

CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 428

WEIGHT: 1486 Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Regulus	19/12/23	F10326 VHE 89171	179247 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	19/01/24	V201247 V14670756	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	19/12/23	P208179 VPL 97529	177532 103292 01	
RCS 355	20 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Regulus	19/12/23	P302051 VPL 9780		
RCS 355	30 mm					

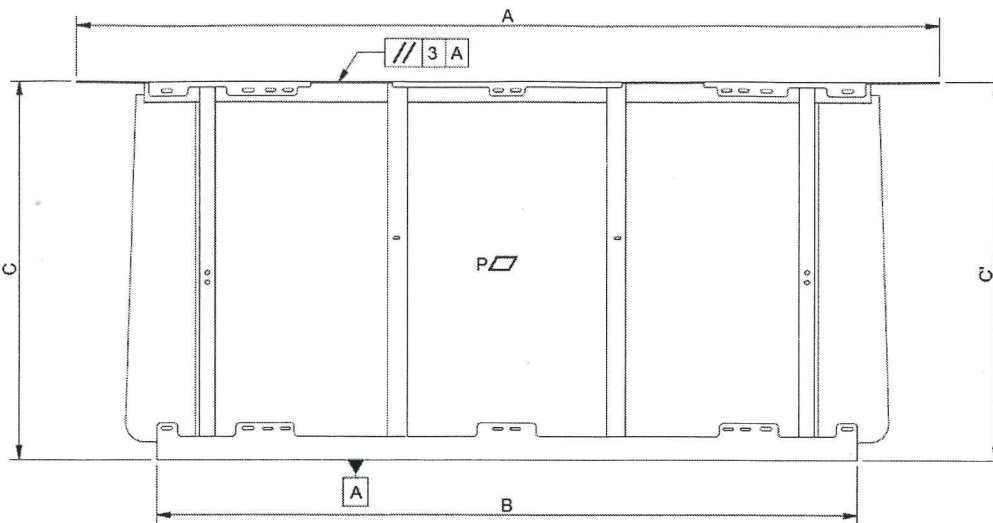
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Regulus	19/12/23	F207405 V14651423	179252 102206 01	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					




GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm				176986 102208 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	19/12/23	F201099 V14535262	175569 102206 01	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

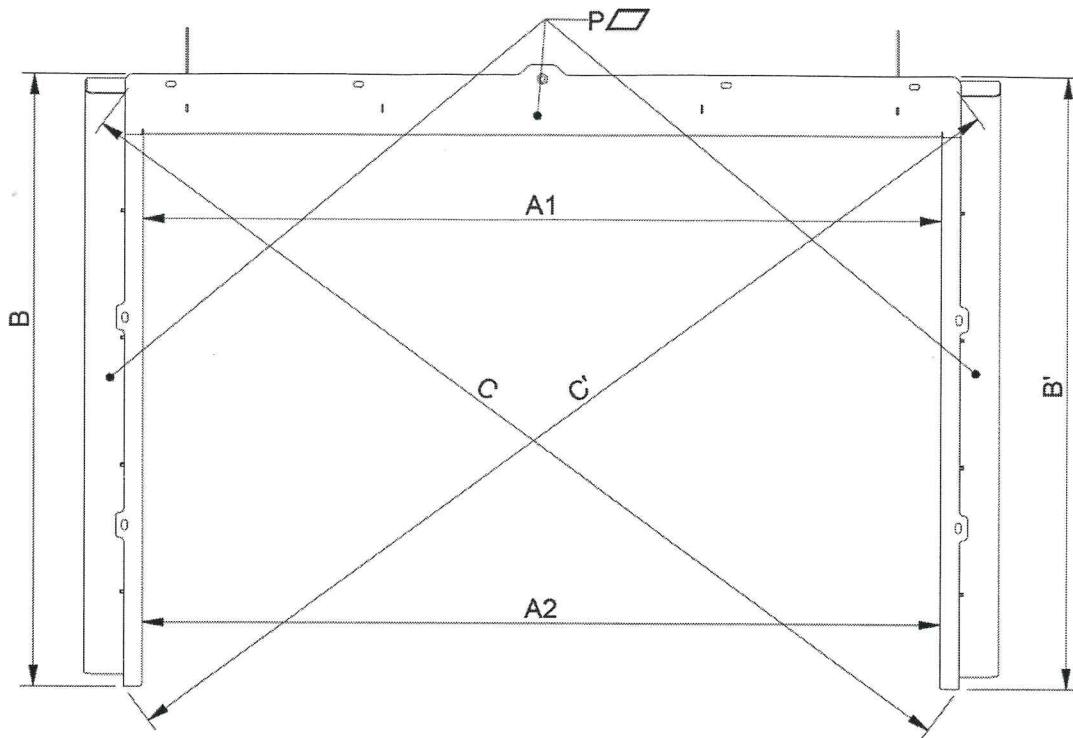
Cabin Roof Assembly: GN002839

Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	DYLAN DAYIDS	Assembly Date:	20 24/01/17			
Sign:		Wire Batch No.:				



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 24/01/17
Dimensional Control						
Rep		Toler.	Dimension measured		Measuring Equipment	Observations
A	2216	+5/-0	2216		Tape Measure	Aw/H
B	1800	± 4	1801			Aw/H
C	976	+2/-3	976	977		Aw/H
QC Inspector:	Leon		Sign:		Date:	20 24/01/17
Geometrical Control						
Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planity P		6 mm	Pass		Ruler	Aw/H
//	3	A	Pass		Set Square	Aw/H
QC Inspector:	Leon		Sign:		Date:	20 24/01/17

Cabin Front Frame Assembly: GN002840				
Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	Bambelo Gcanani	Assembly Date:	2024/01/17	
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:	2024/01/17
Dimensional Control					
Rep	Theoretical Dim	Toler.	Dimension Measured		Observations
A1	1910	± 2	1912		Acceptable
A2	1910		1910		
B	1475	± 1	1474	1474	
C	Diagonals C - C' ≤ 3		8476	8475	
QC Inspector:			LEON	Sign:	<i>[Signature]</i>
				Date:	2024/01/17
Geometrical Control					
Nature of checks		Dimension Measured		Measuring Equipment	Observations
P : Planeity	4 mm	Passed		Ruler	Acceptable
QC Inspector:			LEON	Sign:	<i>[Signature]</i>
				Date:	2024/01/17

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	<input type="checkbox"/>
Operator:	<i>Xenon</i>	Assembly Date:	20 <i>24/01/08</i>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	<i>2202152</i>			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

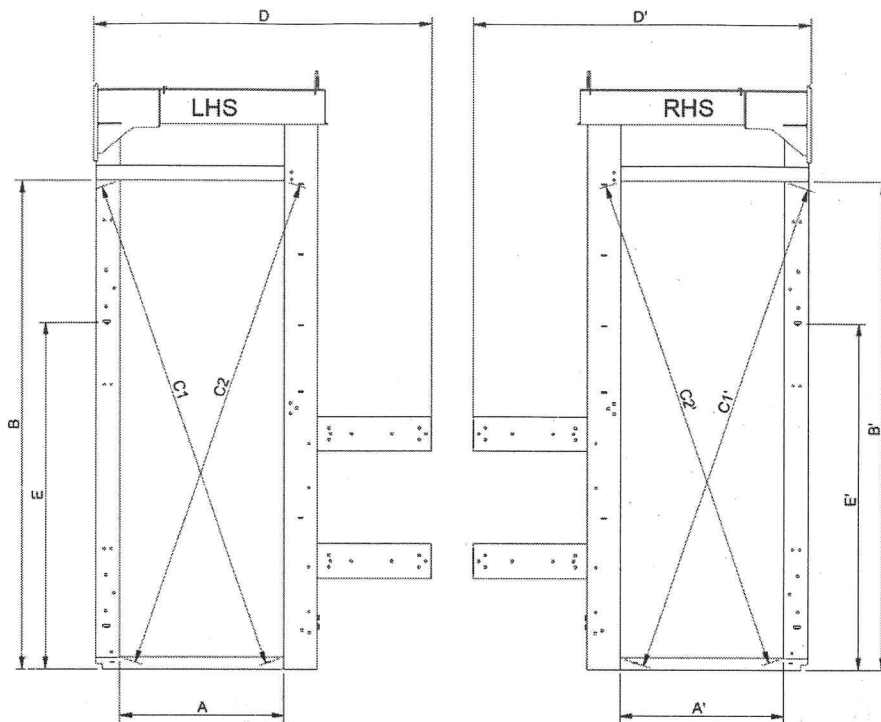
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Glenn</i>	Assembly Date:	20 <i>24/01/08</i>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	<i>2202152</i>			

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Glenn</i>	Assembly Date:	20 <i>24/01/08</i>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	<i>2202152</i>			

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:	20 24/01/08			
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	<input type="checkbox"/>
QC Inspector:	LEON	Sign:	<i>LEON</i>	Date:	20 24/01/09	

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	695.5	695	Tape Measure	Accepted
B	2086	+1/-3	2086	2086		Accepted
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2154	2152		Accepted
C1 - C2			2154.5	2154		Accepted
D	1438	+2/-3	1440	1439		Accepted
E			1484	1484		Accepted

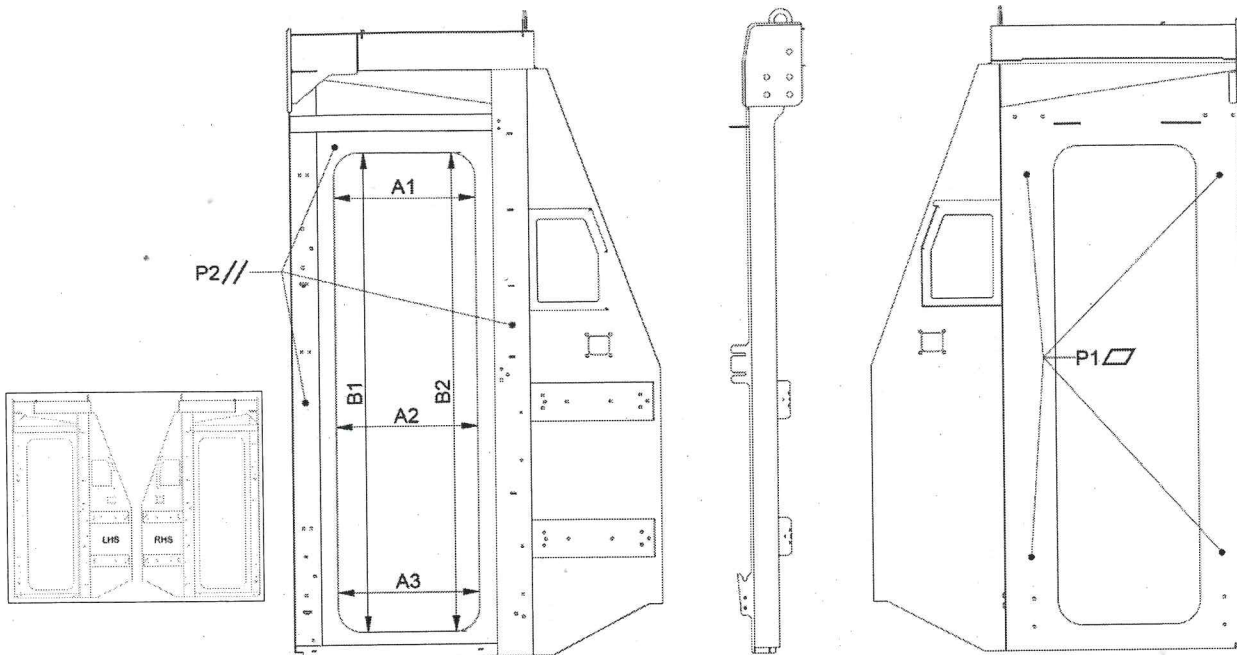
QC Inspector: LEON Sign: *LEON* Date: 20 24/01/08

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	Passed	Ruler	Accepted
QC Inspector:	LEON	Sign:	<i>LEON</i>	Date: 20 24/01/08

Cabin LHS/RHS Side Assembly: GN002838/GN002837

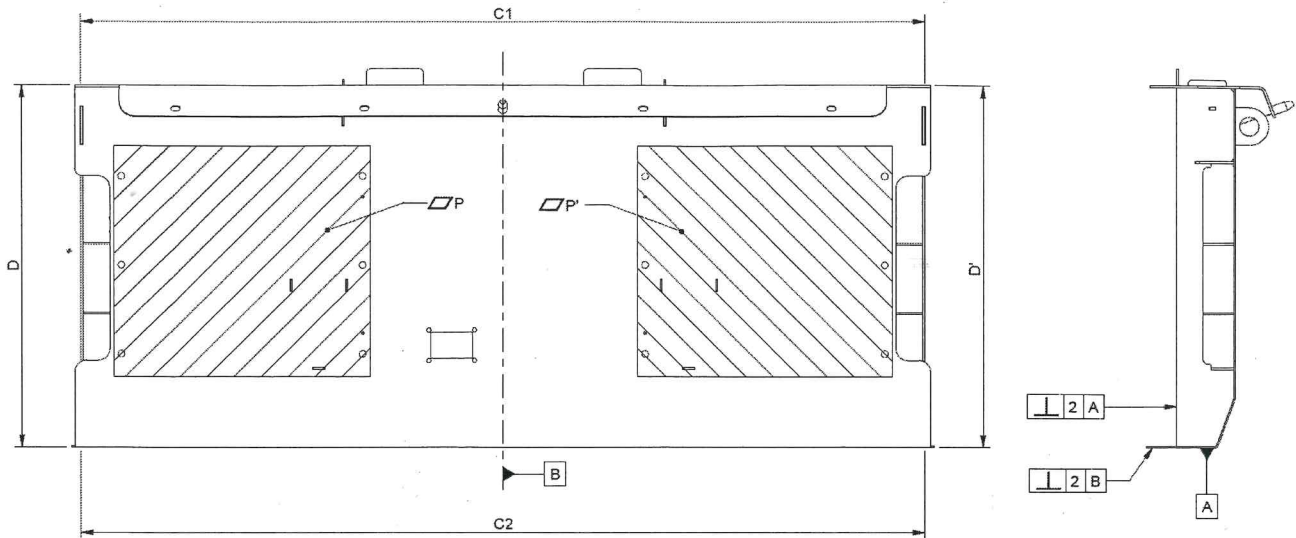
Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Xander</i>	Assembly Date:	2024/01/09			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			



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:	2024/01/16		
Dimensional Control							
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	560	± 2	558	558	Tape Measure	<i>Acceptable</i> <i>Acceptable</i> <i>Acceptable</i> <i>Acceptable</i> <i>Acceptable</i>	
A2			559	559			
A3			559	560			
B1	1900	± 2	1898	1898			
B2			1898	1898			
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/01/16		
Geometrical Control							
Nature of checks			Dimension Measured	Measuring Equipment	Observations		
P1 : Planeity	4 mm		<i>P1 Pass</i>	Ruler	<i>Acceptable</i> <i>Acceptable</i>		
P2 : Planeity	2 mm		<i>P2 Pass</i>	Ruler			
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/01/16		

Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	BEVAN J. JAVENHILL	Assembly Date:	2023/01/17			
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:	2024/01/17	

Dimensional Control

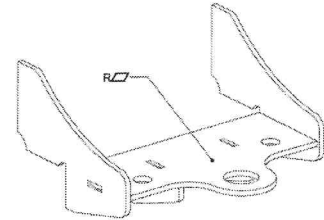
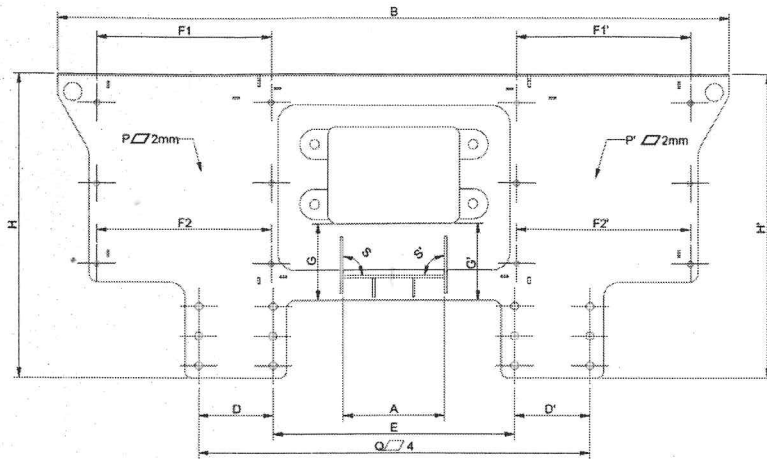
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2213	2210	Tape Measure	Acceptable
D / D'	956	± 2	958	958		Acceptable
QC Inspector:	LEON	Sign:		Date:	2024/01/17	

Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planarity 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__/__/__	

Cabin Front Headstock Assembly: GN002841


Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	ATR Boon	Assembly Date:	2024/01/13			
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:	2024/01/13	

Dimensional Control

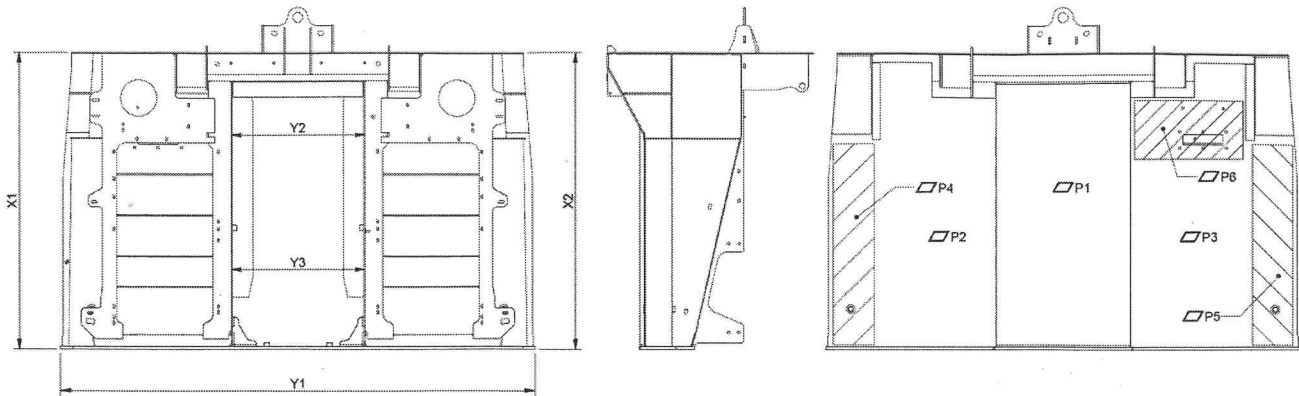
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	340	± 1	340		Tape Measure	Accepted	
B	2240	± 4	2244			Accepted	
D / D'	250	± 1	251	251		Accepted	
E	808	± 2	808			Accepted	
F1 / F1'	580	± 1	581	581		Accepted	
F2 / F2'			581			Accepted	
G / G'	258	± 1	259	259		Accepted	
H / H'	1019	± 2	1020	1020		Accepted	
QC Inspector:		Leon		Sign:		Date:	20_24_01/13

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations	
O: Planeity of global assembly	4 mm	Passes	Ruler	Accepted	
P / P': Planeity	2 mm	Passes	Ruler	Accepted	
Q: Planeity Surface of Supports	4 mm	Passes	Ruler	Accepted	
R: Planeity Coupler Support	2 mm	Passes	Ruler	Accepted	
S: Perpendicularity coupler	1mm	Planes	Square	Accepted	
QC Inspector:	Leon	Sign:		Date:	2024/01/13

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>16</u>	
Sign:	<i>[Signature]</i>	Wire Batch No.:	<u>2202165</u>	




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>27</u> / <u>01</u> / <u>16</u>


Dimensional Control

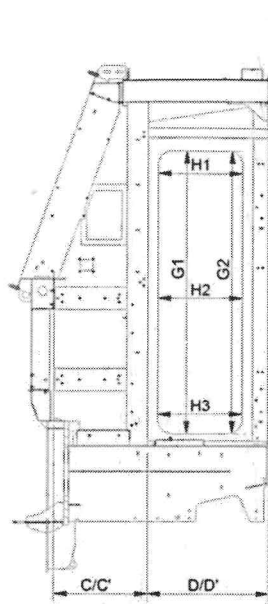
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	<u>1487</u>	<u>1486</u>	Tape Measure	<i>Accepted</i>
Y 1	2354	± 3	<u>2351</u>			<i>Accepted</i>
Y2 / Y3	666	± 1	<u>668</u>	<u>669</u>		<i>Accepted</i>
QC Inspector:		<i>LEON</i>	Sign:		<i>[Signature]</i>	Date: 20 <u>23</u> / <u>01</u> / <u>16</u>

Geometrical Control

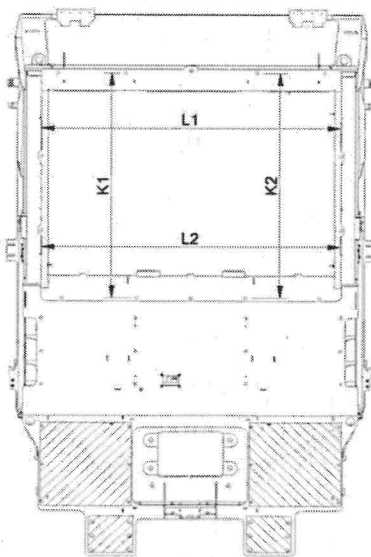
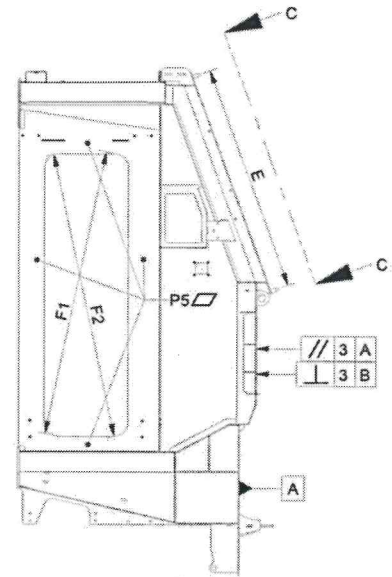
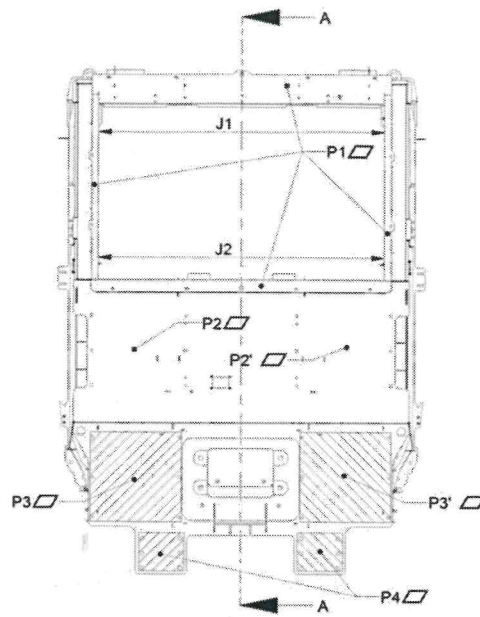
Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P1 : Planeity	4 mm	PASSED		Ruler	Accepted	
P2 / P3 : Planeity	4 mm	PASSED		Ruler	Accepted	
P4 / P5 : Planeity	2 mm	PASSED		Ruler	Accepted	
P6 : Planeity	2 mm	PASSED		Ruler	Accepted	
QC Inspector:	LEON		Sign:		Date:	2023/01/16

Cabin Structure Assembly: GN002834

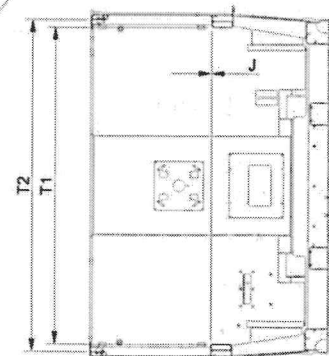
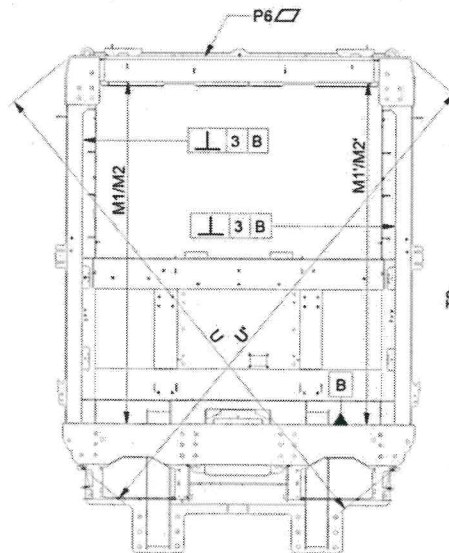
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLOOM	Assembly Date:	20 24/01/16			
Sign:		Wire Batch No.:	2202152			



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:	2024/01/19
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	626	624	Acceptable				
D / D'	813	± 2,5	812	812	Acceptable				
E	1531.5	± 3	1529		Acceptable				
G1 / G'1	Height 1900	+1	1897	1897	Acceptable				
G2 / G'2		-3	1898	1898	Acceptable				
H1 / H'1	Width 560	+1 -3	557	557	Acceptable				
H2 / H'2			558	558	Acceptable				
H3 / H'3			559	558	Acceptable				
F1 / F'1	Diagonals 1939		1935	1937	Acceptable				
F2 / F'2			1935	1934	Acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	0	3	Acceptable				
J	Gap of Doors	± 1,5	0		Acceptable				
K1 / K2	1515	± 3	1513	1514	Acceptable				
L1 / L2	1996	± 3	1998	1996	Acceptable				
M1 / M'1	2306	± 3	2466	2466	Acceptable				
M2 / M'2			2477	2476	Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2127	2128	Acceptable				
T2 / T'2	2230 Top/Bottom		2231	2229	Acceptable				
Difference	U - U' (3522)	≤ 4mm	3519	3520	Acceptable				
QC Inspector:		Leon		Sign:				Date:	2024/01/19
Geometrical Control									
Nature of checks				Toler.	LHS / Dimension Measured / RHS		Observations		
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:	2024/01/19


Cabin Bracket Assembly: GN002833



Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>CHARL BLOEM</i>	Assembly Date:	20 <i>24</i> / <i>01</i> / <i>19</i>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	<i>220252.</i>			

Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Luigiolo</i>	Assembly Date:	20 <i>24</i> / <i>02</i> / <i>02</i>			
Sign:	<i>[Signature]</i>	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: 		
Date:	2024/02/07				
Record of Shot Blasting					
Operator:		Date:	2024/02/07		
Start Time:	07:15	End Time:	11:38		
Temperature ($\geq 15^{\circ}$):	21-04°C	Humidity ($\leq 75\%$):	38-03%		
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: 		
Date:	2024/02/07				
Shot Blasting Cleaning					
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID		Sign: 		
Date:	2024/02/07				
Shot Blasting Control					
Temperature $\geq 15^{\circ}$:	20-02°C	Humidity $\leq 75\%$:	41-07		
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:	ALAN		Sign: 		
Date:	07/02/24				

Record of Priming							
Start Time:		18:00		End Time:		20:00	
Temperature $\geq 15^{\circ}$:		25 $^{\circ}$ C		Humidity $\leq 75\%$:		37%	
Paint Batch No.:		7246866		Paint Expiry Date:		06/05/2024	
Hardener Batch No.:		7287752		Hardener Expiry Date:		13/04/2024	
Desolvation Start Time:		20:00		Desolvation End Time:		20:15	
Stoving Start Time:		20:15		Stoving End Time:		21:15	
Stoving Temp:		60 $^{\circ}$ C					
Operator:		KYLE		Sign:		KYLE	
Date:		2024/02/01					
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 48.6	5: 39.8	1: 66.8	5: 102.3	1: 38.7	5: 86.9	1: 102.6	5: 56.9
2: 51.3	6: 66.9	2: 113	6: 70.8	2: 44.3	6: 70.8	2: 88.6	6: 108.3
3: 64.8	7: 80.6	3: 109.6	7: 89.8	3: 56.9	7: 69.8	3: 113.8	7: 70.8
4: 102	8: 72.1	4: 102.3	8: 96.5	4: 80.6	8: 77.8	4: 120.6	8: 68.7
Min:	38.6	Min:	66.8	Min:	38.7	Min:	56.9
Max:	102	Max:	113	Max:	86.9	Max:	120.6
Average:	70.4	Average:	89.9	Average:	62.8	Average:	88.7
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 81.8	5: 70.8	1: 66.8	5: 80.2	1: 60.8	5: 61.8	1: 88.7	5: 60.9
2: 53.7	6: 70.8	2: 60.3	6: 90.3	2: 116.8	6: 40.8	2: 102	6: 69
3: 69.8	7: 113	3: 58.7	7: 66.8	3: 102.3	7: 39.6	3: 116	7: 72.6
4: 102.8	8: 100.8	4: 96.8	8: 50.1	4: 71.8	8: 113.8	4: 49.8	8: 77.8
Min:	53.7	Min:	50.1	Min:	39.6	Min:	49.8
Max:	113	Max:	100.3	Max:	116	Max:	102
Average:	83.3	Average:	70.2	Average:	73	Average:	75.9
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 109.8	5: 71.8	1: 60.9	5: 80.6	1: 80.6	5: 46.9	1: 111.3	5: 41.4
2: 80.6	6: 90.6	2: 44.6	6: 100	2: 118	6: 71.6	2: 90.8	6: 59.8
3: 66.9	7: 86.9	3: 50.6	7: 91.8	3: 66.9	7: 108	3: 70.6	7: 80.2
4: 84.8	8: 71.8	4: 72.3	8: 82.3	4: 54.3	8: 91.8	4: 69.8	8: 71.6
Min:	50.6	Min:	44.6	Min:	46.9	Min:	41.4
Max:	109	Max:	100	Max:	118	Max:	111.3
Average:	79.8	Average:	72.3	Average:	82.4	Average:	77.2
Primer has been inspected and is free of defects				Confirmed		Yes	No
QC Inspector:		Reece		Sign:			
Date:		09/02/24					

Record of Painting NCSS3010 R90B							
Start Time:		9:00		End Time:		9:30	
Temperature $\geq 15^{\circ}$:		25°C		Humidity $\leq 75\%$:		39%	
Paint Batch No.:		8136210		Paint Expiry Date:		17/11/24	
Hardener Batch No.:		7250479041		Hardener Expiry Date:		04/24	
Desolvation Start Time:		9:30		Desolvation End Time:		9:45	
Stoving Start Time:		9:45		Stoving End Time:		10:45	
Stoving Temp:		60°C					
Operator:		Colin		Sign:			
Date:		20/02/08					
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: 113.6	5: 79.6	1: 89.6	5: 88.6				
2: 90.8	6: 104	2: 126.9	6: 141.6				
3: 86.4	7: 120	3: 120.8	7: 136.9				
4: 90	8: 113	4: 116.8	8: 102.6				
Min: 86.4		Min: 88.6					
Max: 120		Max: 141.6					
Average: 103		Average: 114					
Painting NCSS3010 R90B has been inspected and is free of defects							
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	44.6		
QC Inspector:		Reece		Sign:			
Date:		13/02/24					

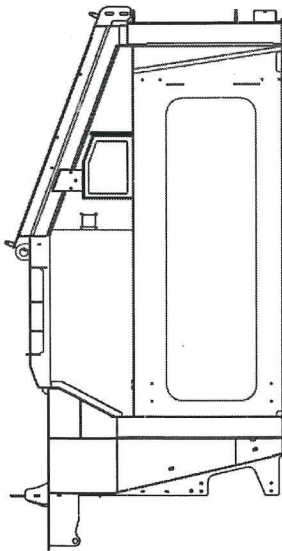
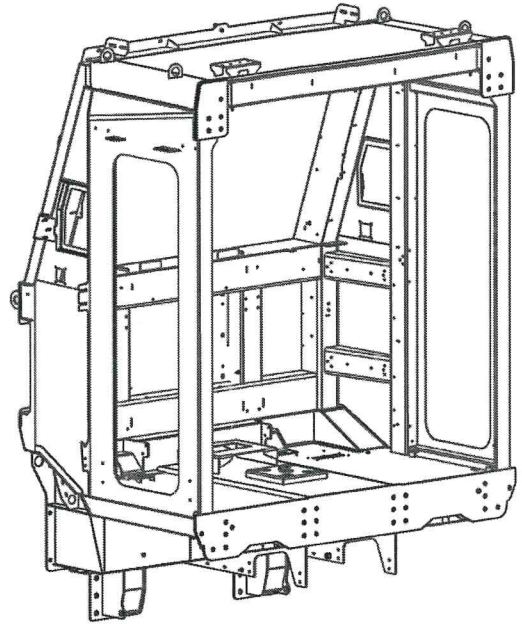
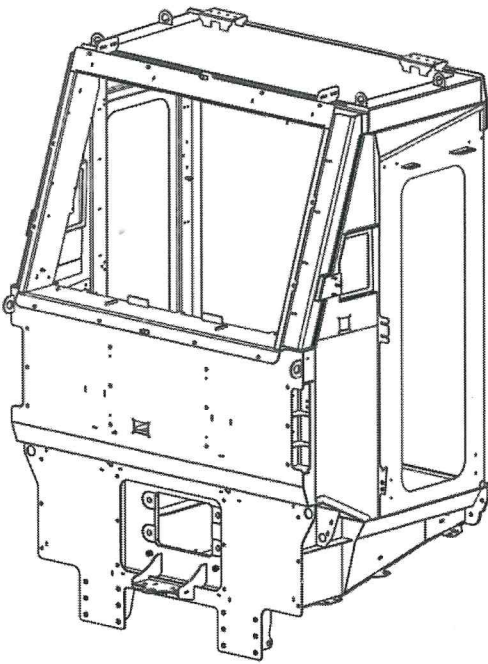
Record of Painting Blue NCSS1565 B					
Start Time:		1:00		End Time:	
Temperature $\geq 15^{\circ}$:		25°C		Humidity $\leq 75\%$:	
Paint Batch No.:		8032294		Paint Expiry Date:	
Hardener Batch No.:		7250479041		Hardener Expiry Date:	
Desolvation Start Time:		1:30		Desolvation End Time:	
Stoving Start Time:		1:45		Stoving End Time:	
Stoving Temp:		60°C			
Operator:		Colin		Sign:	
Date:		2024/02/08			
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: 102	5: 74.8	1: 120.8	5: 114.6		
2: 74	6: 116.8	2: 117.8	6: 98.7		
3: 98.6	7: 130.8	3: 103.6	7: 108.6		
4: 108.6	8: 140.1	4: 112.8	8: 116.8		
Min:	74.8	Min:	98.7		
Max:	140	Max:	120.8		
Average:	107	Average:	109		
Painting NCSS3010 R90B has been inspected and is free of defects					
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	89.6
QC Inspector:		Reece		Sign:	
Date:		13/02/24		PPH	

Record of RAL 7012							
Start Time:		10:00		End Time:		12:30	
Temperature $\geq 15^{\circ}$:		25°C		Humidity $\leq 75\%$:		33%	
Paint Batch No.:		8096599		Paint Expiry Date:		21/09/2024	
Hardener Batch No.:		7250479041		Hardener Expiry Date:		04/24	
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:		Netchuko		Sign:		an Shangas	
Date:		2024/02/10					
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 124.3	5: 113.6	1: 102.3	5: 160.7	1: 90	5: 124.6	1: 89.9	5: 103
2: 146.9	6: 87.8	2: 116.8	6: 146.9	2: 88.6	6: 113.6	2: 113.6	6: 104.8
3: 151.4	7: 169.8	3: 100.6	7: 131.4	3: 102.6	7: 119.8	3: 124.3	7: 160.9
4: 180.9	8: 143.2	4: 174.6	8: 109.8	4: 140.8	8: 130.6	4: 116.8	8: 71.8
Min:	89.8	Min:	100.6	Min:	88.6	Min:	71.8
Max:	180.9	Max:	174.6	Max:	140.8	Max:	160.9
Average:	135	Average:	137	Average:	114	Average:	115
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 113.6	5: 102.6	1: 116.8	5: 116.8	1: 90.8	5: 100.8	1: 102.6	5: 124.3
2: 120.8	6: 86.3	2: 120.8	6: 104.6	2: 120.8	6: 116.8	2: 88.6	6: 116.8
3: 144.3	7: 114.8	3: 121.6	7: 137.9	3: 113.6	7: 120.6	3: 96.8	7: 161.8
4: 94.6	8: 160.9	4: 113.8	8: 104.6	4: 104.8	8: 74.6	4: 100.9	8: 103.2
Min:	86.3	Min:	104.6	Min:	74.6	Min:	88.6
Max:	160.9	Max:	137.9	Max:	120.9	Max:	161.8
Average:	133	Average:	120	Average:	97.3	Average:	125
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 90.8	5: 118.9	1: 111.3	5: 102.3				
2: 116.8	6: 102.6	2: 120.6	6: 118.7				
3: 140.8	7: 194.8	3: 116.7	7: 131.8				
4: 120.6	8: 106.9	4: 102.6	8: 124.3				
Min:	90.8	Min:	102.3				
Max:	194.8	Max:	131.8				
Average:	142	Average:	116				
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	49.6		
QC Inspector:		Reece		Sign:		R. Ball	
Date:		13/02/24					
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:	A. M. M. M. M.	DATE:	13/02/24		

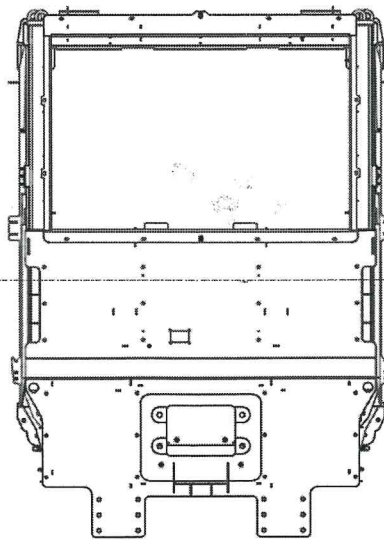
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REWORK IDENTIFICATION

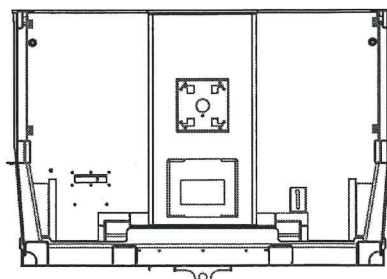
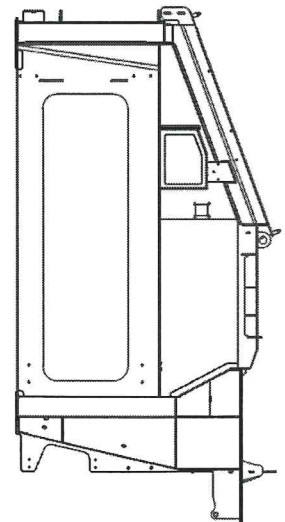
(MARK SECTIONS EFFECTED NUMERICALLY)



XSEC0001



XSEC0001



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CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	428	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
	2291	13/02/24