

CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 423

WEIGHT: 1492 Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegamex	19/12/23	F110326 VF1E8917	178247 104525 01	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegamex	12/01/24	V29257 VF1L70752	176226 103023 01	
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegamex	19/01/24	P208120 VF1L97574	177336 103052 01	
RCS 355	20 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegamex	19/12/23	D320051 VF1L9780		
RCS 355	30 mm					

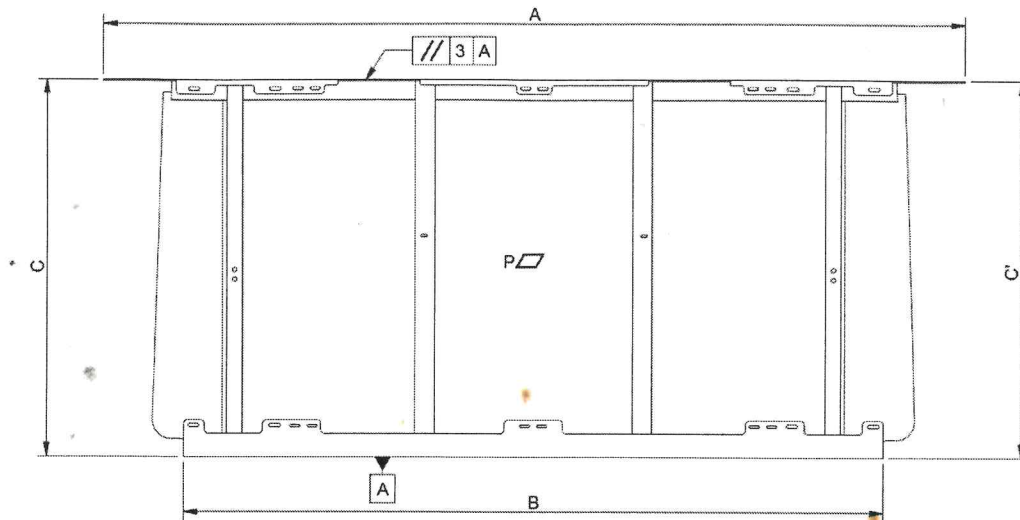
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegamex	19/12/23	F207905 VF1L651923	175252 102206 01	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm				171486 102206 01	
RCS 450	6 mm					
RCS 450	6 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegamex	19/12/23	F201030 VF1L545762	179560 102206 01	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

Cabin Roof Assembly: GN002839


Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	DYLAN DAVIDS	Assembly Date:	20 23 / 12 / 07	
Sign:		Wire Batch No.:	1072 58201	




Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	LEON	Sign:		Date: 20 23 / 12 / 07

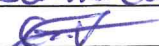
Dimensional Control

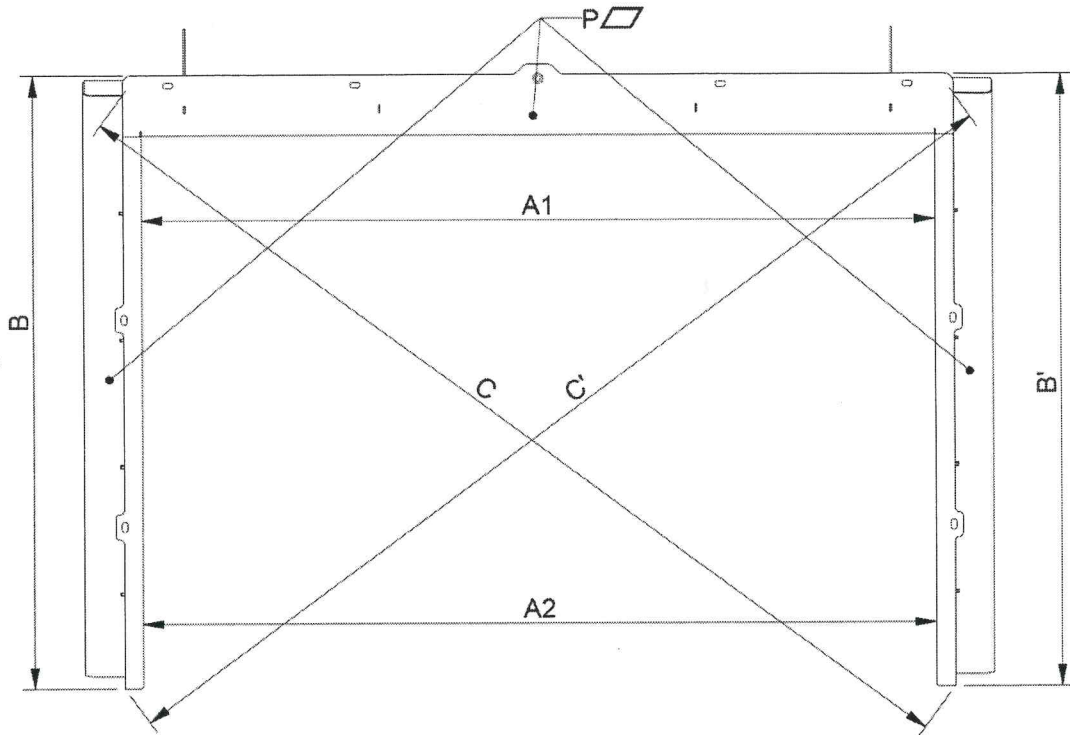
Rep		Toler.	Dimension measured		Measuring Equipment	Observations
A	2216	+5/-0	2216		Tape Measure	Acceptable
B	1800	± 4	1800			Acceptable
C	976	+2/-3	976	976		Acceptable
QC Inspector:		LEON		Sign:		Date: 20 23 / 12 / 07




Geometrical Control

Nature of Checks		Dimension Measured	Measuring Equipment	Observations
Planeity P	6 mm	Passed	Ruler	Acceptable
//	3	A PASSED	Set Square	Acceptable
QC Inspector:		LEON		Sign:  Date: 20 23 / 12 / 07


Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Bambello Gahan.	Assembly Date:	20_23/12/07			
Sign:		Wire Batch No.:	2202152			




Welding Control						
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042			Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	LEON	Sign:		Date:	20_23/12/07	
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	1910	± 2	1912		Tape Measure	Acceptable
A2	1910		1911			Acceptable
B	1475	± 1	1475	1475		Acceptable
C	Diagonals C - C' ≤ 3		2478	2475		Acceptable
QC Inspector:	LEON	Sign:		Date:	20_23/12/07	
Geometrical Control						
Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P : Planeity	4 mm	Passed		Ruler	Acceptable	
QC Inspector:	LEON	Sign:		Date:	20_23/12/07	

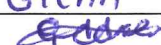
Cabin LHS/RHS Wing Mirror Plate Assembly: GN002846/GN002844

Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	TKB	Assembly Date:	2023/12/00			
Sign:		Wire Batch No.:	2202152			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

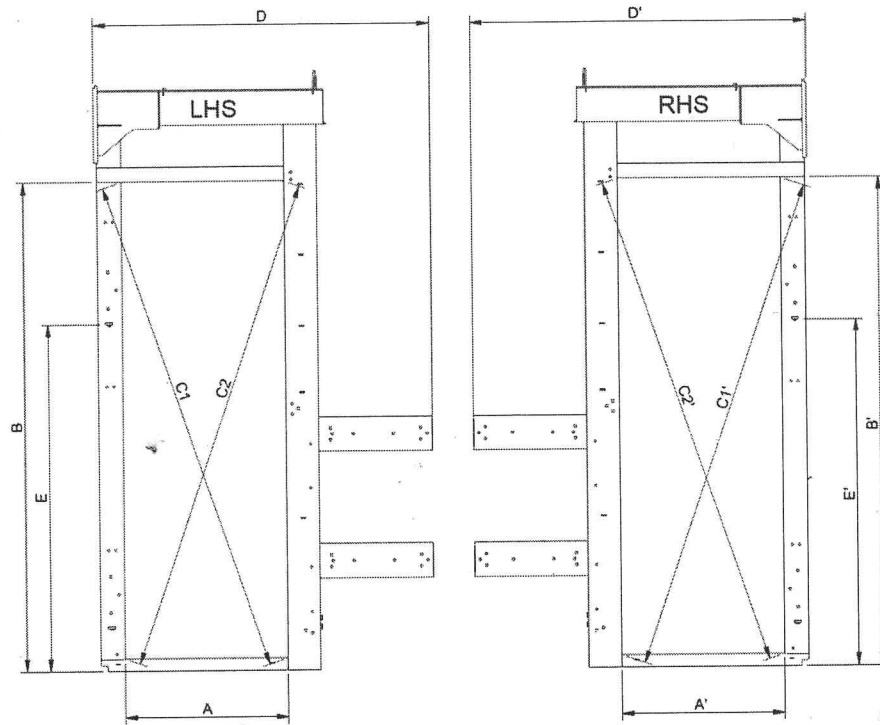
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	2023/12/04			
Sign:		Wire Batch No.:	2202152			

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	2023/12/04			
Sign:		Wire Batch No.:	2202152			

Cabin LHS/RHS Door Frame Assembly: GN002839

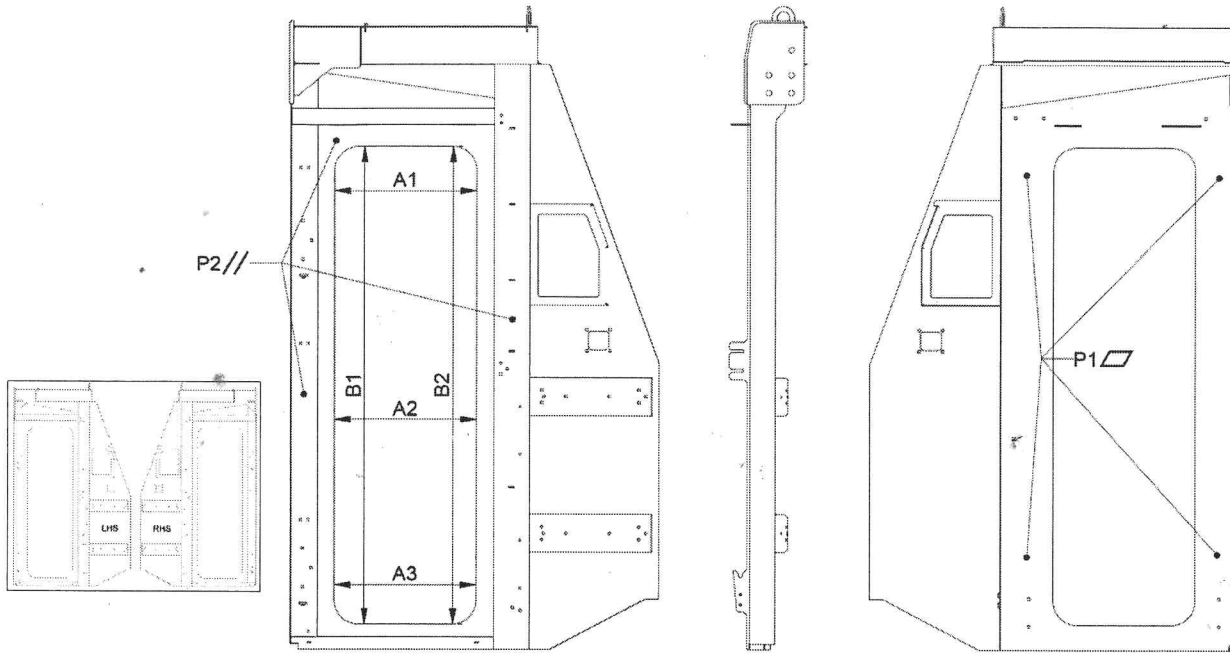
Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	2023/12/06			
Sign:		Wire Batch No.:	2202152			



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: 2023/12/07
Dimensional Control							
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	695	± 2	695	696	Tape Measure	696	Acceptable
B	2086	+1/-3	2085	2086		2086	Acceptable
C1 / C2	Difference of diagonals C1 - C2 ≤ 3		2154	2155		2155	Acceptable
C1 - C2			2152	2155		2155	Acceptable
D	1438	+2/-3	1440	1440		1440	Acceptable
E			1482	1484			Acceptable
QC Inspector:		LEON		Sign:			Date: 2023/12/07
Geometrical Control							
Nature of checks			Dimension Measured		Measuring Equipment	Observations	
P1 : planeity of 2 edges		4 mm	PASSEO		Ruler	Acceptable	
QC Inspector:		LEON		Sign:			Date: 2023/12/07

Cabin LHS/RHS Side Assembly: GN002838/GN002837


Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>xamke</i>	Assembly Date:	20 <u>23</u> / <u>12</u> / <u>07</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			




Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>23</u> / <u>12</u> / <u>08</u>	

Dimensional Control

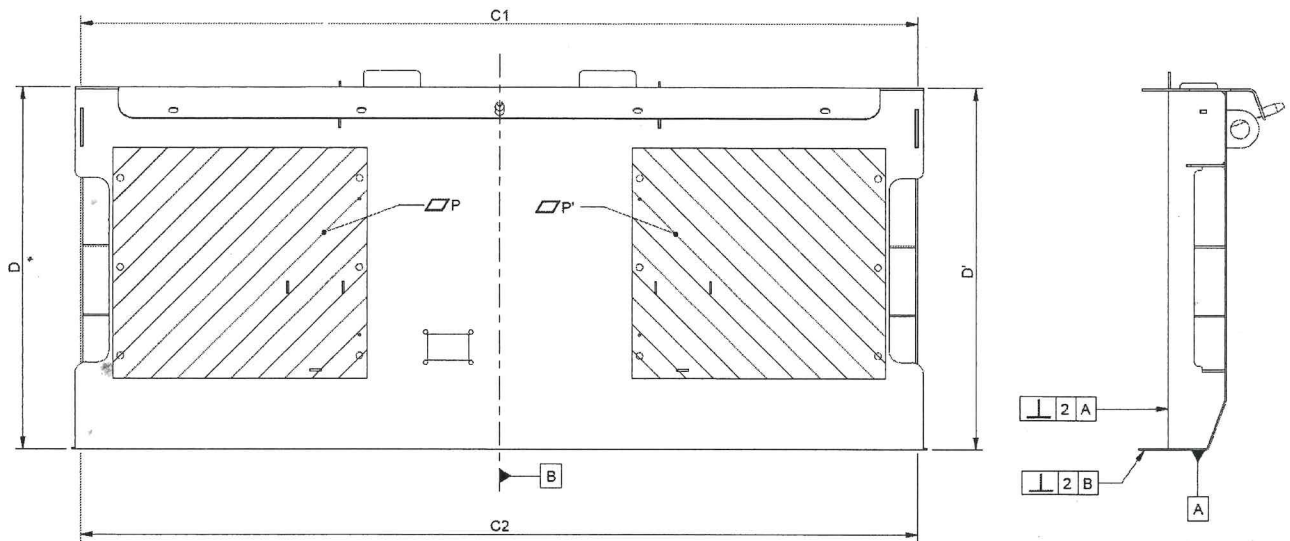
Rep	Theorical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	560	± 2	558	558	Tape Measure	Acceptable	
A2			559	559		Acceptable	
A3			559	559		Acceptable	
B1	1900	± 2	1898	1898		Acceptable	
B2			1898	1898		Acceptable	
QC Inspector:		Leon		Sign:		Date:	2023/12/08

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations	
P1 : Planeity	4 mm	Passed	Ruler	Acceptable	
P2 : Planeity	2 mm	Passed	Ruler	Acceptable	
QC Inspector:	LEON	Sign:		Date:	20 ²³ /12/08

Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>SOVAN J. JASEN HILL</i>	Assembly Date:	2022/12/02	
Sign:		Wire Batch No.:	2202152	



Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date: 2023/12/07

Dimensional Control

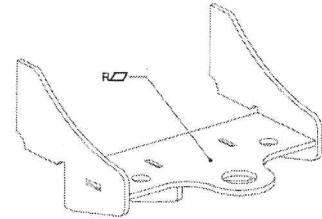
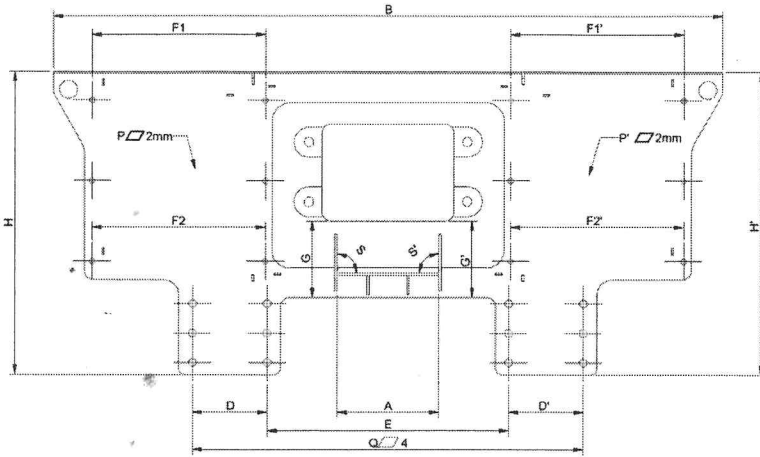
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2211	2212	Tape Measure	<i>Acceptable</i>
D / D'	956	± 2	955	955		<i>Acceptable</i>
QC Inspector:	<i>LEON</i>		Sign:		<i>[Signature]</i>	Date: 2023/12/07

Geometrical Control

Nature of Checks			Dimension Measured	Measuring Equipment	Observations
Planity P / P'		2 mm	<i>Passo</i>	Ruler	<i>Acceptable</i>
Perpendicularity	2	A	<i>Passo</i>	Set Square	<i>Acceptable</i>
	2	B	<i>Passo</i>	Set Square	<i>Acceptable</i>
QC Inspector:	<i>LEON</i>		Sign:		<i>[Signature]</i>
					Date: 2023/12/07

Cabin Front Headstock Assembly: GN002841


Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	No
Operator:	TK Boodu	Assembly Date:	20 ²³ / ₁₂ / ₀₈	
Sign:	<i>[Signature]</i>	Wire Batch No.:	B...	




Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	Leon	Sign:	<i>[Signature]</i>	Date: 20 ²³ / ₁₂ / ₀₈

Dimensional Control

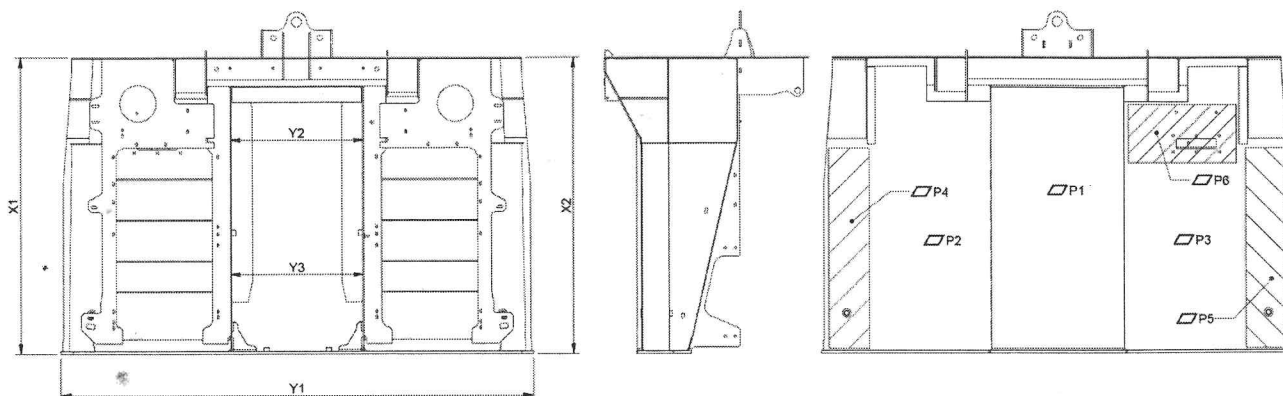
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	340	± 1	340		Tape Measure	Acceptable	
B	2240	± 4	2244			Acceptable	
D / D'	250	± 1	250.5	250.5		Acceptable	
E	808	± 2	808			Acceptable	
F1 / F1'	580	± 1	581	581		Acceptable	
F2 / F2'			581	581		Acceptable	
G / G'	258	± 1	258	257		Acceptable	
H / H'	1019	± 2	1020	1020		Acceptable	
QC Inspector:		Leon		Sign:		Date:	20 <u>23</u> / <u>12</u> / <u>08</u>

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations	
O: Planeity of global assembly	4 mm	Passed	Ruler	Acceptable	
P / P': Planeity	2 mm	Passed	Ruler	Acceptable	
Q: Planeity Surface of Supports	4 mm	Passed	Ruler	Acceptable	
R: Planeity Coupler Support	2 mm	Passed	Ruler	Acceptable	
S: Perpendicularity coupler	1mm	Passed	Square	Acceptable	
QC Inspector:	Leon	Sign:		Date:	20 ²³ / ¹² / ⁰⁸


Cabin Underframe Assembly: GN002835

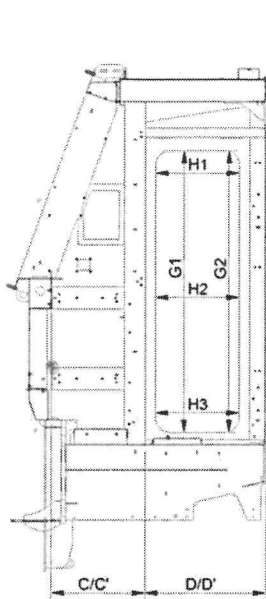
Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes		No
Operator:	<i>Michael Wood</i>	Assembly Date:	20 <u>23</u> / <u>12</u> / <u>07</u>		
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152		



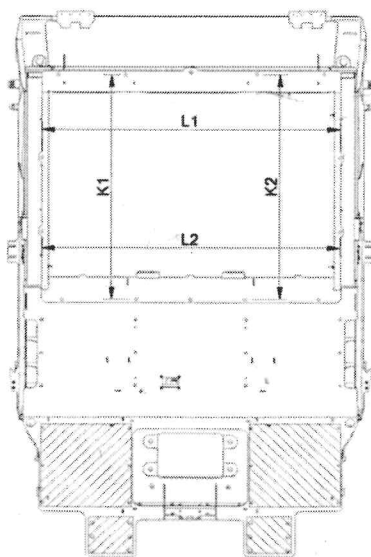
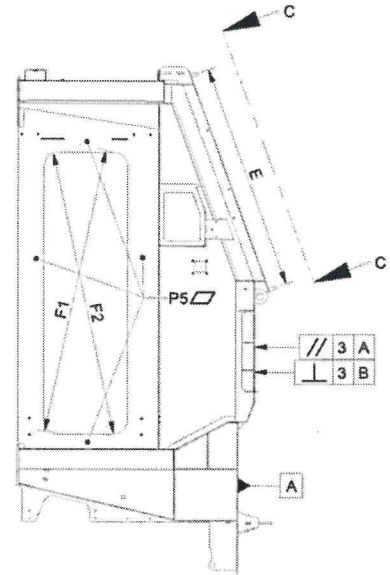
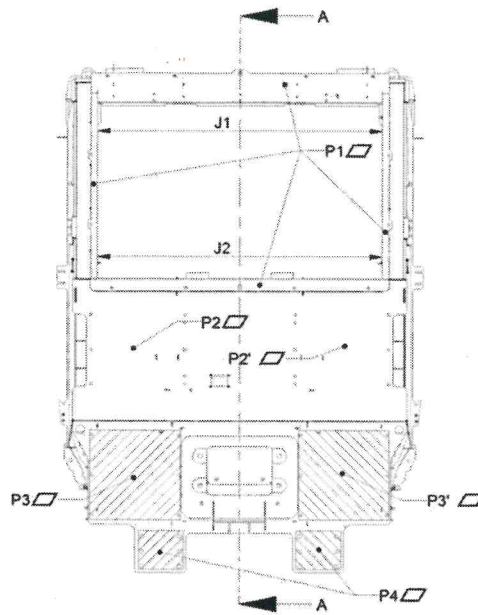
Welding Control						
Assembly Completed as per WI/SOS MD_0042			Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>23</u> / <u>12</u> / <u>07</u>	
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	<i>1487</i>	<i>1487</i>	Tape Measure	<i>Acceptable</i>
Y 1	2354	± 3	<i>2354</i>			<i>Acceptable</i>
Y2 / Y3	666	± 1	<i>667</i>	<i>667</i>		<i>Acceptable</i>
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>23</u> / <u>12</u> / <u>07</u>	
Geometrical Control						
Nature of checks			Dimension Measured	Measuring Equipment	Observations	
P1 : Planeity	4 mm		<i>Pass</i>	Ruler	<i>Acceptable</i>	
P2 / P3 : Planeity	4 mm		<i>Pass</i>	Ruler	<i>Acceptable</i>	
P4 / P5 : Planeity	2 mm		<i>Pass</i>	Ruler	<i>Acceptable</i>	
P6 : Planeity	2 mm		<i>Pass</i>	Ruler	<i>Acceptable</i>	
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>12</u> / <u>07</u>	

Cabin Structure Assembly: GN002834

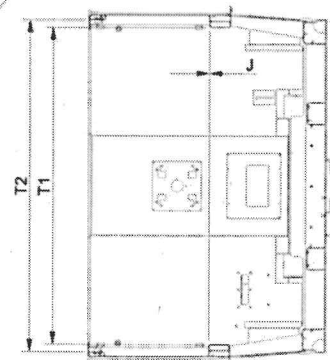
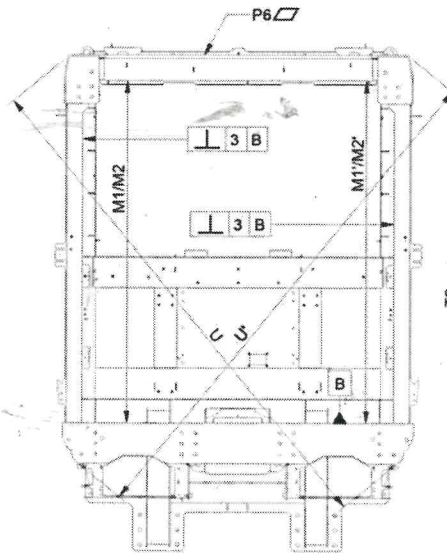
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:	CHARL BLOOM	Assembly Date:	20 23/12/07		
Sign:		Wire Batch No.:	2202152		



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:		Bridley		Sign:		Bridley		Date: 2023/12/12	
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	625	625	Acceptable				
D / D'	813	± 2,5	813	813	Acceptable				
E	1531.5	± 3	1529		Acceptable				
G1 / G'1	Height	+1	1898	1900	Acceptable				
G2 / G'2	1900	-3	1899	1899	Acceptable				
H1 / H'1	Width 560	+1	557	557	Acceptable				
H2 / H'2		-3	558	559	Acceptable				
H3 / H'3		558	560	Acceptable					
F1 / F'1*	Diagonals 1939		1937	1937	Acceptable				
F2 / F'2			1935	1935	Acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	3	3	Acceptable				
J	Gap of Doors	± 1,5	0		Acceptable				
K1 / K2	1515	± 3	1517	1515	Acceptable				
L1 / L2	1996	± 3	1995	1995	Acceptable				
M1 / M'1	2306	± 3	2473	2471	Acceptable				
M2 / M'2			2466	2467	Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2130	2131	Acceptable				
T2 / T'2	2230 Top/Bottom		2231	2231	Acceptable				
Difference	U - U' (3522)	≤ 4mm							
QC Inspector:		Bridley		Sign:		Bridley		Date: 2023/12/12	
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:		Bridley		Sign:		Bridley		Date: 2023/12/12	

Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091	Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Chad Bloom	Assembly Date:	20 23 / 12 / 22		
Sign:		Wire Batch No.:	2202452		


Cabin Rivnut Assembly: GN002832

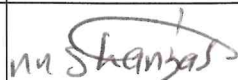
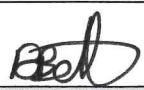

Assembly Completed as per WI/SOS MD_0092	Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
Operator:		Assembly Date:	20 __ / __ / __		
Sign:		Wire Batch No.:			

Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Fasteners positioned in all Rivnuts and Bosses	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Masked as per GMS-SOS-GIBELA-CABIN-001	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID	Sign:		TD [Signature]	
Date:	2024/01/27				
Record of Shot Blasting					
Operator:		Date:	2024/01/27		
Start Time:	07 HOS	End Time:	10 H30		
Temperature ($\geq 15^\circ$):	20 - 02 %	Humidity ($\leq 75\%$):	65 - 01 %		
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:	2024/01/27				
Shot Blasting Cleaning					
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID	Sign:		TD [Signature]	
Date:	2024/01/27				
Shot Blasting Control					
Temperature $\geq 15^\circ$:	23 - 09 %	Humidity $\leq 75\%$:	62 - 04 %		
Internal Roughness $3.2 \leq Ra \leq 12.5$	As Per Example	External Roughness $3.2 \leq Ra \leq 12.5$	As Per Example		
QC Inspector:	Leon	Sign:		A	
Date:	07/01/24				

Record of Priming									
Start Time:		2:00		End Time:		4:00			
Temperature $\geq 15^{\circ}$:		25C		Humidity $\leq 75\%$:		49%			
Paint Batch No.:		7296866		Paint Expiry Date:		6/5/2024			
Hardener Batch No.:		7287752		Hardener Expiry Date:		15/04/2024			
Desolvation Start Time:		4:00		Desolvation End Time:		4:15			
Stoving Start Time:		4:15		Stoving End Time:		5:15			
Stoving Temp:		60C							
Operator:		CRNIG		Sign:		CRNIG			
Date:		20/01/27							
Priming Control									
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front			
1: 64.3	5: 44.8	1: 65.7	5: 41.6	1: 71.8	5: 61.0	1: 71.7	5: 51.7		
2: 72.1	6: 51.7	2: 63.8	6: 78.1	2: 55.4	6: 48.3	2: 56.9	6: 61.1		
3: 72.8	7: 59.6	3: 60.1	7: 78.0	3: 42.0	7: 58.9	3: 68.0	7: 46.9		
4: 79.7	8: 71.1	4: 69.7	8: 42.2	4: 63.8	8: 73.8	4: 70.4	8: 41.4		
Min:	51.7	Min:	41.6	Min:	42.0	Min:	41.4		
Max:	79.7	Max:	78.0	Max:	73.8	Max:	71.7		
Average:	63.8	Average:	62.6	Average:	59.3	Average:	58.4		
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside			
1: 78.5	5: 54.3	1: 76.1	5: 80.1	1: 74.0	5: 73.8	1: 74.2	5: 54.6		
2: 77.5	6: 61.9	2: 81.5	6: 68.5	2: 73.8	6: 78.5	2: 63.1	6: 61.1		
3: 78.0	7: 41.7	3: 80.4	7: 64.6	3: 84.1	7: 69.0	3: 41.8	7: 70.0		
4: 42.3	8: 65.7	4: 71.8	8: 83.1	4: 64.4	8: 43.2	4: 53.7	8: 68.9		
Min:	41.7	Min:	64.6	Min:	43.2	Min:	41.8		
Max:	78.5	Max:	83.1	Max:	78.5	Max:	74.2		
Average:	62.7	Average:	76.4	Average:	70.7	Average:			
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS			
1: 48.6	5: 51.9	1: 71.0	5: 49.4	1: 84.6	5: 64.3	1: 64.3	5: 41.8		
2: 72.5	6: 67.9	2: 61.6	6: 62.1	2: 89.7	6: 72.8	2: 81.7	6: 69.2		
3: 55.2	7: 69.9	3: 85.9	7: 70.8	3: 81.9	7: 79.3	3: 74.2	7: 77.5		
4: 75.6	8: 49.8	4: 65.6	8: 78.5	4: 76.7	8: 75.8	4: 70.7	8: 82.6		
Min:	48.6	Min:	49.4	Min:	64.3	Min:	41.8		
Max:	75.6	Max:	85.9	Max:	89.7	Max:	82.6		
Average:		Average:	68.1	Average:	78.5	Average:	70.2		
Primer has been inspected and is free of defects				Confirmed		Yes		No	
QC Inspector:		Zothib		Sign:		H. Ouy			
Date:		30.01.2024							

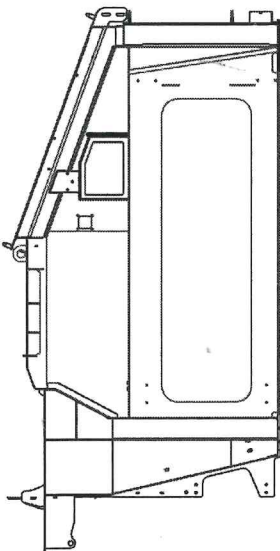
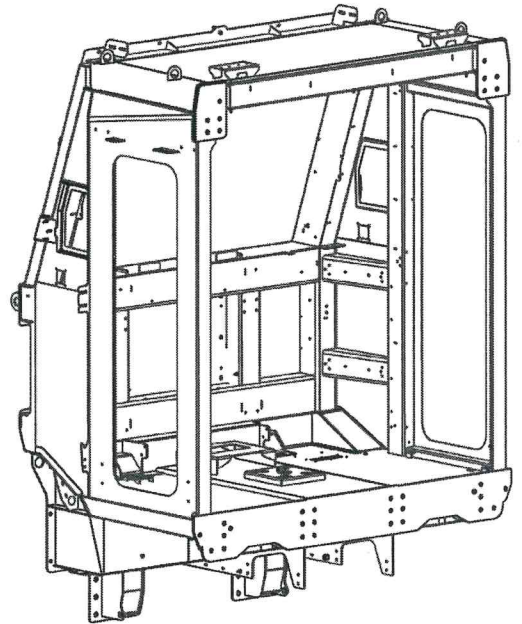
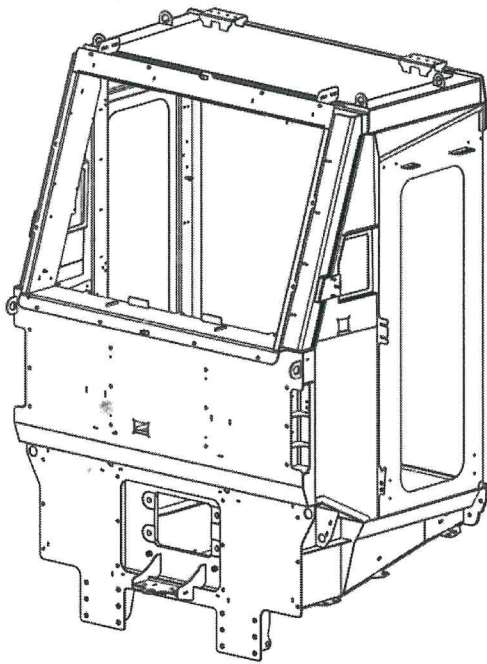
Record of Painting NCSS3010 R90B					
Start Time:				End Time:	
Temperature $\geq 15^{\circ}$:		25.2		Humidity $\leq 75\%$:	
Paint Batch No.:		8136210		Paint Expiry Date:	
Hardener Batch No.:		72504 79041		Hardener Expiry Date:	
Desolvation Start Time:				Desolvation End Time:	
Stoving Start Time:				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: 106.4	5: 111.6	1: 107.2	5: 140.8		
2: 13.4	6: 79.8	2: 114.3	6: 113.4		
3: 186.9	7: 96.8	3: 120	7: 107.4		
4: 180.1	8: 109.1	4: 96.8	8: 90.6		
Min:	79.8	Min:	90.6		
Max:	186.9	Max:	140.8		
Average:	106.5	Average:	111.3		
Painting NCSS3010 R90B has been inspected and is free of defects					
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	39.8
QC Inspector:		Reece		Sign:	
Date:		31/01/24			

Record of Painting Blue NCSS1565 B								
Start Time:				End Time:				
Temperature $\geq 15^{\circ}$:				Humidity $\leq 75\%$:				
Paint Batch No.:		8032294		Paint Expiry Date:				
Hardener Batch No.:		7290479041		Hardener Expiry Date:				
Desolvation Start Time:				Desolvation End Time:				
Stoving Start Time:				Stoving End Time:				
Stoving Temp:								
Operator:				Sign:				
Date:		20 __/__/__						
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: 113.6	5: 120.9	1: 114.8	5: 116.8					
2: 112.4	6: 119.6	2: 102.6	6: 120.8					
3: 86.7	7: 90.8	3: 120.6	7: 146.8					
4: 146.8	8: 74.6	4: 131.8	8: 136.9					
Min:	74.6	Min:	102					
Max:	146	Max:	146.8					
Average:	108.1	Average:	123.8					
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	93.6			
QC Inspector:		Reece		Sign:				
Date:		31/01/24						

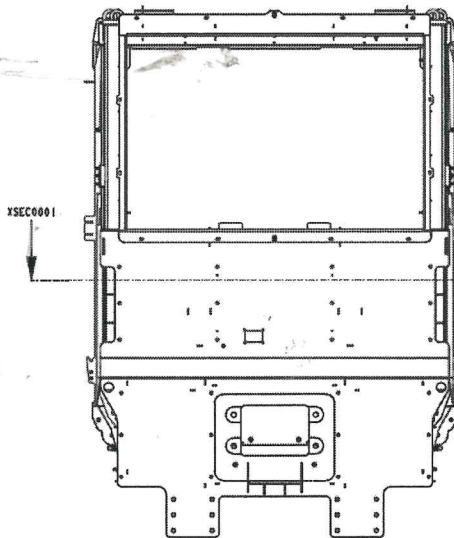
Record of RAL 7012							
Start Time:		02:00		End Time:		06:00	
Temperature $\geq 15^{\circ}$:		25°C		Humidity $\leq 75\%$:		34%	
Paint Batch No.:		8096599		Paint Expiry Date:		21/09/2024	
Hardener Batch No.:		725047941		Hardener Expiry Date:		04/2024	
Desolvation Start Time:		06:00		Desolvation End Time:		06:15	
Stoving Start Time:		06:15		Stoving End Time:		07:15	
Stoving Temp:		60°C					
Operator:		Ntuthuko		Sign:			
Date:		20/01/30					
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 106.9	5: 124.6	1: 124.3	5: 96.8	1: 124.8	5: 101.3	1: 81.2	5: 76.9
2: 177.6	6: 131.6	2: 116.4	6: 76.8	2: 138.8	6: 81.2	2: 104.3	6: 112.6
3: 161.8	7: 143.1	3: 90.8	7: 102.4	3: 149.5	7: 79.6	3: 114.6	7: 126.8
4: 122.6	8: 116.8	4: 113.8	8: 160.6	4: 160.6	8: 176.9	4: 113.8	8: 136.9
Min:	102	Min:	76.8	Min:	79.6	Min:	96.9
Max:	167	Max:	160.6	Max:	160	Max:	136
Average:	133.1	Average:	108.9	Average:	126.5	Average:	108.3
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 111	5: 124	1: 141.1	5: 140.7	1: 129.7	5: 116.8	1: 112.6	5: 108.3
2: 89.6	6: 169.8	2: 126.9	6: 103.4	2: 161.8	6: 98.1	2: 93.7	6: 69.8
3: 113.6	7: 134.2	3: 84.1	7: 79.6	3: 166.8	7: 102.3	3: 77.8	7: 84.5
4: 124.8	8: 118.6	4: 116.8	8: 128.8	4: 102.6	8: 145.1	4: 86.4	8: 85.4
Min:	89.6	Min:	84.1	Min:	98.1	Min:	69.8
Max:	169.8	Max:	141	Max:	166	Max:	112
Average:	91.3	Average:	115.1	Average:	130.4	Average:	89.8
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 124.8	5: 116.8	1: 167.8	5: 108.1				
2: 140.8	6: 104.6	2: 69.8	6: 79.4				
3: 134.7	7: 161.8	3: 116.8	7: 104.7				
4: 97.8	8: 99.8	4: 103.2	8: 117.8				
Min:	97.8	Min:	79.4				
Max:	161.8	Max:	167				
Average:	122.4	Average:	108.4				
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	48.2		
QC Inspector:		Peece		Sign:			
Date:		31/01/24					
SEALING OF CABIN							
All areas where there is no welding has been sealed with SIKA				Confirmed	YES	<input checked="" type="checkbox"/>	NO
All sealants have been neatly applied along joints				Confirmed	YES	<input checked="" type="checkbox"/>	NO
SIGN OFF							
CLOCK No:	2400	OPERATOR SIGN:		DATE:	31/01/24		

REWORK IDENTIFICATION

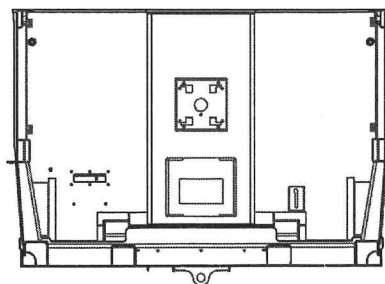
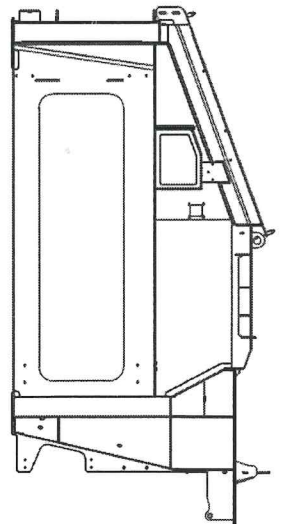
(MARK SECTIONS EFFECTED NUMERICALLY)



XSEC0001



XSEC0001

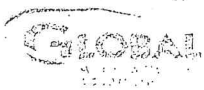


FAULT TRACKING

DESCRIPTION	LOCATION ON CAB	REWORKED BY (COMPANY NUMBER)	QC VALIDATED

REMINDERS / COMMENTS

DEPARTMENT	DETAILS OR COMMENT
	Primer details not recorded on time.



CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	423	Checks Updated:	2021/07/07

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

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

Quality approval for release Signature	CO. NO:	DATE
Prevo	2241	2/01/24