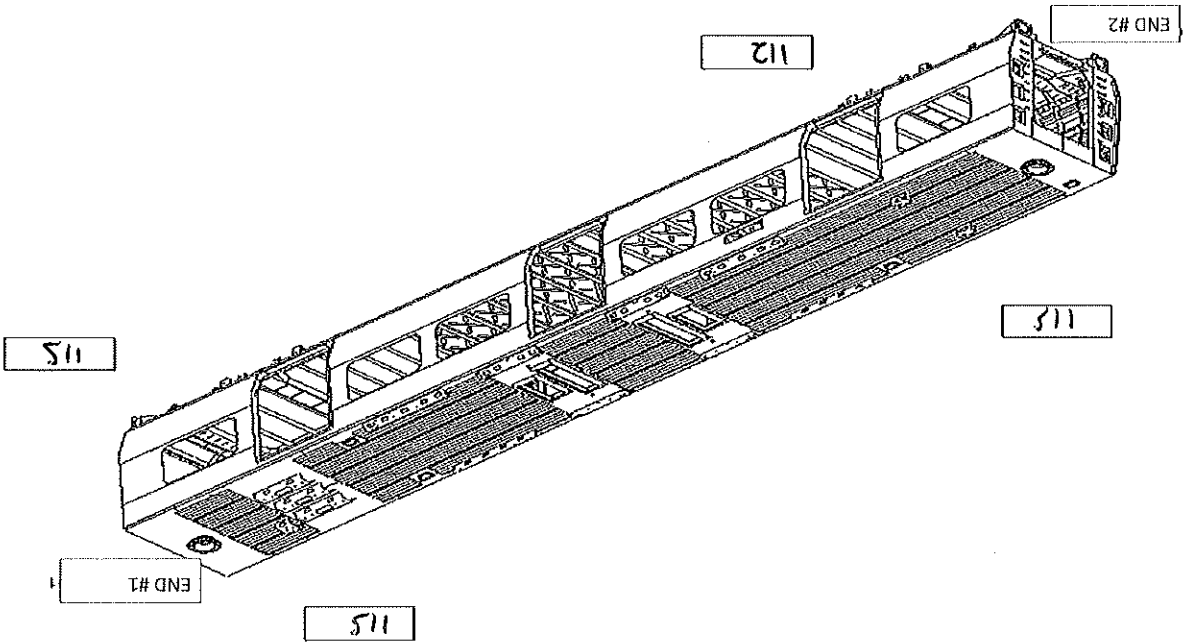
 CIBELQ	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000226487	Rev.	29	Date	14/04/2023
		Project: PRASA			
		SI.CB2230.256.V29			

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



	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 29 Date 14/04/2023	Project: PRASA SI.CB2230.256.V29
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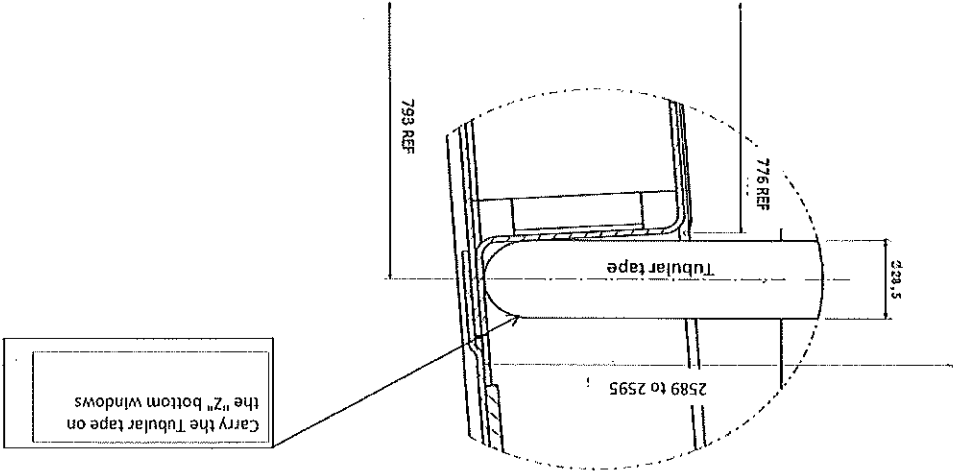
Twist measured in transversal and longitudinal = Maximum 3mm. Measure twist on air spring plates (LHS and RHS), both End 1 and End 2 following twist measurement document.



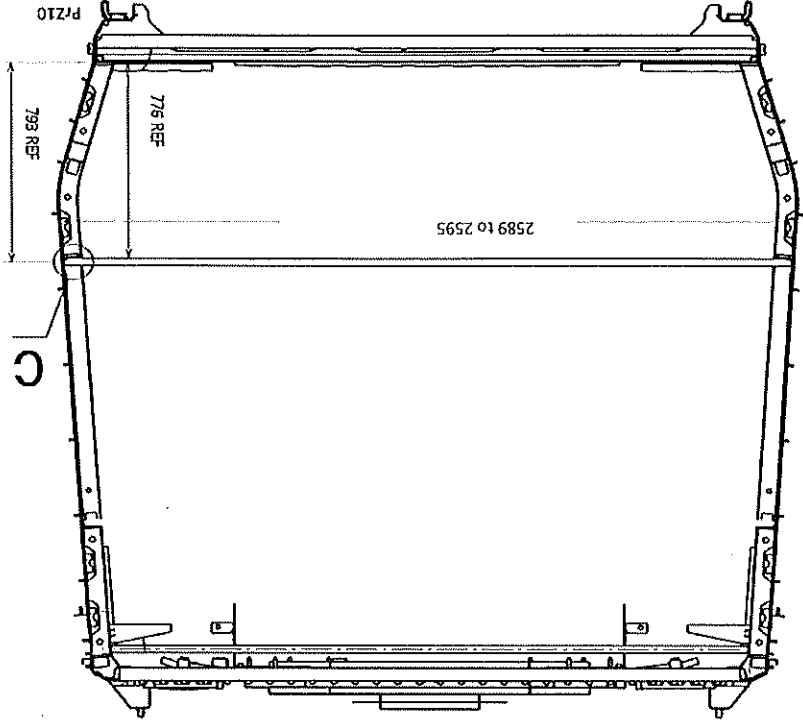
3	LONGITUDINAL
0	TRANSVERSE
TWIST FOUND ON END 1	
0	LONGITUDINAL
3	TRANSVERSE
TWIST FOUND ON END 2	

 CIBEL	CARBODYSHELL M1,M3,M4 ASSEMBLY		DT00000226487
	Rev.	29	
	Date	14/04/2023	
Project: PRASA		SI.CB2230.256.V29	

Specifications of Details for CBS measurement CB1230



Detail C



Assembling boiler : Boitumele
Welder : Zanele

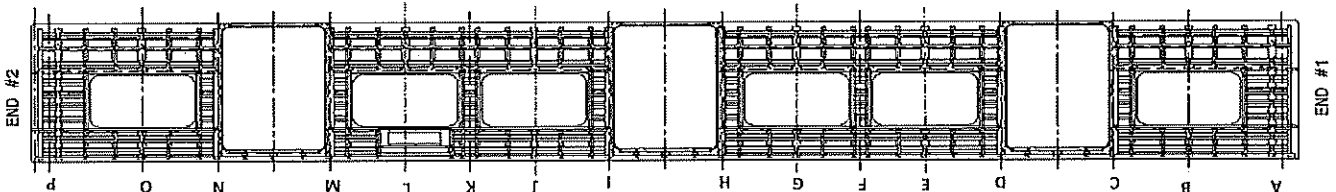


Dye-penetration test to be performed by quality personnel

Dye penetrant test

Threshold verification		Nominal value : 38	
Door 1	L	38	R
	R	38	L
Door 2	L	38	R
	R	38	L
Door 3	L	38	R
	R	38	L
Door 4	L	38	R
	R	38	L
Door 5	L	38	R
	R	38	L
Door 6	L	38	R
	R	38	L

- P 2589
 - O 2589
 - N 2592
 - M 2595
 - L 2595
 - K 2594
 - J 2595
 - I 2593
 - H 2592
 - G 2595
 - F 2595
 - E 2595
 - D 2593
 - C 2589
 - B 2590
 - A 2595
- 2589 to 2595mm



GIBELD


CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487


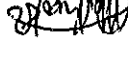
Rev. 29
Date 14/04/2023

Project: PRASA
SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230

[illegible]


 CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000226487	Rev.	29	Project: PRASA SI.CB2230.256.V29
	Date	14/04/2023	
	Self Inspection - Final Result		

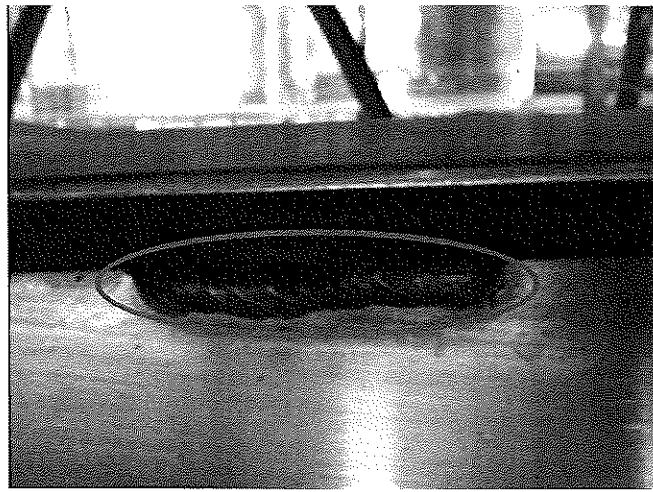
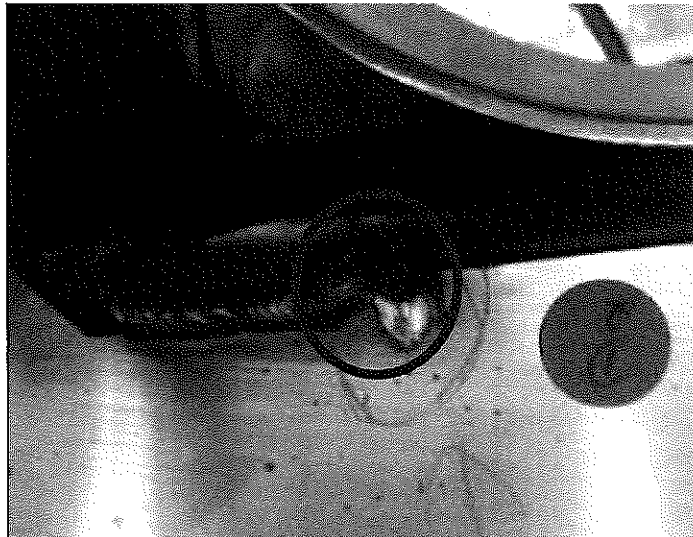
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	GO	activities must not impact the next stage)	08/02/24	Lepato		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party)	02/02/24	Richard		
		There are activities pending that impact the activities of the next process		Operations		
		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		

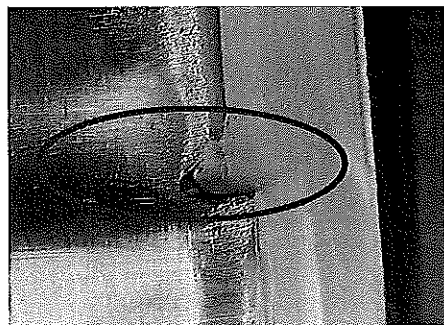
Operations

Quality


ANNEXURE A: Arc Welding Quality Acceptance Standard

		CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000226487	Rev. 29	Date 14/04/2023	Project: PRASA SI.CB2230.256.V29
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ANNEXURE B: Sealant

	CARBODYSHELL M1,M3,M4 ASSEMBLY		Rev. 29	Project: PRASA	SI.CB2230.256.V29
	DT00000225487				
	Date				
		14/04/2023			