



APPLICABLE FROM TRAINSET 190+ AS PER BASELINE 10.4

SELF INSPECTION SHEET

CONFIDENTIAL INFORMATION


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

APPLICATION REFERENCE

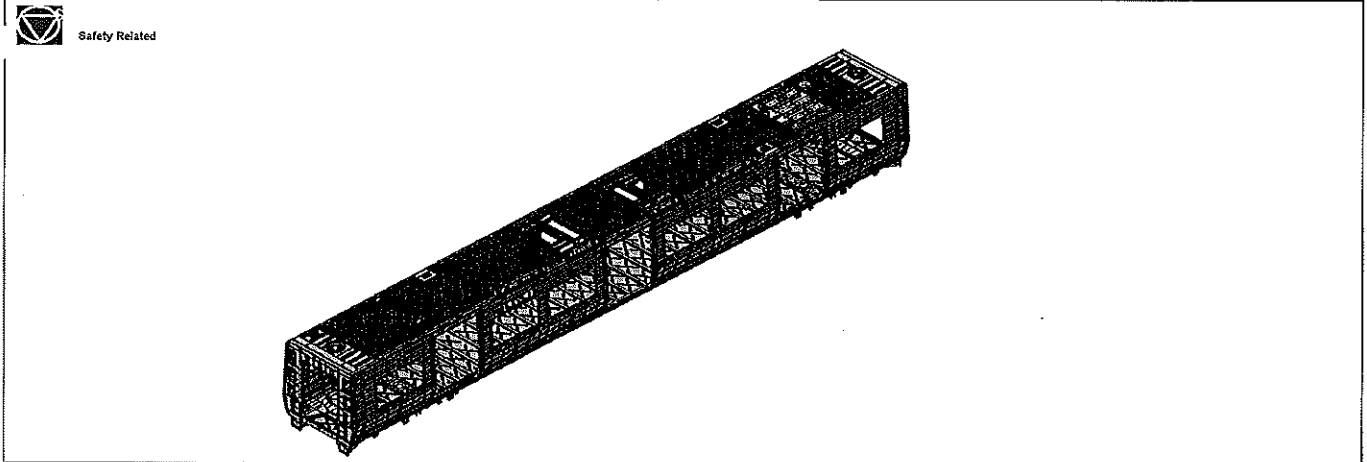
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?	
				TCA	M4	M	M2	M3	TCA			
<input type="checkbox"/>	DTR30225487/3	AAD0001276566	CARBODYSHELL M3, M4 ASSEMBLY	CB2210					X		PRA.CB2210.TR30225487/3.V30	YES

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018
			CHECKER	Nosizo Pindela	10/01/2018
			COMPILER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	CHECKER	Nosizo Pindela	2018/05/18
			REVISOR	Ramokone Motama	2018/05/18
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1290	APPROVER	Itumeleng Modiba	2018/07/04
			CHECKER	Nosizo Pindela	2018/07/04
			REVISOR	Ramokone Motama	2018/07/04
3	2018/12/12	Added dimensional check points to CB2210	APPROVER	Itumeleng Modiba	2018/12/12
			CHECKER	Nosizo Pindela	2018/12/12
			REVISOR	Ramokone Motama	2018/12/12
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	22/01/2019
			CHECKER	Nosizo Pindela	22/01/2019
			REVISOR	Vanessa Ntuli	22/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISOR	Nosizo Pindela	13/03/2019
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	21/08/2019
			CHECKER	Nosizo Pindela	21/08/2019
			REVISOR	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	06/08/2020
			REVISOR	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			REVISOR	Bongane Masina	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISOR	Mpho Mulaudzi	17/08/2021
25	19/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	19/02/2022
			CHECKER	Andani Muthelo	19/02/2022
			REVISOR	Andani Muthelo	19/02/2022
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlampe Amogelang	14/04/2023
			REVISOR	Mohlampe Amogelang	14/04/2023
30	20/07/2023	New Baseline change 10.4	APPROVER	Ngobeni Tyson	28/07/2023
			CHECKER	Mohlampe Amogelang	28/07/2023
			REVISOR	Mohlampe Amogelang	28/07/2023
31	07/11/2023	Added traceability for welding sections	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Mohlampe Amogelang	07/11/2023
			REVISOR	Ntokozo Zwane	07/11/2023

TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
15022	M4	P. MCA... 409964	11/04/24	SI.CB2210.254.V30	17

	CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3	Rev. 31	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	

Car: M3 & M4	NCR:	Work station: CB2210
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I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	M3	M4	M2	M3	M4	CB					
DTR30225487/3					X		V31		✓	[Signature]	[Signature] 11/07/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULAR	30823-0	15/03/25	✓	[Signature]	[Signature]
LASER TAPE	105425924	02/01/25	✓	[Signature]	[Signature] 11/04/24
20M TAPE	G16770102	18/11/24	✓	[Signature]	[Signature]

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSi	814018-74097	MIG	✓	[Signature]	[Signature] 11/07/24
ER 308 L	099687-70527	TIG	✓	[Signature]	[Signature]





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II - Self Inspection - Items to Check

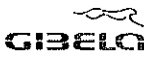
II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		11/04/24
02	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓		11/04/24
03	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		11/04/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		11/04/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓		11/04/24
06	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓		11/04/24

GIBELG

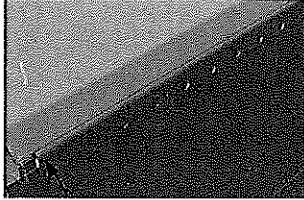
2024 -04- 11

INDUSTRIAL QUALITY
MAINLINE

	CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3	Rev. 31	Project: PRASA SI.CB2210,254.V30
		Date 07/11/2023	

Welding Traceability

Roof ring welds



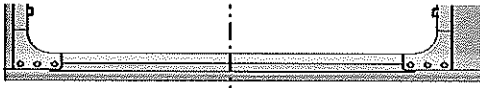
<p style="text-align: center;">LHS</p> Boiler maker (Name & Sign): <u>WINGA [Signature]</u>	<p style="text-align: center;">Welder (Name & Sign): <u>Sifb [Signature]</u></p>
<p style="text-align: center;">RHS</p> Boiler maker (Name & Sign): <u>[Signature]</u>	<p style="text-align: center;">Welder (Name & Sign): <u>Sifb [Signature]</u></p>

END 1

<p style="text-align: center;">LHS</p> Boiler maker (Name & Sign): <u>WINGA [Signature]</u>	<p style="text-align: center;">Welder (Name & Sign): <u>Sifb [Signature]</u></p>
<p style="text-align: center;">RHS</p> Boiler maker (Name & Sign): <u>[Signature]</u>	<p style="text-align: center;">Welder (Name & Sign): <u>Sifb [Signature]</u></p>

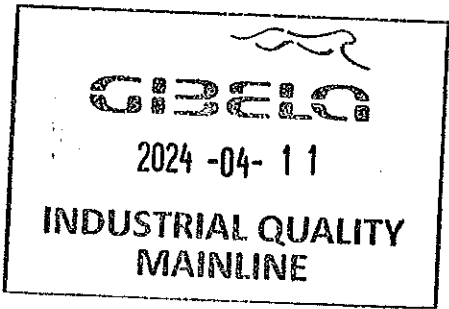
END 2

Door ring welds



<p style="text-align: center;">LHS</p> Boiler maker (Name & Sign): <u>WINGA [Signature]</u>
<p style="text-align: center;">Welder (Name & Sign): <u>KEITH K. WOOD</u></p>

<p style="text-align: center;">RHS</p> Boiler maker (Name & Sign): <u>Innocent [Signature]</u>
<p style="text-align: center;">Welder (Name & Sign): <u>KEITH K. WOOD</u></p>





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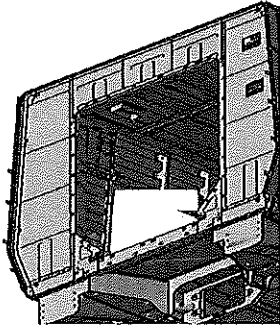
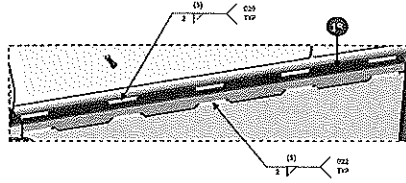
Date

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Project: PRASA

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EUF Reinforcement Plates



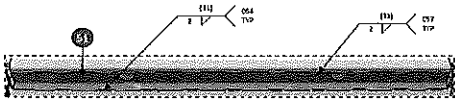
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Boiler maker (Name & Sign):

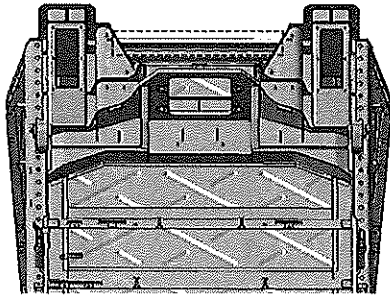
Tim Rader

Welder (Name & Sign):

NTINDIKOSI



END 2



Underneath the CAR

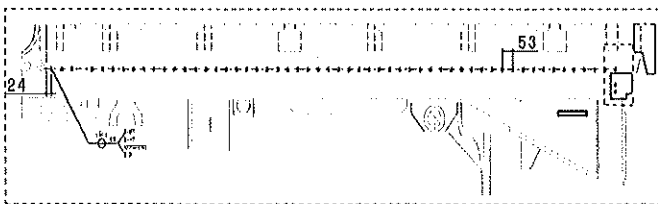
END 2

Boiler maker (Name & Sign):

GERALD

Welder (Name & Sign):

KEITH



FEDOLI

Operator:

SIPHOKAZI

GIBELQ

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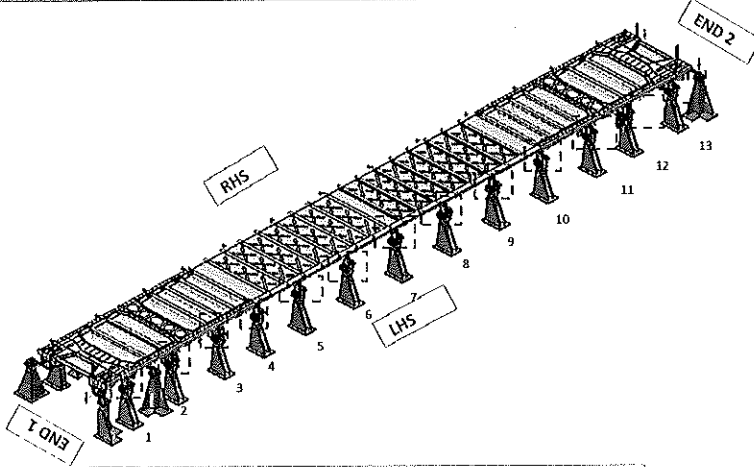


CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

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Specifications of Details for CBS measurement



Measure gap between jig pillar / chair and underframe = 0mm. No gap.

After loading and clamping

Fill in the gap found on each jig pillars / chair and underframe should be 0mm.

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0

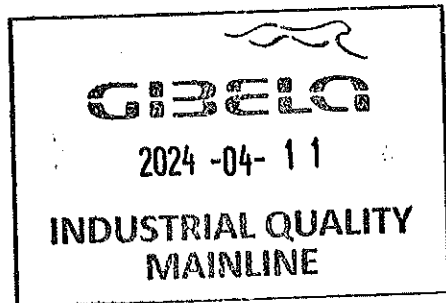
Signature Operations: Date: 11/04/23

After Welding.

Fill in the gap found each jig pillars / chair and underframe should be 0mm.

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0

Signature Industrial Quality: Date: 11/04/23



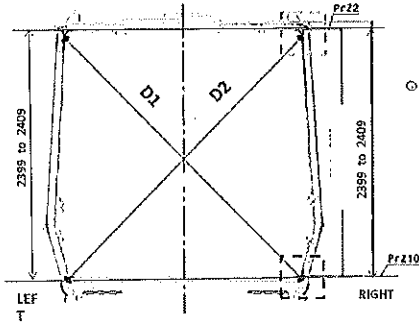
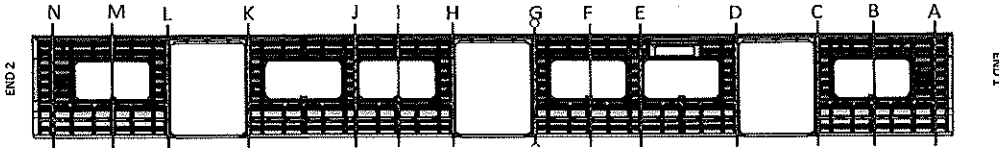


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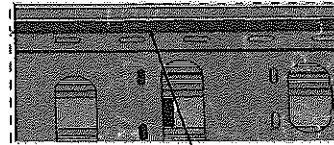
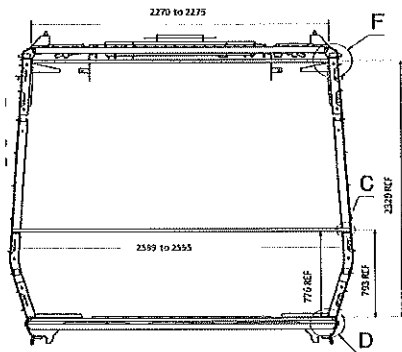
Specifications of Details for CBS measurement



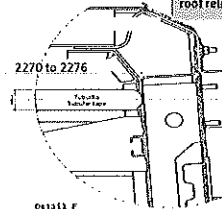
Measurement positions on roof rail and sidewall omega corner.



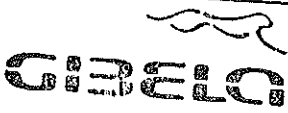
Measurement positions on sidewall and side sill corner.

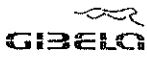


Reinforcement area measurement positions on roof reinforcement area.



Detail F
Don't forget to check the reinforcement


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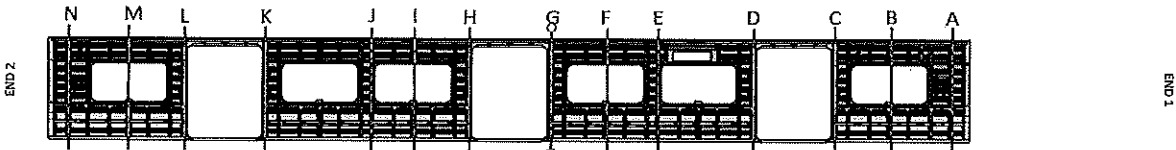


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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Specifications of Details for CBS measurement



PME Column LHS - RHS should be ≤ 2 MM on each point.

BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5 mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3267	3268	1	2404	2404	0
B	3270	3270	0	2406	2405	1
C	3268	3267	1	2404	2406	2
D	3268	3270	2	2404	2405	1
E	3271	3269	2	2404	2403	1
F	3269	3269	0	2406	2404	2
G	3269	3271	2	2405	2404	1
H	3268	3270	2	2403	2404	1
I	3269	3268	1	2405	2405	0
J	3271	3271	0	2406	2404	2
K	3269	3268	1	2405	2406	1
L	3266	3266	0	2404	2404	0
M	3269	3268	1	2406	2406	0
N	3265	3266	1	2405	2404	1

Handwritten signature and date: 11/04/24



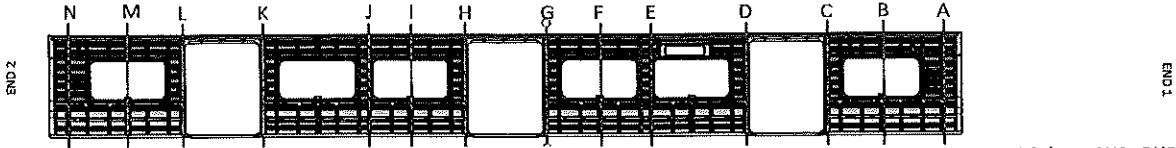


CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

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Specifications of Details for CBS measurement

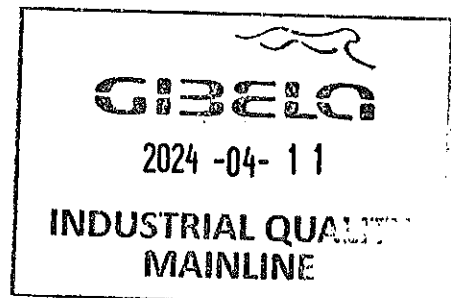


PME Column LHS - RHS should be $\leq 2\text{MM}$ on each point.

AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3096	3095	1	2404	2404	0
B	3069	3069	0	2406	2404	2
C	3098	3097	1	2405	2404	1
D	3099	3098	1	2404	2404	0
E	3068	3068	0	2405	2406	1
F	3069	3068	1	2405	2404	1
G	3095	3096	1	2406	2404	2
H	3098	3098	0	2404	2404	0
I	3068	3066	2	2405	2406	1
J	3066	3067	1	2404	2404	0
K	3096	3095	1	2406	2405	1
L	3095	3098	3	2404	2406	2
M	3066	3067	1	2404	2405	1
N	3096	3097	1	2404	2404	0

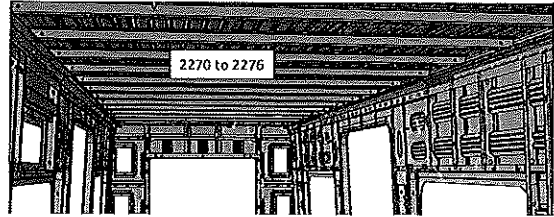
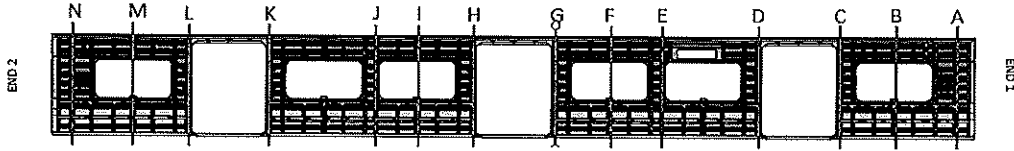
11/04/24



	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31	Project: PRASA SI.CB2210.254.V30
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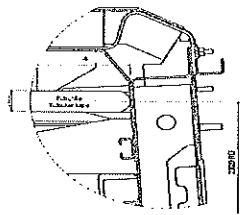
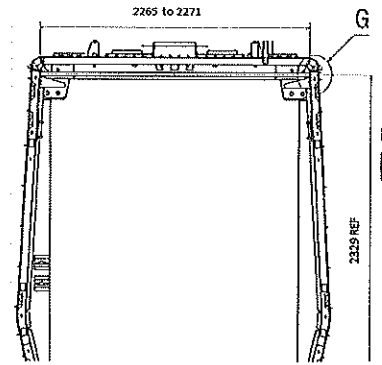
CBS measurement

BEFORE WELDING

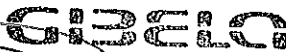


- 2270 to 2276
- A. 2271
 - B. 2275
 - C. 2274
 - D. 2275
 - E. 2276
 - F. 2274
 - G. 2272
 - H. 2274
 - I. 2276
 - J. 2276
 - K. 2274
 - L. 2276
 - M. 2274
 - N. 2274

Do not consider reinforcement (Take measurements top area of zee profile



Consider in the reinforcement detail



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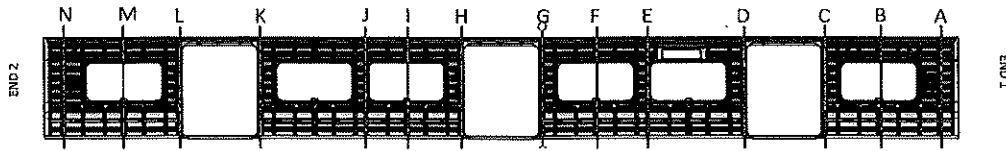
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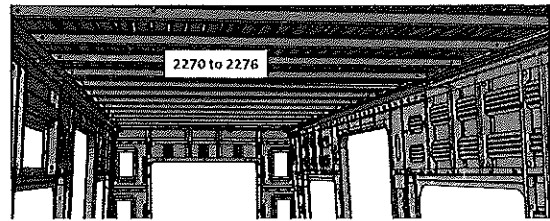
Project: PRASA
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CBS measurement

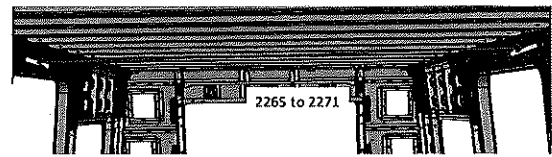
AFTER WELDING



	2265 to 2271	2270 to 2276
A	2268	
B		there
C	2268	
D	2266	
E		2276
F		2276
G	2268	
H	2269	
I		2276
J		2276
K	2268	
L	2268	
M		2274
N	2269	

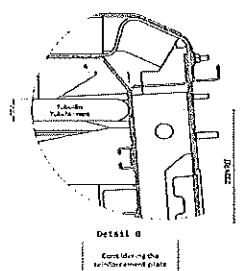
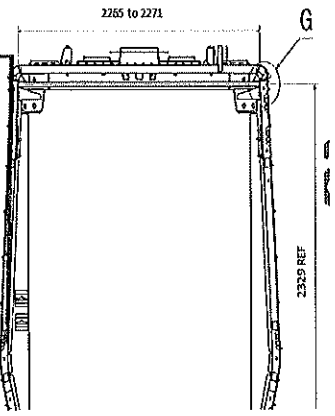


Do not consider reinforcement (Take measurements top area of zee profile



Take measurement close to radius (considering reinforcement)

GIBELQ
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2265 to 2271

Handwritten signature and number 409964

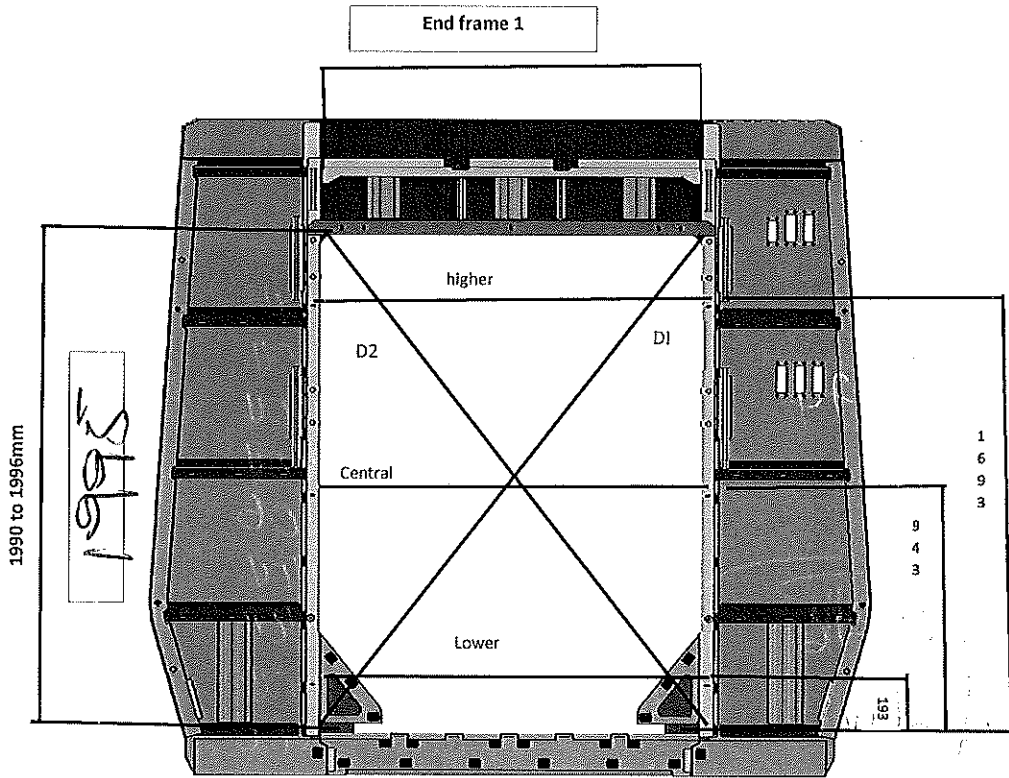


CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

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Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3mm$

Higher Dimension

1381

D1

2415

Central Dimension

1381

D2

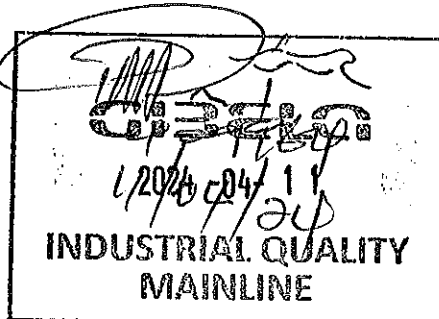
2416

Lower Dimension

1380

D1-D2

1



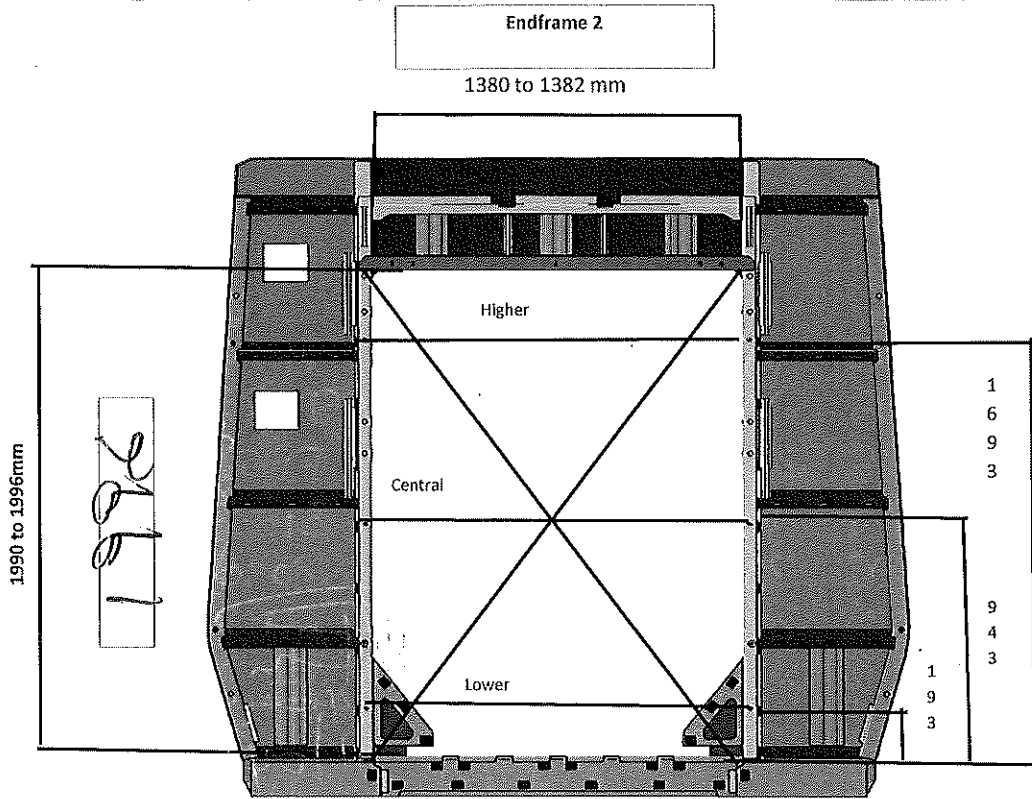


CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

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Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3mm$

Higher Dimension	1380	D1	24/15
Central Dimension	1381	D2	24/15
Lower Dimension	1381	D1-D2	0

GIBELCO
 2024-04-11
 INDUSTRIAL QUALITY
 11/04/2024

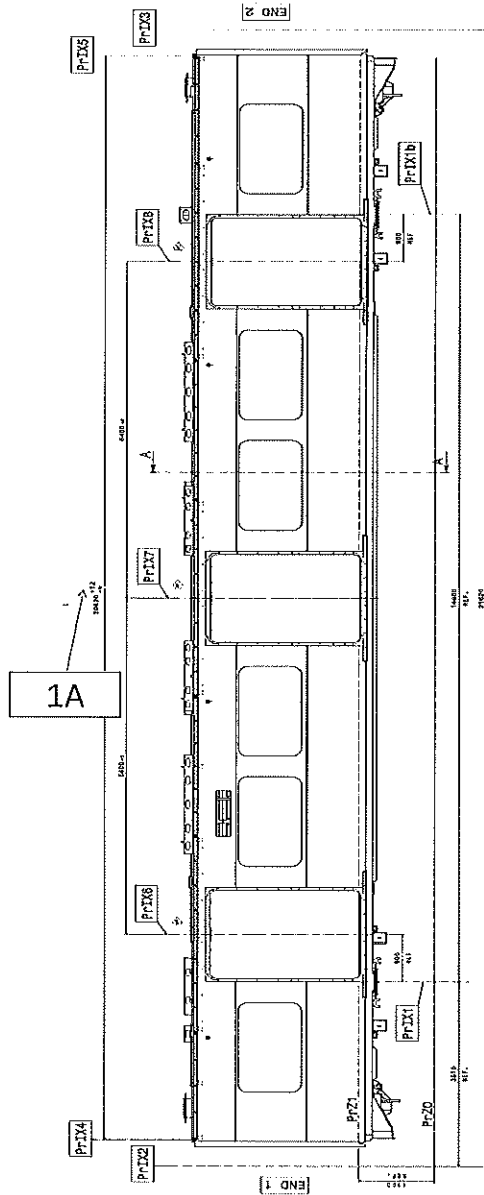


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SI.CB2210.254.V30

Specifications of Details for CBS measurement



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20615

RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20615

409969
11/04/24

Dye penetrant test

Dye-penetration test to be performed by quality personnel



2024 -04- 11
INDUSTRIAL QUALITY
MAINLINE



○

○

Self Inspection - Final Result

		DATE	NAME	SIGNATURE
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	11/04/2023	F. MALATSI Operations
			11/04/2023	Ambergelag Industrial Quality
	NO GO	There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)		
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)		

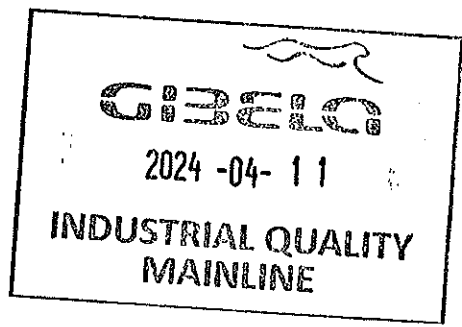
In case of "NO GO", describe blocking problems

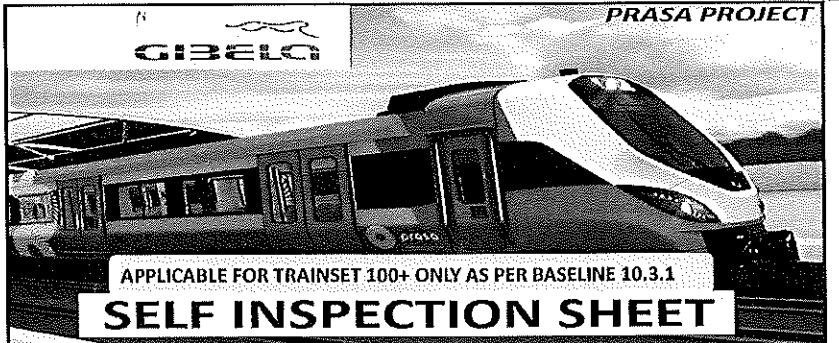
In case of "NO GO", the operations manager must define below action plan to ensure "GO":

Item	Description	Responsible	Due date	Status

Operations

Quality






APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1
SELF INSPECTION SHEET

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

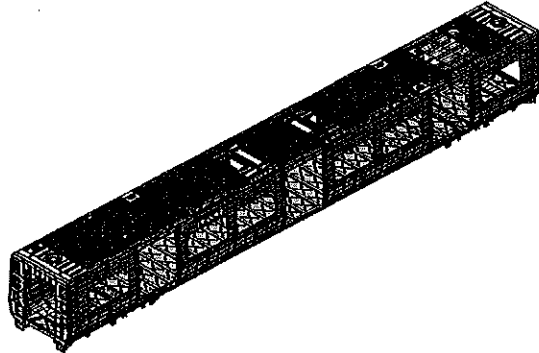
APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?
				TC1	MA1	MS1	MS2	MS3	TC2		
<input type="checkbox"/>	DIR30225481/2	CARBODYSHELL ML.F3.1% ASSEMBLY	CB2220		X	X			X	PRA.CB2220.DTR3022548 712.V21	YES
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<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE						
0	01/02/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	01/02/2018						
			CHECKER	Nosizo Pindela	01/02/2018						
			COMPILER	Thanyani Mathegu	01/02/2018						
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	18/05/2018						
			CHECKER	Nosizo Pindela	18/05/2018						
			REVISED BY	Ramokone Motama	18/05/2018						
2	2018/07/05	Certain dimensional checks added and others moved to CB1210	APPROVER	Itumeleng Modiba	2018/07/05						
			CHECKER	Nosizo Pindela	2018/07/05						
			REVISED BY	Ramokone Motama	2018/07/05						
3	2018/06/12	Width tolerance as per DT0000336600	APPROVER	Itumeleng Modiba	2018/06/12						
			CHECKER	Nosizo Pindela	2018/06/12						
			REVISED BY	Nosizo Pindela	2018/06/12						
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019						
			CHECKER	Nosizo Pindela	24/01/2019						
			REVISED BY	Vanessa Ntuli	24/01/2019						
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements Remove	APPROVER	Itumeleng Modiba	13/03/2019						
			CHECKER	Nosizo Pindela	13/03/2019						
			REVISED BY	Nosizo Pindela	13/03/2019						
10	22/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	22/08/2019						
			CHECKER	Nosizo Pindela	22/08/2019						
			REVISED BY	Nosizo Pindela	22/08/2019						
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020						
			CHECKER	Bongane Masina	06/08/2020						
			REVISED BY	Bongane Masina	06/08/2020						
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021						
			CHECKER	Bongane Masina	19/04/2021						
			REVISED BY	Bongane Masina	19/04/2021						
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021						
			CHECKER	Mpho Mulaudzi	17/08/2021						
			REVISED BY	Mpho Mulaudzi	17/08/2021						
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	19/02/2022						
			CHECKER	Andani Muthelo	19/02/2022						
			REVISED BY	Andani Muthelo	19/02/2022						
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbhombhi	14/06/2022						
			CHECKER	Andani Muthelo	14/06/2022						
			REVISED BY	Andani Muthelo	14/06/2022						
27	19/10/2022	Addition of traceability for sealant application & welding	APPROVER	Collins Mbhombhi	19/10/2022						
			CHECKER	Ntokozo Zwane	19/10/2022						
			REVISED BY	Amogelang Mohlampe	19/10/2022						
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023						
			CHECKER	Ntokozo Zwane	14/04/2023						
			REVISED BY	Amogelang Mohlampe	14/04/2023						
29	28/10/2023	Addition of bracket quantity	APPROVER	Ngebani Tyson	28/10/2023						
			CHECKER	Ntokozo Zwane	28/10/2023						
			REVISED BY	Amogelang Mohlampe	28/10/2023						
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES						
222	M04	Tetelo	10/04/24	SI.CB2220.250.V29	13						

RECEIVED
 05-17
 QUALITY


	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29	Project: PRASA SI.CB2220.250.V29
		Date 28/10/2023	

Car: A14, A338 A4	NCR:	Work station:	CB2220
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I - Documentation and Instruments Control





1.1 - Documentation Control

Document	Type of car					Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	M1	M2	M3	M4	M5					
DTR30225487/2									N/A	

10/04/24



1.2 - Instruments Control

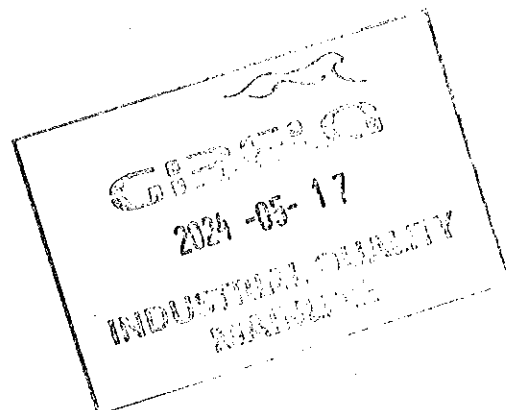
Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Turbular Measuring Tape	32823-3	15/05/25	✓	 10/04/24	 10/04/24
	GIBTP0391	05/05/24	✓	 10/04/24	 10/04/24

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Welding Wire	E231067	MIG Welding	✓	 10/04/24	 10/04/24



GIBELQ		CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2		Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29		
II - Self Inspection - Items to Check							
II.1 - Items to check							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB2220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB2220.DTR30225487/2	✓		10/04/24	10/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		10/04/24	10/04/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		10/04/24	10/04/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		10/04/24	10/04/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		10/04/24	10/04/24
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓		10/04/24	10/04/24
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: Temperature (Min - Max (°)) Min-Max 10°C - 35°C Relative humidity (Min - Max (%)) Min-Max 25% - 80%	Sealant Batch No: 20514390 Exp Date: 10/05/24 Actuals Temperature: 20 Humidity: 60	✓		12/04/24	10/04/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278555	✓		12/04/24	10/04/24
09		Verification of safety welds	Approved according to DTD0000210658 reference and Self inspection	✓		10/04/24	10/04/24

Approved according to
DTD0000210658 reference and
Self inspection

2024-05-17

INDUSTRIAL QUALITY
MAINLINE



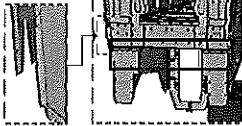
CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30226487/2

Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB2220.250.V29

II - Self Inspection - Items to Check

SEALANT APPLICATION



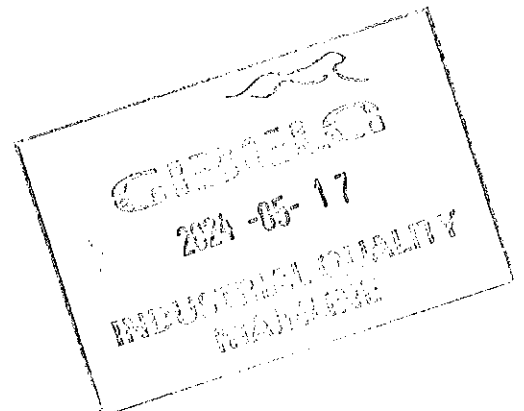
AREA 1 & 2 END 1


Operator (Name & sign):

Μετ. Ηολοζις:

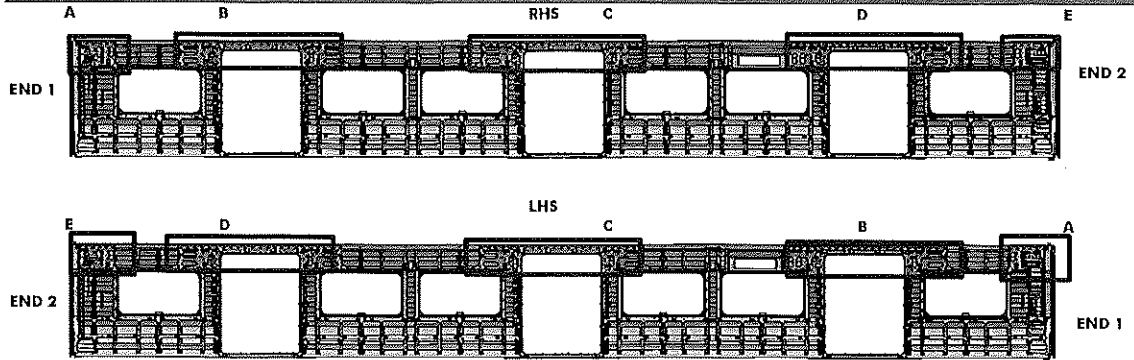
Operator (Name & sign):

Μετ. Ηολοζις:





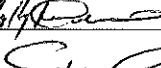
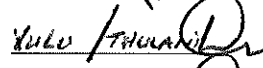
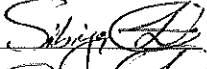
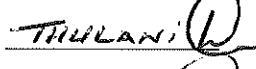
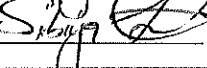
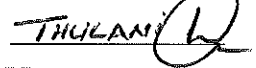


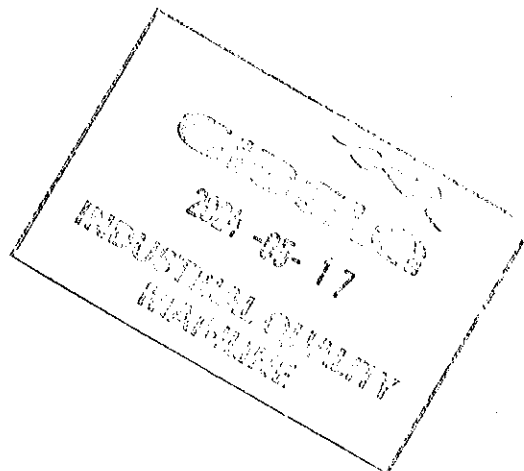
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project PRASA
		29	
		Date	SI.CB2220.250.V29
		28/10/2023	

II - Self Inspection - Items to Check

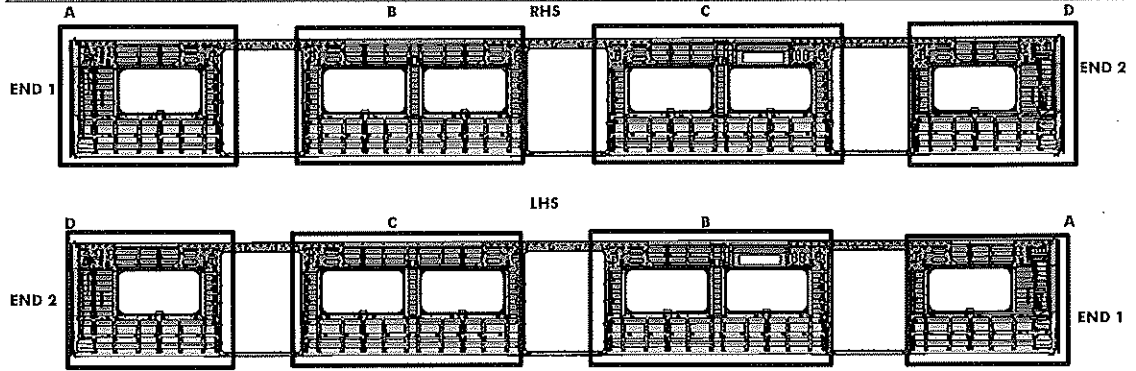


REINFORCEMENT WELDING

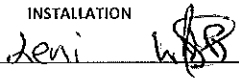
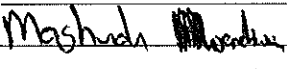
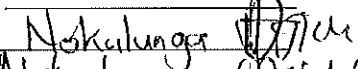

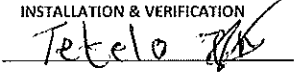
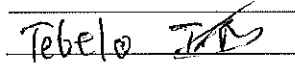
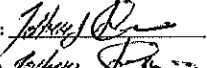

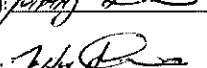
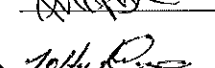
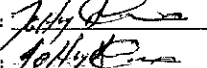

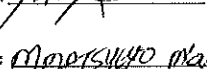
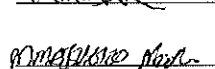

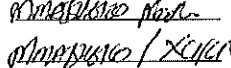
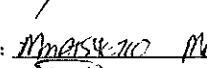
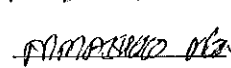
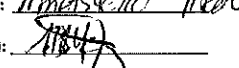
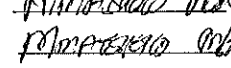


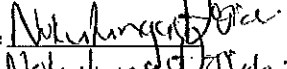
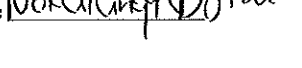
AREA	LHS	RHS
A	Operator (Name&sign): 	
B	Operator (Name&sign): 	
C	Operator (Name&sign): 	
D	Operator (Name&sign): 	
E	Operator (Name&sign): 	

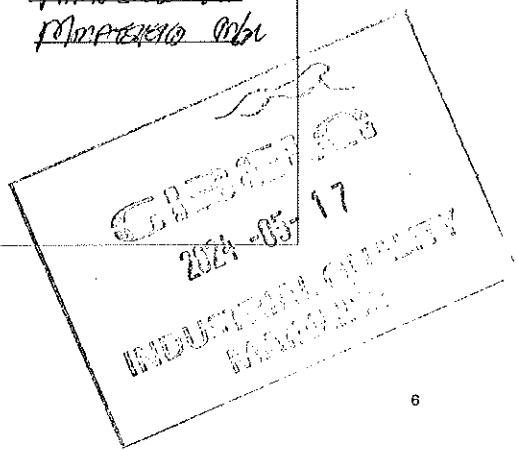


II - Self Inspection - Items to Check

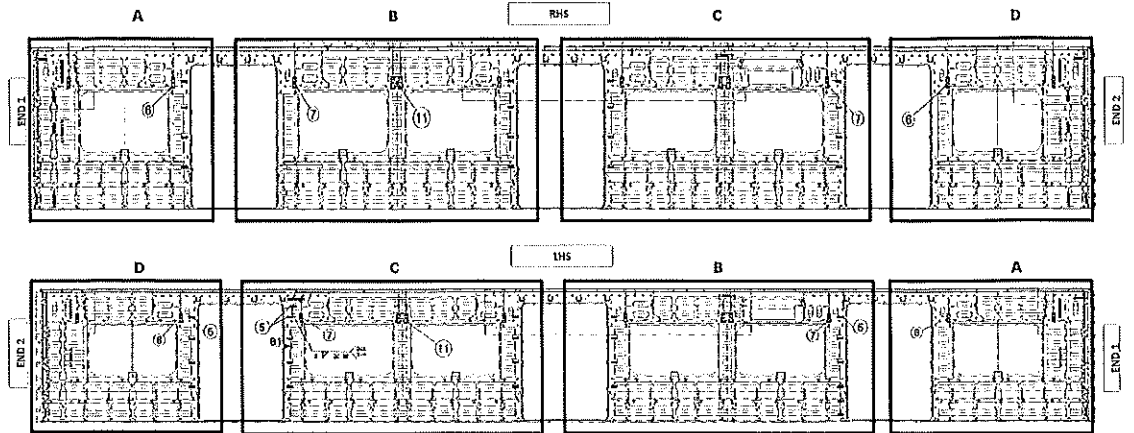


BRACKETING

INSTALLATION		
C-RAILS:	Operator: <u>Deni</u> 	
	Operator: _____	
DOOR MECHANISMS:	Operator: <u>Mashuda</u> 	
	Operator: _____	
TAPPING PADS	Operator: <u>Nokulunga</u> 	
	Operator: <u>Nokulunga</u> 	
INSTALLATION & VERIFICATION		
SEAT & LUGGAGE BRACKETS:	Operator: <u>Tebelo</u> 	
	Operator: _____	
SEAT BRACKETS VERIFICATION:	Operator: <u>Tebelo</u> 	
	Operator: _____	
WELDING		
AREA	LHS	RHS
A (Seat brackets)	Operator (Name&sign): <u>Johannes</u> 	<u>Johannes</u> 
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>Johannes</u> 	<u>Johannes</u> 
B (Seat brackets)	Operator (Name&sign): <u>Johannes</u> 	<u>Johannes</u> 
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>Johannes</u> 	<u>Johannes</u> 
C (Seat brackets)	Operator (Name&sign): <u>Mampesiso</u> 	<u>Mampesiso</u> 
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>Johannes</u> 	<u>Mampesiso / XCH</u> 
D (Seat brackets)	Operator (Name&sign): <u>Mampesiso</u> 	<u>Mampesiso</u> 
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>Mampesiso</u> 	<u>Mampesiso</u> 
ENDS		
END 1 TAPPING PADS WELDING:	Operator (Name&sign): <u>Nokulunga</u> 	
END 1 TAPPING PADS WELDING:	Operator (Name&sign): <u>Nokulunga</u> 	



M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

RHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7	✓	
	B	4	✓	
	C	8	✓	
	D	8	✓	
SEAT BRACKETS	A	13	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	3	✓	
	B	5	✓	
	C	4	✓	
	D	3	✓	

ROOF ENDS:
 CRAILS 2 OFF EACH END
 EARTH BUSH 6 OFF EACH END

VERIFICATION BY: Tetelo

LHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2	✓	
	B	6	✓	
	C	11	✓	
	D	8	✓	
SEAT BRACKETS	A	13	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	3	✓	
	B	5	✓	
	C	6	✓	
	D	2	✓	

ROOF ENDS:
 CRAILS 2 OFF EACH END
 EARTH BUSH 6 OFF EACH END

VERIFICATION BY: Tetelo

QUANTITIES (M1)

RHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7		
	B	8		
	C	8		
	D	8		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	2		
	B	4		
	C	5		
	D	3		

ROOF ENDS:
 CRAILS 2 OFF EACH END
 EARTH BUSH 6 OFF EACH END

VERIFICATION BY: _____

LHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	10		
	C	11		
	D	6		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	7		
	C	6		
	D	2		

ROOF ENDS:
 CRAILS 2 OFF EACH END
 EARTH BUSH 6 OFF EACH END

VERIFICATION BY: _____

GIBELO
 INDUSTRIAL QUALITY
 289-86-17
 MADE IN BRAZIL

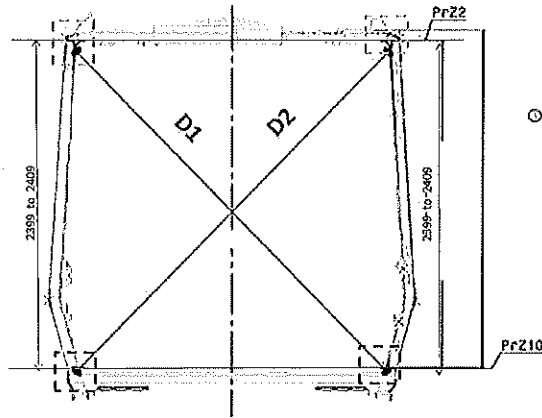


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

Rev.
29
Date
26/10/2023

Project: PRASA
SI.CB2220.250.V29

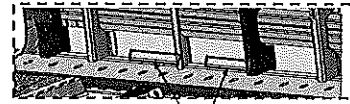
Specifications of Details for CBS measurement



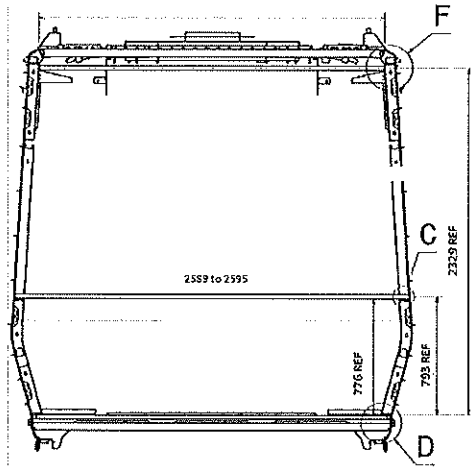
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



GIBELA
2024-05-17
INDUSTRIAL QUALITY
WARRANTY

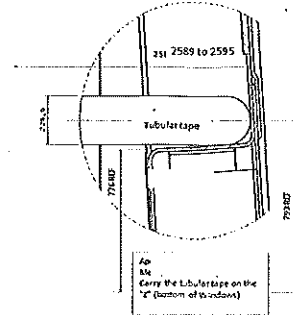
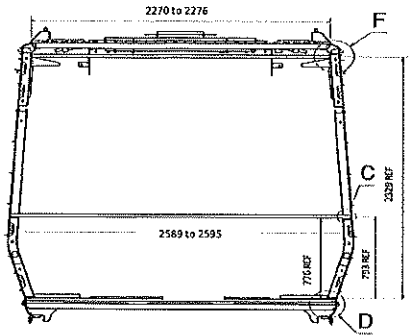


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30226487/2

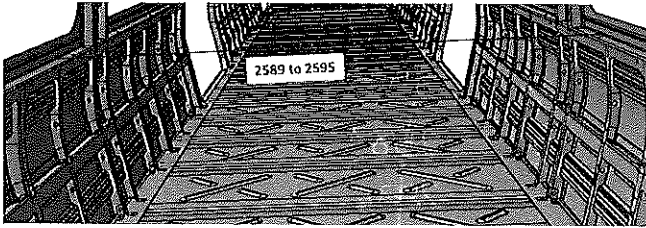
Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB2220.250.V29

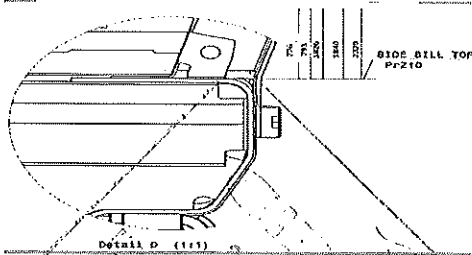
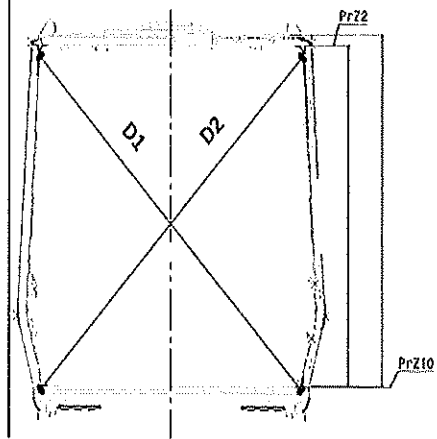
CBS measurement



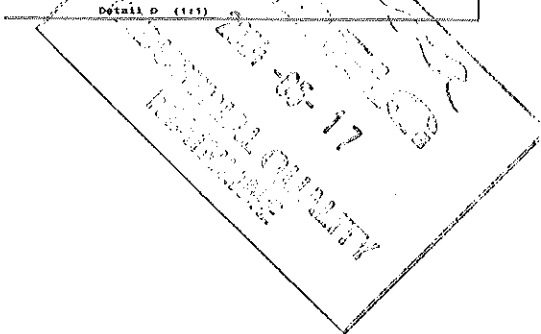
Detail C

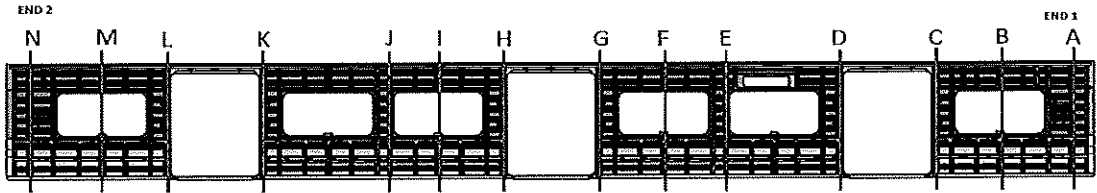


Take measurement close to
radius



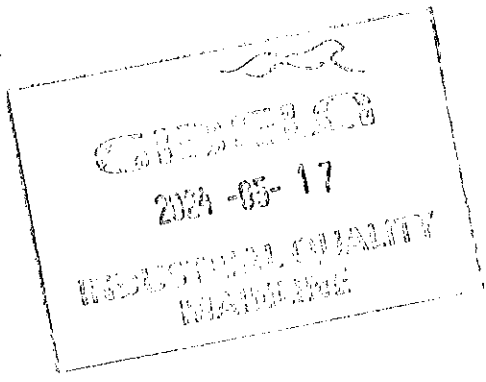
Detail D (1:1)





BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3230	3298	2	2590
B	3266	3268	2	2592
C	3296	3296	2	2589
D	3294	3296	2	2594
E	3266	3268	2	2592
F	3269	3266	3	2593
G	3297	3294	3	2594
H	3295	3296	1	2590
I	3268	3267	1	2591
J	3267	3266	1	2590
K	3296	3295	1	2590
L	3295	3296	1	2592
M	3267	3268	1	2592
N	3300	3297	3	2591



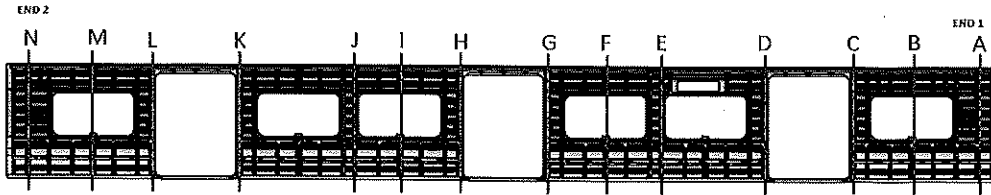


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

Rev.
29
Date
28/10/2023

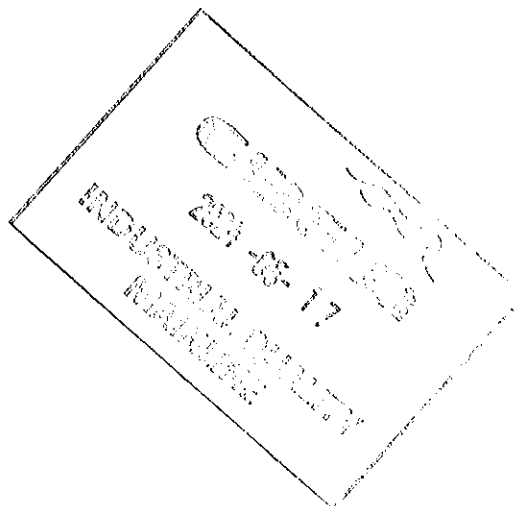
Project PRASA
SI.CB2220.250.V29

CBS measurement



AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3298	2	2590
B	3267	3266	1	2592
C	3300	3298	2	2589
D	3296	3298	2	2594
E	3268	3266	2	2592
F	3266	3266	2	2594
G	3297	3299	2	2590
H	3300	3298	2	2591
I	3295	3297	2	2590
J	3268	3265	3	2590
K	3300	3297	3	2592
L	3297	3295	2	2592
M	3269	3265	4	2592
N	3298	3296	2	2591



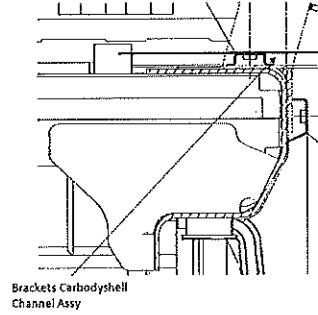
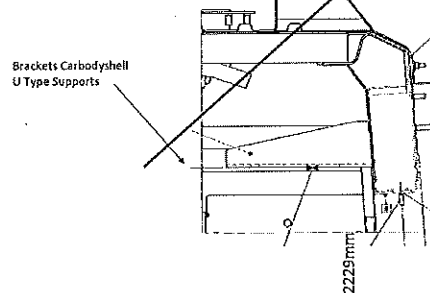
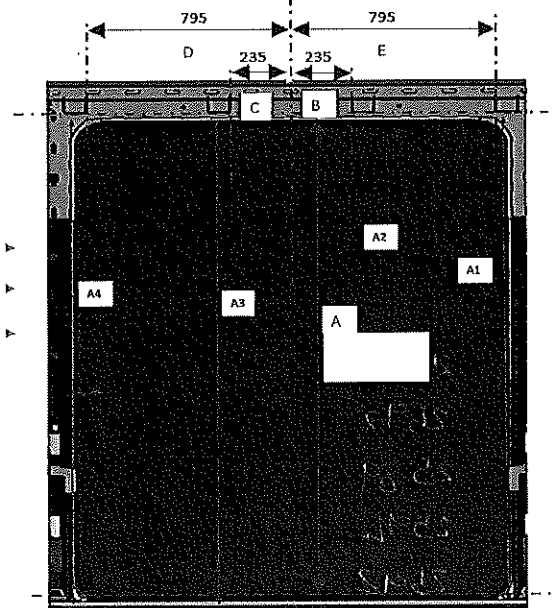


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30226487/2

Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB2220.250.V29

Specifications of Details for CBS measurement CB1220



DOOR 1 - UIS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2231
A3	2230 to 2232	2231
A4	2230 to 2232	2234
B	234 to 236	235
C	234 to 236	234
D	794 to 796	795
E	794 to 796	794

DOOR 2 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2232
A3	2230 to 2232	2231
A4	2230 to 2232	2231
B	234 to 236	234
C	234 to 236	233
D	794 to 796	795
E	794 to 796	794

DOOR 2 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2230
A3	2230 to 2232	2231
A4	2230 to 2232	2231
B	234 to 236	235
C	234 to 236	236
D	794 to 796	794
E	794 to 796	795

DOOR 1 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2231
A3	2230 to 2232	2232
A4	2230 to 2232	2231
B	234 to 236	235
C	234 to 236	234
D	794 to 796	794
E	794 to 796	795

DOOR 2 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2231
A3	2230 to 2232	2232
A4	2230 to 2232	2231
B	234 to 236	234
C	234 to 236	235
D	794 to 796	794
E	794 to 796	795

DOOR 3 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2231
A3	2230 to 2232	2231
A4	2230 to 2232	2230
B	234 to 236	234
C	234 to 236	235
D	794 to 796	794
E	794 to 796	795

GIBELO
2024-05-17
INDUSTRIAL QUALITY
MANAGEMENT

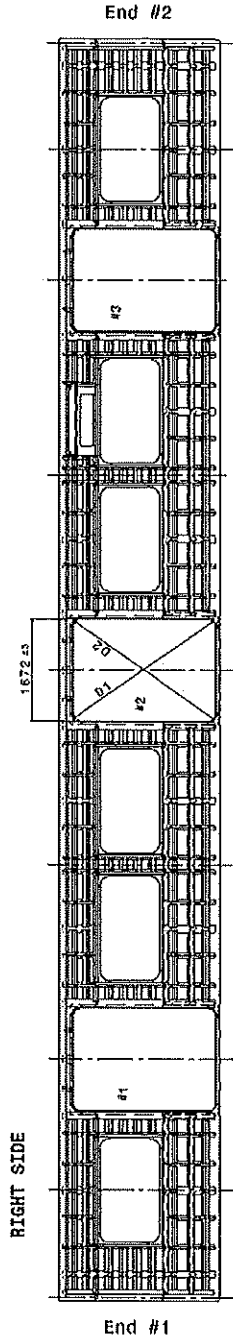


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30226487/2

Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB2220.250.V29

Specifications of Details for CBS measurement CB1/220

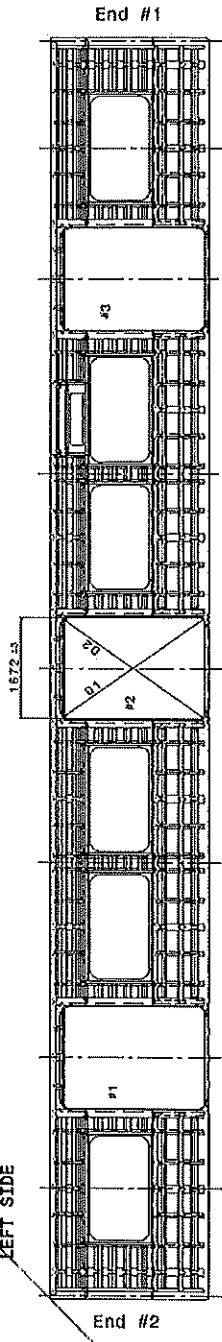


Doors diagonal D1-D2 maximum difference ≤ 4mm

#1	#2	#3
D1	2748	2748
D2	2747	2746
D1-D2	1	1

Doors length = 1672.53mm

#1	#2	#3
HIGHER DIMENSION	1674	1674
CENTRAL DIMENSION	1673	1673
LOWER DIMENSION	1672	1672

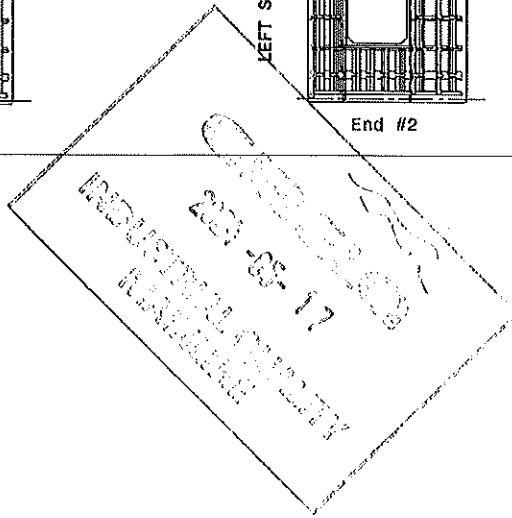


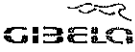
Doors diagonal D1-D2 maximum difference ≤ 4mm



#1	#2	#3
D1	2747	2748
D2	2746	2748
D1-D2	1	2

Doors length = 1672.53mm

#1	#2	#3
HIGHER DIMENSION	1674	1673
CENTRAL DIMENSION	1672	1673
LOWER DIMENSION	1671	1672



	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226467/2	Rev. 29	Project: PRASA SI.CB2220.250.V29
		Date 28/10/2023	
		Self Inspection - Final Result	

Is the car good to advance to the next workstation/process? (Approval of Operations Manager and Industrial Quality)		DATE	NAME	SIGNATURE			
HOLD POINT	<input checked="" type="checkbox"/>	GO	(If activities are not complete, the missing activities must not impact the next stage)	16/10/24	Tebedo Operations		
		GO	Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	10/04/24	Richmond Industrial Quality		
		There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)					Operations
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)					Industrial Quality

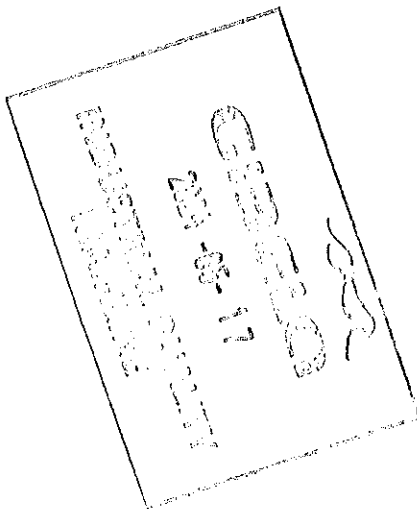
In case of "NO GO", describe blocking problems


In case of "NO GO", the operations manager must define below action plan to ensure "GO":

Item	Description	Responsible	Due date	Status

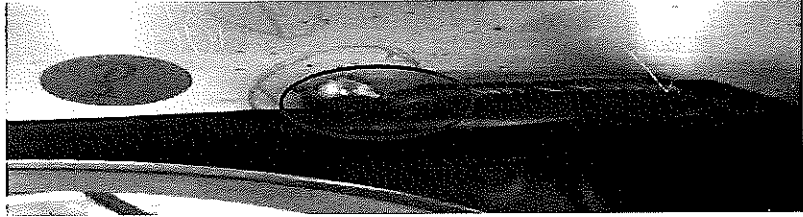

Operations

Quality



	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487I2	Rev.	Project: PRASA SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	

ANNEXURE A: Arc Welding Quality Acceptance Standard




APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

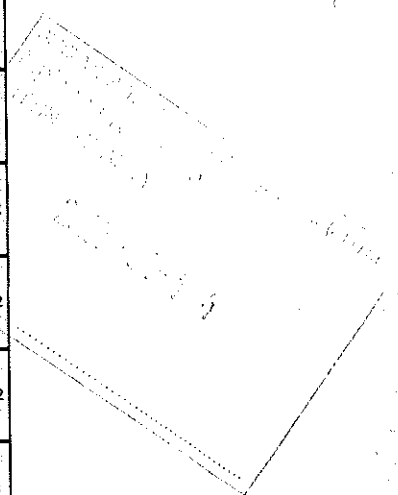
CONFIDENTIAL INFORMATION

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

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ? 
				TC3	MA	M1	M2	M3	TC2		
<input type="checkbox"/>	DT00000225487	AAD0001278566 CARBODYSHELL M1, M3, M4 ASSEMBLY	CB2230		X			X		PRA.CB2230.DT000002 25487.V20	YES
<input type="checkbox"/>											
<input type="checkbox"/>											

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	2018/08/02	GIBELA NEW CREATION	APPROVER	Philippe Marques	2018/08/02
			CHECKER	Nosizo Pindela	2018/08/02
			COMPILER	Nosizo Pindela	2018/08/02
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	30/5/2018
			CHECKER	Nosizo Pindela	30/5/2018
			REVISED BY	Nosizo Pindela	30/5/2018
2	2018/05/07	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	2018/05/07
			CHECKER	Nosizo Pindela	2018/05/07
			REVISED BY	Ramokone Motama	2018/05/07
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			REVISED BY	Vanessa Ntuli	24/01/2019
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	23/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	23/08/2019
			CHECKER	Nosizo Pindela	23/08/2019
			REVISED BY	Nosizo Pindela	23/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	20/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbhombhi	14/06/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
27	26/07/2022	Threshold measurements addition	APPROVER	Collins Mbhombhi	26/07/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
28	17/10/2022	Added traceability of sealant application	APPROVER	Collins Mbhombhi	17/10/2022
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
29	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
30	06/11/2023	Added threshold traceability for boiler makers and welders	APPROVER	Ngobeni Tyson	06/11/2023
			CHECKER	Andani Muthelo	
			REVISED BY	Ntokozo Zwane	



TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
222	MO4	Buhle 426965	15/09/24	SI.CB2230.256.V29	12



CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000226487

Rev.
30
Date
06/11/2023

Project: PRASA
SI.CB2230.256.V29

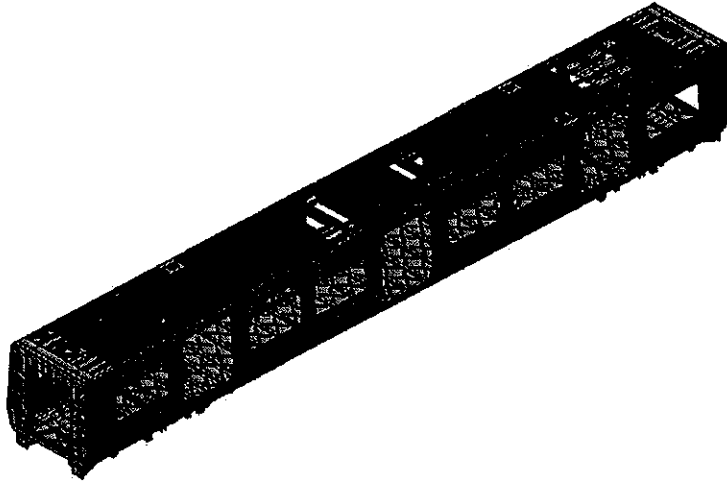
Car:

NCR:

Work station: CB2230



Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car					Revision	Observation	OK	Signature/Date (Operations)	Signature/Date (Quality)
	M	W	U	M	TC					
PRA.CB2230.DT00000226487				X		29		X	N/A 15/02/24	15/02/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Operations)	Signature/Date (Quality)
Tubular	22713-1	2024/11/15	X	15/04/24	15/02/24
Combination Square	GARCS0140	2024/06/26	X	15/04/24	15/02/24
Steel Ruler	GIBST300	2024/09/14	X	15/04/24	15/02/24
Measuring Tape	GIBTA001	2024/03/23	X	15/04/24	15/02/24

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308 LSi	273557	Mig Welding	X	15/04/24	15/02/24

Handwritten notes and signatures at the bottom right of the page.



CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

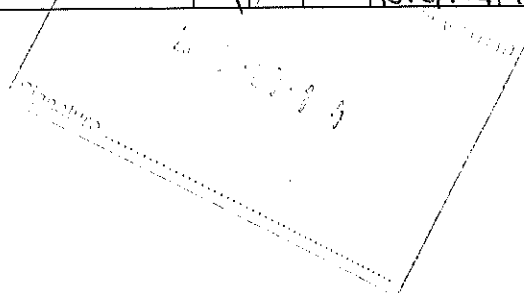
Rev.
30
Date
06/11/2023

Project: PRASA
SI.CB2230.256.V29

II - Self Inspection - Items to Check

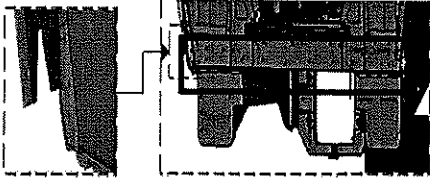
II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	SI	Signature/Date (Operations)	Signature/Date (Quality)						
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	X	15/04/24	15/04/24						
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	X	15/04/24	15/04/24						
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	X	15/04/24	15/04/24						
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	X	15/04/24	15/04/24						
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	X	15/04/24	15/04/24						
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	X	15/04/24	15/04/24						
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: <table border="1" style="font-size: small;"> <tr> <td>Temperature Min - Max (°)</td> <td>Min-Max</td> <td>10°C - 35°C</td> </tr> <tr> <td>Relative humidity Min - Max (%)</td> <td>Min-Max</td> <td>25% - 95%</td> </tr> </table>	Temperature Min - Max (°)	Min-Max	10°C - 35°C	Relative humidity Min - Max (%)	Min-Max	25% - 95%	Sealant Batch No: FA02810051 Exp Date: ___ / ___ / 20___ Actuals Temperature: <u>18°C</u> Humidity: <u>67%</u>	X	15/04/24	15/04/24
Temperature Min - Max (°)	Min-Max	10°C - 35°C										
Relative humidity Min - Max (%)	Min-Max	25% - 95%										
08	N/A	Verification of sealant application on the roof and sidewall finishers.	Sealant must be: -Applied straight and even -Free of gaps,cracks,damage and debris (flashes, dirt, dust) Refer to Annexure B	X	15/04/24	15/04/24						
09	N/A	Verification of sealant application in certain regions in the drawing.	AAD0001278566	X	15/04/24	15/04/24						



II - Self Inspection - Items to Check

AREA 1



END 2 SEALANT

OPERATOR
(Name & sign):

Zanele [Signature]

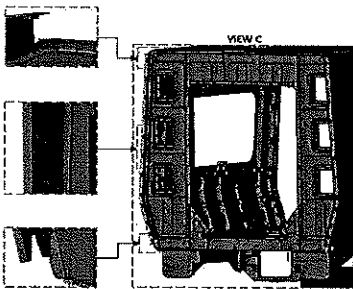
OPERATOR
(Name & sign):

Zanele [Signature]

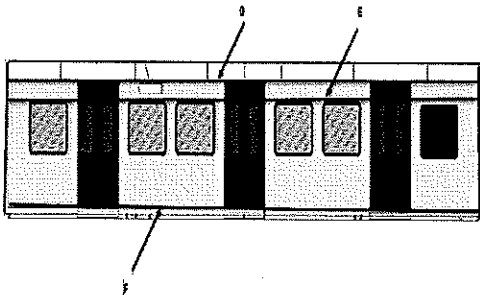
OPERATOR
(Name & sign):

Boikunelo [Signature]

AREA 2 (VIEW G)



H



Area D,E,F,G,H,I

Operator (Name & sign):

LHS
D, E, F, G, H, I

RHS
D, E, F, G, H, I

Operator (Name & sign):

LERATO [Signature]

LERATO [Signature]

Operator (Name & sign):

Buhle [Signature]

Buhle [Signature]

Operator (Name & sign):

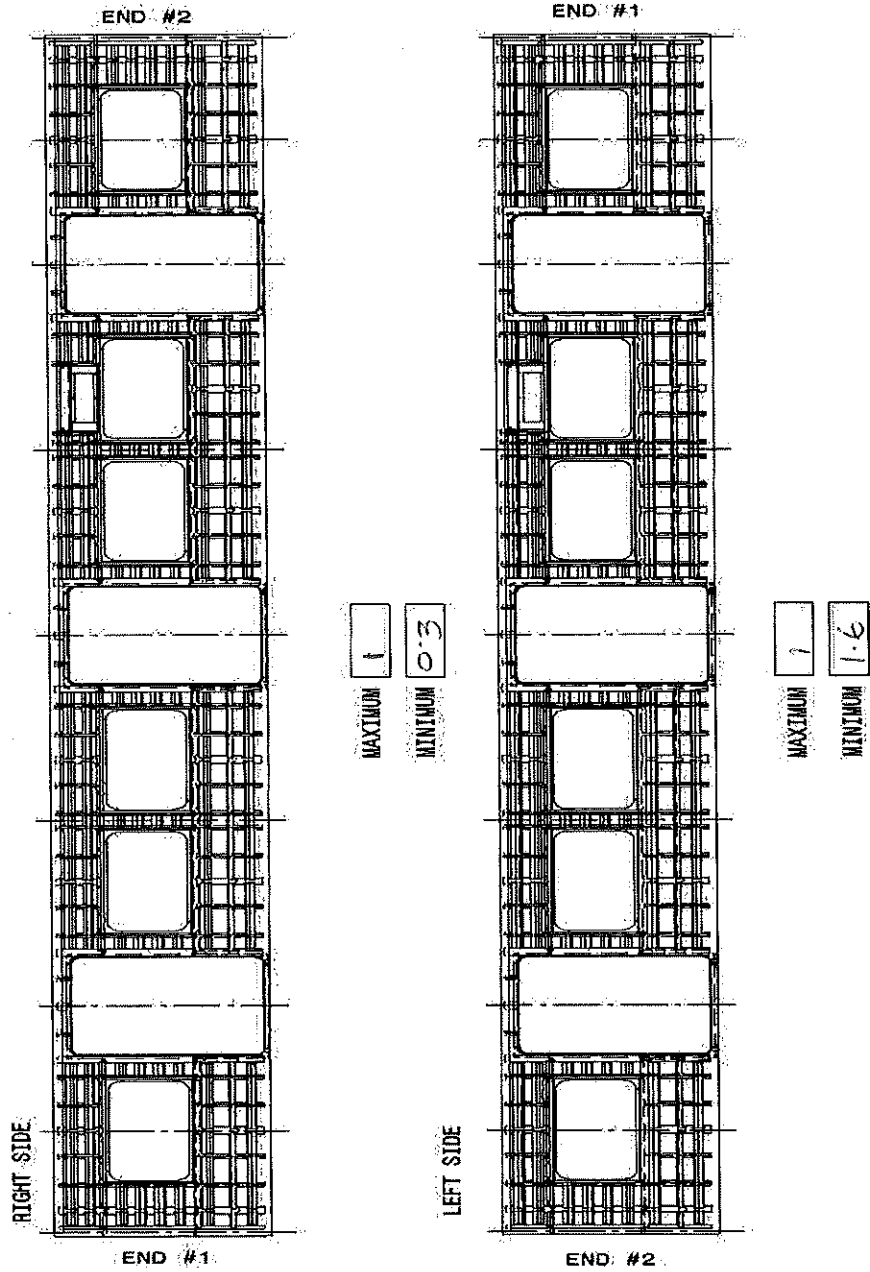
Operator (Name & sign):

Operator (Name & sign):

Handwritten notes and signatures at the bottom right of the page.

Specifications of Details for CB5 measurement CB1230

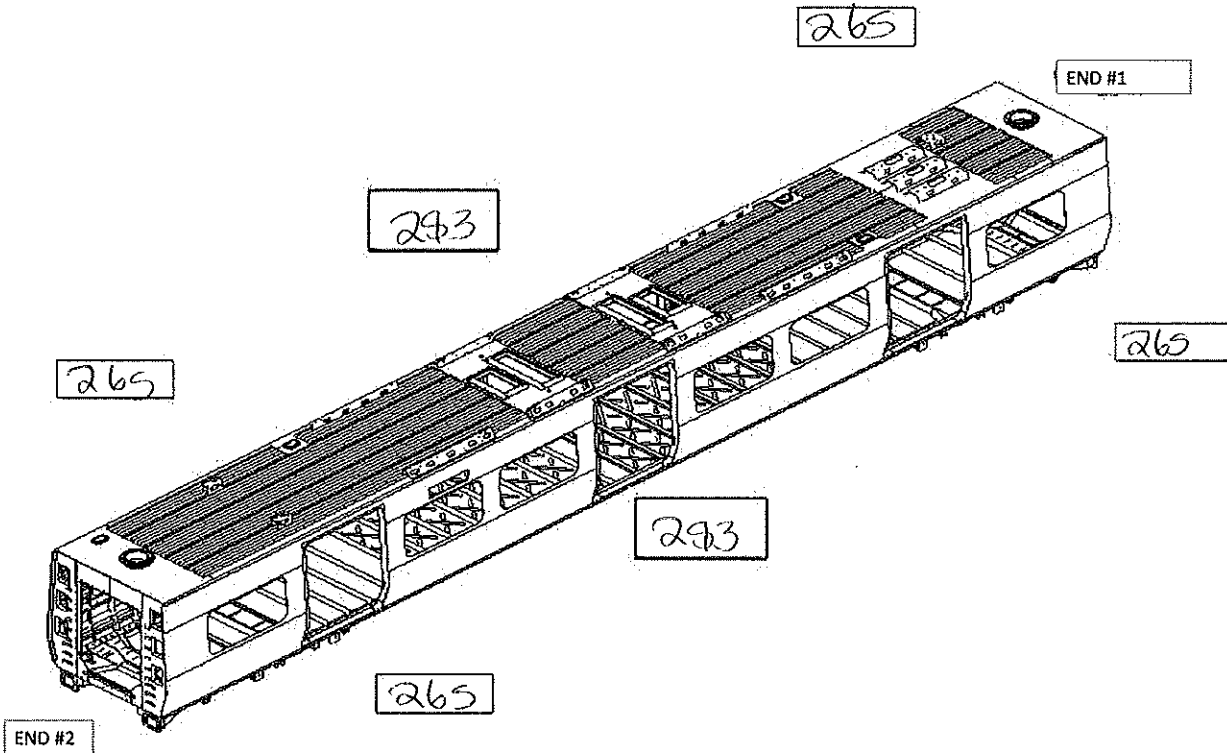
Flatness side left and right maximum of 2mm in the valley to peak measured in 900mm. Record the maximum and minimum value found and indicate the corresponding region.



Signature: _____
Date: 2023-06-11

Specifications of Details for CBS measurement CB1230

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

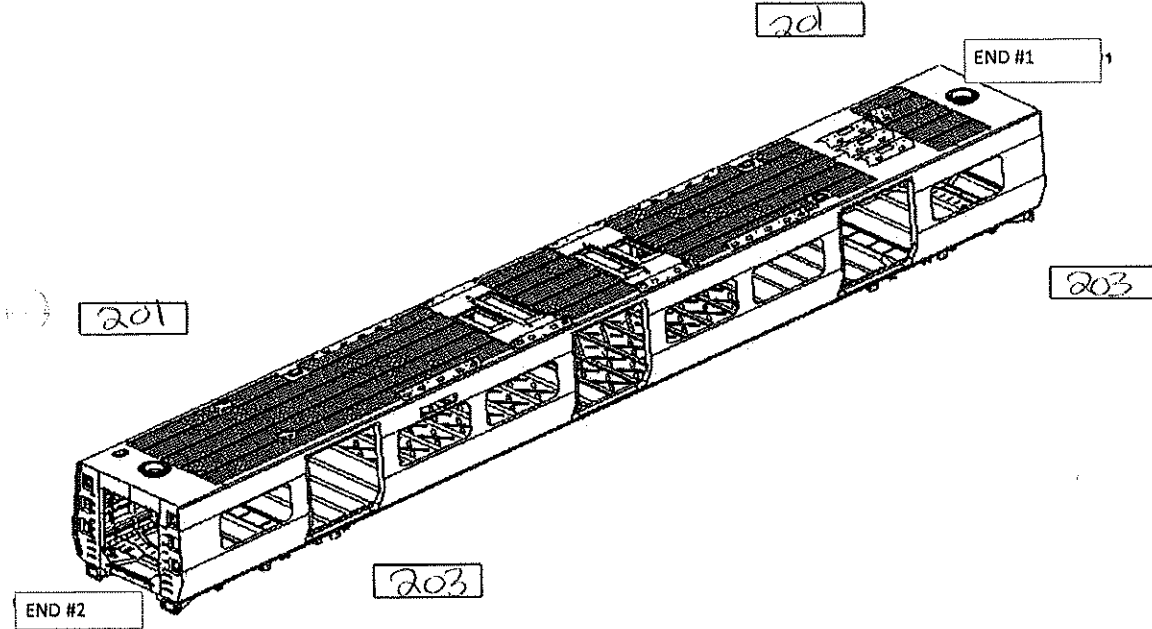


MEASURED CAMBER VALUES

RIGHT	i1	1φ
LEFT	a1	1φ

Specifications of Details for CBS measurement CB1230

Twist measured in transversal and longitudinal = Maximum 3mm. Measure twist on air spring plates (LHS and RHS), both End 1 and End 2 following twist measurement document.

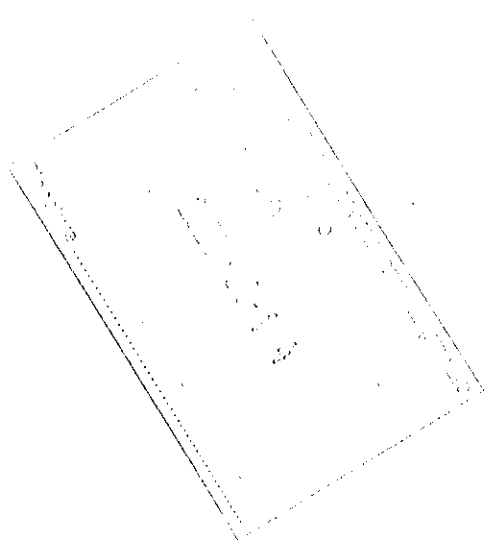


TWIST FOUND ON END 1

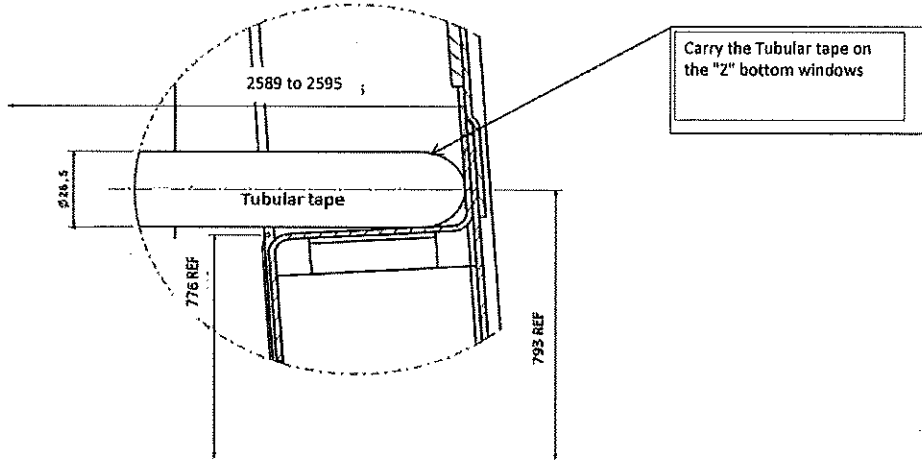
TRANVERSE
LONGITUDINAL

TWIST FOUND ON END 2

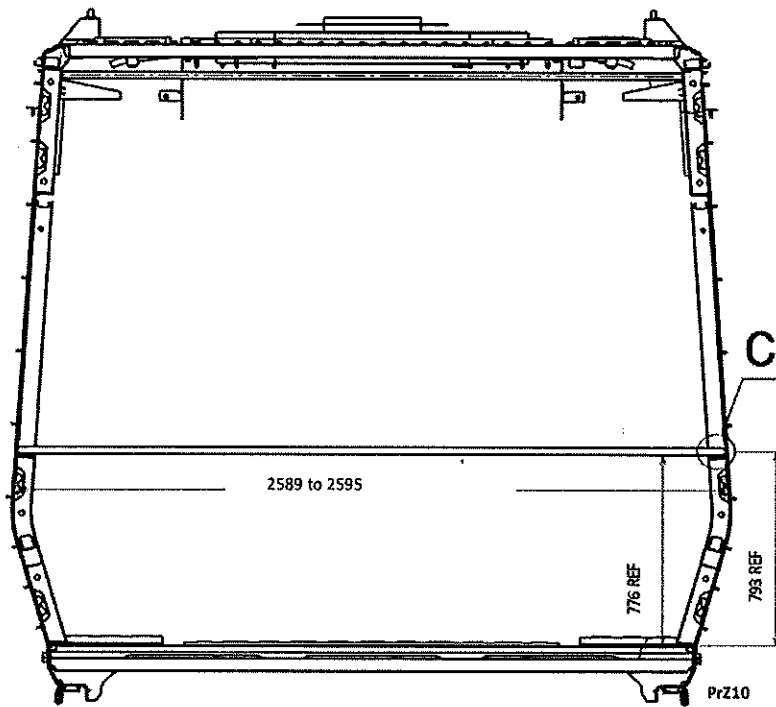
TRANVERSE
LONGITUDINAL



Specifications of Details for CBS measurement CB1230

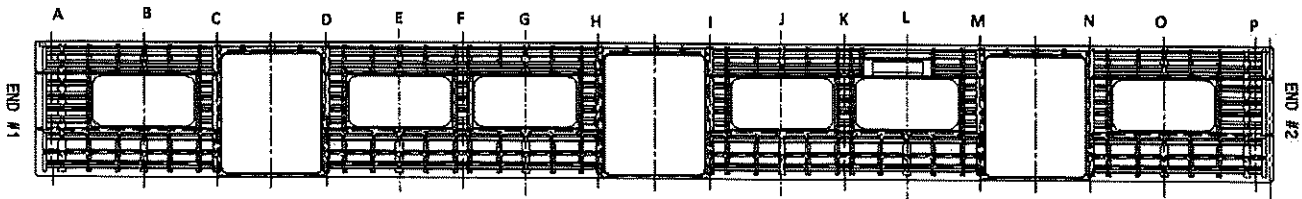


Detail C



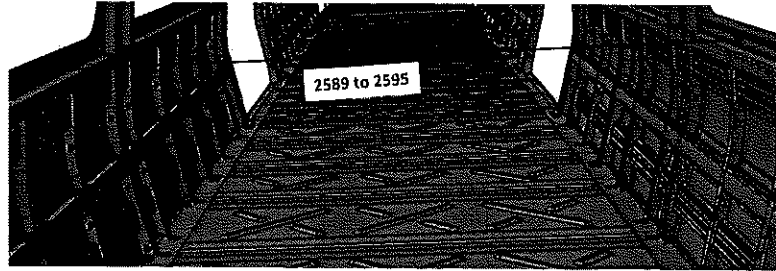
Signature

Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	2589
B	2592
C	2591
D	2594
E	2593
F	2595
G	2595
H	2593
I	2594
J	2595
K	2594
L	2594
M	2593
N	2595
O	2593
P	2595



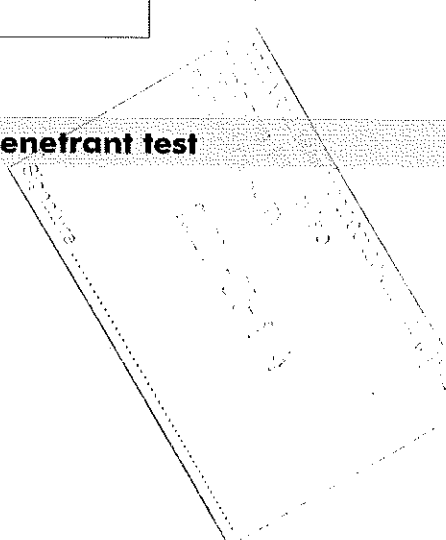
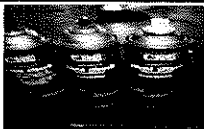
Threshold verification						Nominal value :38
Door 1		Door 2		Door 3		
L	R	L	R	L	R	
38	38	38	39	38	39	
Door 4		Door 5		Door 6		
L	R	L	R	L	R	
38	39	38	38	38	38	

BOILER MAKER: M. Mallopolo

WELDER: Thulane

Dye penetrant test

Dye-penetration test to be performed by quality personnel





CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000226487

Rev.
30
Date
06/11/2023

Project: PRASA
SI.CB2230.256.V29

Self Inspection - Final Result

Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)		DATE	NAME	SIGNATURE
HOLD POINT	(If activities are not complete, the missing activities must not impact the next stage)	15/04/24	Buhle Operations	
	Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	15/04/24	Ardeni Industrial Quality	
	There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			
	There are non-conformities impact the quality of the product and there is no corrective action defined yet)			

In case of "NO GO", describe blocking problems

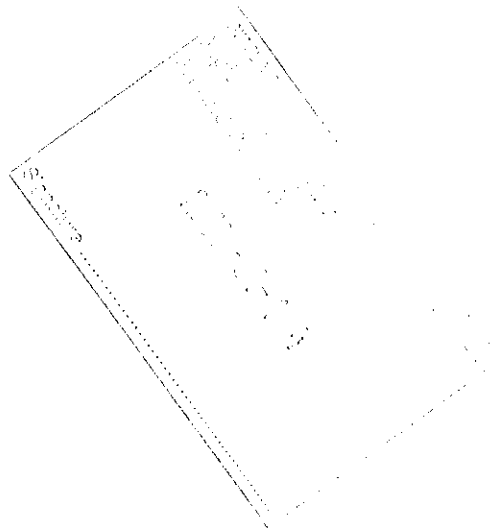
()

In case of "NO GO", the operations manager must define below action plan to ensure "GO":

Item	Description	Responsible	Due date	Status

Operations

Quality



ANNEXURE A: Arc Welding Quality Acceptance Standard

