

GIBELA

PRASA PROJECT



APPLICABLE FROM TRAINSET 100+ AS PER BASELINE 10.3.1

# SELF INSPECTION SHEET

**CONFIDENTIAL INFORMATION**

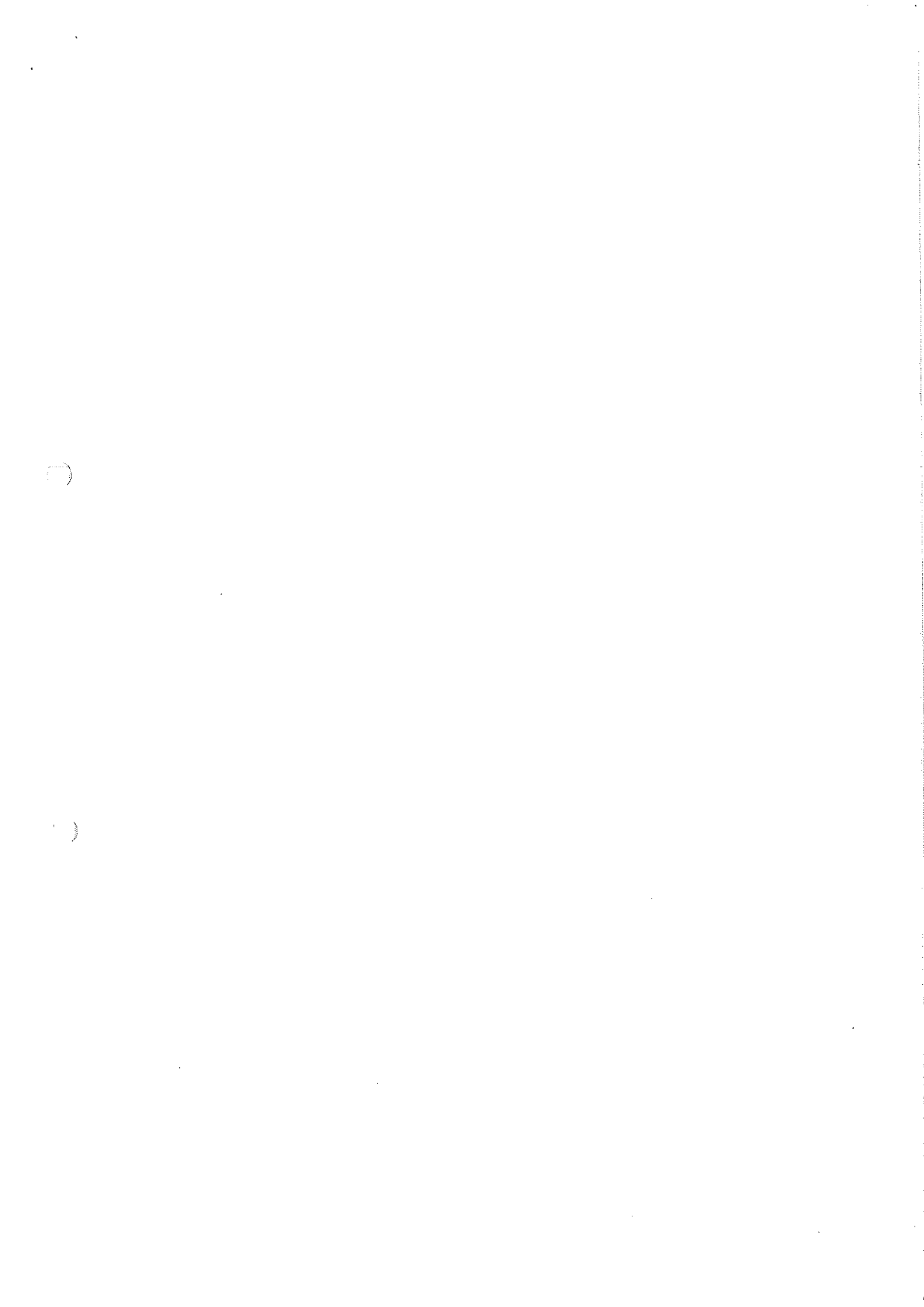
This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

**APPLICATION REFERENCE**

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY?	
				Tc1	M6	M1	M2	M3	Tc2			
<input type="checkbox"/>	DTR30225487/3	AAD0001278566	CARBODYSHELL M1 ASSEMBLY	CB1210			<input checked="" type="checkbox"/>				PRA.CB1210.DTR30225 487/3.V25	YES
<input type="checkbox"/>												
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	APPROVER	Itumeleng Modiba	2018/05/18							
			CHECKER	Nosizo Pindela	2018/05/18							
			REVISED BY	Ramokone Motama	2018/05/18							
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230	APPROVER	Itumeleng Modiba	2018/07/04							
			CHECKER	Nosizo Pindela	2018/07/04							
			REVISED BY	Ramokone Motama	2018/07/04							
3	2018/12/12	Added dimensional check points to CB1210	APPROVER	Itumeleng Modiba	2018/12/12							
			CHECKER	Nosizo Pindela	2018/12/12							
			REVISED BY	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							
			REVISED BY	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							
			REVISED BY	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							
			REVISED BY	Nosizo Pindela	21/08/2019							
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								
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021							
			CHECKER	Mpho Mulaudzi								
			REVISED BY	Mpho Mulaudzi								
25	19/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	19/02/2022							
			CHECKER	Andani Muthelo								
			REVISED BY	Andani Muthelo								
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023							
			CHECKER	Mohlampe Amogelang								
			REVISED BY	Mohlampe Amogelang								
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023							
			CHECKER	Zwane Ntokozo								
			REVISED BY	Mohlampe Amogelang								
28	07/11/2023	Addition of welding traceability	APPROVER	Ngobeni Tyson	07/11/2023							
			CHECKER	Andani Muthelo								
			REVISED BY	Ntokozo Zwane								
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF-INSPECTION NUMBER	PAGES							
TS222	M1	P. MALATI 409964	11/04/24	SI.CB1210.254.V28	17							

**INDUSTRIAL QUALITY MAINLINE**  
 2024-04-11



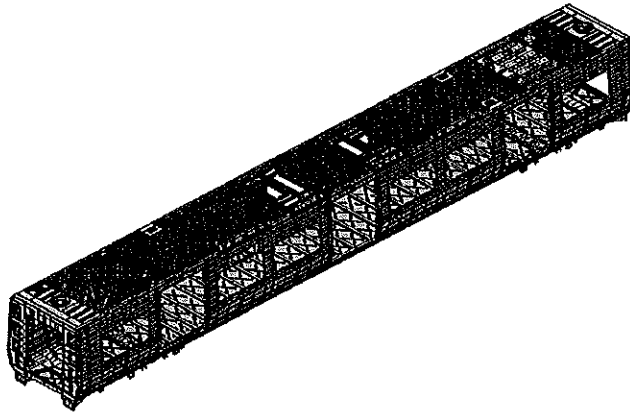


	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA
		Date 07/11/2023	SI.CB1210.254.V28

Car: M1	NCR:	Work station: CB1210
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Safety Related



I - Documentation and Instruments Control

1.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	D	E	S	Q	3	U					
DTR30225487/3		X					V28		✓	[Signature]	[Signature]

1.2 - Instruments Control

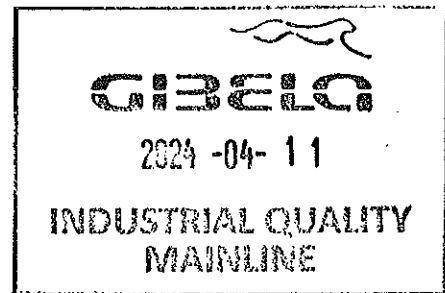
Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULAR	32823-2	15/03/25	✓	[Signature]	[Signature]
USER TAPE	125425924	08/10/25	✓	[Signature]	[Signature]
SOM TAPE	61570102	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	314018-74097	MIG	✓	[Signature]	[Signature]
ER 308 L	299687-70002	TIG	✓	[Signature]	[Signature]






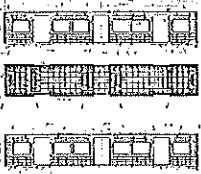
CARBODYSHELL M1 ASSEMBLY DTR30225487/3

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II - Self Inspection - Items to Check

II.1 - Items to check

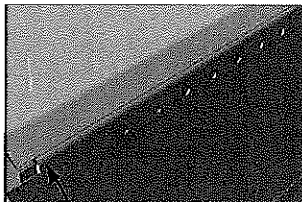
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls, Endframes, Roof and Underframe)	DT00000311225	✓	[Signature] 11/04/24	[Signature] 11/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	[Signature] 11/04/24	[Signature] 11/04/24
03	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓	[Signature] 11/04/24	[Signature] 11/04/24
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	[Signature] 11/04/24	[Signature] 11/04/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	[Signature] 11/04/24	[Signature] 11/04/24
06		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓	[Signature] 11/04/24	[Signature] 11/04/24
07	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.	✓	[Signature] 11/04/24	[Signature] 11/04/24

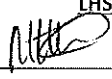


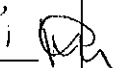
**GIBELQ**  
2024-04-11  
INDUSTRIAL QUALITY  
MAINLINE

	CARBODYSHELL M1 ASSEMBLY DTR30226487/3	Rev. 28	Project: PRASA <b>SI.CB1210.254.V28</b>
		Date 07/11/2023	

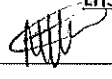


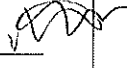
**Welder Traceability**

Roof ring welds



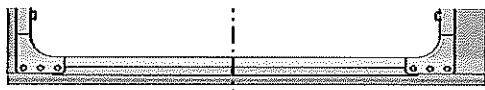
Boiler maker (Name & Sign): <u>Innocent </u> <sup>LHS</sup>	Welder (Name & Sign): <u>MTHOKOZISI </u>
Boiler maker (Name & Sign): <u>SEAN </u> <sup>RHS</sup>	Welder (Name & Sign): <u>MTHOKOZISI </u>


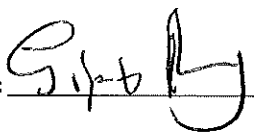
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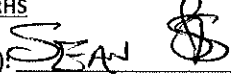
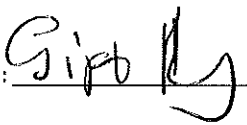
Boiler maker (Name & Sign): <u>Innocent </u> <sup>LHS</sup>	Welder (Name & Sign): <u>MTHOKOZISI </u>
Boiler maker (Name & Sign): <u>SEAN </u> <sup>RHS</sup>	Welder (Name & Sign): <u>MTHOKOZISI </u>

END 2

Door ring welds



Boiler maker (Name & Sign): <u>SEAN </u> <sup>LHS</sup>
Welder (Name & Sign): <u>GIFT </u>

Boiler maker (Name & Sign): <u>SEAN </u> <sup>RHS</sup>
Welder (Name & Sign): <u>GIFT </u>



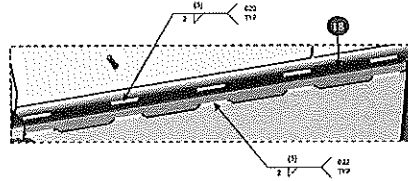
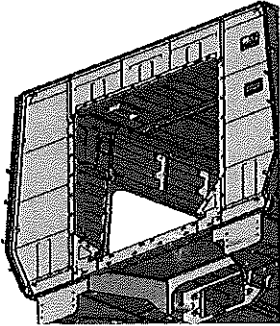


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EUF Reinforcement Plates

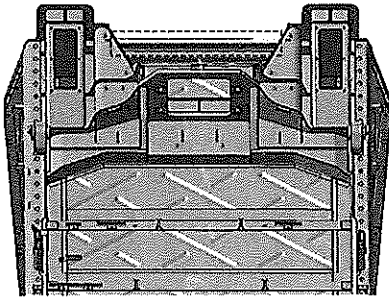


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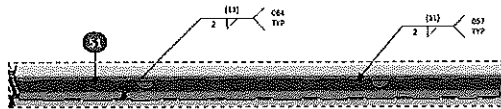
Boiler maker (Name & Sign): GERALD G. Masob

Welder (Name & Sign): Thabang

END 2



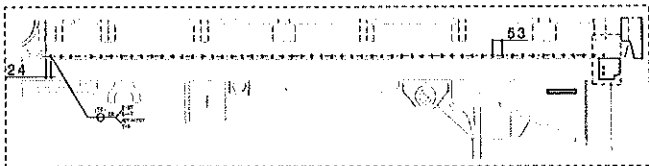
Underneath the CAR



END 2

Boiler maker (Name & Sign): Jobego Masob

Welder (Name & Sign): Jobego Masob



OPERATOR: Jobego Masob



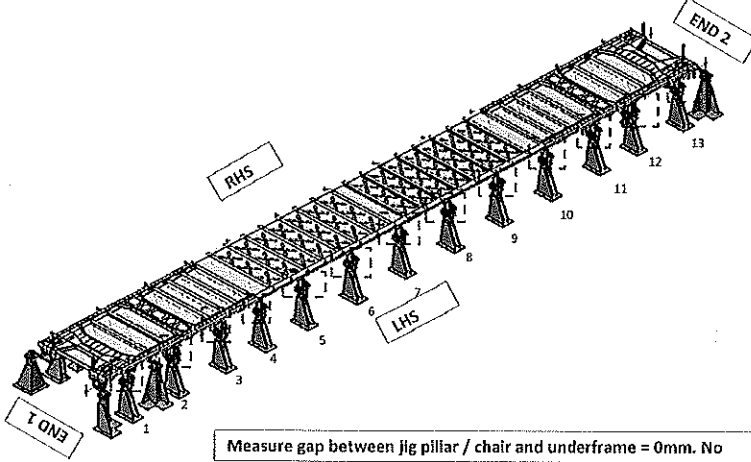


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Specifications of Details for CBS measurement



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	1	0	0	0	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	1	0	0	0	0	0	0	0	0	0

Signature Operational:

Date:

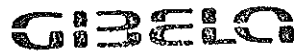
After Welding.

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:



2024-04-11

INDUSTRIAL QUALITY  
MAINLINE

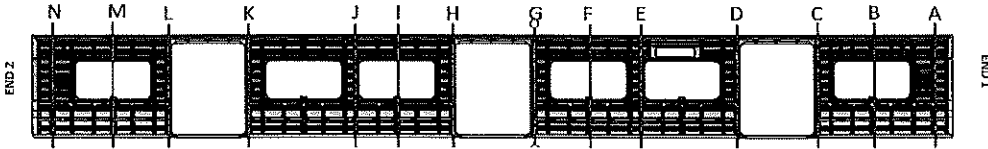


CARBODYSHELL M1 ASSEMBLY DTR30226487/3

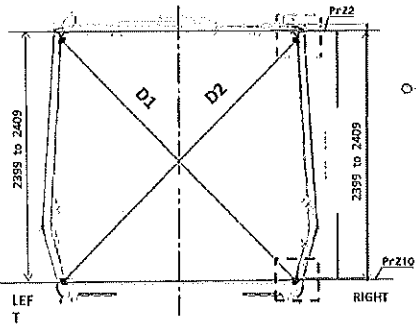
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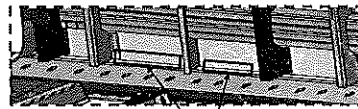
Specifications of Details for CBS measurement



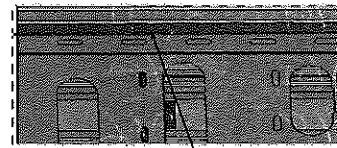
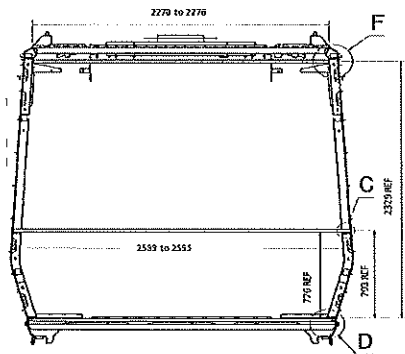
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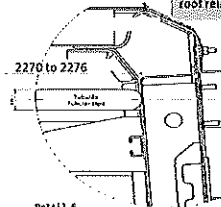
Measurement positions on roof rail and sidewall omega corner.



Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.



D-1413 P  
Don't consider the reinforcement



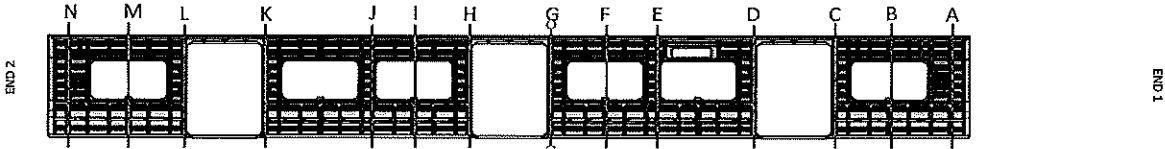


CARBODYSHELL M1 ASSEMBLY DTR30226487/3

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Specifications of Details for CBS measurement

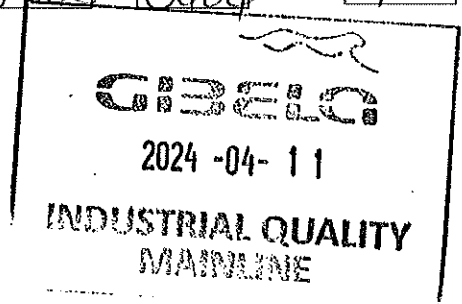


PME Column LHS - RHS should be  $\leq 2\text{MM}$  on each point.

BEFORE WELDING

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

409964  
11/04/24



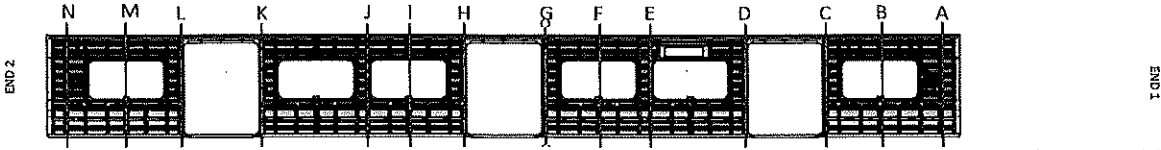


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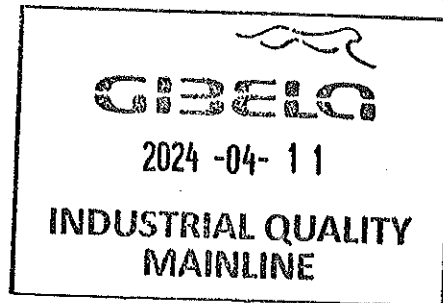
Specifications of Details for CBS measurement



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

AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5$ mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS $\leq 2$
A	3295	3296	1	2404	2406	2
B	3269	3269	2	2404	2405	1
C	3296	3298	2	2406	2404	2
D	3299	3297	2	2403	2404	1
E	3267	3266	1	2426	2425	1
F	3270	3270	0	2405	2404	1
G	3296	3298	2	2405	2404	1
H	3296	3296	0	2406	2405	1
I	3268	3269	1	2404	2404	0
J	3269	3271	2	2405	2404	1
K	3296	3298	1	2406	2404	2
L	3298	3298	0	2404	2404	0
M	3269	3270	1	2404	2405	1
N	3296	3297	1	2404	2405	1



*[Handwritten signature]*  
409960  
11/04/24



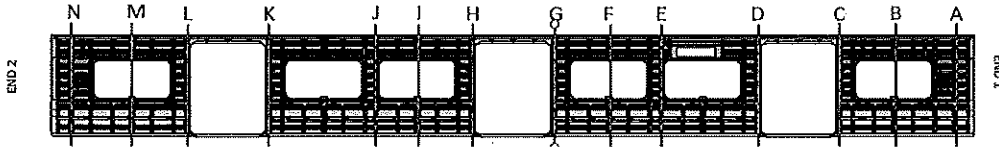
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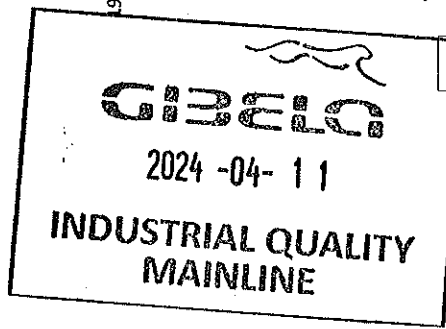
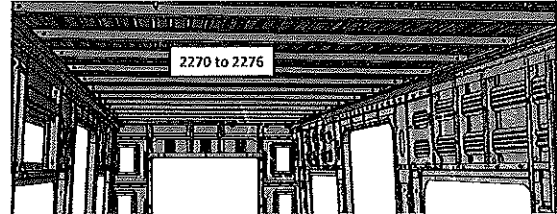
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GBS measurement

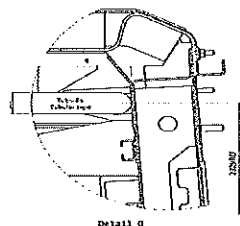
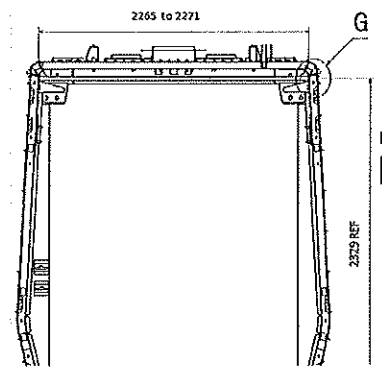
BEFORE WELDING



- 2270 to 2276
- A 2271
- B 2275
- C 2276
- D 2274
- E 2276
- F 2275
- G 2272
- H 2270
- I 2275
- J 2277
- K 2276
- L 2274
- M 2274
- N 2271



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



Handwritten signature and date: 400964 11/04/24



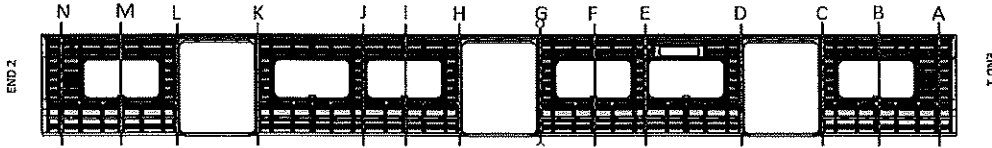
CARBODYSHELL M1 ASSEMBLY DTR30226487/3

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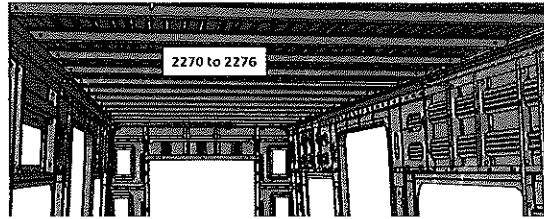
Project: PRASA  
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CBS measurement

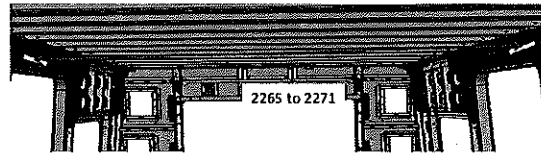
AFTER WELDING



	2265 to 2271	2270 to 2276
A	2269	/
B	/	2274
C	2265	/
D	2268	/
E	/	2276
F	/	2275
G	2267	/
H	2269	/
I	/	2278
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K	2266	/
L	2269	/
M	/	2274
N	2270	/

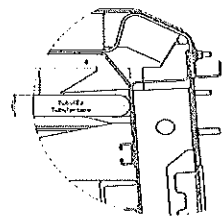
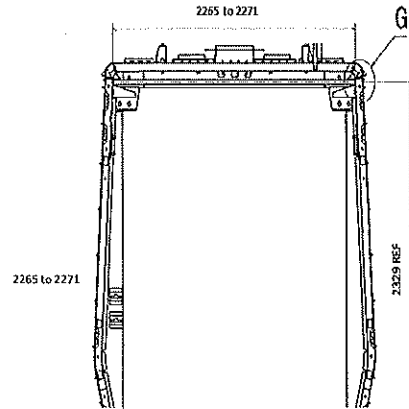


Do not consider reinforcement ( Take measurements top area of zee profile



Take measurement close to radius ( considering reinforcement)

**GIBELCO**  
2024-04-11  
INDUSTRIAL QUALITY  
MAINLINE



*[Handwritten signature]*  
11/04/24

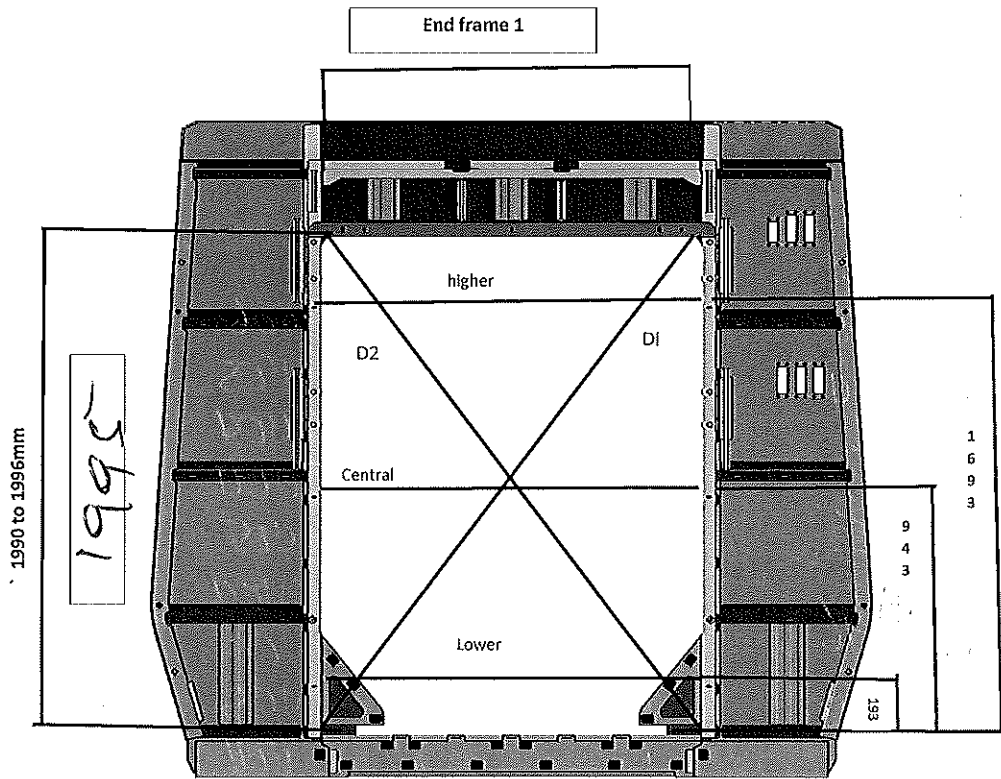


CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev. 28  
Date 07/11/2023

Project: PRA5A  
SI.CB1210.254.V28

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE  $D1-D2 \leq 3mm$

Higher Dimension

1381

D1

2416

Central Dimension

1380

D2

2415

Lower Dimension

1381

D1-D2

1



2024-04-11

INDUSTRIAL QUALITY  
MAINLINE

*Handwritten signature*

409964

11/04/24

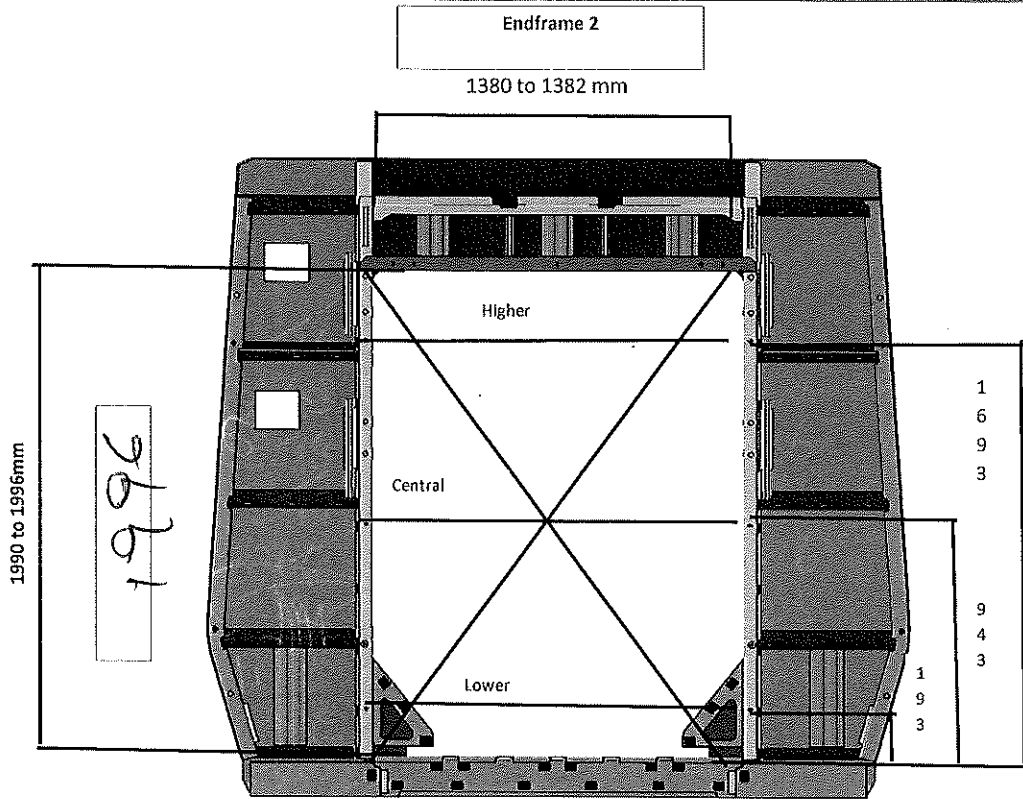


CARBODYSHELL M1 ASSEMBLY DTR30226487/3

Rev. 28  
Date 07/11/2023

Project: PRASA  
SI.CB1210.254.V28

Specifications of Details for CBS measurement



Higher Dimension	1381	D1	2415
Central Dimension	1380	D2	2415
Lower Dimension	1380	D1-D2	0

**GIBELQ**  
2024-04-11  
INDUSTRIAL QUALITY  
MAINLINE

*[Handwritten signature]*  
409964  
11/04/24

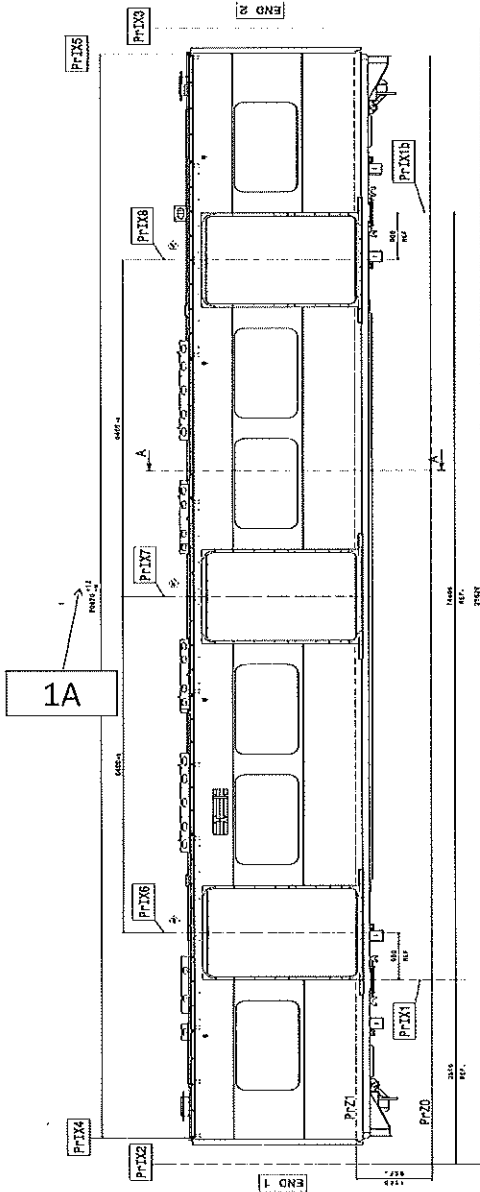


CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev. 28  
Date 07/11/2023

Project: PRASA  
SI.CB1210.254.V28

Specifications of Details for CBS measurement



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20616

RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20616

*[Signature]*  
 209964  
 11/04/24


**GIBELO**  
 2024-04-11  
 INDUSTRIAL QUALITY  
 MAINLINE

Dye penetrant test

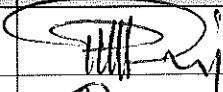
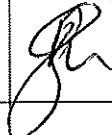
Dye-penetration test to be performed by quality personnel





	CARBODYSHELL M1 ASSEMBLY DTR30226487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

**Self-Inspection - Final Result**

		DATE	NAME	SIGNATURE	
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)	11/04/24	Fowfso Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	11/04/24	Ntokero Industrial Quality	
		There are activities pending that impact 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)			

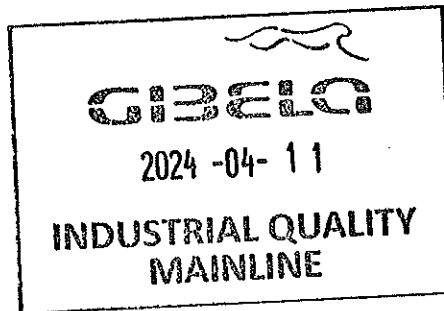
In case of "NO GO", describe blocking problems

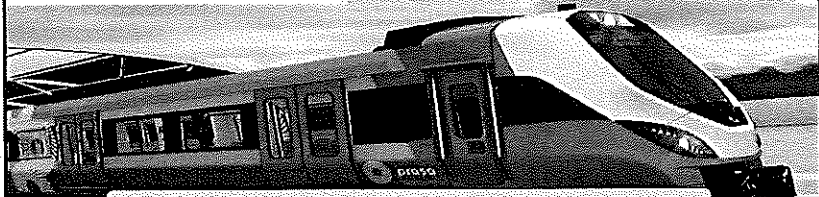
In case of "NO GO", the operations manager must define below action plan to ensure "GO":

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												
MOU/IMG	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?	
				TC1	PA	M1	M2	M3	TC2			
<input type="checkbox"/>	DTR3022548/2	AR00001278566	CB1220		X	X			X		PRA:CB1220.DTR3022548 7/2.V21	YES
<input type="checkbox"/>												
<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		Tharyani 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		Mbhombhi 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		Mbhombhi Collins	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		Mbhombhi Collins	14/06/2022				
					CHECKER		Andani Muthelo	14/06/2022				
					REVISED BY		Andani Muthelo	14/06/2022				
27	17/10/2022	Addition of traceability for sealant application and welding			APPROVER		Mbhombhi Collins	17/10/2022				
					CHECKER		Ntokozi Zwane	17/10/2022				
					REVISED BY		Amogelang Mohlampe	17/10/2022				
28	14/04/2023	Added sealant batch number & welding consumables traceability			APPROVER		Vanessa Ntuli	14/04/2023				
					CHECKER		Ntokozi 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		Ntokozi Zwane	28/10/2023				
					REVISED BY		Amogelang Mohlampe	28/10/2023				
TRAINSET	CAR	OPERATOR NAME & ALPS NO		DATE	SELF INSPECTION NUMBER		PAGES					
T15 222	MD1	ASAHLA 405524		12-09-24	SI.CB1220.250.V29		14					

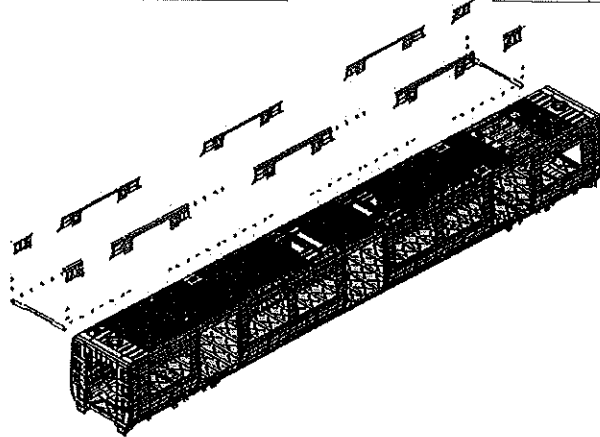
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	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DTR30225487/2	Rev.	Project: PRASA
		29	
		Date	SI.CB1220.250.V29
	28/10/2023		

Car: M1,M3&M4	NCR:	Work station:	CB1220
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Safety Related



**I - Documentation and Instruments Control**

**I.1 - Documentation Control**

Document	Type of car					Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	D	M	U	M	T					
DTR30225487/2	X					29	28-10-2023	X	N/A	

12-04-24 12/04/24

**I.2 - Instruments Control**

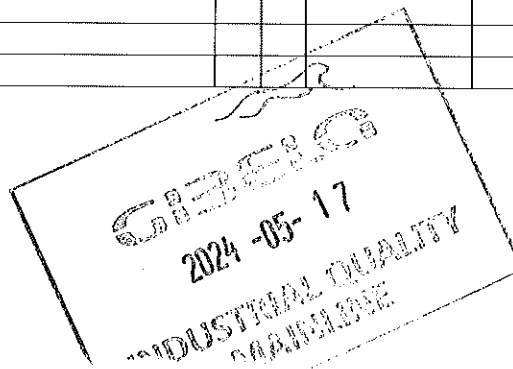
Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
MEASURING TAPE	CH151A0231	10/04/2025	X	12-04-24	
Tubular	325832	15/03/2026	X	12-04-24	12/04/24

**I.3 Consumables**

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308	231067	MIG	X	12-04-24	12/04/24



GIBELQ		CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2		Rev. 29 Date 28/10/2023	Project: PRASA SI.CB1220.250.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.CB1220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB1220.DTR30225487/2	✓		12-04-24	12/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		12-04-24	12/04/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		12-04-24	12/04/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		12-04-24	12/04/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		12-04-24	12/04/24
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.	✓		12-04-24	12/04/24
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: 2001935P Exp Date: 1/05/24 Actuals Temperature: 16 Humidity: 40	✓		12-04-24	12/04/24
08	NA	Verification of sealant application in certain regions in the drawing.	AA00003278566	✓		12-04-24	12/04/24
09		Verification of safety welds	Approved according to DTD000210658 reference and Self inspection	✓		12-04-24	12/04/24

2024-05-17  
 INDUSTRIAL QUALITY  
 MANAGEMENT



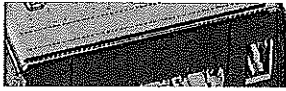
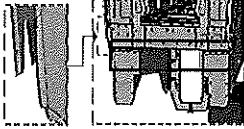
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30226487/2

Rev.  
29  
Date  
28/10/2023

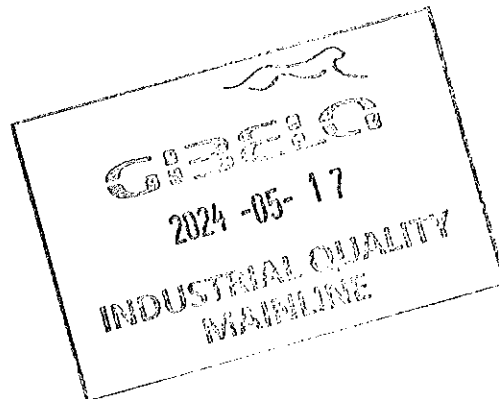
Project: PRASA  
SI.CB1220.250.V29


II - Self Inspection - Items to Check

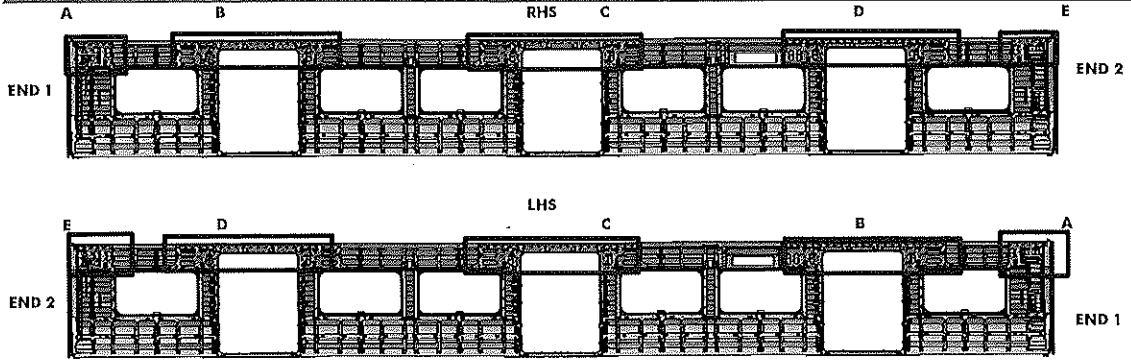
SEALANT APPLICATION



AREA 1 & 2 END 1  
Operator (Name & sign):  
Mthokozi AJJ  
Operator (Name & sign):  
Mthokozi AJJ

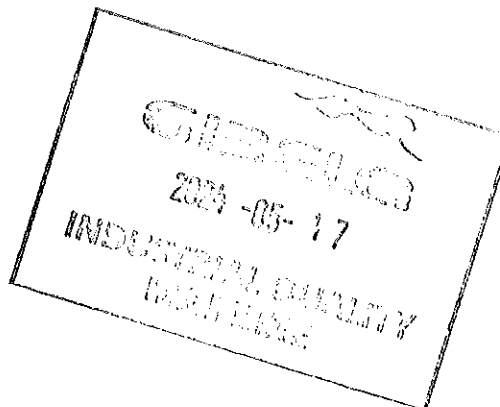


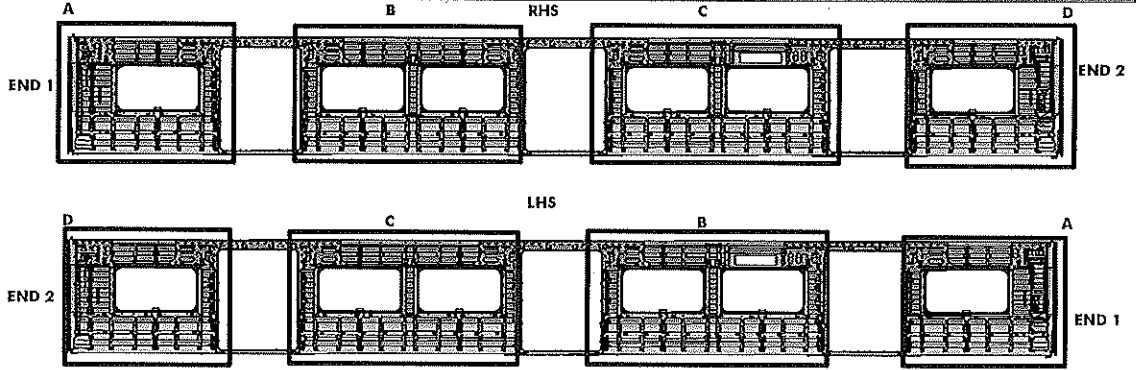
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		29	
		Date	SI.CB1220.250.V29
		28/10/2023	
<b>II - Self Inspection - Items to Check</b>			




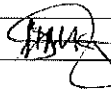

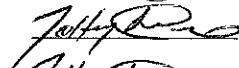
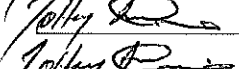
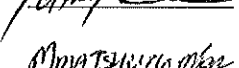
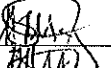
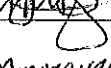
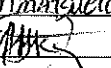
**REINFORCEMENT WELDING**

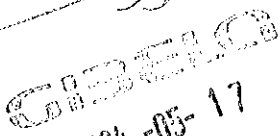
AREA	LHS	RHS
A	Operator (Name&sign): <u>Hokulunga <i>ap</i></u>	<u>Yulu <i>ap</i></u>
B	Operator (Name&sign): <u>Hokulunga <i>ap</i></u>	<u>Yulu <i>ap</i></u>
C	Operator (Name&sign): <u><i>[Signature]</i></u>	<u><i>[Signature]</i></u>
D	Operator (Name&sign): <u><i>Sibiza <i>ap</i></i></u>	<u>THULANI <i>ap</i></u>
E	Operator (Name&sign): <u><i>Sibiza <i>ap</i></i></u>	<u>THULANI <i>ap</i></u>

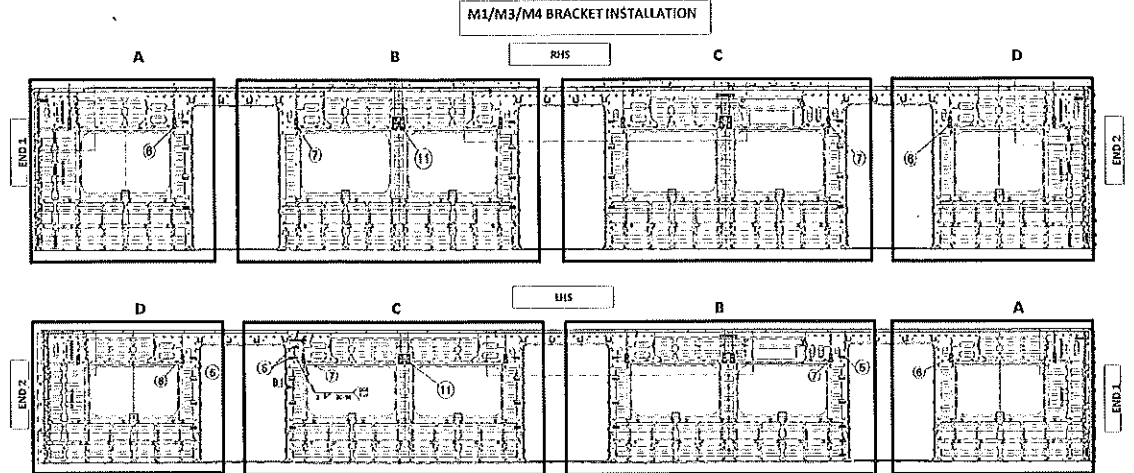




**BRACKETING**

		<b>INSTALLATION</b>	
C-RAILS:	Operator:	AsANDA	
	Operator:		
DOOR MECHANISMS:	Operator:	Mkhize	
	Operator:		
TAPPING PADS	Operator:	Sibiya	
	Operator:	Madini	
		<b>INSTALLATION &amp; VERIFICATION</b>	
SEAT & LUGGAGE BRACKETS:	Operator:	LINDO	LOLO MASHU
	Operator:	THULANI	MADINI S. MASHU
SEAT BRACKETS VERIFICATION:	Operator:		
	Operator:		
<b>WELDING</b>			
AREA	LHS		RHS
A (Seat brackets)	Operator (Name&sign):	LINDO	LINDO
(C-rails, Luggage and earth bushes)	Operator (Name&sign):	LINDO	
B (Seat brackets)	Operator (Name&sign):	LINDO	
(C-rails, Luggage and earth bushes)	Operator (Name&sign):	LINDO	
C (Seat brackets)	Operator (Name&sign):		MATSUZUKO MASHU
(C-rails, Luggage and earth bushes)	Operator (Name&sign):		MATSUZUKO MASHU / S
D (Seat brackets)	Operator (Name&sign):	MATSUZUKO MASHU	MATSUZUKO MASHU
(C-rails, Luggage and earth bushes)	Operator (Name&sign):		MATSUZUKO MASHU
<b>ENDS</b>			
END 1 TAPPING PADS WELDING:	Operator (Name&sign):	S. MASHU	
END 2 TAPPING PADS WELDING:	Operator (Name&sign):	Sibiya	

  
2024-05-17  
INDUSTRIAL QUALITY  
TOLERANCE



**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	6		
	C	4		
	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	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: \_\_\_\_\_

**QUANTITIES (M1)**

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	2	✓	
	B	4	✓	
	C	5	✓	
	D	3	✓	

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

VERIFICATION BY: ASALIDA

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: ASALWAH

2024-05-17  
 INDUSTRIAL QUALITY  
 INSPECTION

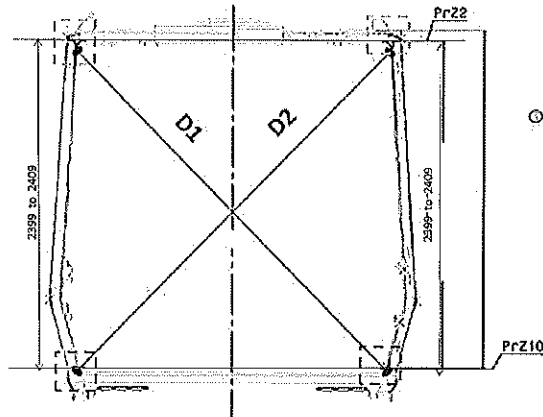


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30226487/2

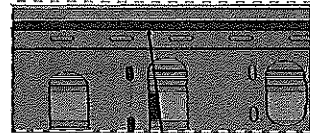
Rev.  
29  
Date  
28/10/2023

Project: PRASA  
SI.CB1220.250.V29

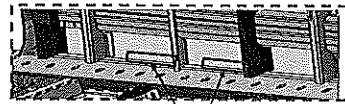
Specifications of Details for CBS measurement



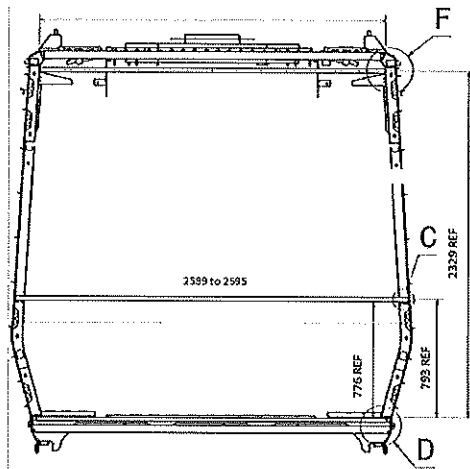
Measurement positions on roof rail and sidewall omega corner.



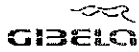
Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



GIBELQ  
2024-05-17  
INDUSTRIAL QUALITY  
MANUFACTURE

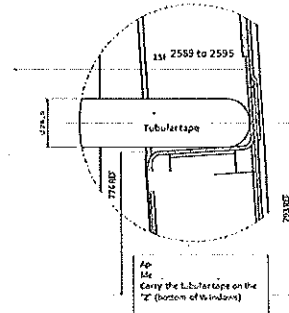
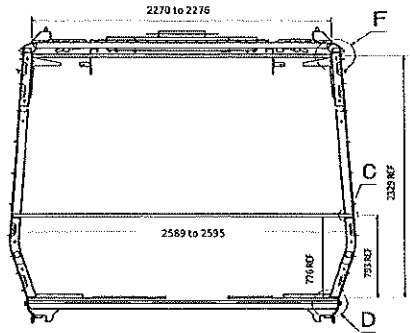


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2

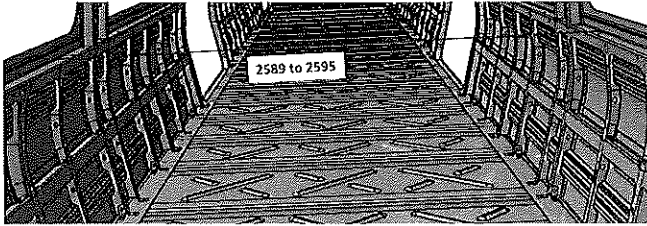
Rev.  
29  
Date  
28/10/2023

Project: PRASA  
SI.CB1220.250.V29

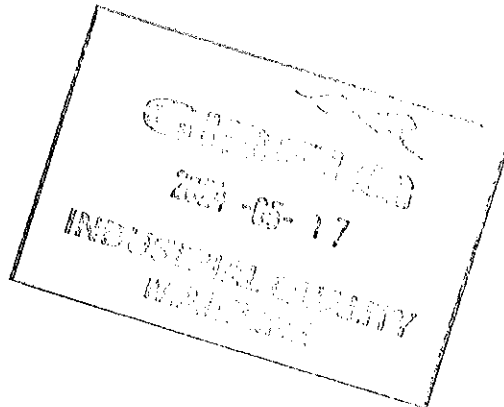
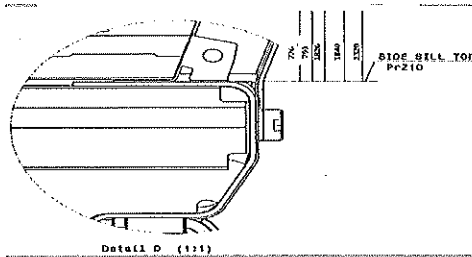
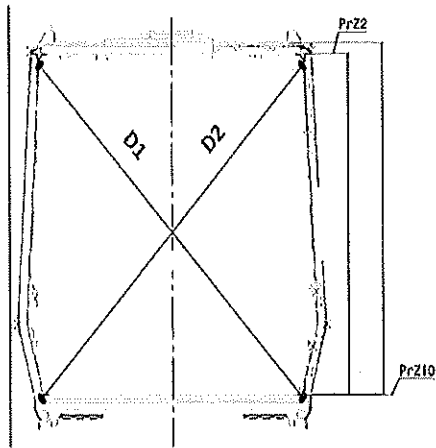
CBS measurement




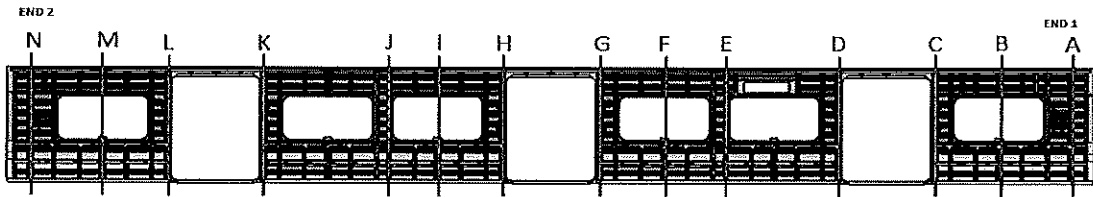
Detail C



Take measurement close to radius

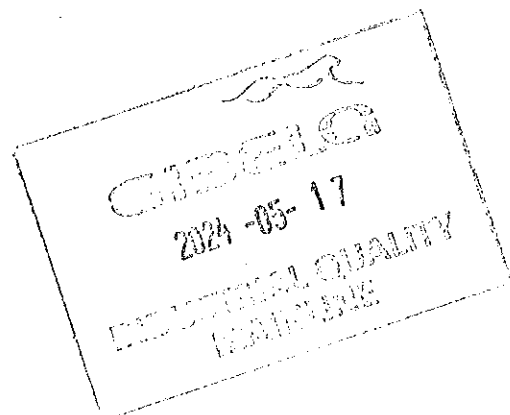


	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA  SI.CB1220.250.V29
		29	
		Date	
		28/10/2023	
<b>GBS measurement</b>			



**BEFORE WELDING**

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3300	0	-
B	3267	3268	1	-
C	3295	3293	2	-
D	3295	3295	0	-
E	3268	3269	1	-
F	3268	3268	0	-
G	3297	3295	2	-
H	3297	3297	0	-
I	3265	3265	0	-
J	3268	3267	1	-
K	3294	3298	4	-
L	3294	3296	2	-
M	3267	3270	3	-
N	3295	3295	5	-



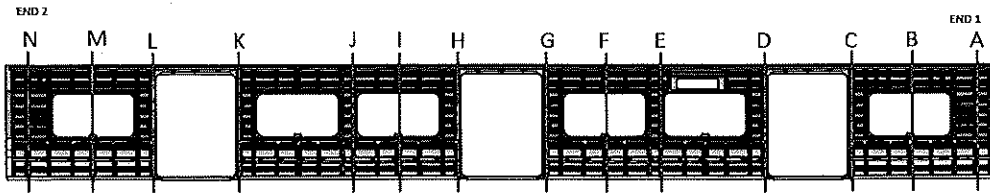


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2

Rev.  
29  
Date  
28/10/2023

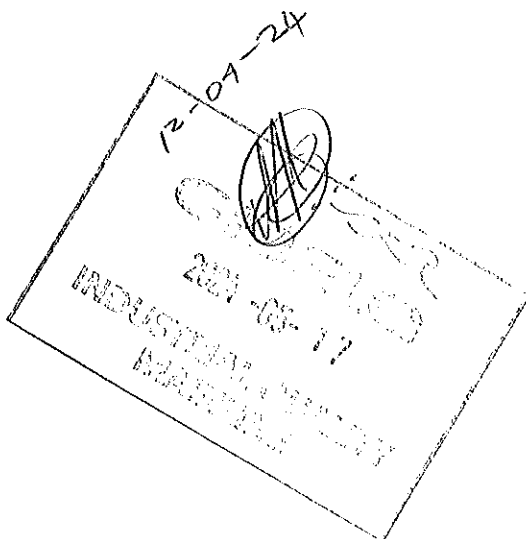
Project: PRASA  
SI.CB1220.250.V29

CBS measurement



AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3299	3300	1	2595
B	3267	3266	1	2589
C	3293	3299	6	2589
D	3294	3295	1	2590
E	3268	3270	2	2595
F	3270	3264	6	2592
G	3296	3300	4	2592
H	3295	3294	1	2590
I	3261	3263	2	2593
J	3266	3267	1	2595
K	3267	3300	3	2592
L	3293	3297	4	2589
M	3263	3268	5	2589
N	3294	3294	3	2595

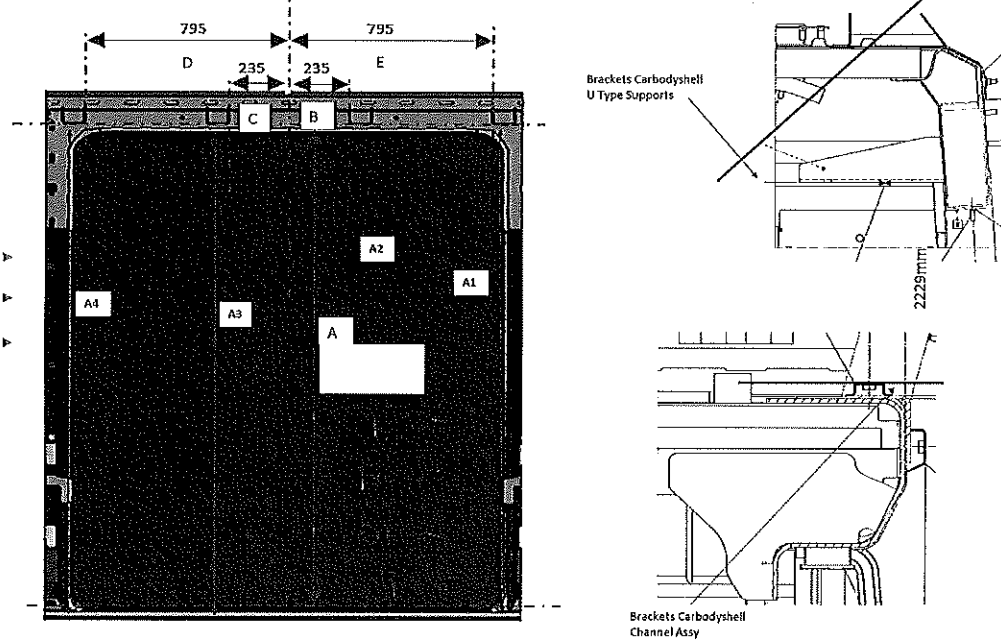




CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30226487/2

Rev. 29 Project: PRASA  
Date 28/10/2023 SI.CB1220.250.V29

Specifications of Details for CBS measurement CB1220



DOOR 1 - LHS

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

DOOR 2 - LHS

	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	235
C	234 to 236	235
D	794 to 796	795
E	794 to 796	795

DOOR 2 - RHS

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

DOOR 1 - RHS

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

DOOR 2 - RHS

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

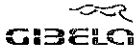
DOOR 3 - RHS

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

*[Handwritten signature]*

12-0A-24

GIBELCO  
2024-05-17  
INDUSTRIAL QUALITY  
MACHINE

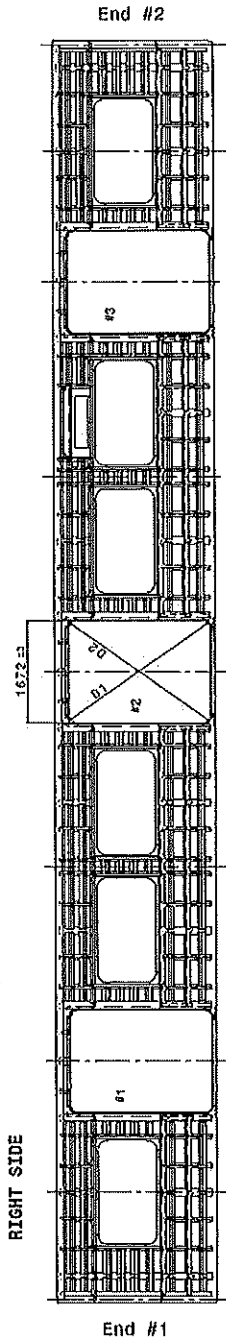


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30226487/2

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29  
Date  
28/10/2023

Project: PRASA  
SI.CB1220.250.V29

Specifications of Details for CBS measurement CB1220



RIGHT SIDE

End #1

Doors diagonal D1-D2 maximum difference ≤4mm

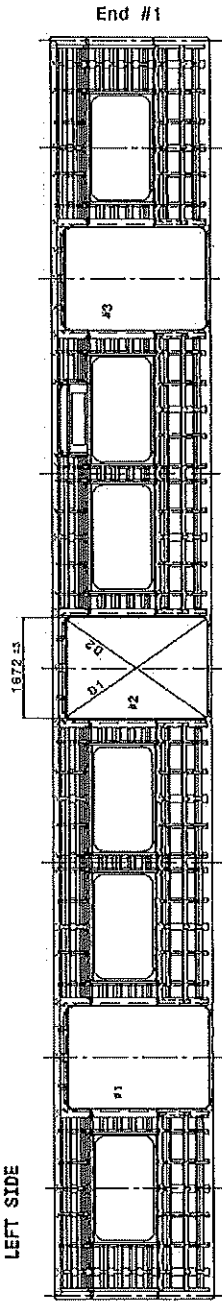
#1	#2	#3
D1	2748	2745
D2	2747	2746
D1-D2	1	1

Doors length = 1672 class

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

LEFT SIDE

End #2



Doors diagonal D1-D2 maximum difference ≤4mm

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


Doors length = 1672 class

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

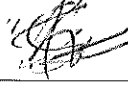
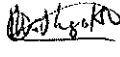
Handwritten signature and date: 2024-05-17

GIBELA  
2024-05-17  
INDUSTRIAL ENERGY  
MACHINE



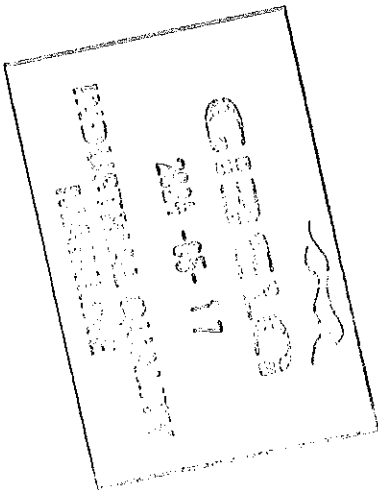
	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DTR30226487/2	Rev. 29	<b>Project: PRASA</b>  <b>SI.CB1220.250.V29</b>
		Date 28/10/2023	


**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	
<b>HOLD POINT</b>	<b>GO</b>	(if activities are not complete, the missing activities must not impact the next stage)	12/04/24	Silvius Operations		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party)	12/04/24	Richardson 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	

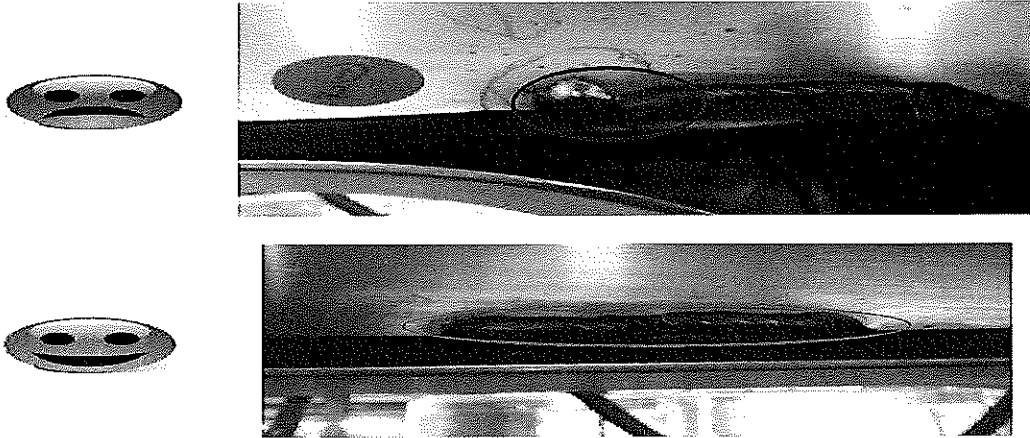
Operations

Quality

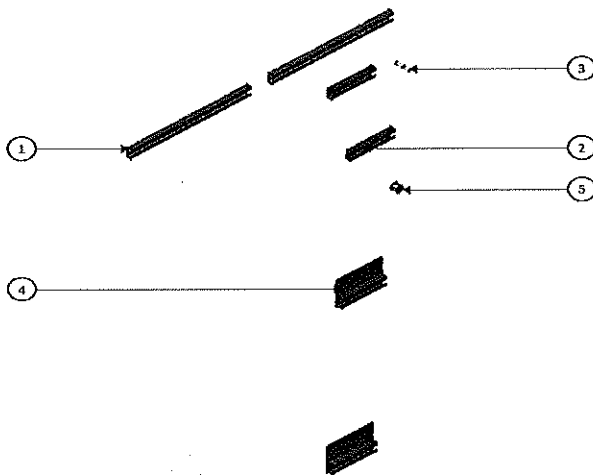


	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DTR30226487/2	Rev.	<b>Project: PRASA</b>  <b>SI.CB1220.250.V29</b>
		29	
		Date	
		28/10/2023	

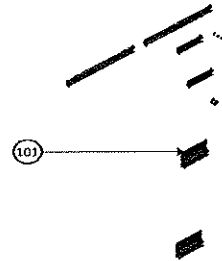
**ANNEXURE A: Arc Welding Quality Acceptance Standard**

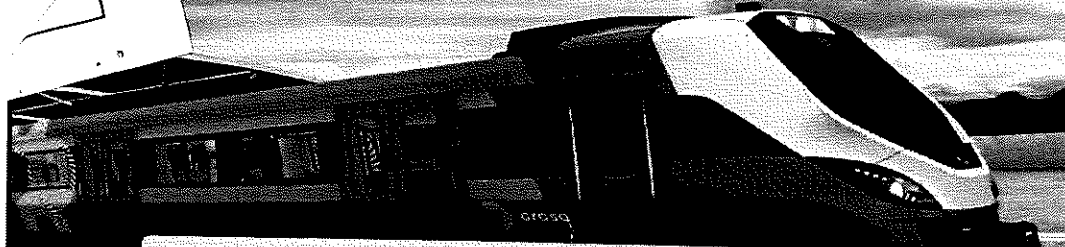


**Station: CB1220-004- U108 & U107**



PART NO.	ITEM NO.	QTY	DESCRIPTION	MASS (KG)
DTF0002074283	5	6	EARTH STUD 6	0.036
AA0001201642	4	6	ASSEMBLY SUPPORT	0.271
DTF0000248305	3	12	WELDING STUD ISO13918 PT - R-SEGO-SS1	0.007
AA0001160424	2	12	ASSEMBLY SUPPORT	0.193
AA0001184412	1	14	ASSEMBLY SUPPORT	0.522
AA0001161003	101	6	CARBODYSHELL BRACKETS CARBODYSHELL M1/M3/M4 CAR(SIDE FRAME MODULE END - 099)	12.132





APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

# SELF INSPECTION SHEET

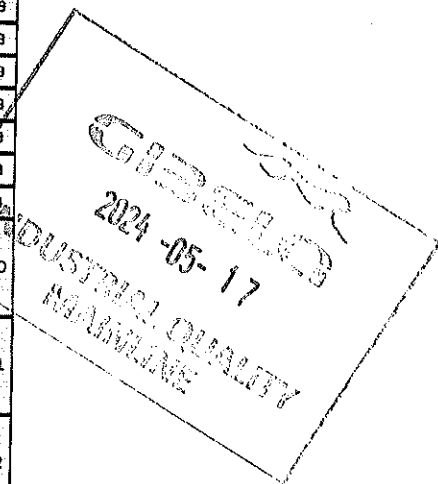
**CONFIDENTIAL INFORMATION**

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 ?	
				TC	M1	M2	M3	M4	TC			
<input checked="" type="checkbox"/>	DT00000225487	AAD0001278566	CARBODYSHELL M1,M3,M4 ASSEMBLY	CB1210		X	X		X		PRA.CB1230.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	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
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	20/02/2022
			CHECKER	Andani Muthelo	20/02/2022
			REVISED BY	Andani Muthelo	20/02/2022
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	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	06/11/2023	Added thresholds traceability for boiler makers and welders	APPROVER	Tyson Ngobeni	06/11/2023
			CHECKER	Andani Muthelo	06/11/2023
			REVISED BY	Ntokozo Zwane	06/11/2023



TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
002	M01	KGOTSO 626952	18/04/24	SI.CB1230.256.V28	11



CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.  
29  
Date  
08/11/2023

Project: PRASA  
SI.CB1230.256.V28

Car:

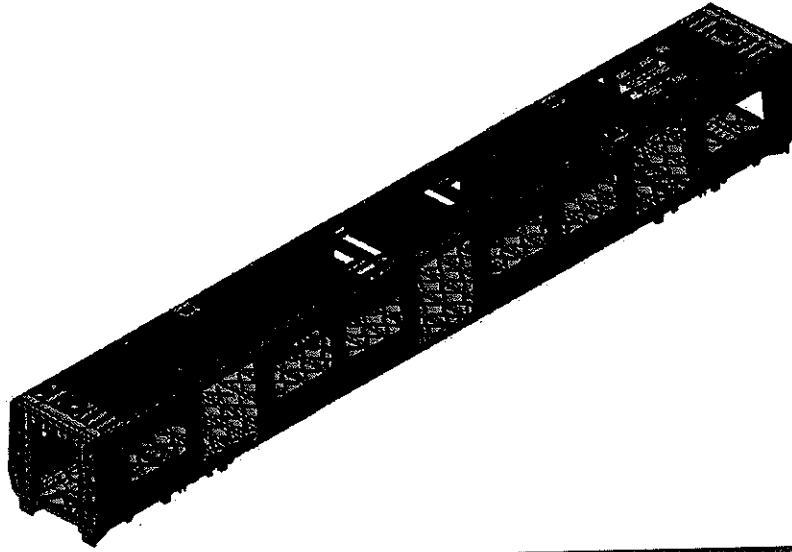
NCR:

Work station:

CB1230



Safety Related



**I - Documentation and Instruments Control**

**1.1 - Documentation Control**

Document	Type of car					Revision	Observation	Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4	T02				
PRA.CB1230.DT00000225487	X					30	X	N/A 15/04/24	15/04/24

**1.2 - Instruments Control**

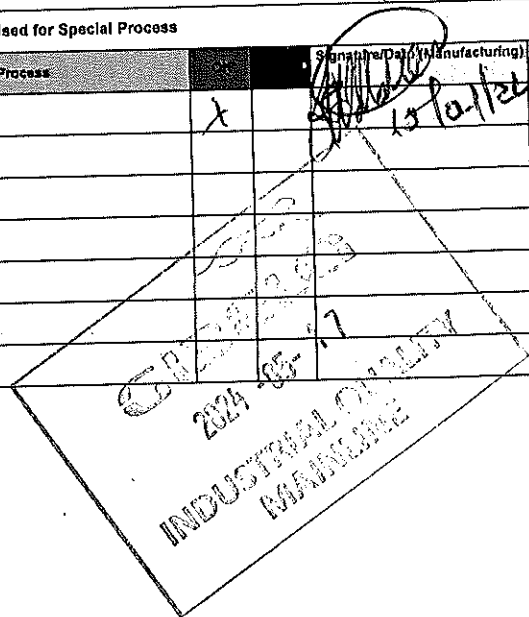
**Monitoring and Measuring Instrument Control - Used for Special Process**

Instruments	Serial number	Calibration or Verification Validation Date	Signature/Date (Operations)	Signature/Date (Quality)
Measuring Tape	GIB 0794	25/04/24	X	15/04/24
Combination Square	GIB 0072	27/07/24	X	15/04/24
Tubulose	02713	26/06/24	X	15/04/24

**1.3 Consumables**

**Welding Consumable Control - Used for Special Process**

Filter Material	Heat Number	Welding Process	Signature/Date (Manufacturing)	Signature/Date (Quality)
L81 308	E231067	MIG	X 15/04/24	15/04/24



**II - Self Inspection - Items to Check**

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	Signature/Date (Operations)	Signature/Date (Quality)						
01	N/A	Assembly according to Instruction Engineering nº PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487		15/04/24						
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675		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		15/04/24						
		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002		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.		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.		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"> <tr> <td>Temperature Min - Max (1)</td> <td>Min-Max</td> <td>10°C - 35°C</td> </tr> <tr> <td>Relative humidity Min - Max (1)</td> <td>Min-Max</td> <td>25% - 60%</td> </tr> </table>	Temperature Min - Max (1)	Min-Max	10°C - 35°C	Relative humidity Min - Max (1)	Min-Max	25% - 60%	Lot FA Sealant Batch No: 20812031 Exp Date: 10/05/24  Actuals Temperature: 15°C Humidity: 62%		15/04/24
Temperature Min - Max (1)	Min-Max	10°C - 35°C									
Relative humidity Min - Max (1)	Min-Max	25% - 60%									
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.		15/04/24						

2024-05-17  
INDUSTRIAL QUALITY  
MARGOLINE



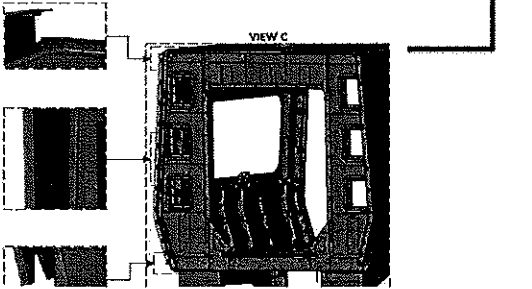
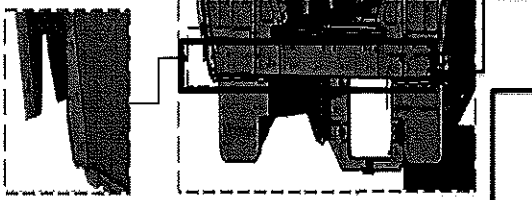
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.  
29  
Date  
06/11/2023

Project: PRASA  
SI.CB1230.256.V28

**END 2 SEALANT**

AREA 1



H

OPERATOR  
(Name & sign):

Boitumelo *[Signature]*

OPERATOR  
(Name & sign):

Boitumelo *[Signature]*

OPERATOR  
(Name & sign):

Boitumelo *[Signature]*

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):

Nonhlanhla *[Signature]*

Nonhlanhla *[Signature]*

Operator (Name & sign):

\_\_\_\_\_

\_\_\_\_\_

Operator (Name & sign):

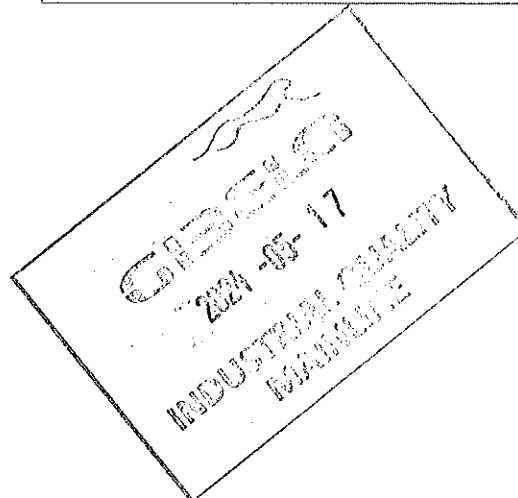
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\_\_\_\_\_

Operator (Name & sign):

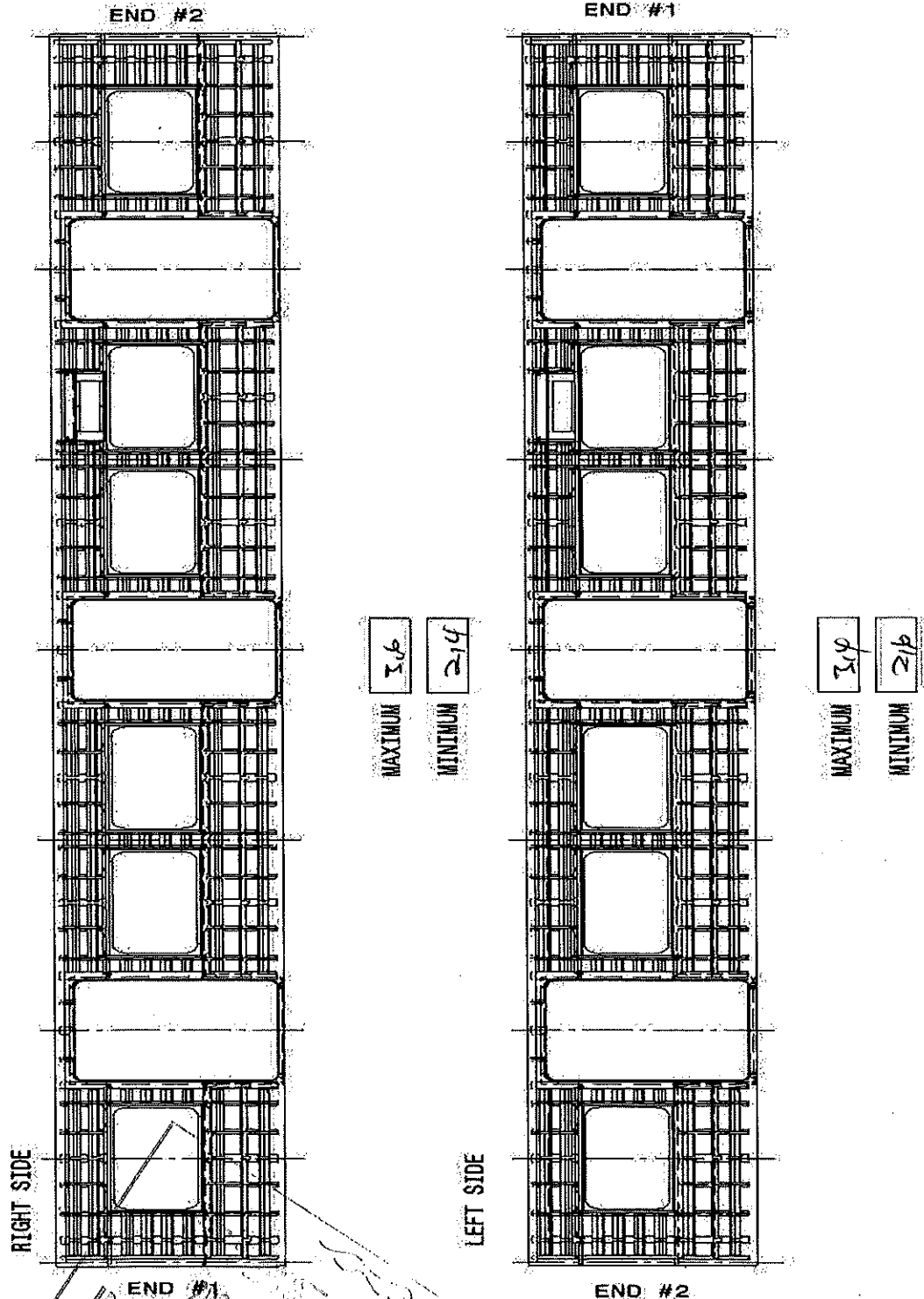
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Specifications of Details for CBS measurement CB1230

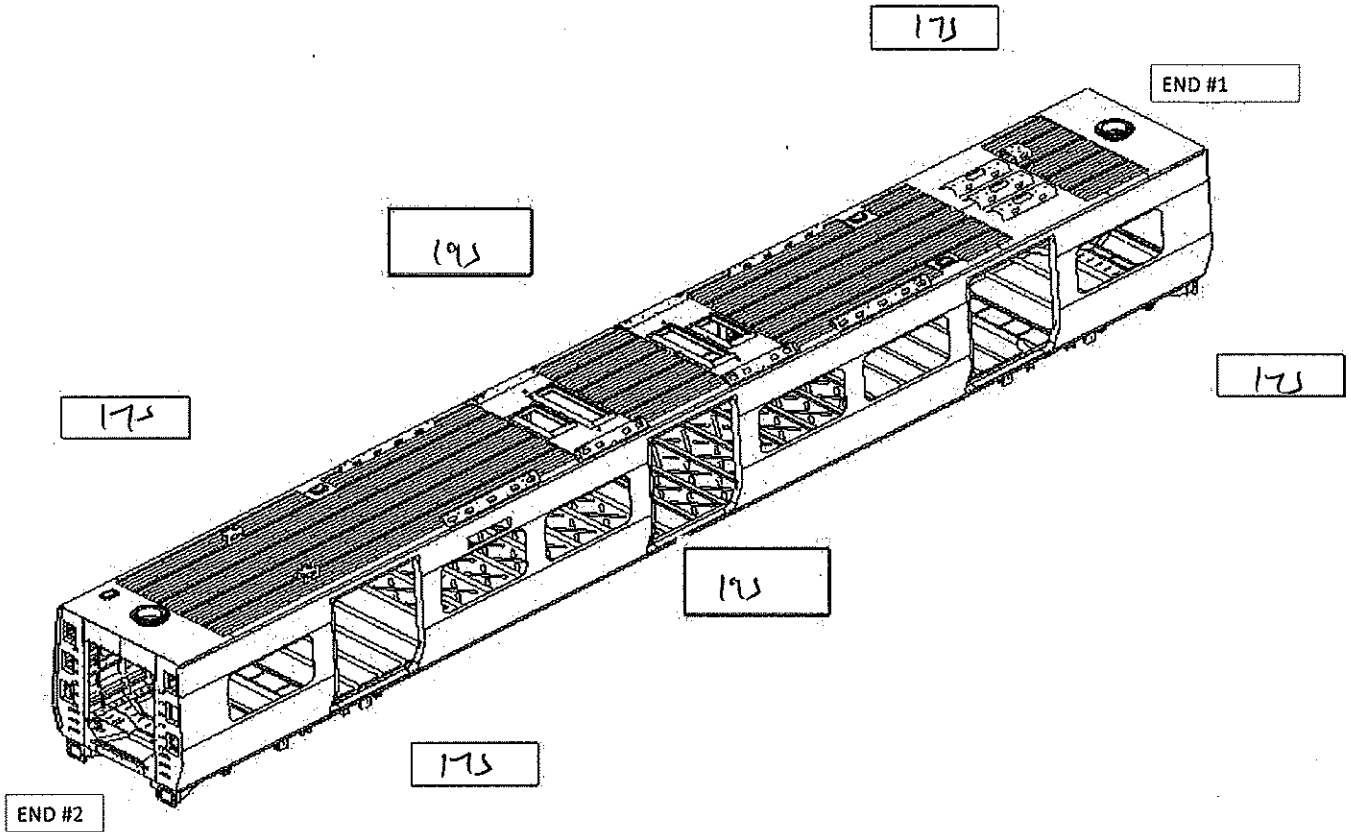
Flatness side left and right maximum of 2mm in the valley to peak measured in 900mm. Recod the maximum and minimum value found and indicate the corresponding region.



END #2  
2024-05-17  
INDUSTRIAL QUALITY  
MEASUREMENT

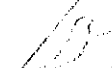
Specifications of Details for CBS measurement CB1230

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



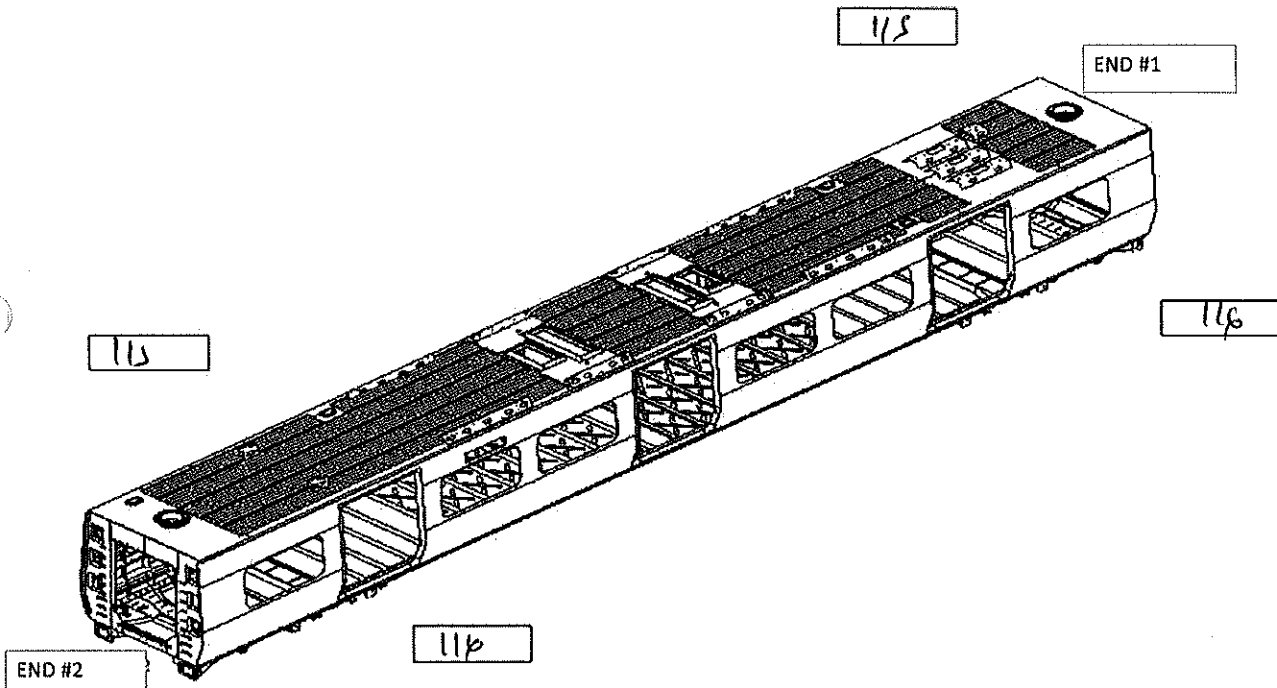
MEASURED CAMBER VALUES

RIGHT	$\frac{1}{2}$	20
LEFT	$\frac{a1}{a1}$	20

  
 GIBELO  
 2018-08-17  
 INDUSTRIAL GROUP  
 INDUSTRIAL GROUP

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.

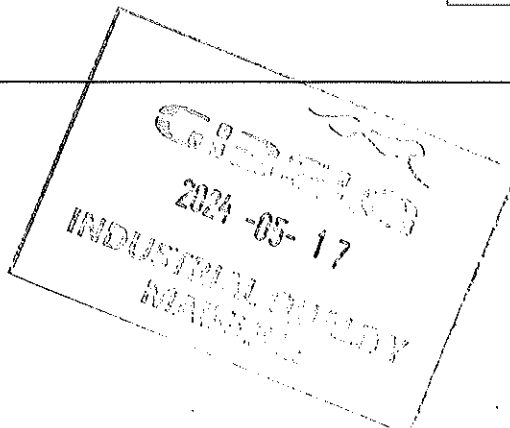


TWIST FOUND ON END 1

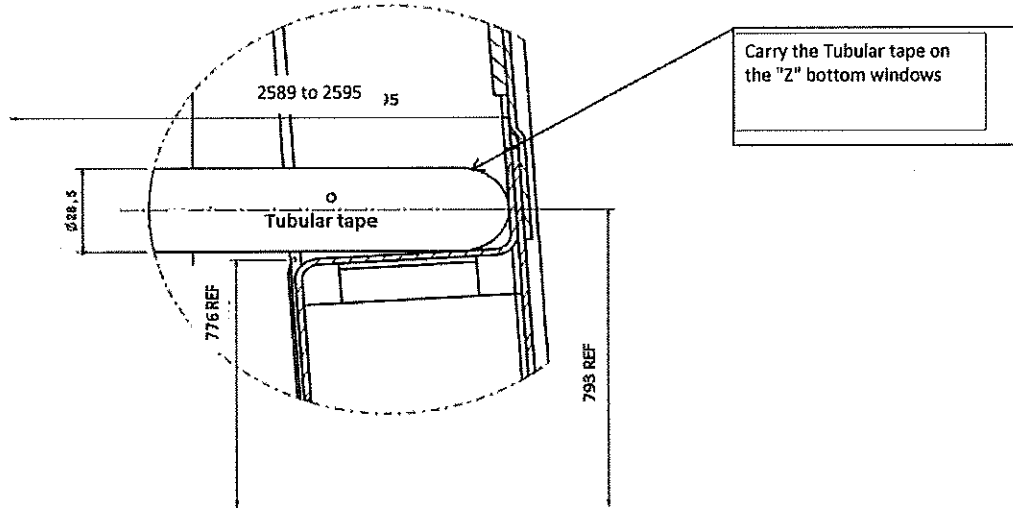
TRANVERS   
LONGITUDIN

TWIST FOUND ON END 2

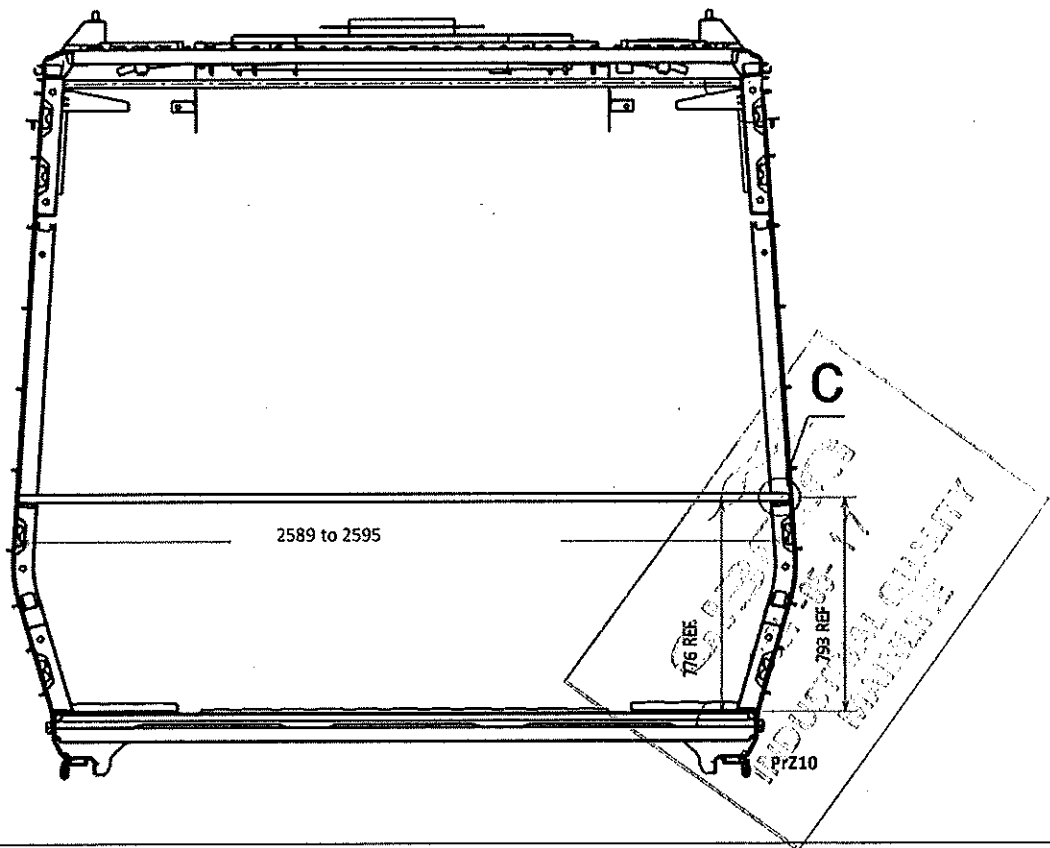
TRANVERSE   
LONGITUDINAL



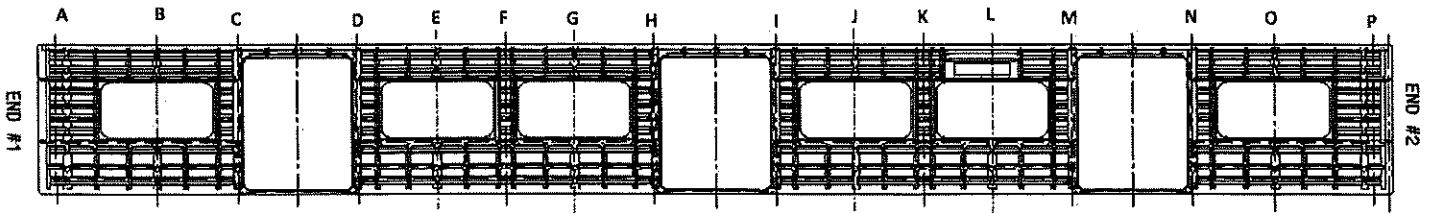
Specifications of Details for CBS measurement CB1230



Detail C

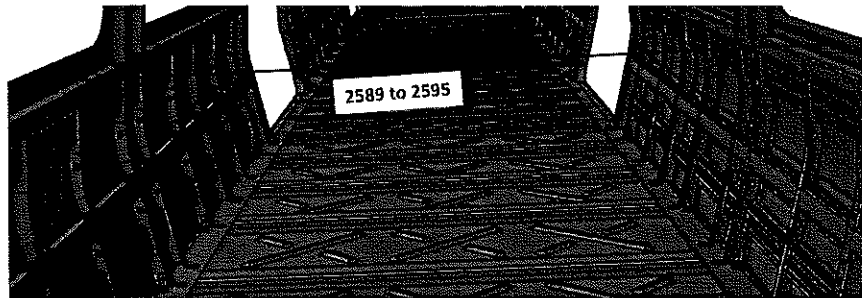


Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	2590
B	2591
C	2591
D	2589
E	2592
F	2591
G	2594
H	2591
I	2590
J	2594
K	2594
L	2595
M	2589
N	2590
O	2593
P	2591



Threshold verification						Nominal value :38
Door 1		Door 2		Door 3		
L	R	L	R	L	R	
38	38	38	39	39	39	
Door 4		Door 5		Door 6		
L	R	L	R	L	R	
38	37	37	38	37	38	

BOILER MAKER: Buhle Angola  
weider mmathapel0

2024-05-17  
INDUSTRIAL QUALITY  
MEASUREMENT





CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.  
29  
Date  
06/11/2023

Project: PRASA  
SI.CB1230.256.V28

**Self Inspection - Final Result**

Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)		DATE	NAME	SIGNATURE
<b>HOLD POINT</b>	(If activities are not complete, the missing activities must not impact the next stage)	15/04/24	K. GOTSIS Operations	
	Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	15/04/24	Richard 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)			

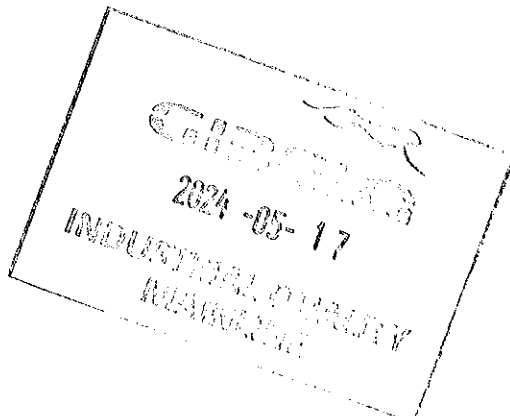
In case of "NO GO", describe blocking problems

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

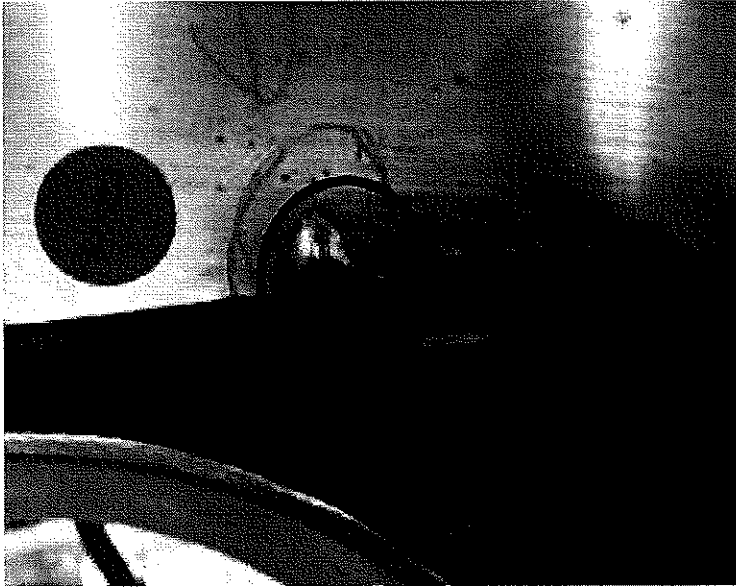
Item	Description	Responsible	Due date	Status

Operations

Quality



ANNEXURE A: Arc Welding Quality Acceptance Standard



11230-4-TC  
122c-4M1  
110-4M2

