

CABIN STRUCTURE QUALITY CARD

CAB No.: CAB_426

WEIGHT: 1487

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Regulus	12/12/13	F110326 VITE 89171	176047 104825 01	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Regulus	17/10/14	V209257 V=K17756	176226 103223 01	
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Regulus	17/10/14	V206171 VPL47576	177332 103222 01	
RCS 355	20 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Regulus	10/12/13	V332081 VAK 9786		
RCS 355	30 mm					

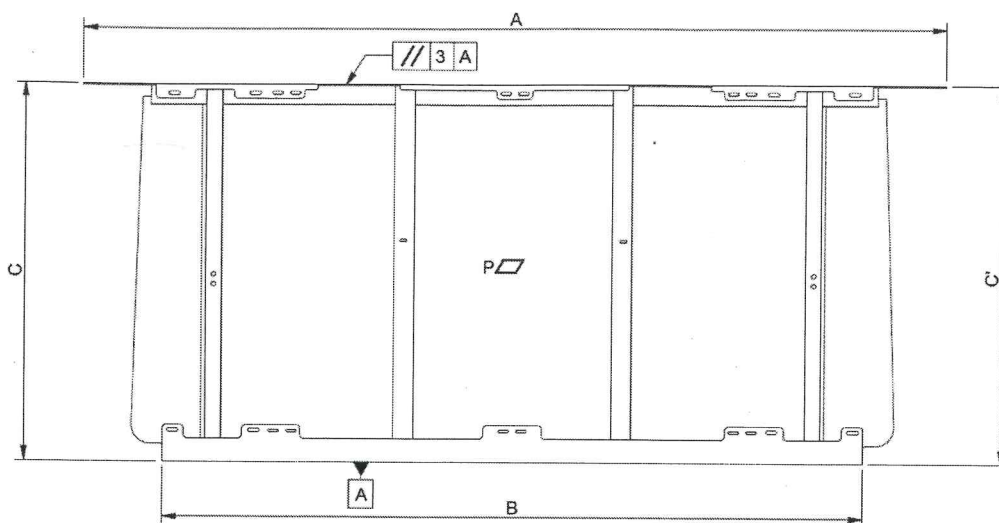
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Regulus	19/12/14	F207405 VH651973	175052 12206 01	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm				176046 12206 01	
RCS 450	6 mm					
RCS 450	6 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Regulus	14/12/14	F201739 VH655762	175469 12206 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	<input type="checkbox"/>
Operator:	DYLAN DAVIDS	Assembly Date:	20 24/01/12			
Sign:		Wire Batch No.:	107238201			




Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	LEON	Sign:		Date:	20 24/01/12	

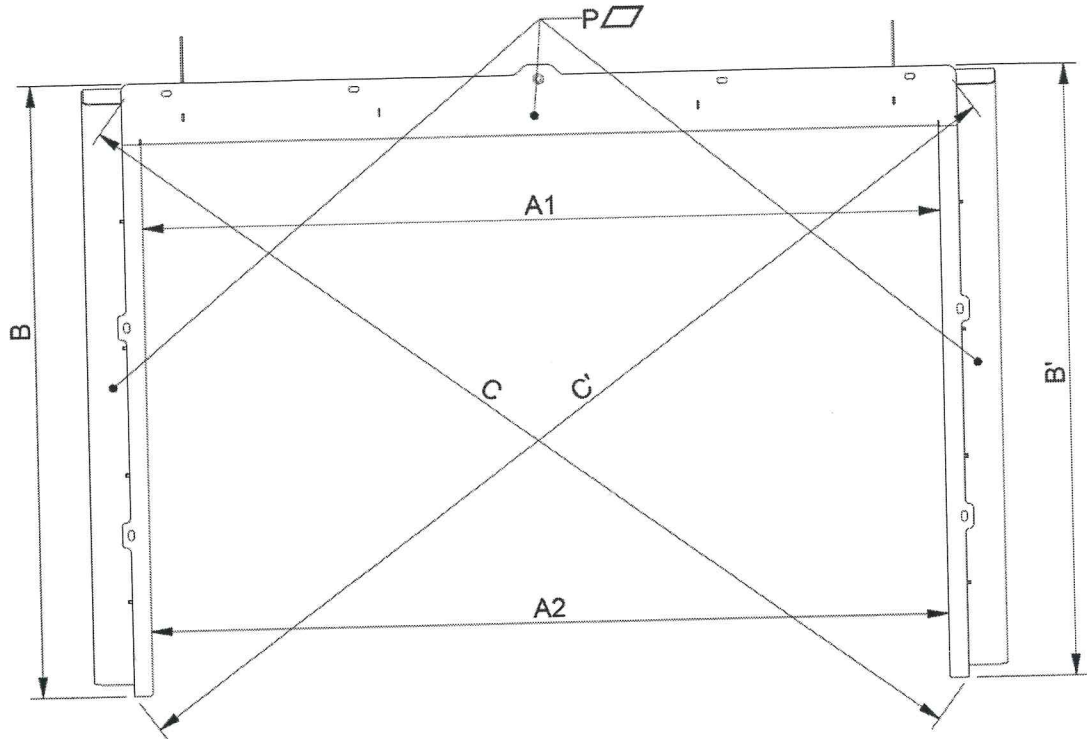
Dimensional Control

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	977		Acceptable
QC Inspector:	LEON	Sign:		Date:	20 24/01/12	

Geometrical Control

Nature of Checks		Dimension Measured	Measuring Equipment	Observations	
Planeity P	6 mm	Pass	Ruler	Acceptable	
//	3	A	Set Square	Acceptable	
QC Inspector:	LEON	Sign:		Date:	20 24/01/12

Cabin Front Frame Assembly: GN002840				
Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	Bambelo G. G. G.	Assembly Date:	2024/01/12	
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:	2024/01/12	
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	1910	± 2	1911		Tape Measure	Acceptable
A2	1910		1912			Acceptable
B	1475	± 1	1475	1475		Acceptable
C	Diagonals C - C' ≤ 3		2476	2477		Acceptable
QC Inspector:	Leon	Sign:		Date:	2024/01/12	
Geometrical Control						
Nature of checks		Dimension Measured		Measuring Equipment		Observations
P : Planeity		4 mm		Ruler		Acceptable
QC Inspector:	Leon	Sign:		Date:	2024/01/12	

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>23</u> / <u>12</u> / <u>18</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

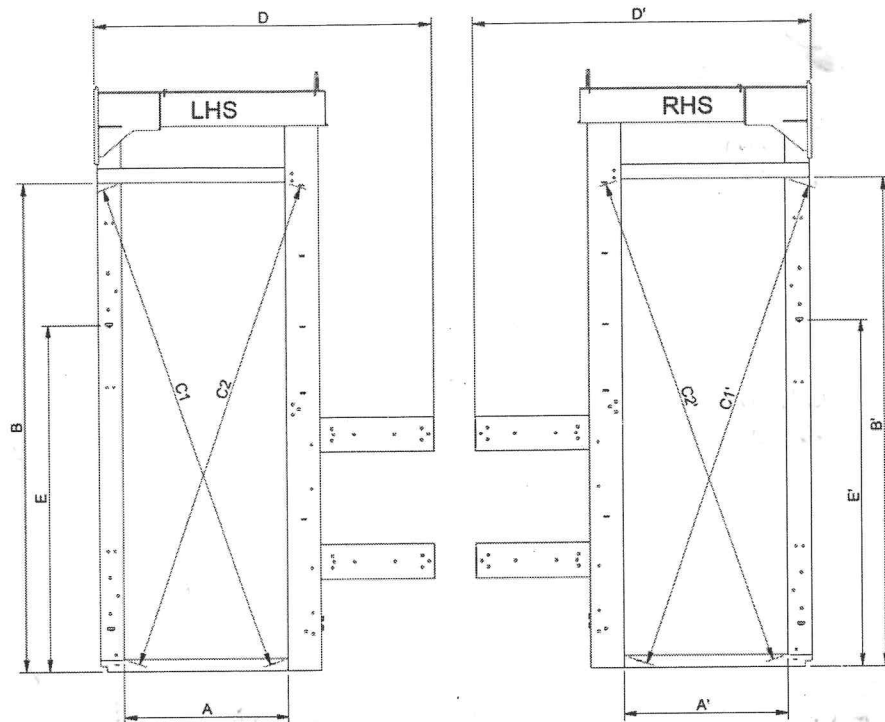
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>Glenn</i>	Assembly Date:	20 <u>23</u> / <u>12</u> / <u>18</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

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:	<i>Glenn</i>	Assembly Date:	20 <u>23</u> / <u>12</u> / <u>18</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

Cabin LHS/RHS Door Frame Assembly: GN002839

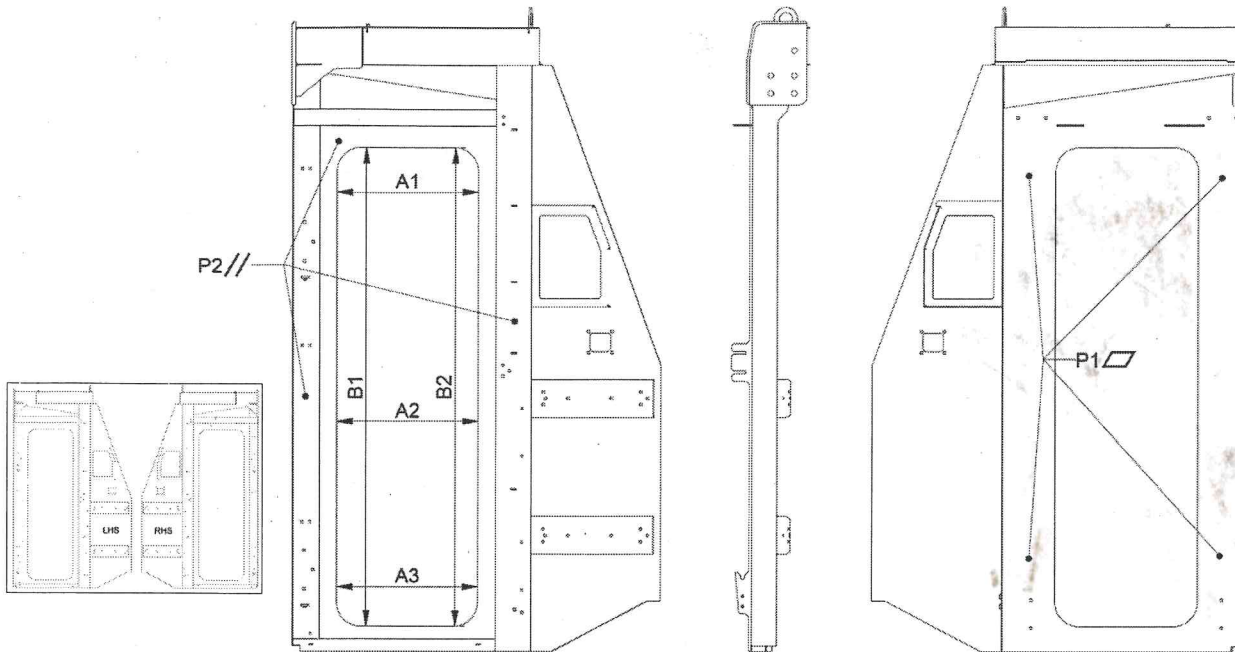
Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	Glenn	Assembly Date:	20 23 /12/18		
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152		



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:		LEON		Sign:	<i>[Signature]</i>	Date:	20 23 /12/19
Dimensional Control							
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	695	± 2	695	695	Tape Measure	Acceptable	
B	2086	+1/-3	2086	2084		Acceptable	
C1 / C2	Difference of diagonals C1 - C2 ≤ 3		2152	2152		Acceptable	
C1 - C2			2154	2154		Acceptable	
D	1438	+2/-3	1438	1439		Acceptable	
E			1483	1484		Acceptable	
QC Inspector:		LEON		Sign:	<i>[Signature]</i>	Date:	20 23 /12/19
Geometrical Control							
Nature of checks			Dimension Measured		Measuring Equipment	Observations	
P1 : planeity of 2 edges		4 mm	P9260		Ruler	Acceptable	
QC Inspector:		LEON		Sign:	<i>[Signature]</i>	Date:	20 23 /12/19

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>Xan</i>	Assembly Date:	20 <u>23</u> / <u>12</u> / <u>18</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>24</u> / <u>01</u> / <u>12</u>

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	559	560	Tape Measure	Acceptable
A2			560	559		Acceptable
A3			560	559		Acceptable
B1	1900	± 2	1898	1898		Acceptable
B2			1898	1898		Acceptable

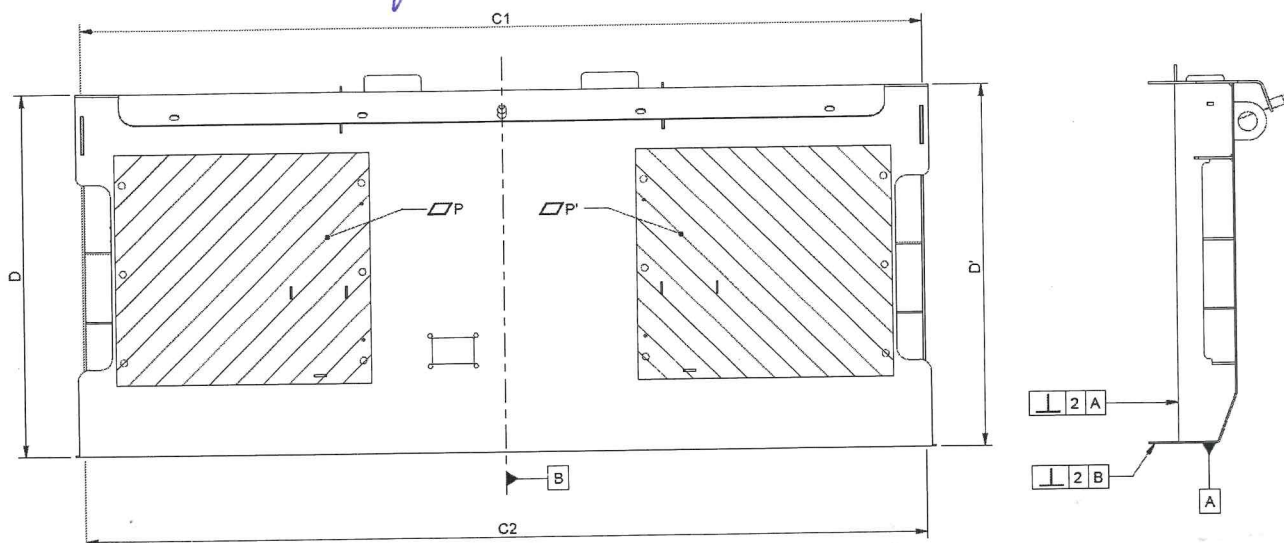
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>01</u> / <u>12</u>
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Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	<i>Passes</i>	Ruler	Acceptable
P2 : Planeity	2 mm	<i>Passes</i>	Ruler	Acceptable
QC Inspector:		Sign:		Date: 20 <u>23</u> / <u>01</u> / <u>12</u>

Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	BEVAN J. JENHILL	Assembly Date:	2023/01/12		
Sign:		Wire Batch No.:	2202152		



Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	LEON	Sign:		Date:	2024/01/12

Dimensional Control

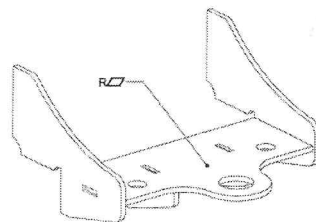
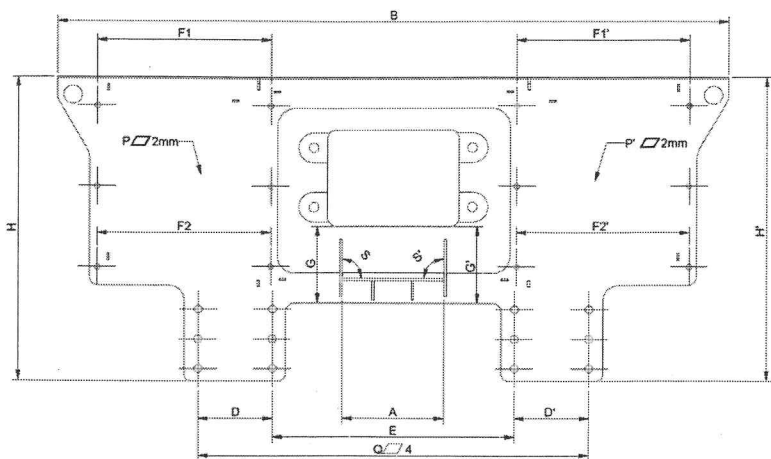
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2212	2211	Tape Measure	Accepted
D / D'	956	± 2	955	955		Accepted
QC Inspector:	LEON	Sign:		Date:	2024/01/12	

Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planeity P / P'			2 mm	Passed	Ruler	Accepted
Perpendicularity	2	A	Passed	Set Square	Accepted	
	2	B	Passed	Set Square	Accepted	
QC Inspector:	LEON	Sign:		Date:	2024/01/12	

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 BODEN	Assembly Date:	2023/12/22			
Sign:	<i>[Signature]</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	<input type="checkbox"/>
QC Inspector:	C. CHATTERTON	Sign:	<i>[Signature]</i>	Date:	20__/__/__	

Dimensional Control

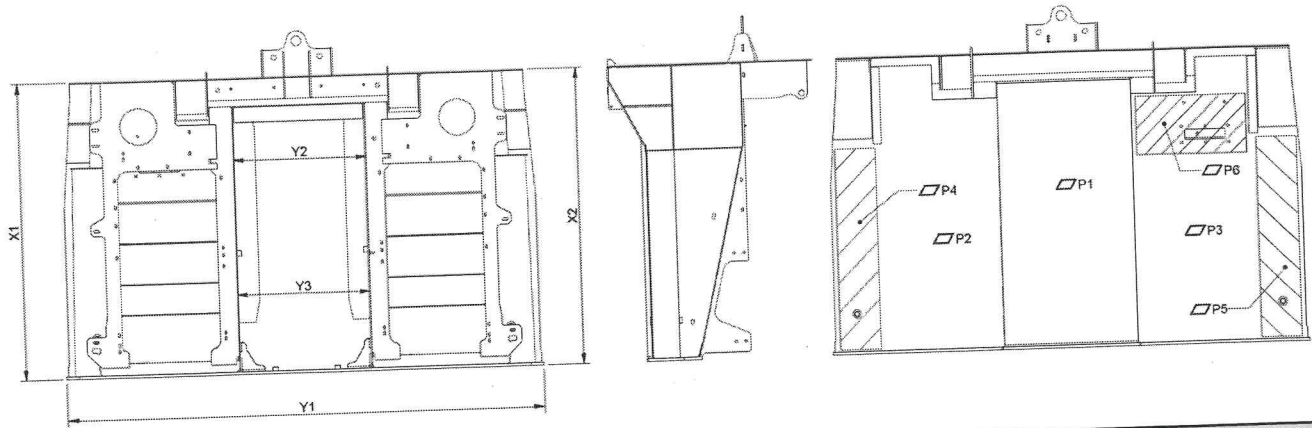
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	± 1	339		Tape Measure	Acceptable
B	2240	± 4	2244			Acceptable
D / D'	250	± 1	250.5	250		Acceptable
E	808	± 2	807			Acceptable
F1 / F1'	580	± 1	581	581		Acceptable
F2 / F2'			581	581		Acceptable
G / G'	258	± 1	257	258		Acceptable
H / H'	1019	± 2	1020	1020		Acceptable
QC Inspector:		C. CHATTERTON		Sign:		Date: 2024/01/08

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:	C. CHATTERTON	Sign:	<i>[Signature]</i>	Date: 2024/01/08


Cabin Underframe Assembly: G^N002835

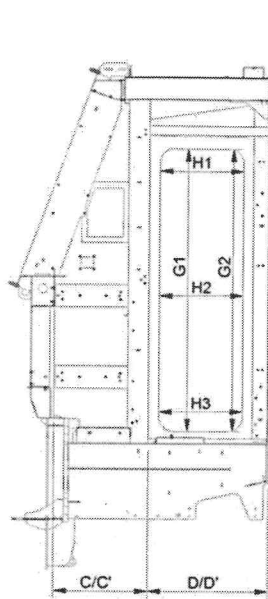
Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	20 <u>24</u> / <u>01</u> / <u>12</u>	
Sign:	<i>[Signature]</i>	Wire Batch No.:	<u>2202152</u>	



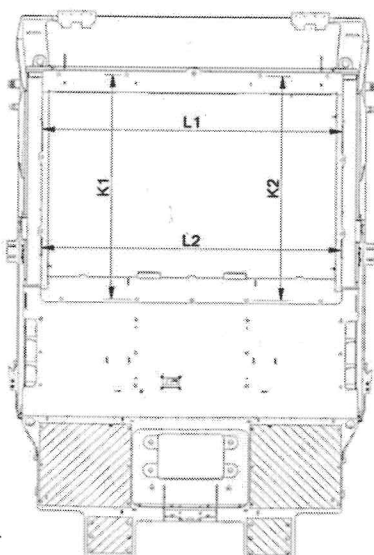
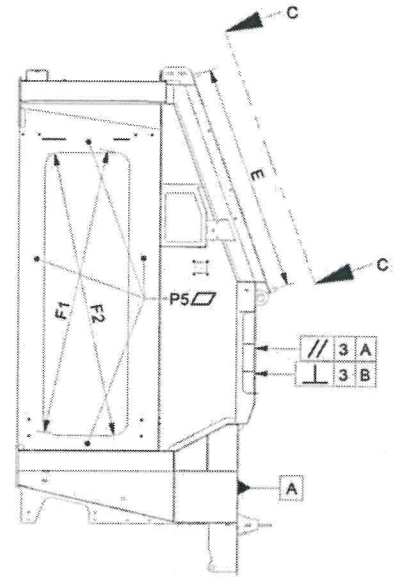
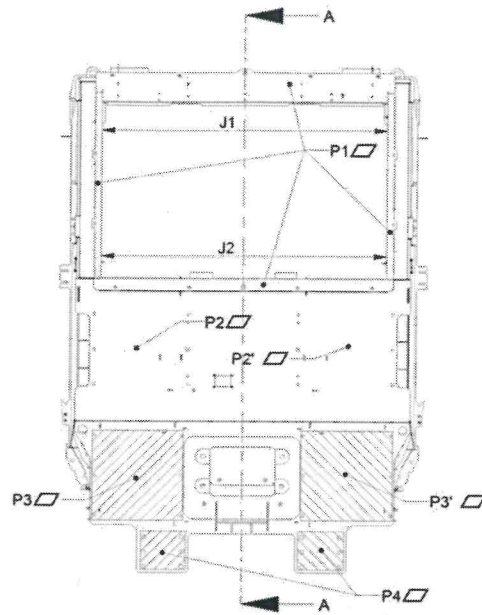
Welding Control						
Assembly Completed as per WI/SOS MD_0042				Confirmed	Yes	No
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>01</u> / <u>12</u>	
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	<i>1486</i>	<i>1485</i>	Tape Measure	<i>Accepted</i>
Y 1	2354	± 3	<i>2354</i>			<i>Accepted</i>
Y2 / Y3	666	± 1	<i>668</i>	<i>667</i>		<i>Accepted</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>01</u> / <u>12</u>	
Geometrical Control						
Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P1 : Planeity	4 mm	<i>Passed</i>		Ruler	<i>Accepted</i>	
P2 / P3 : Planeity	4 mm	<i>Passed</i>		Ruler	<i>Accepted</i>	
P4 / P5 : Planeity	2 mm	<i>Passed</i>		Ruler	<i>Accepted</i>	
P6 : Planeity	2 mm	<i>Passed</i>		Ruler	<i>Accepted</i>	
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>01</u> / <u>12</u>	

Cabin Structure Assembly: GN002834

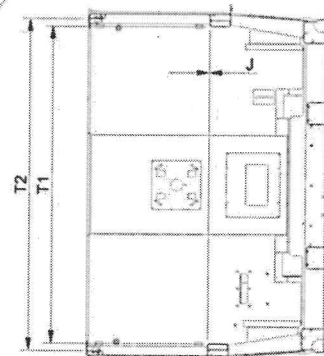
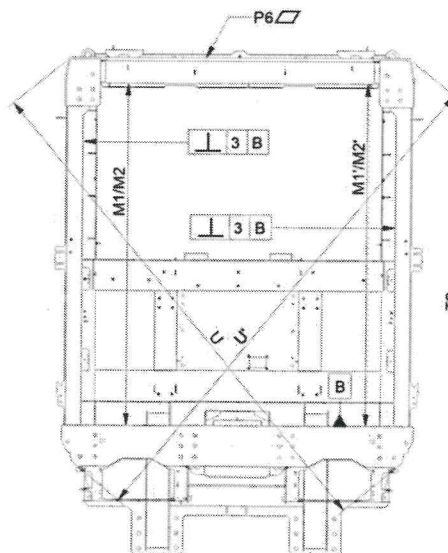
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:	CHARL BLOOM	Assembly Date:	20 24 / 01 / 22		
Sign:		Wire Batch No.:	2202152		



SECTION A-A




AUX VIEW: C



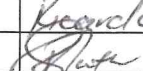
SECTION B-B

Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed		Yes	<input checked="" type="checkbox"/> No	
QC Inspector:		LEON		Sign:				Date:	20_24 / _01 / _15
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	625	625	Acceptable				
D / D'	813	± 2,5	812	812	Acceptable				
E	1531.5	± 3	1531		Acceptable				
G1 / G'1	Height 1900	+1	1897	1898	Acceptable				
G2 / G'2		-3	1898	1898	Acceptable				
H1 / H'1	Width 560	+1 -3	557	557	Acceptable				
H2 / H'2			559	559	Acceptable				
H3 / H'3			559	559	Acceptable				
F1 / F'1	Diagonals 1939		1935	1938	Acceptable				
F2 / F'2			1935	1936	Acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	0	2	Acceptable				
J	Gap of Doors	± 1,5	0		Acceptable				
K1 / K2	1515	± 3	1514	1514	Acceptable				
L1 / L2	1996	± 3	1998	1996	Acceptable				
M1 / M'1	2306	± 3	2468	2468	Acceptable				
M2 / M'2			2478	2478	Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2127	2127	Acceptable				
T2 / T'2	2230 Top/Bottom		2230	2230	Acceptable				
Difference	U - U' (3522)	≤ 4mm	3520	3520	Acceptable				
QC Inspector:		LEON		Sign:				Date:	20_24 / _01 / _15
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_24 / _01 / _15

Cabin Bracket Assembly: GN002833

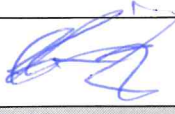

Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	CHARL BLOEM	Assembly Date:	20 24 /01/15			
Sign:		Wire Batch No.:	220252			



Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input type="checkbox"/>	No	
Operator:	Reardo	Assembly Date:	2024/02/02			
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:	2024/02/02				
Record of Shot Blasting					
Operator:		Date:	2024/02/02		
Start Time:	08 H 15	End Time:	11 H 00		
Temperature ($\geq 15^\circ$):	20-03 °C	Humidity ($\leq 75\%$):	70-01 %		
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:	2024/02/02				
Shot Blasting Cleaning					
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID	Sign:		TD [Signature]	
Date:	2024/02/02				
Shot Blasting Control					
Temperature $\geq 15^\circ$:	23-02 °C	Humidity $\leq 75\%$:	71-02 %		
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 Hunter	Sign:		D	
Date:	02/02/24				

Record of Priming							
Start Time:		16:00		End Time:		18:00	
Temperature $\geq 15^{\circ}$:		25°C		Humidity $\leq 75\%$:		56%	
Paint Batch No.:		7296966		Paint Expiry Date:		06-05-24	
Hardener Batch No.:		7087752		Hardener Expiry Date:		15-04-24	
Desolvation Start Time:		18:00		Desolvation End Time:		18:15	
Stoving Start Time:		18:15		Stoving End Time:		20:15	
Stoving Temp:		60°C					
Operator:				Sign:		GRIFF	
Date:		2024/02/02					
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 68,4	5: 75,1	1: 67,9	5: 100	1: 35,3	5: 70,4	1: 88,4	5: 58,7
2: 60,0	6: 57,2	2: 75,9	6: 31,5	2: 59,6	6: 48,1	2: 81,9	6: 59,1
3: 100	7: 96,6	3: 59,6	7: 92	3: 43,3	7: 62,1	3: 73,4	7: 50,4
4: 31,5	8: 100	4: 40,9	8: 76,4	4: 38,5	8: 82,4	4: 46,1	8: 81,9
Min:	31,5	Min:	31,5	Min:	35,3	Min:	46,1
Max:	100	Max:	100	Max:	82,4	Max:	88,4
Average:	73,6	Average:	65,7	Average:	58,8	Average:	67,2
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 47,6	5: 41,4	1: 90,1	5: 77,1	1: 37,5	5: 75,9	1: 40,4	5: 39,5
2: 95	6: 67,5	2: 60	6: 100	2: 62,1	6: 99,1	2: 54,3	6: 47,6
3: 63,5	7: 85,9	3: 81,9	7: 99,1	3: 88,4	7: 81,5	3: 54,1	7: 45,5
4: 51,9	8: 50	4: 40,1	8: 92,5	4: 71,4	8: 72,1	4: 40	8: 48,5
Min:	41,4	Min:	40,1	Min:	37,5	Min:	39,5
Max:	95	Max:	100	Max:	99,1	Max:	54,3
Average:	68,2	Average:	70,0	Average:	68,3	Average:	44,4
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 65,1	5: 87,3	1: 72,1	5: 98,1	1: 52,1	5: 68,4	1: 76,9	5: 77,4
2: 61,1	6: 82,1	2: 84	6: 96,6	2: 70,4	6: 53,3	2: 42,8	6: 84,4
3: 80,1	7: 91,1	3: 41,1	7: 94,5	3: 42,3	7: 85,1	3: 50	7: 85,9
4: 72	8: 100	4: 100	8: 105	4: 64,5	8: 97,1	4: 57,1	8: 68,4
Min:	61,1	Min:	41,1	Min:	42,3	Min:	42,8
Max:	100	Max:	105	Max:	97,1	Max:	85,9
Average:	78,8	Average:	86,4	Average:	69,7	Average:	64,3
Primer has been inspected and is free of defects				Confirmed		Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>	
QC Inspector:		Zothile		Sign:		+ @	
Date:		03.02.2024					

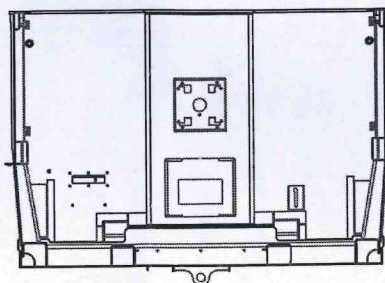
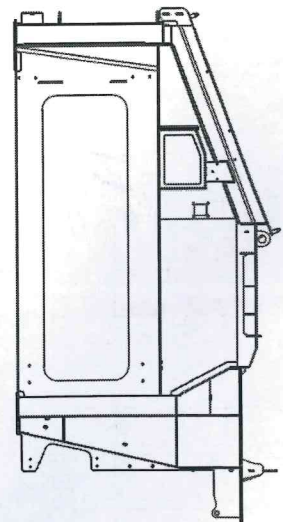
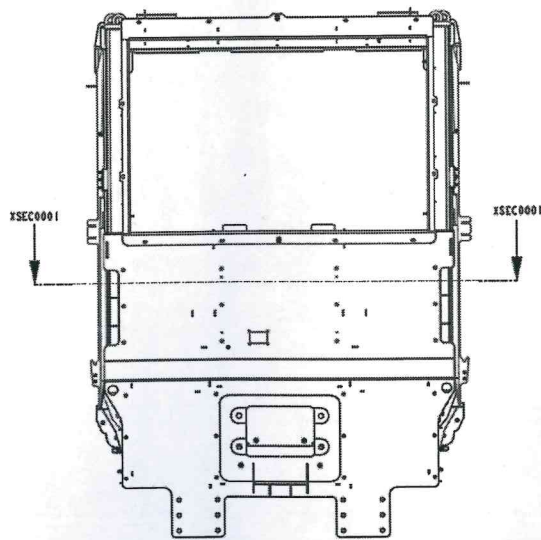
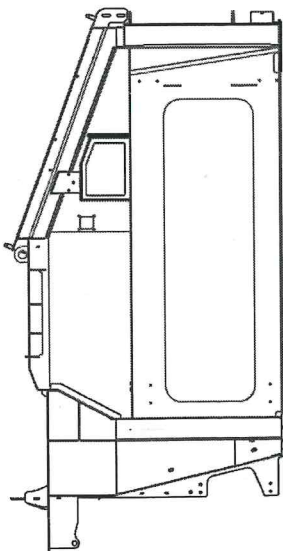
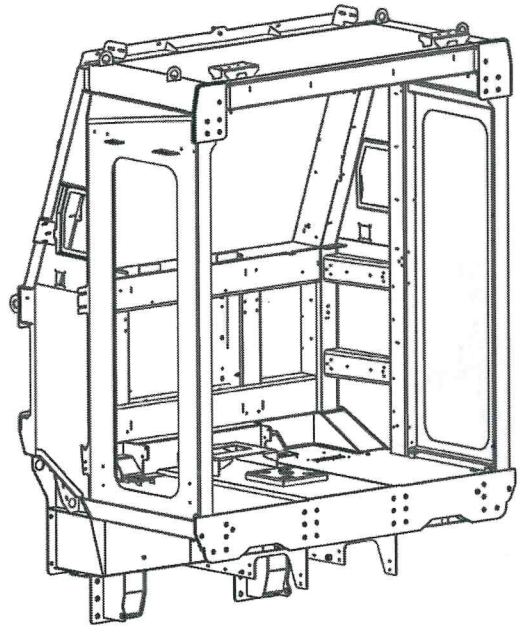
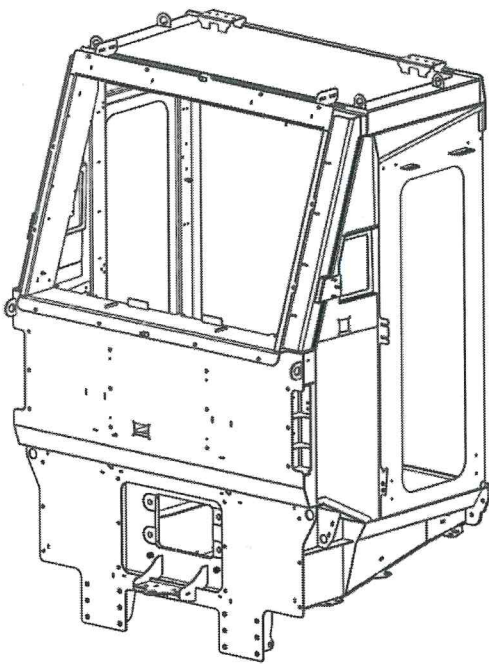
Record of Painting NCSS3010 R90B			
Start Time:	9:00	End Time:	9:30
Temperature $\geq 15^{\circ}$:	25°C	Humidity $\leq 75\%$:	56%
Paint Batch No.:	8136210	Paint Expiry Date:	09-05-24
Hardener Batch No.:	7309146 051	Hardener Expiry Date:	05-24
Desolvation Start Time:	9:30	Desolvation End Time:	9:45
Stoving Start Time:	9:45	Stoving End Time:	10:45
Stoving Temp:	600°C		
Operator:	Colin	Sign:	
Date:	2024/04/02		
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: 128	5: 91.4	1: 112	5: 81.7
2: 113	6: 105	2: 123	6: 104
3: 83.5	7: 91.6	3: 98.0	7: 118
4: 80.9	8: 95.6	4: 125	8: 91.1
Min:	80.9	Min:	81.7
Max:	128	Max:	125
Average:		Average:	
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	39.6
QC Inspector:	Zothile	Sign:	
Date:	08.02.2024		

Record of Painting Blue NCSS1565 B			
Start Time:	12:00	End Time:	12:30
Temperature $\geq 15^{\circ}$:	25°C	Humidity $\leq 75\%$:	56%
Paint Batch No.:	8B6206	Paint Expiry Date:	24/11/24
Hardener Batch No.:	7309146.051	Hardener Expiry Date:	05-24
Desolvation Start Time:	12:30	Desolvation End Time:	12:45
Stoving Start Time:	12:45	Stoving End Time:	13:45
Stoving Temp:	60°C		
Operator:	Colin	Sign:	
Date:	20/05/02		
Painting Blue NCSS1565 B Control			
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS	
1: 121	5: 120	1: 135	5: 124
2: 97.2	6: 125	2: 101	6: 131
3: 104	7: 116	3: 127	7: 120
4: 137	8: 100	4: 98.6	8: 128
Min:	97.2	Min:	98.6
Max:	137	Max:	135
Average:		Average:	
Painting NCSS3010 R90B has been inspected and is free of defects		Confirmed	Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	91.2
QC Inspector:	Zothile	Sign:	
Date:	05.02.2024		

Record of RAL 7012							
Start Time:	20:00 hr			End Time:	20:18		
Temperature $\geq 15^{\circ}$:	25°C			Humidity $\leq 75\%$:	52/10		
Paint Batch No.:	809 6599			Paint Expiry Date:	21-09-24		
Hardener Batch No.:	7300146			Hardener Expiry Date:	05-24		
Desolvation Start Time:	13hr			Desolvation End Time:	25 hr 15		
Stoving Start Time:	23:15:			Stoving End Time:	20 hr 15		
Stoving Temp:	60°C						
Operator:	NTHUKO			Sign:	NTHUKO		
Date:	20/02/24						
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 84.0	5: 89.0	1: 120	5: 161	1: 99.2	5: 142	1: 149	5: 158
2: 102	6: 124	2: 157	6: 127	2: 110	6: 96.2	2: 126	6: 114
3: 123	7: 87.9	3: 130	7: 145	3: 140	7: 108	3: 127	7: 95.3
4: 95.1	8: 87.0	4: 146	8: 167	4: 160	8: 144	4: 146	8: 106
Min:	84.0	Min:	120	Min:	96.2	Min:	95.3
Max:	124	Max:	167	Max:	160	Max:	158
Average:	104	Average:	143	Average:	128	Average:	126.6
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 91.5	5: 177	1: 106	5: 155	1: 160	5: 119	1: 131	5: 84.1
2: 106	6: 116	2: 148	6: 110	2: 133	6: 100	2: 135	6: 89.7
3: 115	7: 157	3: 154	7: 139	3: 96.2	7: 89.2	3: 86.5	7: 136
4: 169	8: 120	4: 133	8: 137	4: 139	8: 92.3	4: 138	8: 94.6
Min:	91.5	Min:	106	Min:	89.2	Min:	84.1
Max:	177	Max:	155	Max:	160	Max:	138
Average:	134	Average:	130	Average:	124	Average:	111
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 131	5: 155	1: 143	5: 135				
2: 137	6: 143	2: 145	6: 116				
3: 137	7: 141	3: 112	7: 101				
4: 129	8: 120	4: 121	8: 100				
Min:	120	Min:	101				
Max:	155	Max:	145				
Average:	137	Average:	123				
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	34.8		
QC Inspector:		Zothile		Sign:			
Date:		04.02.2024					
SEALING OF CABIN							
All areas where there is no welding has been sealed with SIKA				Confirmed	YES	<input checked="" type="checkbox"/>	NO
All sealants have been neatly applied along joints				Confirmed	YES	<input checked="" type="checkbox"/>	NO
SIGN OFF							
CLOCK No:	2400	OPERATOR SIGN:		DATE:	04/02/24		

REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)




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

REMINDERS / COMMENTS	
DEPARTMENT	DETAILS OR COMMENT

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	426	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 CLOSED NO BREAKS IN THE SEALANT CORRECT BEAD 	0			
4	RIVET NUTS ARE PROPERLY CRIMPED <ul style="list-style-type: none"> RIVETS ARE MARKED CORRECT 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
	2285	04.02.2024