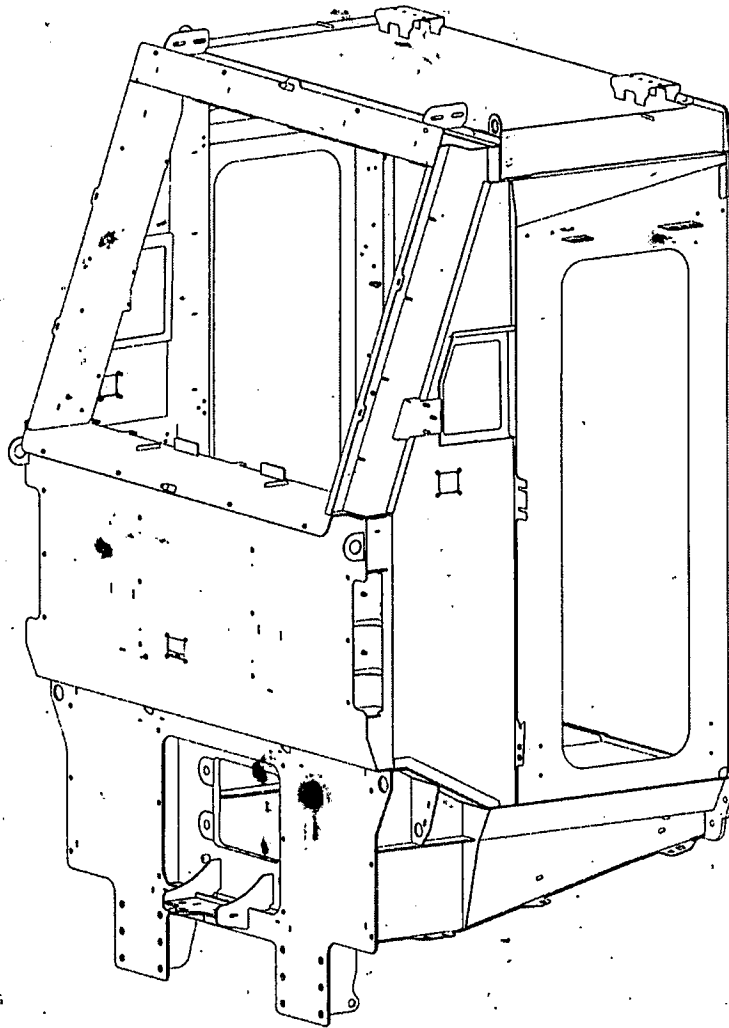


GLOBAL

MANUFACTURING
SOLUTIONS



CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 4 4 0 _

WEIGHT: 14 92 Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegman	06/02/14	178247 104825 01	LPG9402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	3 mm	Pegman	14/02/14	178820 104640 01	F205272	
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	20 mm	Pegman	28/02/14	178488 104640 01	P300091	
RCS 355	20 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	30 mm	Pegman	12/02/14			
RCS 355	30 mm					

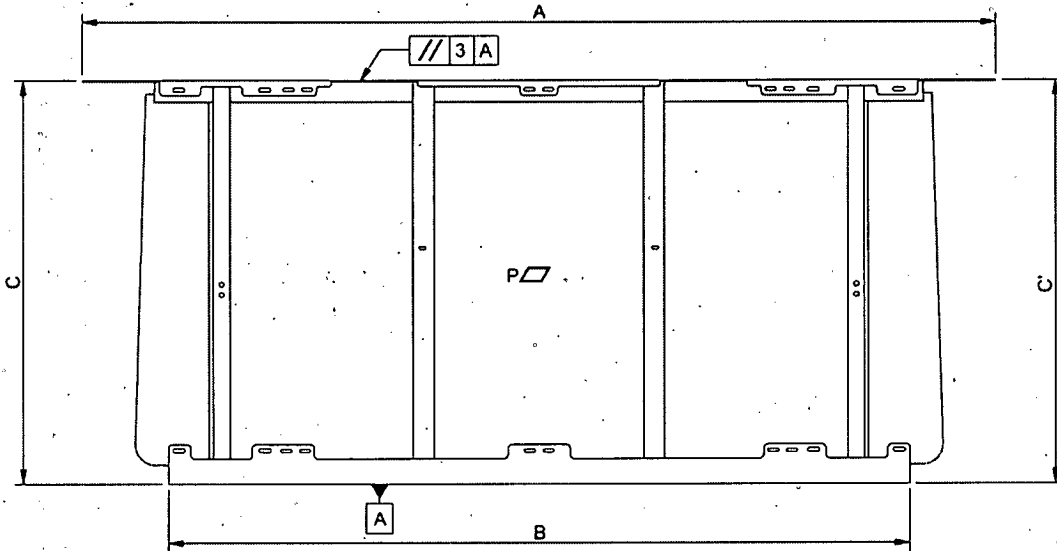
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 450	4 mm	Pegman	8/02/14	178489 104640 01	KHC 35578	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 450	6 mm	Pegman	14/02/14	178515 104640 01	F20705 KHC 28402	
RCS 450	6 mm					
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 450	8 mm	Pegman	22/12/13	175569 102206 01	F207906 V15 58432	
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 24/02/12		
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
QC Inspector: LEON	Sign:	Date:	2024/02/12	

Dimensional Control

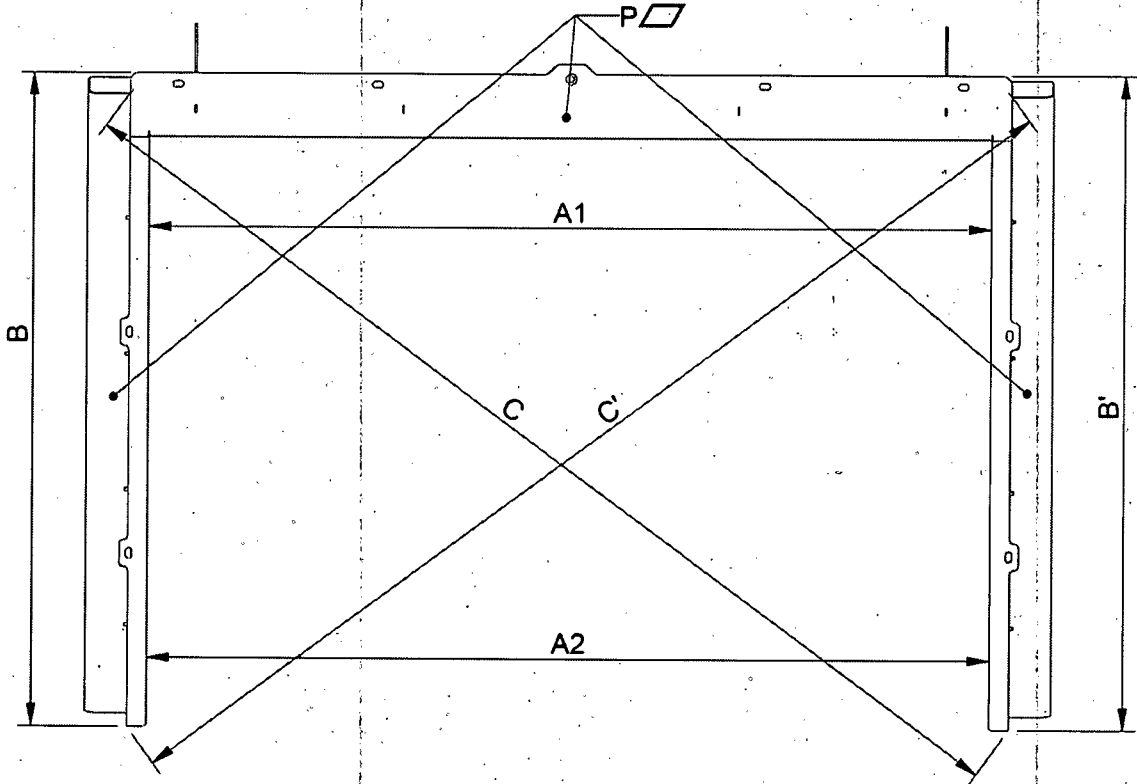
Rep	Toler.	Dimension measured		Measuring Equipment	Observations
A	+5/-0	2216.		Tape Measure	ACCEPTABLE
B	± 4	1800 -			ACCEPTABLE
C	+2/-3	975	976.		ACCEPTABLE
QC Inspector: LEON	Sign:	Date:	2024/02/12		

Geometrical Control

Nature of Checks		Dimension Measured	Measuring Equipment	Observations
Planarity P	6 mm	Passed	Ruler	Acceptable
//	3 A	Passed	Set Square	Acceptable
QC Inspector: LEON	Sign:	Date:	2024/02/12	

Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Bambelo G. Ganan	Assembly Date:	2024/02/12			
Sign:		Wire Batch No.:	220215Z			



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:	2024/02/12	

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	1910	± 2	1910.2		Tape Measure	ACCEPTABLE
A2	1910		1910.			ACCEPTABLE
B	1475	± 1	1475	1475		ACCEPTABLE
C	Diagonals C - C' ≤ 3		2476	2476		ACCEPTABLE
QC Inspector:	Leon	Sign:		Date:	2024/02/12	

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P : Planity	4 mm	Ruler	ACCEPTABLE
QC Inspector:	Leon	Sign:	
Date:	2024/02/12		

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:	2024/01/31		
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202165		

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

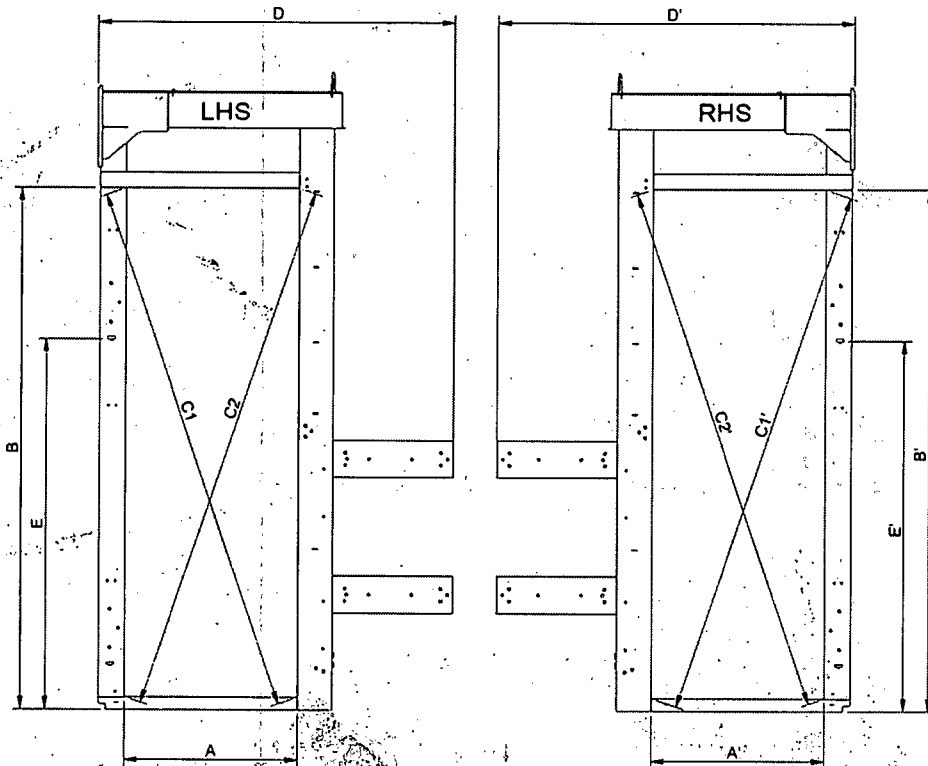
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	<i>Glenn</i>	Assembly Date:	2024/02/01		
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152		

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:	2024/02/01		
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:	2024/02/02		
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:	2024/02/06		

Dimensional Control

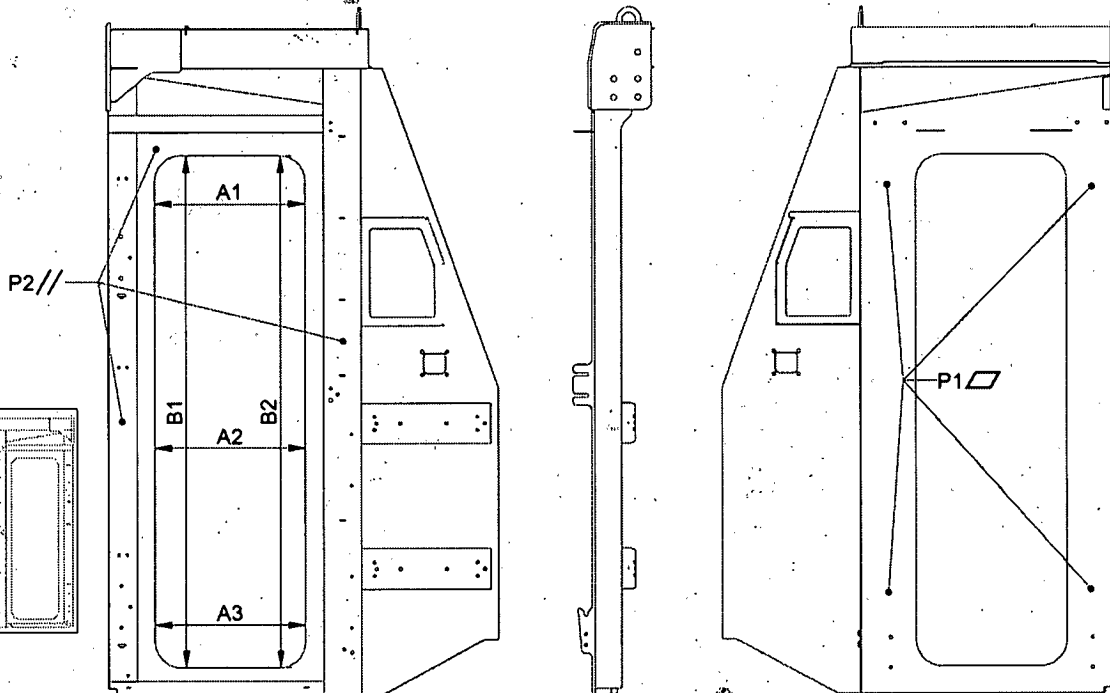
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	696	Tape Measure	Acceptable
B	2086	+1/-3	2086	2085		Acceptable
C1/C2	Difference of diagonals $ C1 - C2 \leq 3$		2152	2153		Acceptable
$ C1 - C2 $			2152	2151		Acceptable
D	1438	+2/-3	1437	1440		Acceptable
E				1433		
QC Inspector:		Leon	Sign:		<i>[Signature]</i>	
				Date:	2024/02/06	

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations	
P1 : planeity of 2 edges	4 mm	Passes	Ruler.	
QC Inspector:		Leon	<i>[Signature]</i>	
		Date:	2024/02/06	

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>Xander</i>	Assembly Date:	2024/02/06		
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:	2024/02/12

Dimensional Control

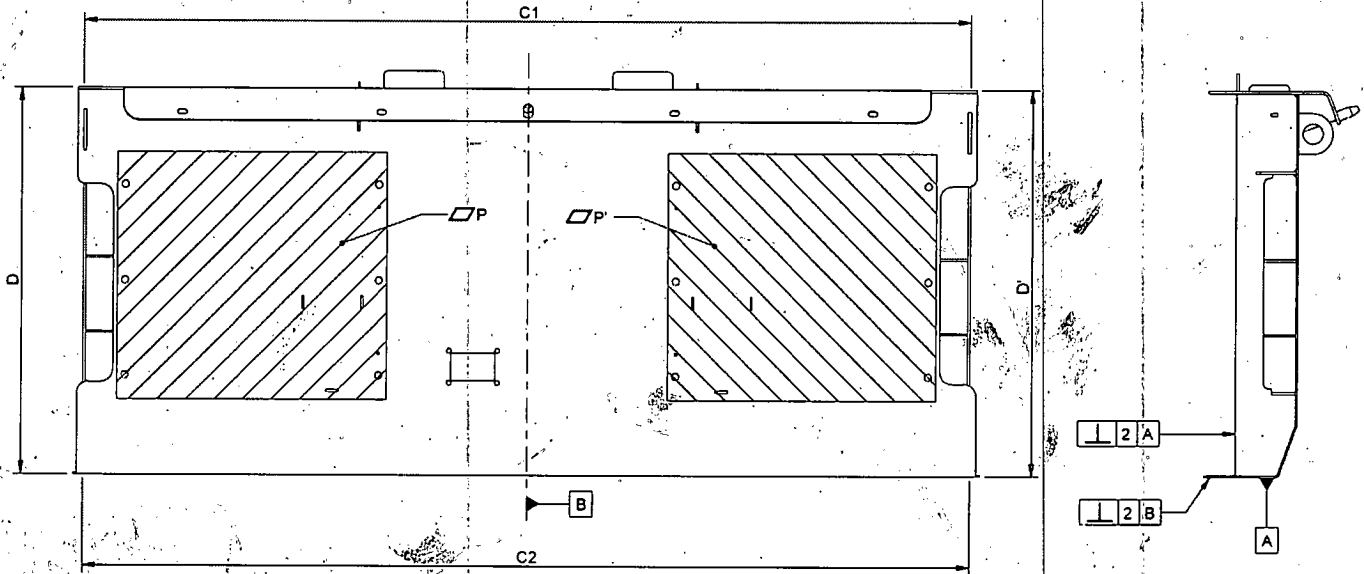
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1			<i>559</i>	<i>559</i>	Tape Measure	<i>Acceptable</i>
A2	560	± 2	<i>589</i>	<i>559</i>		<i>Acceptable</i>
A3			<i>560</i>	<i>560</i>		<i>Acceptable</i>
B1	1900	± 2	<i>1898</i>	<i>1898</i>		<i>Acceptable</i>
B2			<i>1898</i>	<i>1898</i>		<i>Acceptable</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/12	

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Ruler	<i>Acceptable</i>
P2 : Planeity	2 mm	Ruler	<i>Acceptable</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>
			Date: 2024/02/12

Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	<i>DEVAN DANOWHILL</i>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>10</u>		
Sign:	<i>[Signature]</i>	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:	20 <u>24</u> / <u>02</u> / <u>12</u>

Dimensional Control

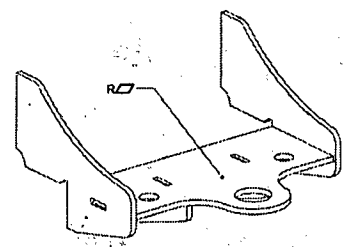
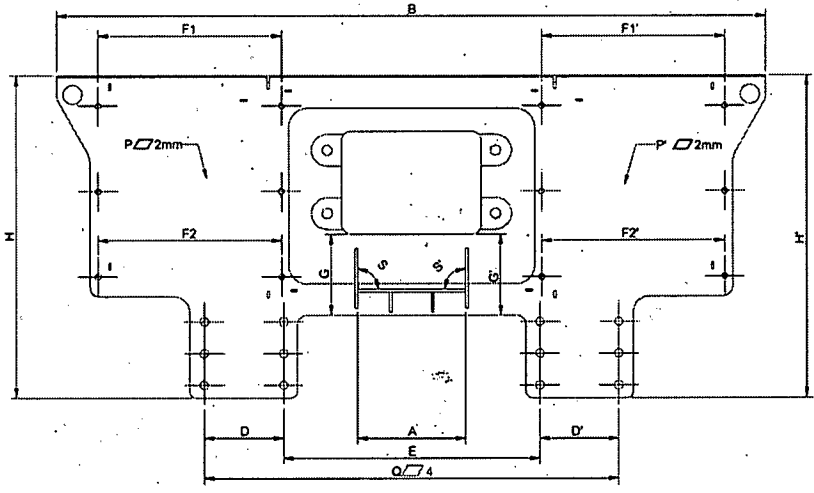
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2214	2214	Tape Measure	Acceptable
D / D'	956	± 2	955	955		Acceptable
QC Inspector:	<i>LEON</i>		Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>02</u> / <u>12</u>

Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planity P / P'		2 mm	<i>Passed</i>		Ruler	<i>Acceptable</i>
Perpendicularity	2	A	<i>Passed</i>		Set Square	<i>Acceptable</i>
	2	B	<i>Passed</i>		Set Square	<i>Acceptable</i>
QC Inspector:	<i>LEON</i>		Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>02</u> / <u>12</u>

Cabin Front Headstock Assembly: GN002841

Assembly Completed as per WI/SOS MD_0019	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator: TK BOON	Assembly Date:	2024/02/06			
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:	2024/02/07		

Dimensional Control

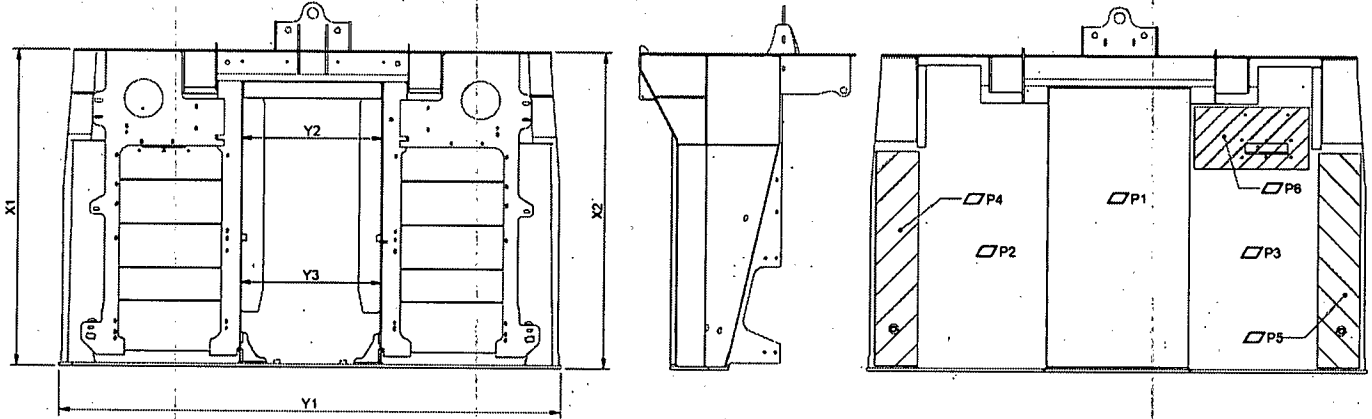
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	± 1	339		Tape Measure	Accepted
B	2240	± 4	2244			Accepted
D / D'	250	± 1	251	251		Accepted
E	808	± 2	808			Accepted
F1 / F1'	580	± 1	581	581		Accepted
F2 / F2'			581	581		Accepted
G / G'	258	± 1	259	259		Accepted
H / H'	1019	± 2	1020	1020		Accepted
QC Inspector: LEON	Sign:	Date:	2024/02/07			

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
O: Planeity of global assembly	4 mm	Ruler	Accepted
P / P': Planeity	2 mm	Ruler	Accepted
Q: Planeity Surface of Supports	4 mm	Ruler	Accepted
R: Planeity Coupler Support	2 mm	Ruler	Accepted
S: Perpendicularity coupler	1mm	Square	Accepted
QC Inspector: LEON	Sign:	Date:	2024/02/07

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>02</u> / <u>12</u>	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202158	



Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	<i>Leow</i>	Sign:	<i>[Signature]</i>	Date: 20 <u>24</u> / <u>02</u> / <u>12</u>

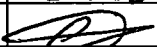
Dimensional Control

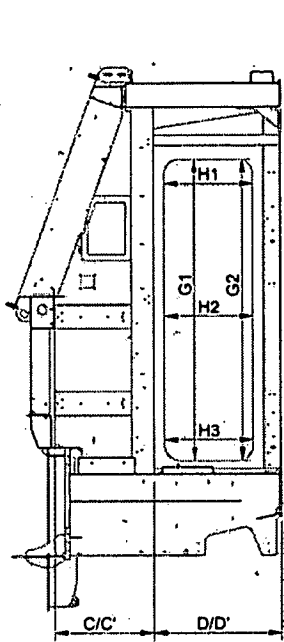
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	<i>1485</i>	<i>1486</i>	Tape Measure	ACCEPTABLE
Y1	2354	± 3	<i>2352</i>			<i>Acceptable</i>
Y2 / Y3	666	± 1	<i>666</i>	<i>666</i>		ACCEPTABLE
QC Inspector:	<i>Leow</i>	Sign:	<i>[Signature]</i>		Date:	20 <u>24</u> / <u>02</u> / <u>12</u>

Geometrical Control

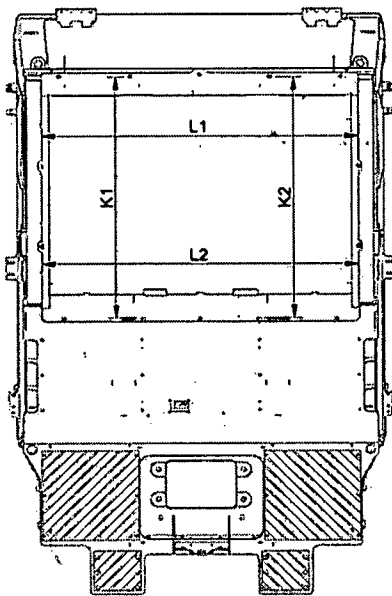
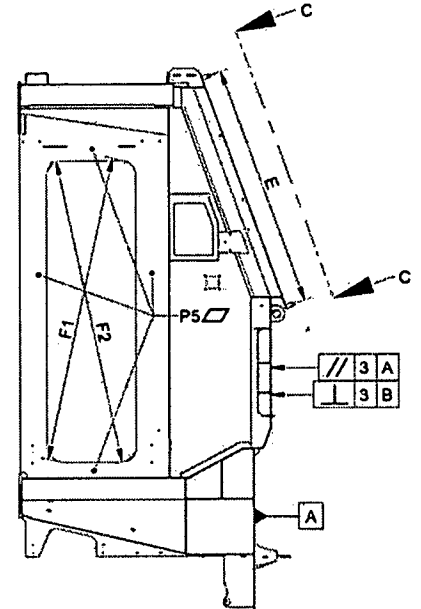
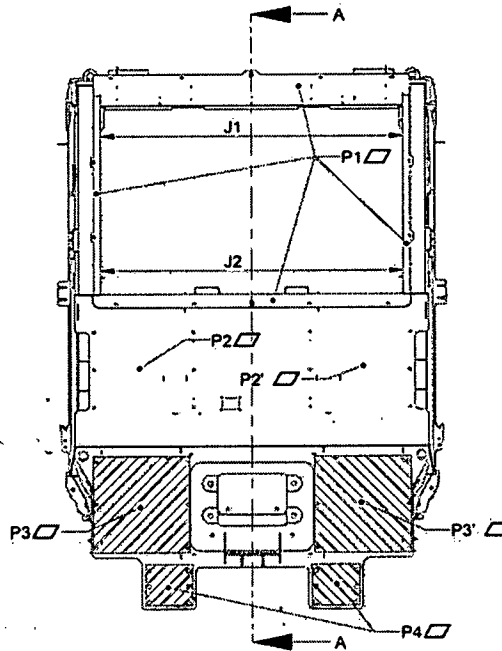
Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Ruler	<i>Acceptable</i>
P2 / P3 : Planeity	4 mm	Ruler	<i>Acceptable</i>
P4 / P5 : Planeity	2 mm	Ruler	<i>Acceptable</i>
P6 : Planeity	2 mm	Ruler	<i>Acceptable</i>
QC Inspector:	<i>Budley</i>	Sign:	<i>[Signature]</i> Date: 20 <u>24</u> / <u>02</u> / <u>12</u>

Cabin Structure Assembly: GN002834

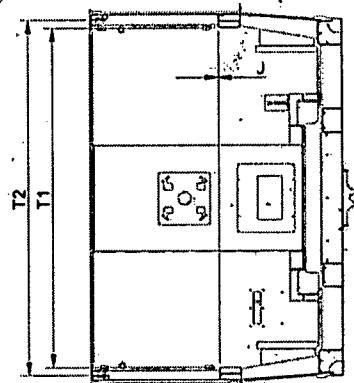
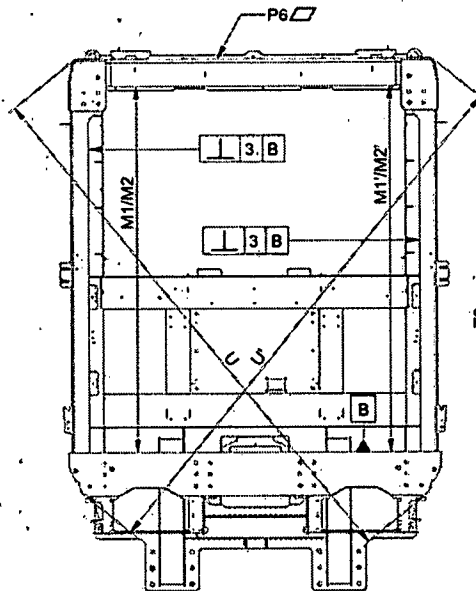
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	/	No
Operator:	<i>CHARL BLOEM</i>	Assembly Date:	20.24/07.12		
Sign:		Wire Batch No.:	2202152.		



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:

LOW

Sign:

Date:

2024/02/12

Dimensional Control

Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations
C / C'	625	± 2	626	626.	ACCEPTABLE
D / D'	813	± 2,5	812	812	ACCEPTABLE
E	1531.5	± 3	1530		ACCEPTABLE
G1 / G'1	Height	+1	1898.	1898.	ACCEPTABLE
G2 / G'2	1900	-3	1898	1898.	ACCEPTABLE
H1 / H'1	Width 560	+1	558	558.	ACCEPTABLE
H2 / H'2		-3	558	559	ACCEPTABLE
H3 / H'3			559.	560	ACCEPTABLE
F1 / F'1	Diagonals 1939		1936	1936	ACCEPTABLE
F2 / F'2			1936	1935	ACCEPTABLE
Difference	F1-F2 / F'1-F'2	≤ 4	0	1	ACCEPTABLE
J	Gap of Doors	± 1,5	0		ACCEPTABLE
K1 / K'2	1515	± 3	1514	1515	ACCEPTABLE
L1 / L'2	1996	± 3	1997	1997.	ACCEPTABLE
M1 / M'1	2306	± 3	2477.	2477.	ACCEPTABLE
M2 / M'2			2465	2465.	ACCEPTABLE
T1 / T'1	2130 Top/Bottom	± 3	2129	2130	ACCEPTABLE
T2 / T'2	2230 Top/Bottom		2230	2229.	ACCEPTABLE
Difference	U - U' (3522)	≤ 4mm	3520	3519.	ACCEPTABLE

QC Inspector:

LOW

Sign:

Date:

2024/02/12

Geometrical Control

Nature of checks		Toler.	LHS / Dimension Measured / RHS		Observations
P1 / P'1	Planity	2 mm	Pass		ACCEPTABLE
P2 / P'2	Planity	2 mm	Pass		ACCEPTABLE
P3 / P'3	Planity	4 mm	Pass		ACCEPTABLE
P4 / P'4	Planity	4 mm	Pass		ACCEPTABLE
P5 / P'5	Planity	4 mm	Pass		ACCEPTABLE
P6 Roof	Planity	6 With 2m Ruler	Pass		ACCEPTABLE
Shield	//	3 A	3	Pass	ACCEPTABLE
Shield	⊥	3 A	3	Pass	ACCEPTABLE
Door Post	⊥	3 A	Front	Pass	ACCEPTABLE
			Back	Pass	ACCEPTABLE

QC Inspector:


LOW

Sign:

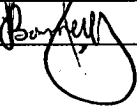
Date:

2024/02/12

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 24/02/12			
Sign:		Wire Batch No.:	2202152			

Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	JERRY W	Assembly Date:	2024/02/12			
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:			
Date: 2024/03/12				

Record of Shot Blasting

Operator:	Date:	2024/03/12
Start Time: 08 15	End Time:	15-00
Temperature ($\geq 15^\circ$): 20-04 $^\circ$ C	Humidity ($\leq 75\%$):	63-09%

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: 2024/03/12				

Shot Blasting Cleaning

Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator: DAVID	Sign:			
Date: 2024/03/12				

Shot Blasting Control

Temperature $\geq 15^\circ$: 19-09 $^\circ$ C	Humidity $\leq 75\%$:	65-02%
Internal Roughness 3.2 \leq Ra \leq 12.5	External Roughness 3.2 \leq Ra \leq 12.5	9, 8 Ra 10, 7 Ra
QC Inspector: DAVID Rudley	Sign:	
Date: 12/03/24		

Record of Priming

Start Time:	18:00	End Time:	20:00
Temperature ≥ 15°:	27°C	Humidity ≤ 75%:	60%
Paint Batch No.:	7978267	Paint Expiry Date:	06/25
Hardener Batch No.:	7331119	Hardener Expiry Date:	01-11-2024
Desolvation Start Time:	20:00	Desolvation End Time:	20:15
Stoving Start Time:	20:15	Stoving End Time:	21:15
Stoving Temp:	60°C		
Operator:	CRAIG	Sign:	CRAIG
Date:	2024/03/12		

Priming Control


DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 43.8	5: 63.4	1: 66.4	5: 62.6	1: 48	5: 59	1: 71	5: 63
2: 61.9	6: 72.9	2: 51.0	6: 42.9	2: 63	6: 51	2: 69	6: 84
3: 54.4	7: 77.7	3: 46.6	7: 69.7	3: 65	7: 78	3: 60	7: 58
4: 68.7	8: 81.6	4: 58.7	8: 73.6	4: 74	8: 70	4: 65	8: 53
Min:	42.8	Min:	42.9	Min:	48	Min:	53
Max:	81.6	Max:	73.6	Max:	78	Max:	84
Average:	65.6	Average:	58.4	Average:	63.5	Average:	65.3
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 64	5: 45	1: 68	5: 59	1: 65	5: 51	1: 62	5: 74
2: 65	6: 44	2: 41	6: 44	2: 54	6: 72	2: 63	6: 81
3: 74	7: 73	3: 63	7: 75	3: 50	7: 55	3: 60	7: 78
4: 63	8: 62	4: 53	8: 81	4: 68	8: 58	4: 70	8: 75
Min:	44	Min:	41	Min:	50	Min:	60
Max:	74	Max:	81	Max:	72	Max:	81
Average:	61	Average:	53.8	Average:	50.6	Average:	62.6
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 69	5: 48	1: 72	5: 61	1: 72	5: 66	1: 63	5: 63
2: 42	6: 64	2: 79	6: 68	2: 78	6: 71	2: 72	6: 49
3: 43	7: 70	3: 70	7: 79	3: 79	7: 74	3: 81	7: 55
4: 59	8: 66	4: 74	8: 73	4: 65	8: 62	4: 68	8: 64
Min:	42	Min:	61	Min:	62	Min:	49
Max:	70	Max:	79	Max:	79	Max:	81
Average:	56	Average:	72	Average:	70.8	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:	13 Mar 2024					

Record of Painting NCSS3010 R90B

Start Time:	09:00	End Time:	10:00
Temperature ≥ 15°:	26°C	Humidity ≤ 75%:	62%
Paint Batch No.:	8156903	Paint Expiry Date:	23.01.2025
Hardener Batch No.:	7502115121	Hardener Expiry Date:	12/24
Desolvation Start Time:	10:00	Desolvation End Time:	10:15
Stoving Start Time:	10:15	Stoving End Time:	11:15
Stoving Temp:	60°C		
Operator:	MUSA	Sign:	MUSA
Date:	2024/02/14		

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: 96.8	5: 103.2	1: 81.2	5: 112.1		
2: 102.4	6: 100.9	2: 77.6	6: 96.8		
3: 74.6	7: 82.6	3: 90.8	7: 84.3		
4: 82.3	8: 113.8	4: 106.8	8: 113.3		
Min: 78.6		Min: 77.6			
Max: 103.2		Max: 113.3			
Average: 94.2		Average: 95.3			
Painting NCSS3010 R90B has been inspected and is free of defects					
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	39.6
QC Inspector:	Peece			Sign:	R.Booth
Date:	13/03/24				

Record of Painting Blue NCSS1565 B

Start Time:	1400	End Time:	1500
Temperature ≥ 15°:	29°C	Humidity ≤ 75%:	59%
Paint Batch No.:	876318	Paint Expiry Date:	02-02-2025
Hardener Batch No.:	750245121	Hardener Expiry Date:	12/24
Desolvation Start Time:	1500	Desolvation End Time:	1515
Stoving Start Time:	1515	Stoving End Time:	1615
Stoving Temp:	60°C		
Operator:	MUSA	Sign:	MUSA
Date:	2024-03-14		

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: 84	5: 118	1: 78.6	5: 104.9		
2: 96	6: 104	2: 77	6: 113.6		
3: 100	7: 116.9	3: 106.6	7: 86.9		
4: 79.8	8: 121.8	4: 86.7	8: 102.4		
Min: 79.8	Min: 77				
Max: 121	Max: 106.6				
Average: 105	Average: 94.4				
Painting NCSS3010 R90B has been inspected and is free of defects					
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	90.6
QC Inspector:		Reece		Sign:	[Signature]
Date:		13/06/24			

Record of RAL 7012

Start Time:	03:00	End Time:	05:00
Temperature ≥ 15°:	27°C	Humidity ≤ 75%:	56%
Paint Batch No.:	8156853	Paint Expiry Date:	06.02.2025
Hardener Batch No.:	7502115121	Hardener Expiry Date:	12/24
Desolvation Start Time:	05:00	Desolvation End Time:	05:15
Stoving Start Time:	05:15	Stoving End Time:	06:15
Stoving Temp:	60°C		
Operator:	NTUTEHWIKO	Sign:	N. N. Shamba
Date:	20 24 03/14		

RAL 7012 Control

DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 118	5: 124	1: 128	5: 135	1: 9116	5: 108	1: 116	5: 143
2: 119	6: 119	2: 136	6: 131	2: 843	6: 79.9	2: 124	6: 135
3: 126	7: 123	3: 124	7: 94.7	3: 110	7: 100	3: 138	7: 138
4: 108	8: 124	4: 120	8: 107	4: 109	8: 120	4: 141	8: 136
Min:	108	Min:	94.7	Min:	79.8	Min:	116
Max:	134	Max:	135	Max:	120	Max:	143
Average:	121	Average:	121	Average:	100	Average:	133

DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 126	5: 124	1: 155	5: 112	1: 160	5: 158	1: 110	5: 154
2: 911	6: 117	2: 139	6: 119	2: 123	6: 151	2: 132	6: 85.3
3: 108	7: 120	3: 158	7: 132	3: 128	7: 135	3: 127	7: 81.4
4: 138	8: 128	4: 144	8: 110	4: 136	8: 126	4: 90.3	8: 105
Min:	911	Min:	110	Min:	123	Min:	85.3
Max:	138	Max:	155	Max:	160	Max:	154
Average:	119	Average:	133	Average:	139	Average:	110

DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 136	5: 98.2	1: 141	5: 110				
2: 141	6: 101	2: 96.1	6: 100				
3: 138	7: 124	3: 73.4	7: 96.6				
4: 131	8: 122	4: 80.9	8: 101				
Min:	98.2	Min:	73.4				
Max:	141	Max:	141				
Average:	123	Average:	99.8				

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				
QC Inspector:	Zothile	Sign:	[Signature]		
Date:	14 Mar 2024				

SEALING OF CABIN

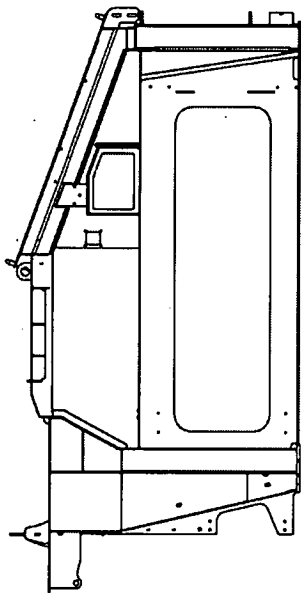
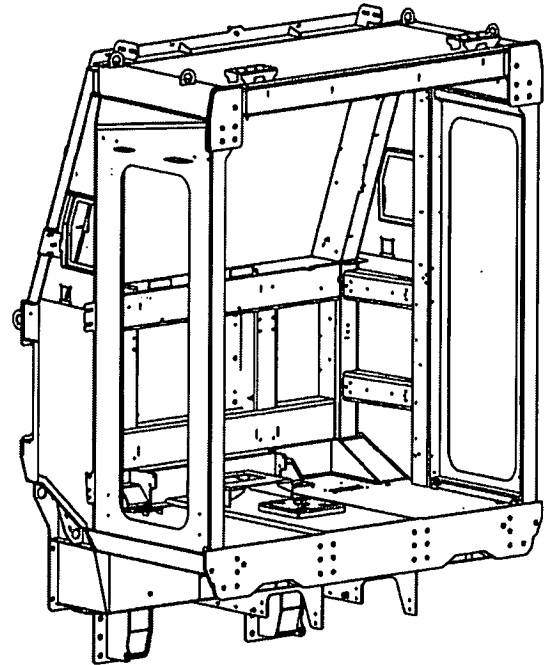
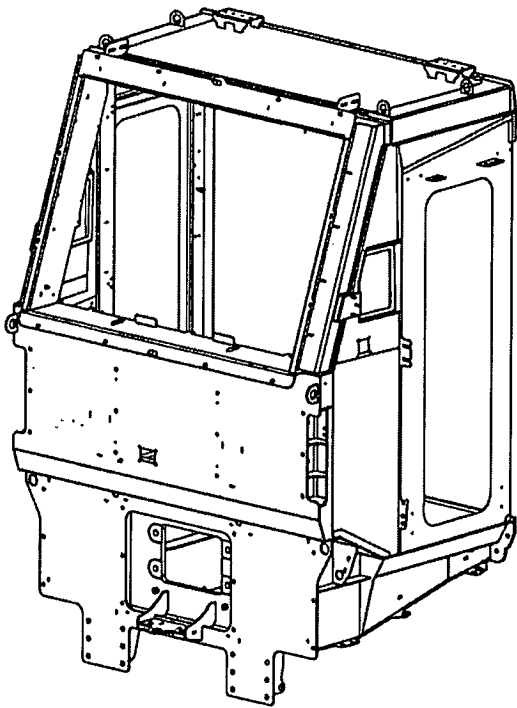
All areas where there is no welding has been sealed with SIKA	Confirmed	YES	<input checked="" type="checkbox"/>	NO	<input type="checkbox"/>
All sealants have been neatly applied along joints	Confirmed	YES	<input checked="" type="checkbox"/>	NO	<input type="checkbox"/>

SIGN OFF

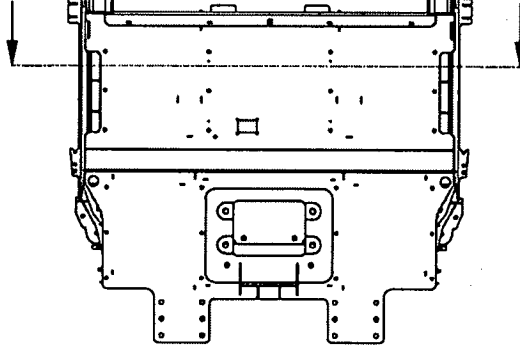
CLOCK No:	2400	OPERATOR SIGN:	Aphile	DATE:	14/03/2024
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REWORK IDENTIFICATION

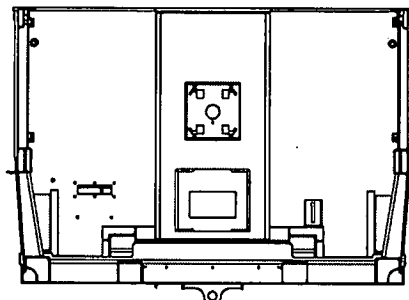
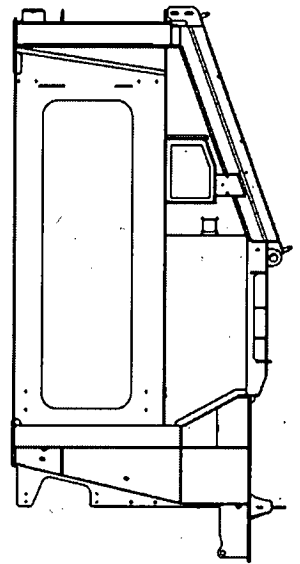
(MARK SECTIONS EFFECTED NUMERICALLY)

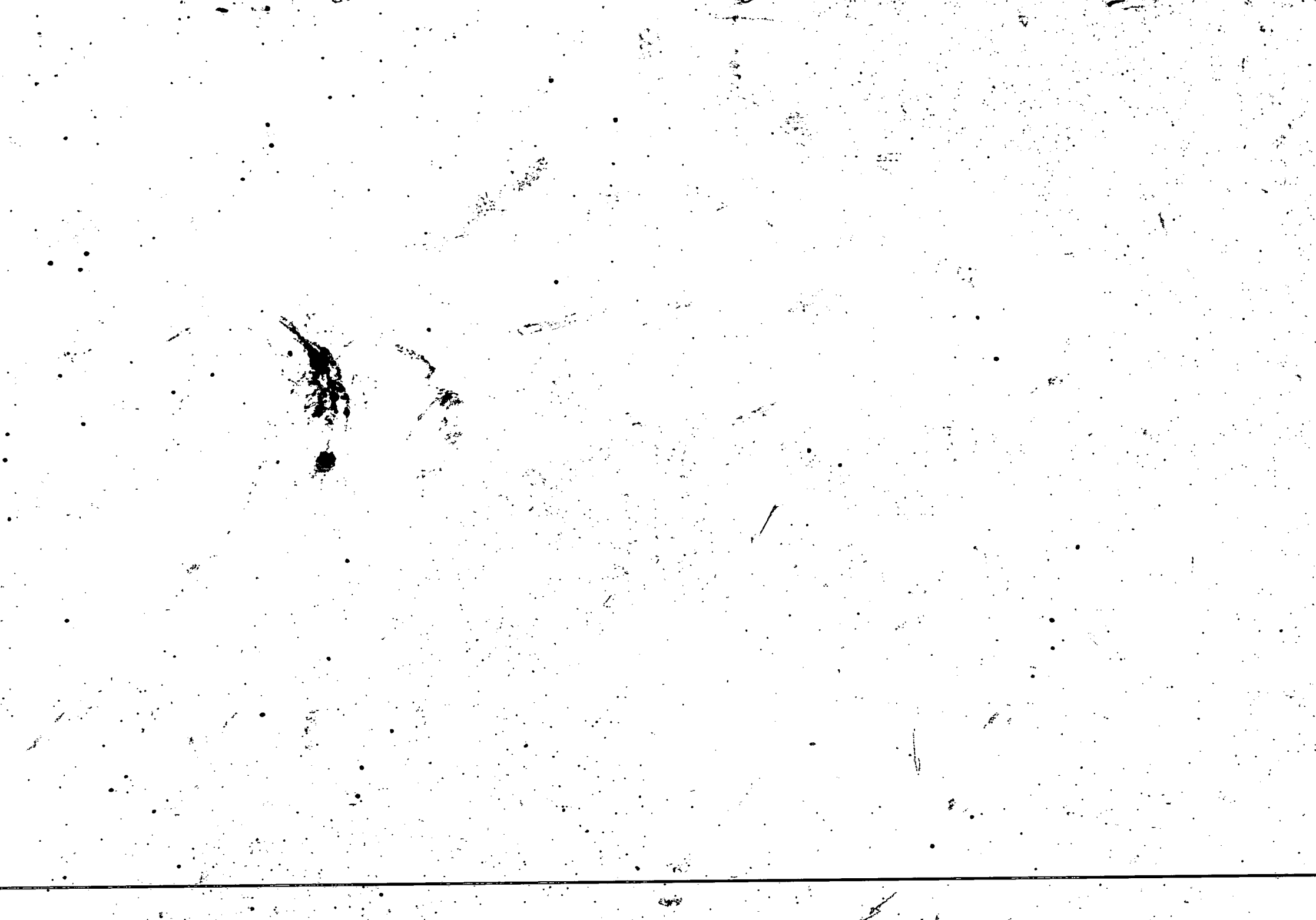


1SEC0001



1SEC0001







CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	0440	Checks Updated:	2022/08/26

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	○			
2	NO PIN HOLES ON CAB STRUCTURE	○			
3	SEALANT IS APPLIED CORRECTLY <ul style="list-style-type: none"> • JOINTS ARE CLOSED • NO BREAKS IN THE SEALANT • CORRECT BEAD 	○			
4	RIVET NUTS ARE PROPERLY CRIMPED <ul style="list-style-type: none"> • RIVETS ARE MARKED • CORRECT GRIP RANGE USED 	○			
5	NO MISS WELDS PRESENT AFTER SANDBLASTING	○			
6	NO VISUAL MISS WELDS (INSPECTION AFTER SEALING)	○			
7					
8					
9					
10					
11					
12					
13					
14					

Quality approval for release Signature	CO. NO.	DATE
	2285	14 Mar 2024