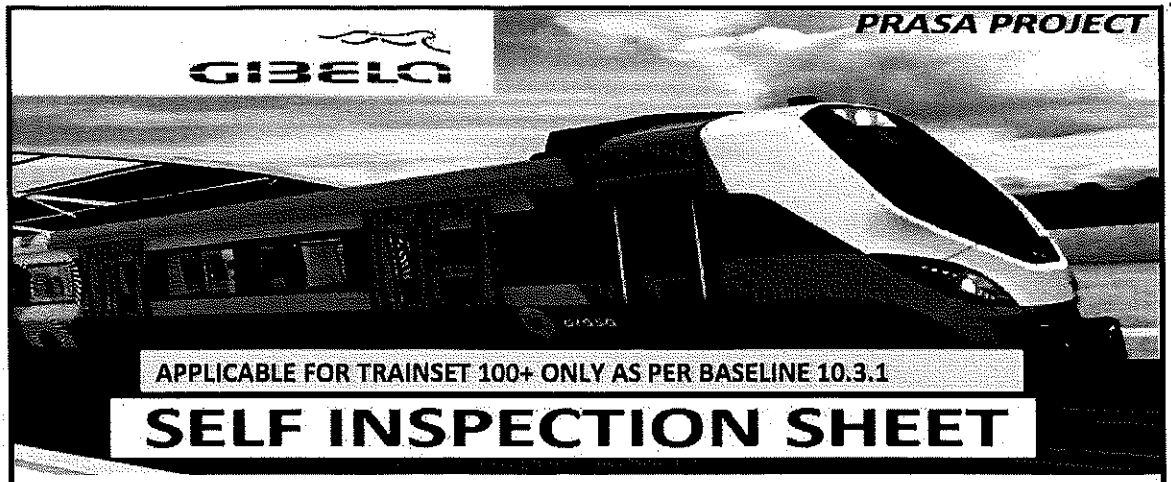


APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?
				TC1	M4	M5	M6	M8	TC2		
OTR30223319/3	AAD0001241033	Carshell Assembly TC	CB1210	(X)					X	PRA.CB1210.DTR3022331 9/3.V25	YES

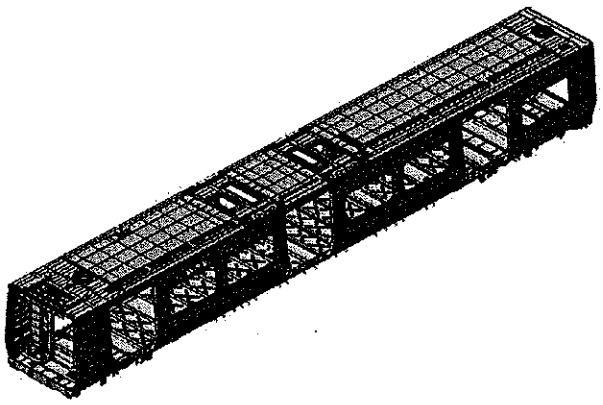
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	09/04/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	09/04/2018
			CHECKER	Nosizo Pindela	09/04/2018
			COMPILER	Thanyani Mathegu	06/04/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motama	2018/05/18
2	2018/06/18	MODIFICATION CONTENT	APPROVER	Itumeleng Modiba	2018/06/18
			CHECKER	Nosizo Pindela	2018/06/18
			REVISED BY	Ramokone Motama	2018/06/18
3	2018/12/12	Additional checkpoints	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	2019/11/03	Record D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	2019/11/03
			CHECKER	Nosizo Pindela	2019/11/03
			REVISED BY	Nosizo Pindela	2019/11/03
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	
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	
20	19/04/2020	New Baseline change 10.3	APPROVER	Timothy Maimela	
			CHECKER	Bongane Masina	19/04/2021
			REVISED BY	Bongane Masina	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi Collins	
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISED BY	Mpho Mulaudzi	
25	21/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombhi Collins	
			CHECKER	Andani Muthelo	21/02/2022
			REVISED BY	Andani Muthelo	
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	
			CHECKER	Mohlampe Amogelang	14/04/2023
			REVISED BY	Mohlampe Amogelang	
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	
			CHECKER	Mathapo Kelebone	27/07/2023
			REVISED BY	Mohlampe Amogelang	
28	07/11/2023	Addition of welding traceability	APPROVER	Ngobeni Tyson	
			CHECKER	Andani Muthelo	07/11/2023
			REVISED BY	Ntokozo Zwane	

TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
223	TC1	Lawrence 482999	15/04/24	SI.CB1210.322.V28	16

GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

Car: TC1 & TC2	NCR:	Work station: CB1210

Safety Related



I - Documentation and Instruments

I.1 - Documentation Control

Document	Type of car TC1	M	M2	C2	M	TC2	Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
DTR30223319/3	✓						V28		✓		N/A	

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Validation	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
LAZER TAPE	1254259721	01/04/24	✓		15/04/24	
3m Mitre TAPE	GIBTP0049	24/11/23	✓		15/04/24	
TUBULAR	32823-2	15/03/24	✓		15/04/24	

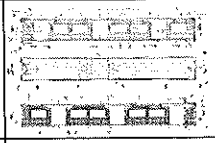
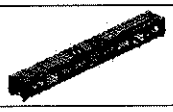
1.3 Consumables

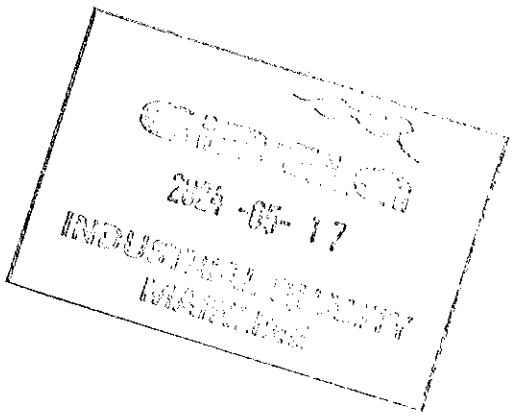
Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSi	3140018-74097	MIG	✓		15/04/24	
ER 308 L	2996807-70322	TIG	✓		15/04/24	
ER 309 LSi	3162283-73957	MIG	✓		15/04/24	

GIBELA 2024-05-17 QUALITY

GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

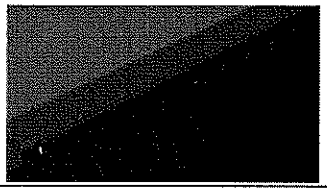
Item	Picture/Drawing	Description	Acceptance criteria / Record				Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls,Endframes,Roof and Underframe)	DT00000284980	✓			15/04/24	15/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓			15/04/24	15/04/24
03		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	15/04/24
04	REFER TO ANNEXURE A	Spot Welding inspected and approved according procedure	IND-SAL-WMS-016 e DTD0000210675	✓			15/04/24	15/04/24
05	REFER TO ANNEXURE B	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓			15/04/24	15/04/24
06		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓			15/04/24	15/04/24
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.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658	✓			15/04/24	15/04/24



GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

Welder traceability

Roof ring welds



END 1

LHS

Boiler maker (Name & Sign): LUNGA Welder (Name & Sign): Mthokozisi

RHS

Boiler maker (Name & Sign): Malefi Welder (Name & Sign): Mthokozisi

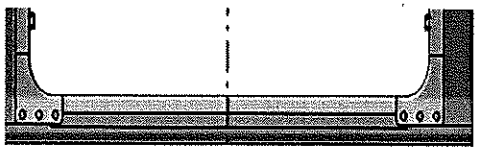
END 2

LHS

Boiler maker (Name & Sign): LUNGA Welder (Name & Sign): Mthokozisi

RHS

Boiler maker (Name & Sign): Malefi Welder (Name & Sign): Mthokozisi



LHS

Boiler maker (Name & Sign): Tumelo

Welder (Name & Sign): Sibu

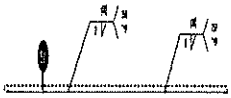
RHS

Boiler maker (Name & Sign): Tumelo

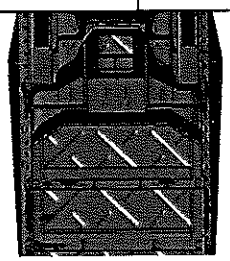
Welder (Name & Sign): Sibu

GIBELA
2024 -05- 17
INDUSTRIAL ENGINEERING
MANAGER

EUF Reinforcement Plates



GIBELO	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

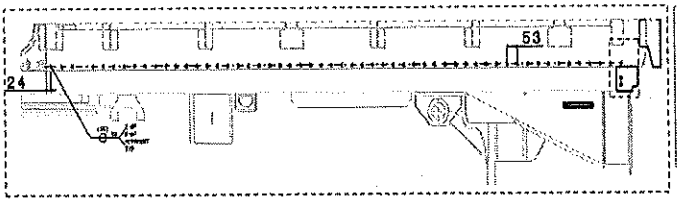


Underneath the CAR

END 2

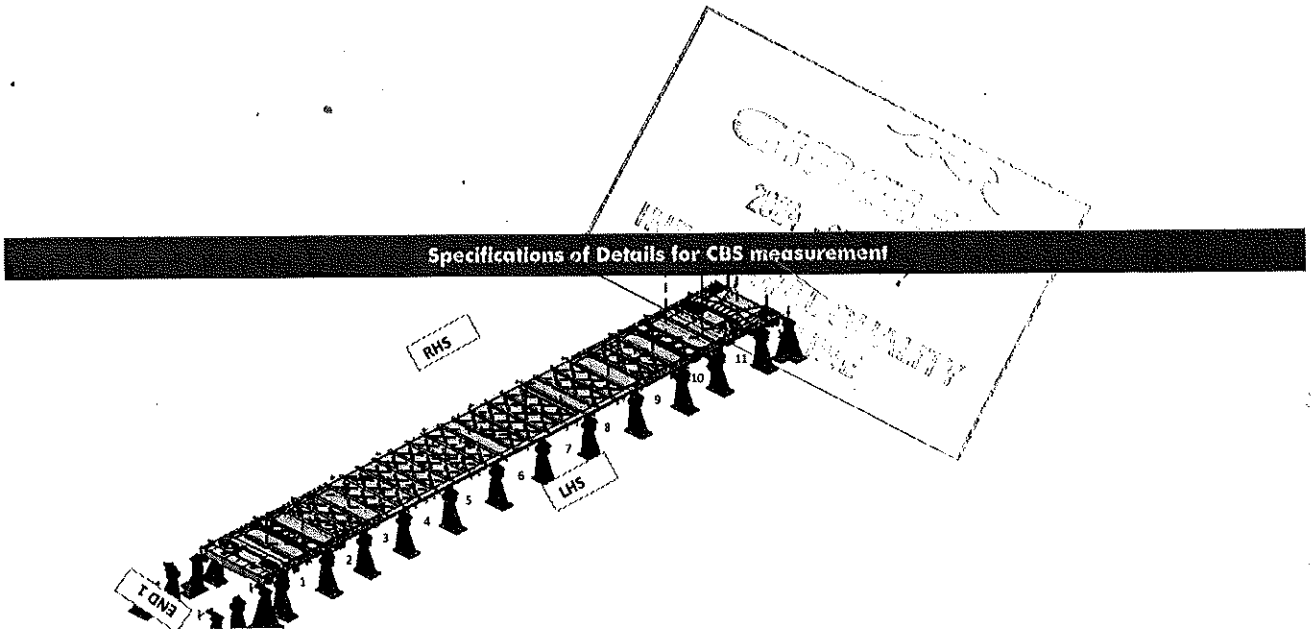
Boiler maker (Name & Sign): Innocent

Welder (Name & Sign): Thabang



FEDOLI

Operator: Lawrence



GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

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

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

After Loading Underframe and Clamping.

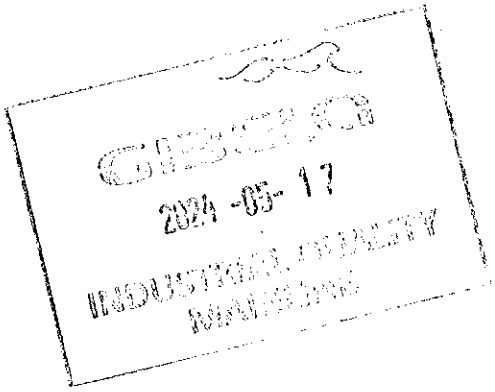
	1	2	3	4	5	6	7	8	9	10	11	12
Left Hand Side				NA								
Right Hand Side												

Signature Operations: [signature] Date: 15/04/24

After Welding.

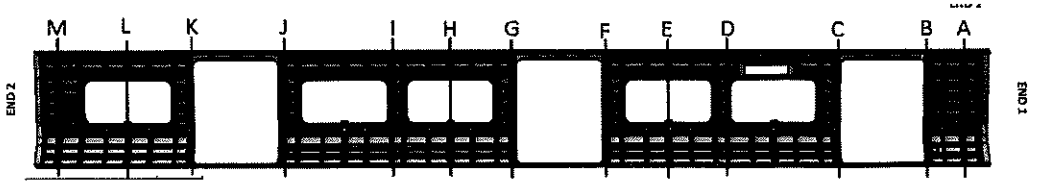
	1	2	3	4	5	6	7	8	9	10	11	12
Left Hand Side						NA						
Right Hand Side												

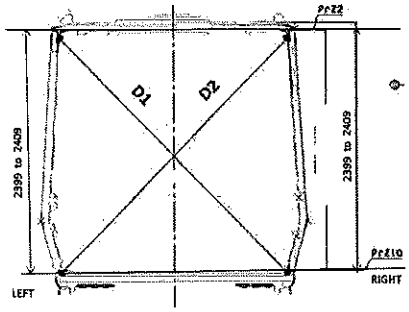
Signature Industrial Quality: [signature] Date: 15/04/24



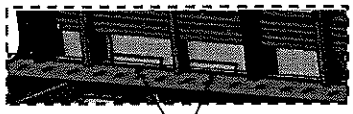
GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

Specifications of Details for CBS measurement

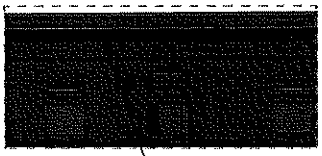




Measurement positions on roof rail and sidewall integral corner



Measurement positions on sidewall and side sill corner

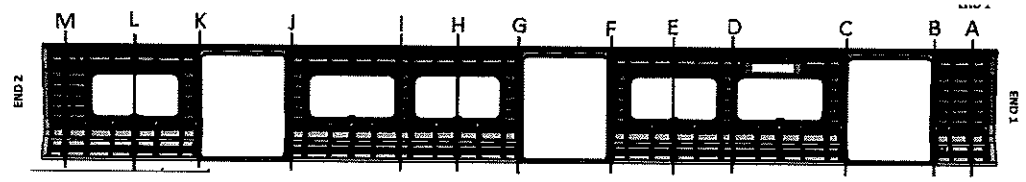


Reinforcement area measurement positions on roof reinforcement area

GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

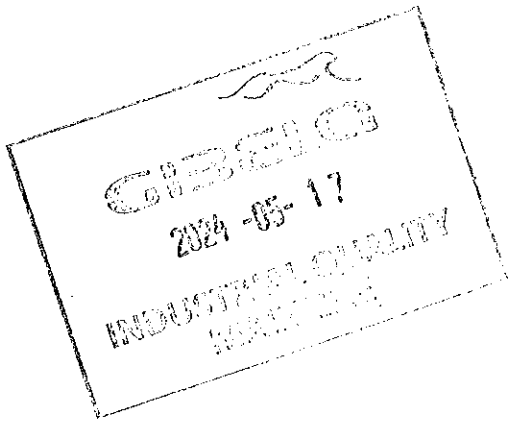
Specifications of Details for CBS measurement

BEFORE WELDING



PME: The difference in Height values measured on the LHS and RHS should be ≤2MM on each point.

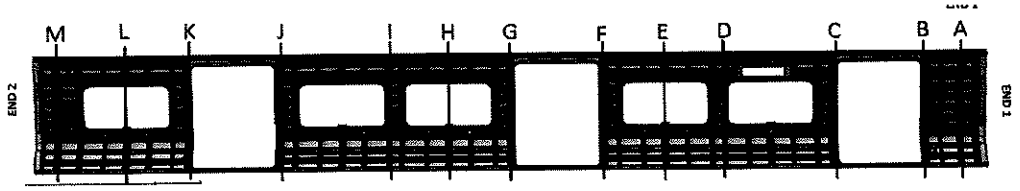
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3266	3265	1	2404	2405	1
B	3267	3267	0	2405	2405	0
C	3266	3265	1	2406	2404	2
D	3267	3267	0	2404	2404	0
E	3266	3267	1	2405	2404	1
F	3268	3266	2	2406	2406	0
G	3266	3267	1	2404	2404	0
H	3267	3266	1	2405	2404	1
I	3266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



GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

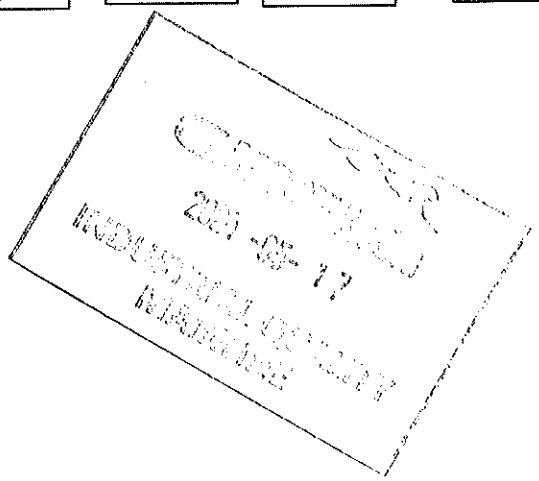
Specifications of Details for CBS measurement

AFTER WELDING



PME: The difference in Height values measured on the LHS and RHS should be ≤2MM on each point.

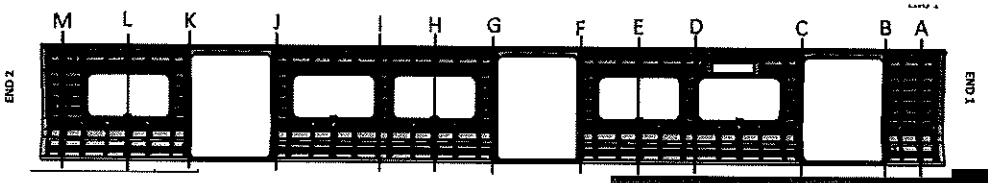
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3266	3265	1	2404	2405	1
B	3294	3296	2	2405	2405	0
C	3292	3294	2	2406	2404	2
D	3267	3267	0	2406	2404	2
E	3266	3267	1	2405	2404	1
F	3298	3298	0	2406	2406	0
G	3297	3298	1	2404	2404	0
H	3267	3266	1	2405	2404	1
I	3266	3267	1	2404	2404	0
J	3296	3296	0	2404	2405	1
K	3297	3297	0	2404	2404	0
L	3268	3268	2	2406	2406	0
M	3294	3294	0	2405	2405	0

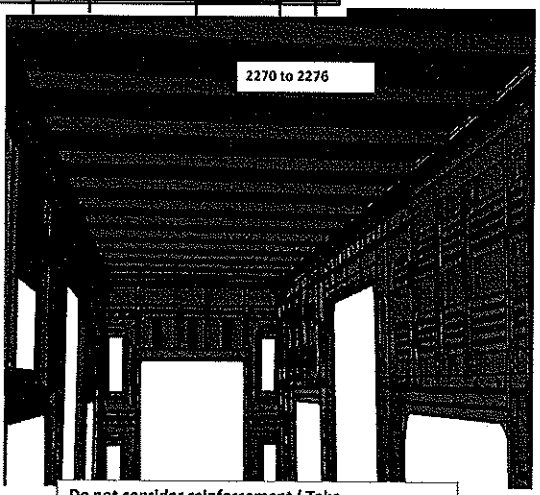


GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

CBS measurement

BEFORE WELDING



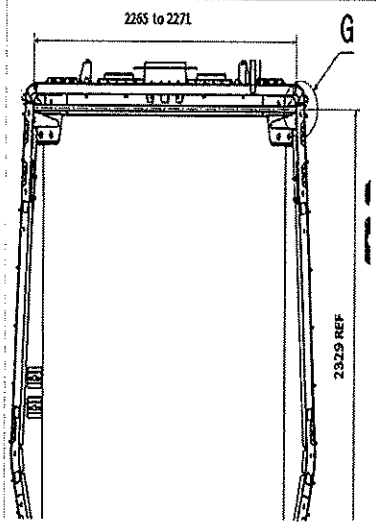


2270 to 2276

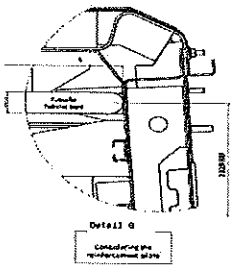
2268 a 2274

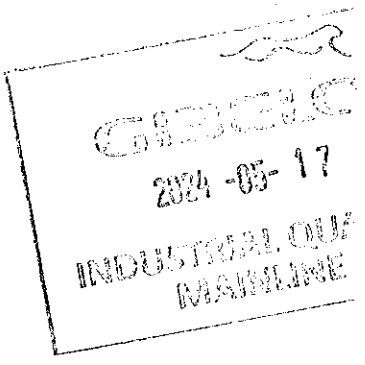
A	2272
B	2270
C	2274
D	2273
E	2274
F	2276
G	2270
H	2272
I	2273
J	2272
K	2270
L	2274
M	2273

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



2265 to 2271

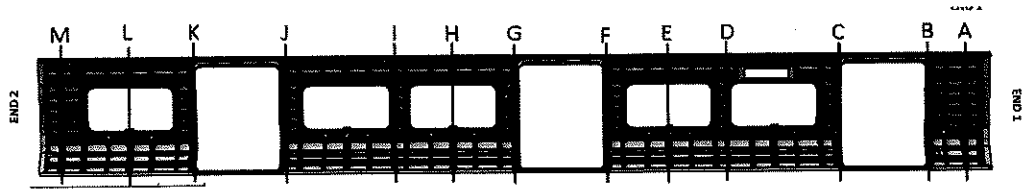




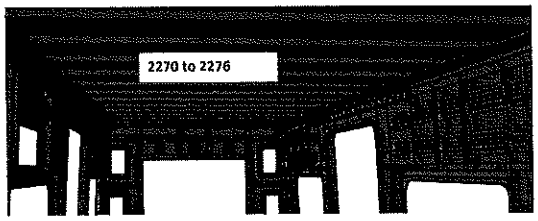
GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

Specifications of Details for CBS measurement

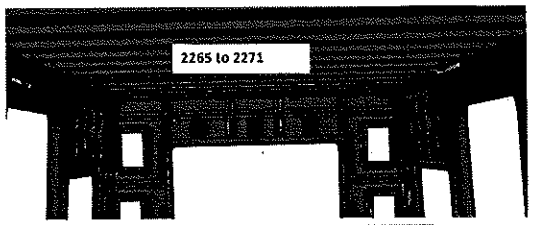
AFTER WELDING



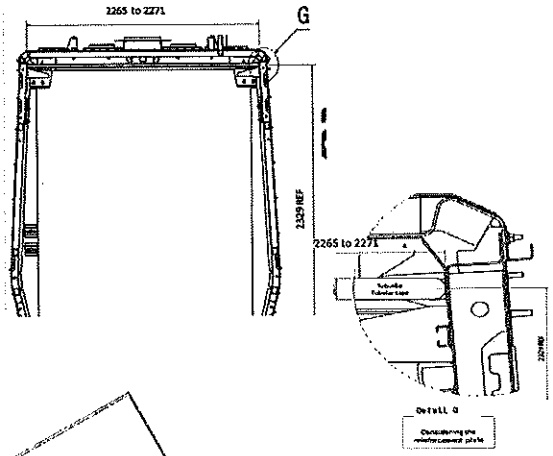
	2265 to 2271	2270 to 2276
A	N/A	2272
B	2268	N/A
C	2270	N/A
D	N/A	2273
E	N/A	2274
F	2271	N/A
G	2266	N/A
H	N/A	2272
I	N/A	2273
J	2268	N/A
K	2266	N/A
L	N/A	2274
M	2269	N/A

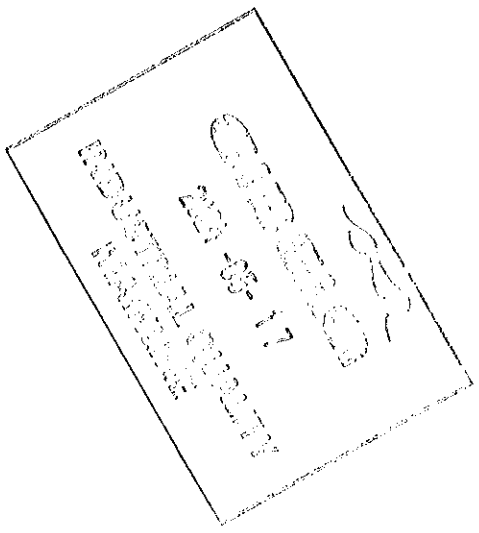


Do not consider reinforcement (Take measurements top area of zee profile



Take measurement close to radius (considering reinforcement)

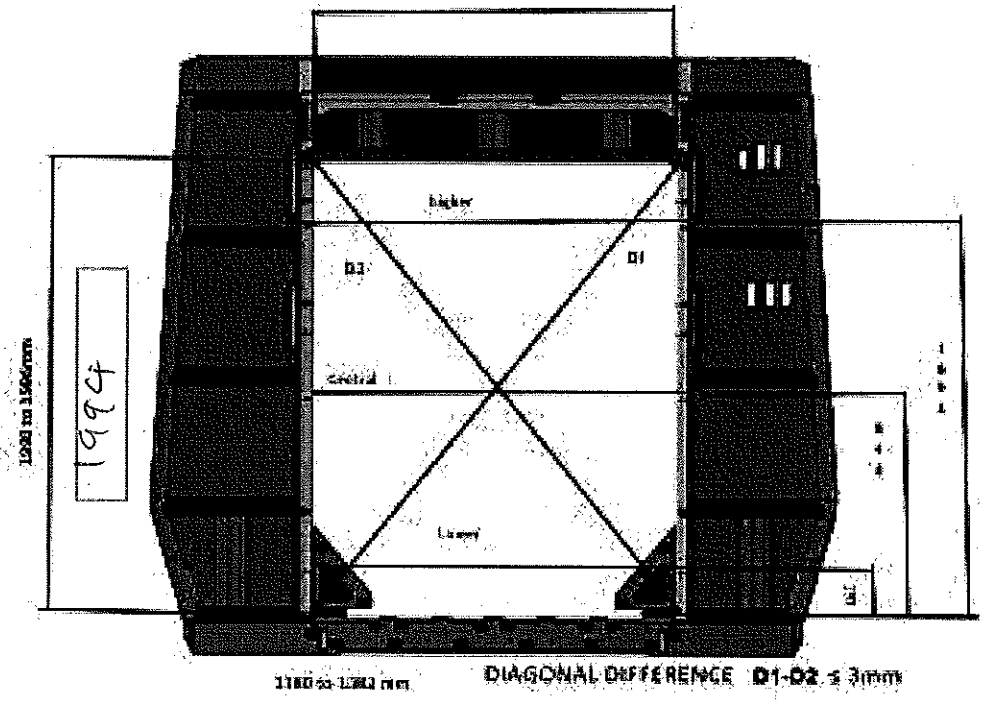




GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

Specifications of Details for CBS measurement

Endframe 2

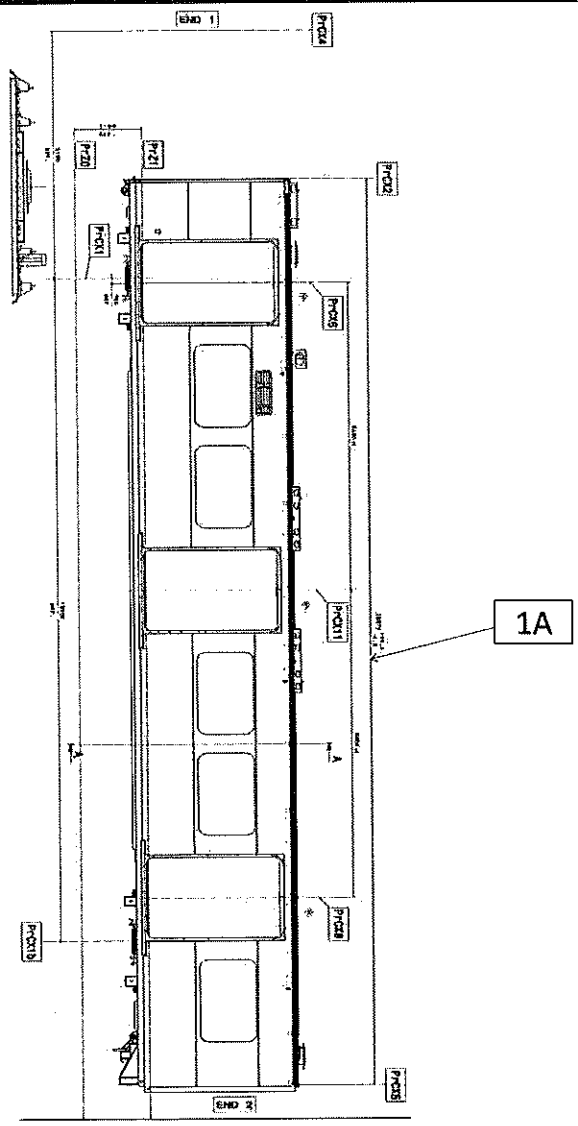


DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension	1380	D1	2415
Central Dimension	1381	D2	2414
Lower Dimension	1380	D1-D2	1

GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

Specifications of Details for CBS measurement

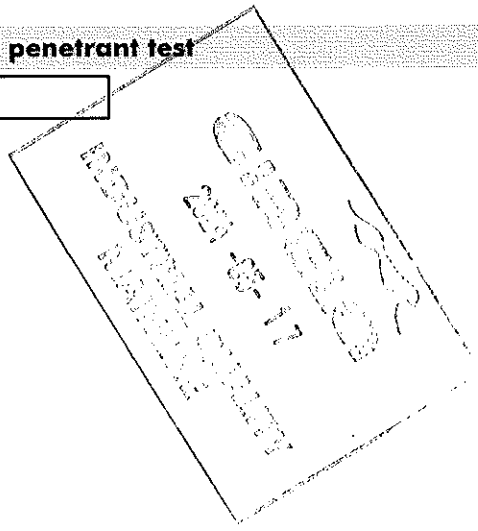


	LEFT SIDE	
	SPECIFICATION SIZE	ACTUAL SIZE
1A	18870 +10.5 -4.5	18876

	RIGHT SIDE	
	SPECIFICATION SIZE	ACTUAL SIZE
1A	18870 +10.5 -4.5	18876

Dye penetrant test

Dye-penetration test to be performed by quality personnel



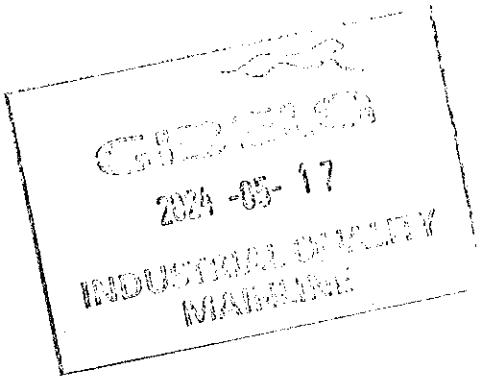
GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

Item	Description of the issue		Signature/Date (Manufacturing)	Signature/Date (Quality)

II.2 - Check List REX

Check List Items

Item	Picture/Drawing	Description	Criteria/Record				Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX					



GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.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
HOLD POINT		GO	If activities are not complete, the missing activities must not impact the next stage!	15/04/24	Laurence Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	15/04/24	Richmond Quality	
			There are activities pendings 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)		Quality	

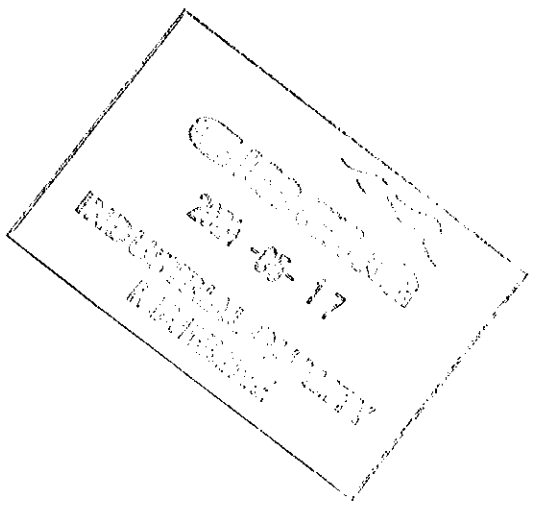
In case of "NO GO", describe blocking problems

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

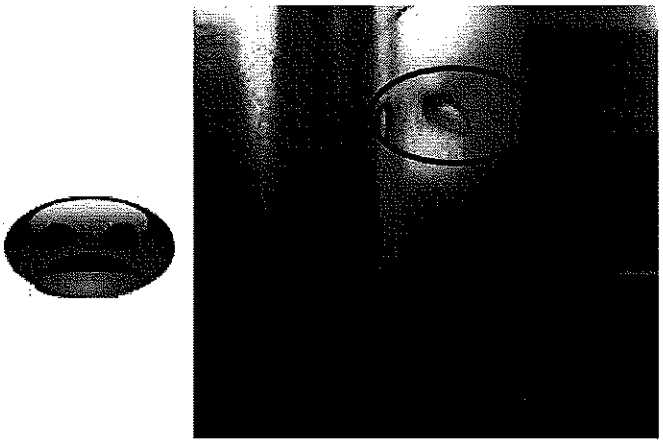
Item	Description	Action	Responsible	Due date	Status

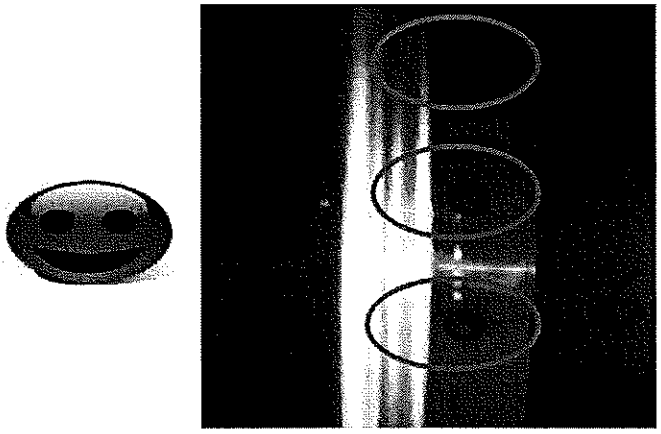
Operations

Quality



ANNEXURE A: Spot Welding Quality Acceptance Standard





GIBELA

PRASA PROJECT

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

APPLICATION REFERENCE

	MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY?
					TC1	MP1	MB1	MB2	MP2	TC2		
☐	DTR30223319/2	AAD000124103J	Carshell Assembly TC	CB1210	X					X	PRA.CB1220.DTR30223 319/2.V20	YES
☐												
☐												
☐												
☐												
☐												

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	09/04/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	09/04/2018
			CHECKER	Nosizo Pindela	09/04/2018
			COMPILER	Thanyani Mathegu	09/04/2018
1	23/05/2018	Team leader and Quality Technician to sign final signature from PME Manager to Quality manager Change	APPROVER	Itumeleng Modiba	23/05/2018
			CHECKER	Nosizo Pindela	23/05/2018
			REVISED BY	Ramokone Motama	23/05/2018
2	05/07/2018	Certain dimensional checks added and others moved to CB1210 and CB1230	APPROVER	Itumeleng Modiba	05/07/2018
			CHECKER	Nosizo Pindela	05/07/2018
			COMPILER	Ramokone Motama	05/07/2018
3	2018/06/12	Certain dimensional checks added and others moved to CB1210 and CB1230	APPROVER	Itumeleng Modiba	2018/06/12
			CHECKER	Nosizo Pindela	2018/06/12
			COMPILER	Ramokone Motama	2018/06/12
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			COMPILER	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
			COMPILER	Nosizo Pindela	13/03/2019
7	20/05/2019	Removed roof width	APPROVER	Itumeleng Modiba	20/05/2019
			CHECKER	Nosizo Pindela	20/05/2019
			REVISED BY	Nosizo Pindela	20/05/2019
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	
			REVISED BY	Bongane Masina	
20	19/04/2021	New Baseline 10.2.6	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	Mulaudzi Mpho	
			REVISED BY	Mulaudzi Mpho	
25	20/02/2022	New Baseline 10.2.6	APPROVER	Mbhombhi Collins	20/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Mbhombhi Collins	14/06/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
27	17/10/2022	Addition of traceability for sealant application and welding.	APPROVER	Mbhombhi Collins	17/10/2022
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
29	28/10/2023	Addition of bracket quantity	APPROVER	Ngobeni Tyson	28/10/2023
			CHECKER	Mathapo Kelebone	
			REVISED BY	Amogelang Mohlampe	

TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
223	TC1	Tetelo	16/04/24	SI.CB1220.323.V29	17

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
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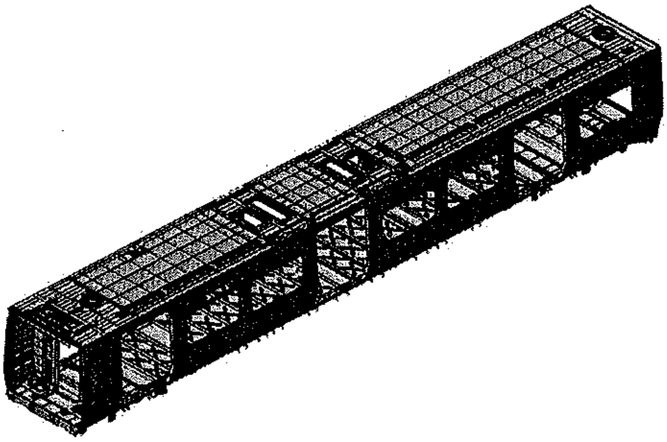
Carro Car:	TC1, TC2

NCR:

Work station: CB1220

Safety Related



I - Documentation and Instruments

I.1 - Documentation Control

Document	Type of car: TC1	M1	M2	M3	M4	TC2	Revision	Observation				Signature/Date (Manufacturing)	Signature/Date (Quality)
DTR30223319/2	✓						29	16/04/24	✓		N/A	[signature] 16/04/24	[signature] 16/04/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Validation	Calibration or Verification Validation Date			Signature/Date (Manufacturing)	Signature/Date (Quality)
Measuring - Tape	G007/4030	16/05/2024	✓		[signature] 16/04/24	[signature] 16/04/24
Turbular	22713	03/08/2024	✓			

1.3 Consumables

Welding Consumable Control - Used for Special Process

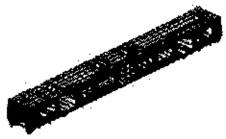
Filler Material	Heat Number	Welding Process			Signature/Date (Manufacturing)	Signature/Date (Quality)
Welding Wire	E23/067	MIG Welding	✓		[signature] 16/04/24	[signature] 16/04/24

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date: 28/10/2023	SI.CB1220.323.V29

II - Control Activities of Prodution

II.1 - Items to check

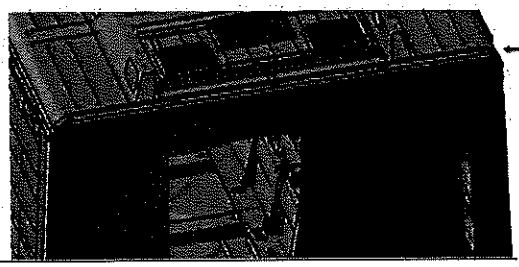
Item	Picture/Drawing	Description	Acceptance criteria / Record				Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering nº PRA.CB1220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	DTR3022‾319/2	✓			16/04/24	16/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓			16/04/24	16/04/24
03	REFER TO ANNEXURE A	Spot Welding inspected and approved according procedure	**IND-SAL-WMS-016 e DTD0000210675**	✓			16/04/24	16/04/24
04	REFER TO ANNEXURE B	Arc Welding inspected and approved according procedure.	**IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000**	✓			16/04/24	16/04/24
05		Cleaning of all Stainless Steel Surface	**According TO GIB-WEL - PROC-0002**	✓			16/04/24	16/04/24
06	N/A	Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			16/04/24	16/04/24
07		Perform visual inspection of welds 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	✓			16/04/24	16/04/24
08	N/A	Before appplication of sealant record the expiry date and make sure that the room temperature and humidity are withion specified values as per Works Instructions Specified: Temperature Min - Max (1) | Min-Max | 10°C - 35°C Relative humidity Min – Max (1) | Min-Max | 25% - 60%	Sealant Batch No: ISR 7003 Exp Date: 09 / 06 / 24 Actuals Temparature: 20°C Humidity: 30%	✓			16/04/24	16/04/24
09	NA	Verification of sealant application in certain regions in the drawing.	AAD0001241033	✓			16/04/24	16/04/24

GIBELA 2024-04-11 INDUSTRIAL QUALITY

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29 Date- 28/10/2023	Project: PRASA SI.CB1220.323.V29					
10	NA	Verification of sealant application on the roof and sidewall finishers	Sealant must be: -Applied straight and even (1.5mm) -Free of gaps,cracks,damage and debris (flashes, dirt, dust) **Refer to Annexure B**	✓			16/04/24	16/04/24

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

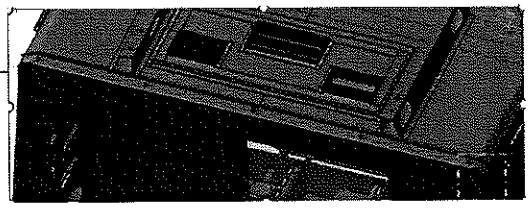
GIBELO	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29



END 1 SEALANT

OPERATOR (Name & sign): Priscilla

OPERATOR (Name & sign): Priscilla

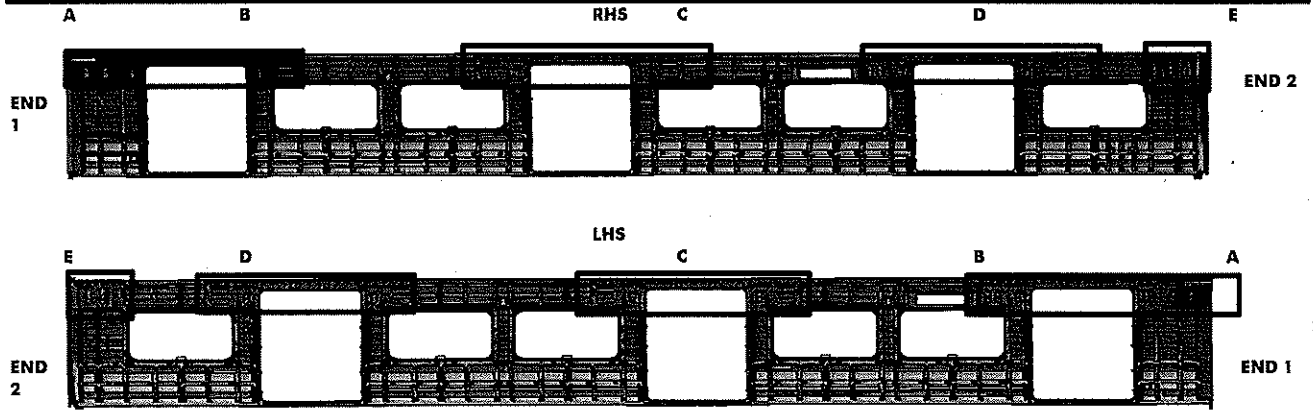


GIBELO

2024 -04- 13

INDUSTRIAL QUALITY
MAINLINE

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29



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):		

GIBELA
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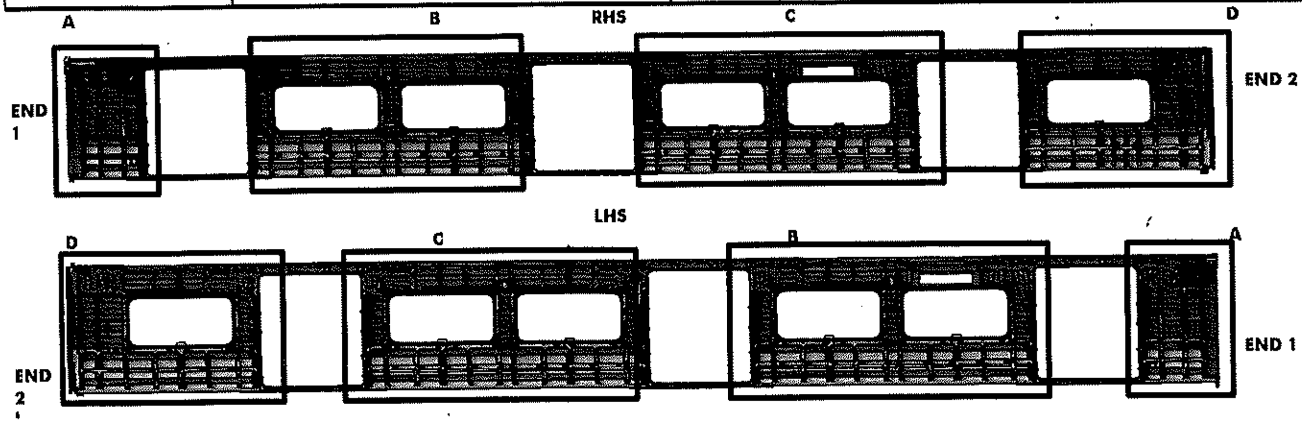
MAINLINE

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29 Date- 28/10/2023	Project: PRASA SI.CB1220.323.V29



BRACKETING

INSTALLATION

C-RAILS:	Operator:	Tefelo [signature]
	Operator:	
DOOR MECHANISMS:	Operator:	Priscilla [signature]
	Operator:	
TAPPING PADS	Operator:	Sibiya [signature]
	Operator:	

INSTALLATION & VERIFICATION

SEAT & LUGGAGE BRACKETS:	Operator:	Mthako [signature]
	Operator:	
SEAT BRACKETS VERIFICATION:	Operator:	Mthoko [signature]
	Operator:	

GIBELA
2024-04-13
INDUSTRIAL QUALITY
MAINLINE

WELDING

AREA		LHS	RHS
A (Seat brackets)	Operator (Name&sign):	N/A	N/A
(C-rails, Luggage and earth bushes)	Operator (Name&sign):	[signature]	S. [signature]
B (Seat brackets)	Operator (Name&sign):	Lindo [signature]	[signature]
(C-rails, Luggage and earth bushes)	Operator (Name&sign):	Lindo [signature]	T.J [signature]
C (Seat brackets)	Operator (Name&sign):	Lindo [signature] / Masindu	Mmasuetic [signature]
(C-rails, Luggage and earth bushes)	Operator (Name&sign):	Lindo [signature]	[signature]
D (Seat brackets)	Operator (Name&sign):	[signature]	Mmasusio [signature]
(C-rails, Luggage and earth bushes)	Operator (Name&sign):	[signature]	Mmasuelo [signature]

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29

ENDS

END 2 TAPPING PADS WELDING: Operator (Name&sign): Sibusiso

END 1 TAPPING PADS WELDING: Operator (Name&sign): N/A

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
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GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
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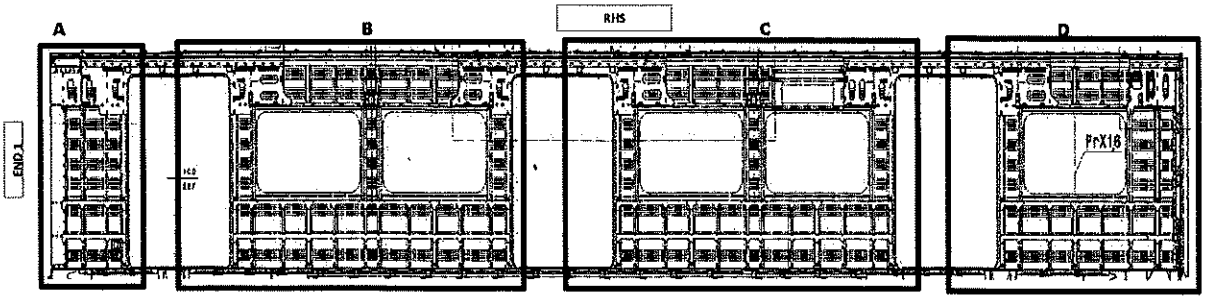
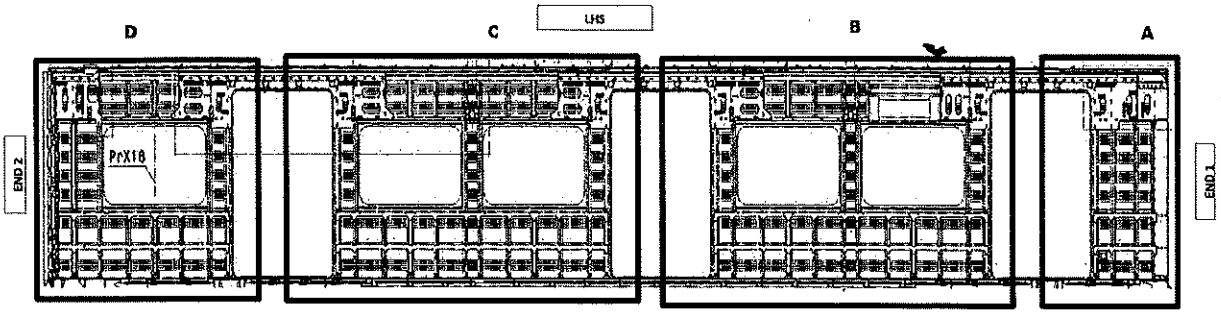
TC BRACKET INSTALLATION

RHS



LHS



QUANTITIES (TC)

RHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	4	✓	
	B	4	✓	
	C	8	✓	
	D	12	✓	
SEAT BRACKETS	A	0	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	1	✓	
	B	4	✓	
	C	5	✓	
	D	4	✓	

ROOF ENDS:

CRAILS 2 OFF END 2
EARTH BUSH 4 OFF END 2

VERIFICATION BY: Tetelo

LHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	4	✓	
	B	8	✓	
	C	4	✓	
	D	8	✓	
SEAT BRACKETS	A	0	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	1	✓	
	B	4	✓	
	C	4	✓	
	D	2	✓	

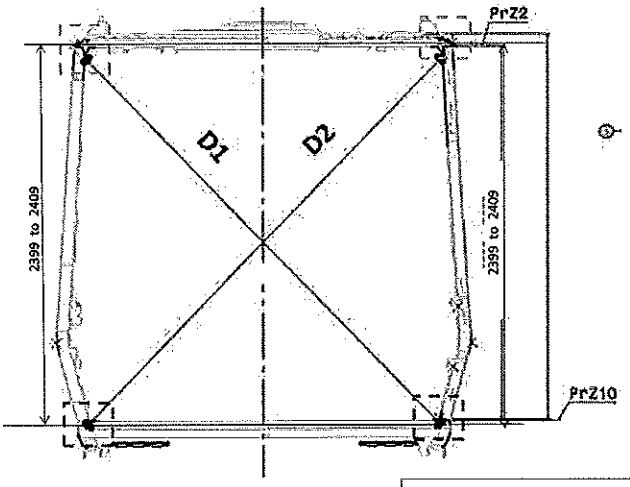
ROOF ENDS:

CRAILS 2 OFF END 2
EARTH BUSH 4 OFF END 2

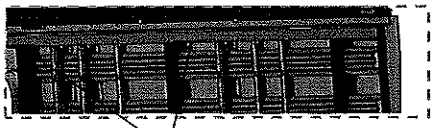
VERIFICATION BY: Tetelo

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

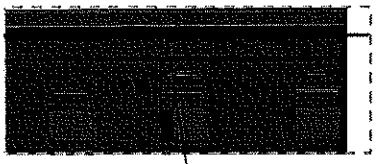
GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29



Take measurement close to radius

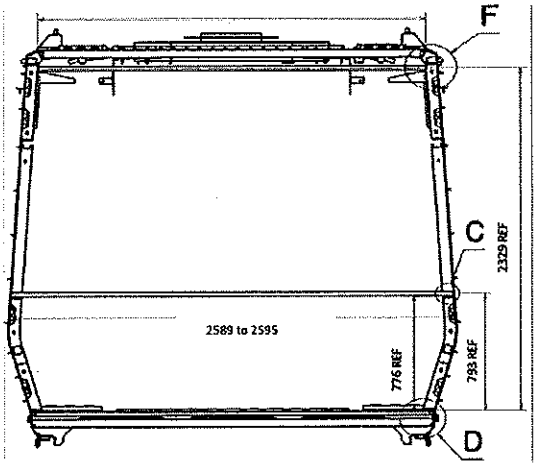


Measurement positions on roof rail and sidewall omega corner



Reinforcement area measurement positions on roof reinforcement area

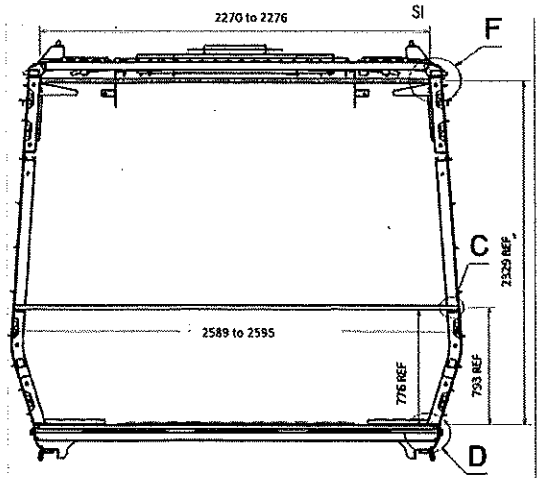
Measurement positions on sidewall and sidesill corner

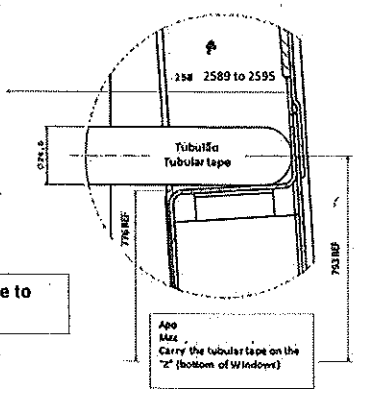


Take measurement close to radius

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

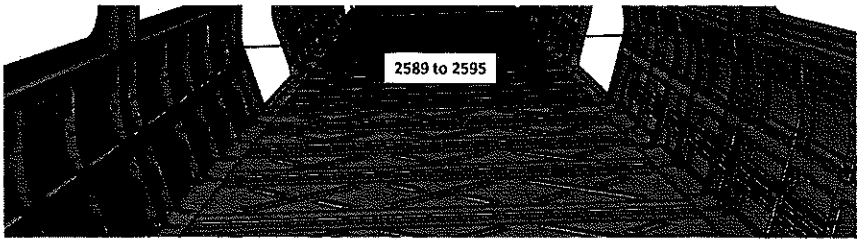
GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29

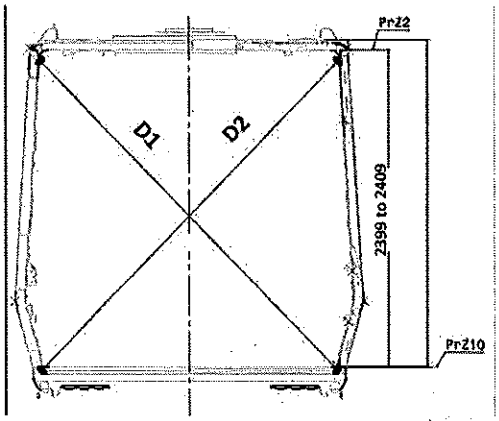




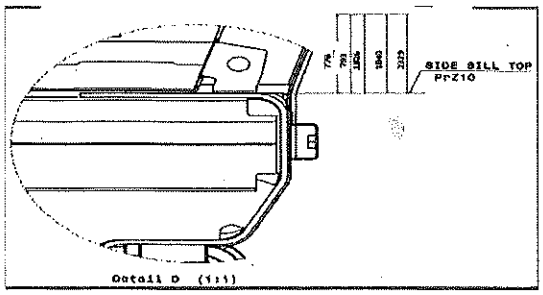
Detail C

Take measurement close to radius

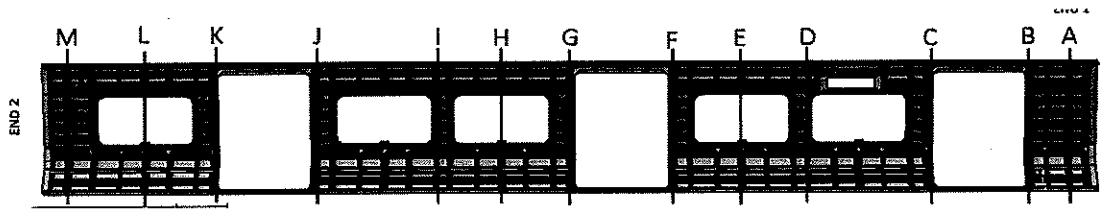




GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE



GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29



BEFORE WELDING

N/A

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3265	3294	2	
B	3294	3297	2	
C	3300	3297	3	
D	3266	3269	3	
E	3267	3269	2	
F	3300	3297	3	
G	3298	3296	2	
H	3266	3268	2	
I	3267	3269	2	
J	3299	3300	1	
K	3297	3299	2	
L	3267	3269	2	
M	3298	3296	2	

GIBELA
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INDUSTRIAL QUALITY
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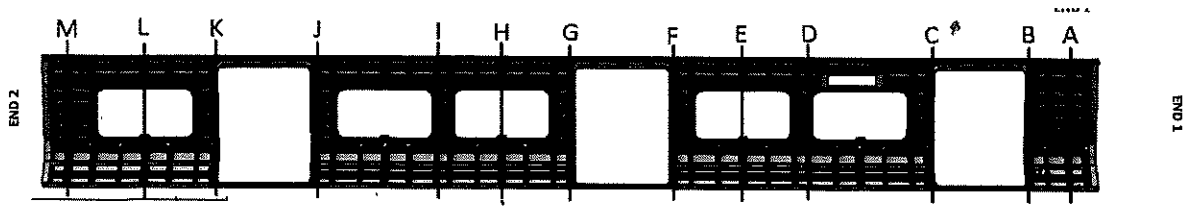
GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29



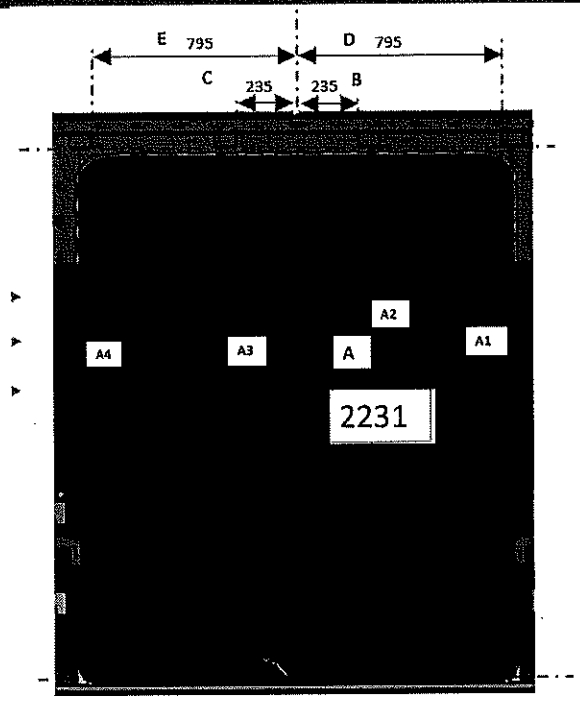
AFTER WELDING

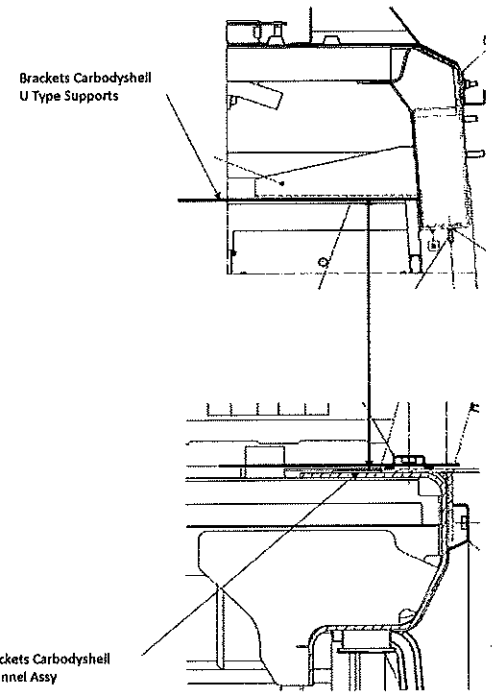
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3267	3269	2	2590
B	3298	3296	2	2591
C	3296	3298	2	2589
D	3265	3268	3	2592
E	3267	3268	1	2591
F	3297	3300	3	2592
G	3299	3297	2	2593
H	3266	3268	2	2591
I	3268	3266	2	2592
J	3297	3299	2	2591
K	3299	3300	1	2590
L	3269	3266	3	2591
M	3300	3297	3	2592

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29

Specifications of Details for CBS measurement





DOOR 1 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2231
A3	2230 to 2232	2231
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 - 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 3 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2230
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

DOOR 1 - RHS

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

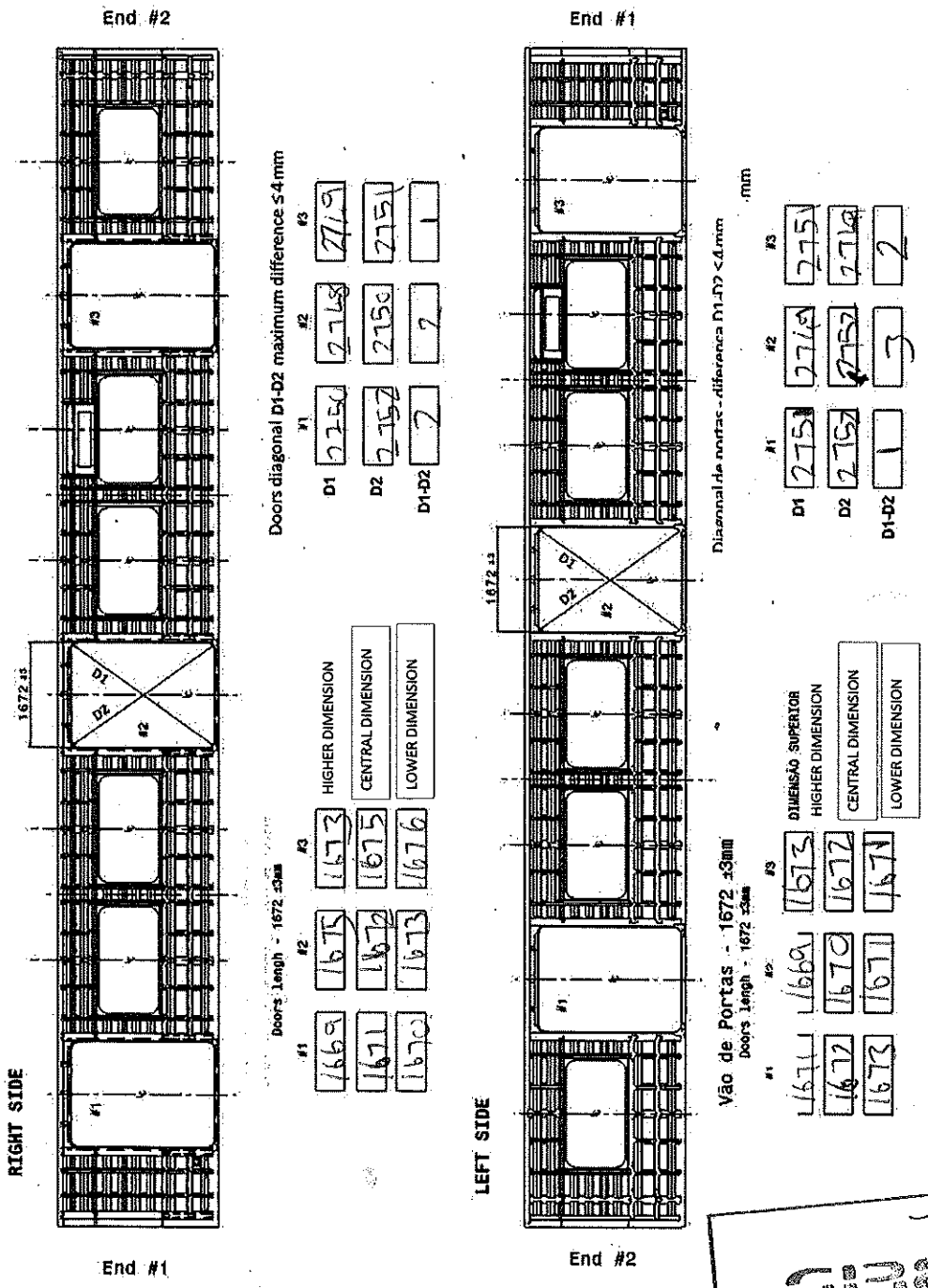
DOOR 3 - RHS

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

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

GIBELO	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29

Specifications of Details for CBS measurement



GIBELO
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29

Specifications of Details for CBS measurement

Dye penetrant test

Dye-penetration test to be performed by quality personnel

Item	Description of the issue		Signature/Date (Manufacturing)	Signature/Date (Quality)

II.2 - Check List REX

Check List Items

Item	Picture/Drawing	Description	Criteria /Record				Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX					

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.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	✓	GO	If activities are not complete, the missing activities must not impact the next stage!	16/04/24	Tebelo Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	16/04/24	Amogelang Industrial Quality	
			There are activities pendings 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":

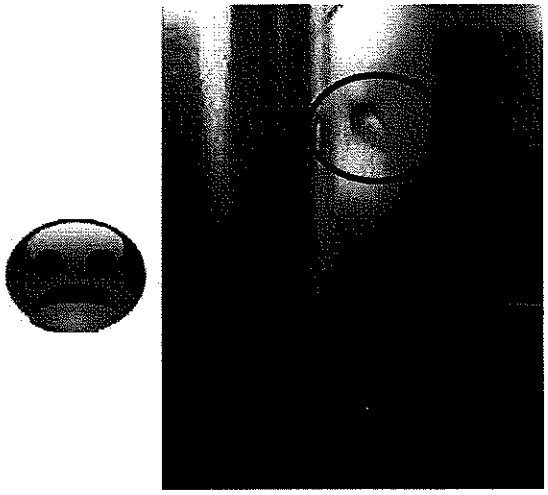
Item	Description	Action	Responsible	Due date	Status

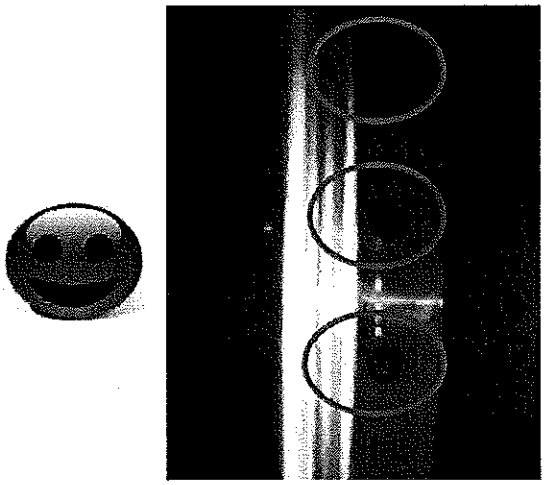
Tebelo
Operations

Quality

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

ANNEXURE A: Spot Welding Quality Acceptance Standard





GIBELA

PRASA PROJECT

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE TC1	M4	M3	M2	M1	TC2	WORK INSTRUCTION	SAFETY ?
☐ OT0000223319	AA00001238963	OT0000223319 Carshell Assembly TC	CB1230	(X)					X	PRA.CB1230.OT000012 23319.V20	YES
☐											

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	06/04/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	09/04/2018
			CHECKER	Nosizo Pindela	09/04/2018
			COMPILER	Thanyani Mathegu	06/04/2018
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	05/07/2018	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	05/07/2018
			CHECKER	Nosizo Pindela	05/07/2018
			COMPILER	Ramokone Motama	05/07/2018
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
			COMPILER	Nosizo Pindela	13/03/2019
7	17/09/2019	Added Cab Fire Barrier Flatness Measurements	APPROVER	Itumeleng Modiba	17/09/2019
			CHECKER	Nosizo Pindela	17/09/2019
			COMPILER	Nosizo Pindela	17/09/2019
10	20/09/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	20/09/2019
			CHECKER	Nosizo Pindela	20/09/2019
			COMPILER	Nosizo Pindela	20/09/2019
15	28/01/2021	New Baseline 10.2.6	APPROVER	Timothy Maimela	28/01/2021
			CHECKER	Bongane Masina	28/01/2021
			COMPILER	Bongane Masina	28/01/2021
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			COMPILER	Bongane Masina	19/04/2021
25	20/04/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	20/02/2022
			CHECKER	Andani Muthelo	20/02/2022
			COMPILER	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	
			COMPILER	Andani Muthelo	
27	26/07/2022	Threashold measurements addition	APPROVER	Collins Mbhombhi	26/07/2022
			CHECKER	Andani Muthelo	
			COMPILER	Andani Muthelo	
28	17/10/2022	Addition of traceability for sealant application	APPROVER	Collins Mbhombhi	17/10/2022
			CHECKER	Ntokozo Zwane	
			COMPILER	Amogelang Mohlampe	
29	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	
			COMPILER	Amogelang Mohlampe	
30	06/11/2023	Added traceability for thresholds for boiler makers and welders	APPROVER	Tyson Ngobeni	06/11/2023
			CHECKER	Andani Muthelo	
			COMPILER	Ntokozo Zwane	

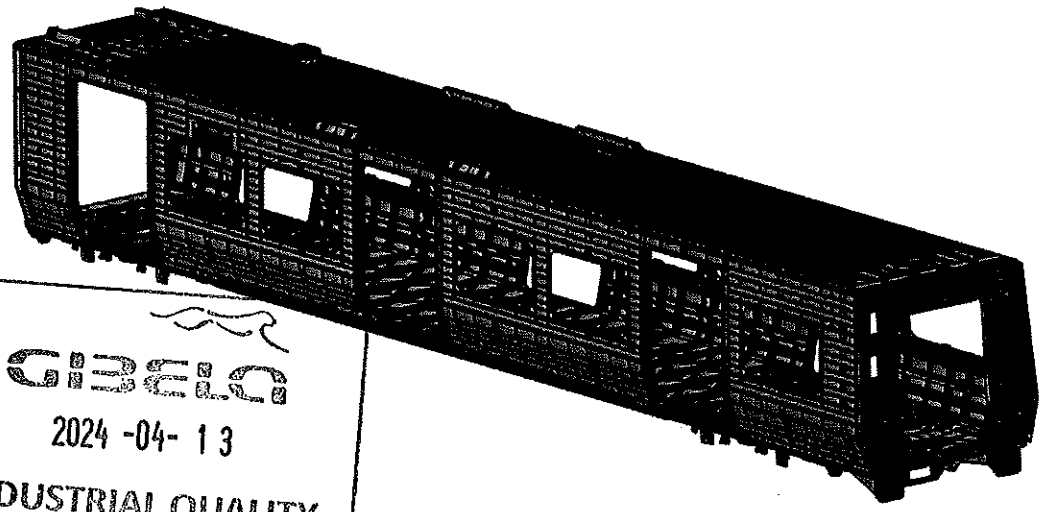
TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
223	TC1	Normathapelo 118300	11/04/2024	SI.CB1230.324.V28	14

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
		Date- 06/11/2023	SI.CB1230.324.V29

Carro Car:	NCR:	Work station:	CB1230

Safety Related



I - Documentation and Instruments

I.1 - Documentation Control

Document	Type of car TC1	M1	M2	M3	M4	TC2	Revision	Observation	OK		N/A	Signature/Date (Operations)	Signature/Date (Quality)
DT00000223319	✓								✓			17/04/24	17/04/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Validation	Calibration or Verification Validation Date	OK		Signature/Date (Operations)	Signature/Date (Quality)
Tubular measuring Tape	GIBELA-2 32816	2015/03/25	✓		17/04/24	
	GIBTM0396	2024/04/05	✓		17/04/24	17/04/24
Coordination equipe	GIBCO.0100	27/07/2024	✓		17/04/24	

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
308	73097	TIG	✓		17/04/24	
308	F23067	MIG	✓		17/04/24	17/04/24

GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
		Date- 06/11/2023	SI.CB1230.324.V29

II - Control Activities of Prodution

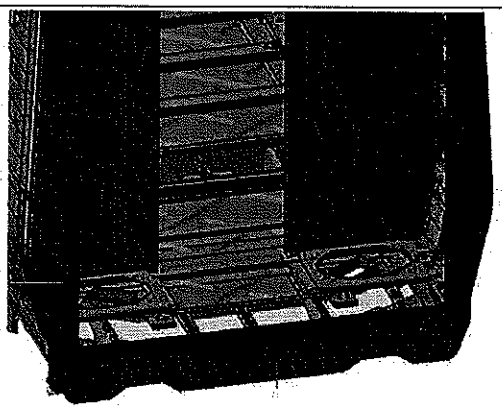
II.1 - items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK			Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering nº DT00000223319	DT00000223319	✓			17/04/24	17/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓			17/04/24	17/04/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 DTD0000210675	✓			17/04/24	17/04/24
04	N/A	Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			17/04/24	17/04/2024
05	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	✓			17/04/24	17/04/24
06	N/A	Before appplication of sealant record the expiry date and make sure that the room temperature and humidity are withion specified values as per Works Instructions Specified: Temperature Min - Max (1) Min-Max 10°C - 35°C Relative humidity Min – Max (1) Min-Max 25% - 80%	Sealant Batch No: 2601914357 Exp Date: ____ / 05 / 2024 Actuals Temparature: 17°C Humidity: 68%	✓			17/04/24	17/04/2024
07	N/A	Verification of sealant application in regions of roof and sideframe finishers.	Sealant must be: -Applied straight and even (1.5mm) -Free of gaps,cracks,damage and debris (flashes, dirt, dust) Refer to Annexure B	✓			17/04/24	17/04/2024

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
		Date- 06/11/2023	SI.CB1230.324.V29

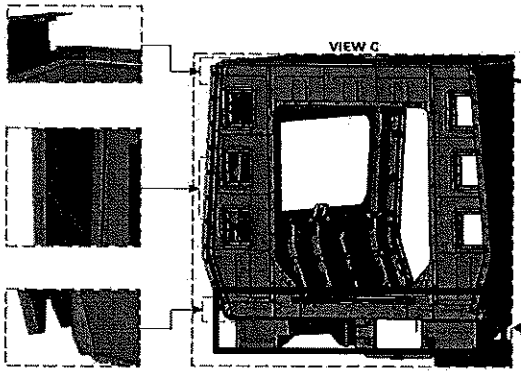
VIEW A



END 1
SEALANT

OPERATOR (Name & sign): Lerato

OPERATOR (Name & sign): Mahlangila

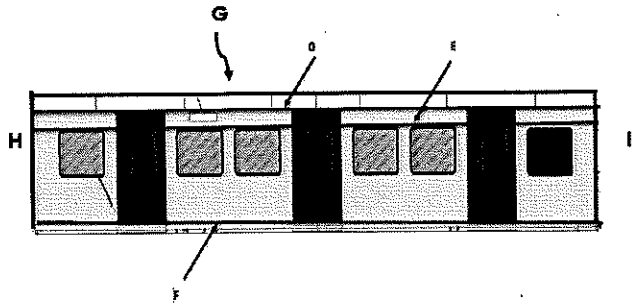


OPERATOR (Name&sign): Leroy

OPERATOR (Name&sign): Leroy

OPERATOR (Name&sign): Zanele/Leroy

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

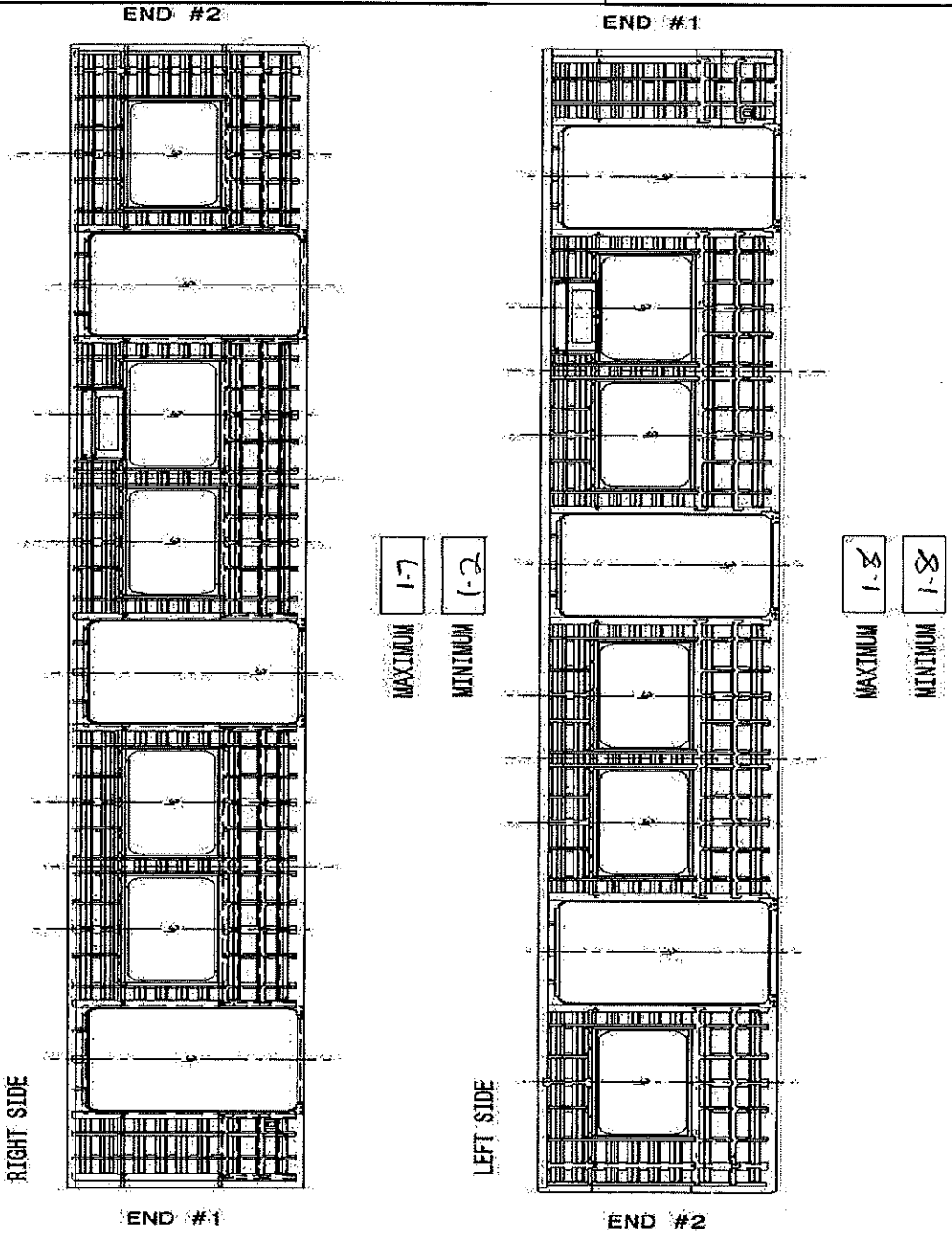


Area D,E,F,G,H,I	LHS	RHS
Operator (Name & sign) :	D,E,F,G,H,I	D,E,F,G,H,I
Operator (Name & sign) :	Lerato	Mahlangu
Operator (Name & sign) :		
Operator (Name & sign) :	Lerato	Mahlangu
Operator (Name & sign) :		
Operator (Name & sign) :		

GIBELO
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
		Date- 06/11/2023	SI.CB1230.324.V29

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

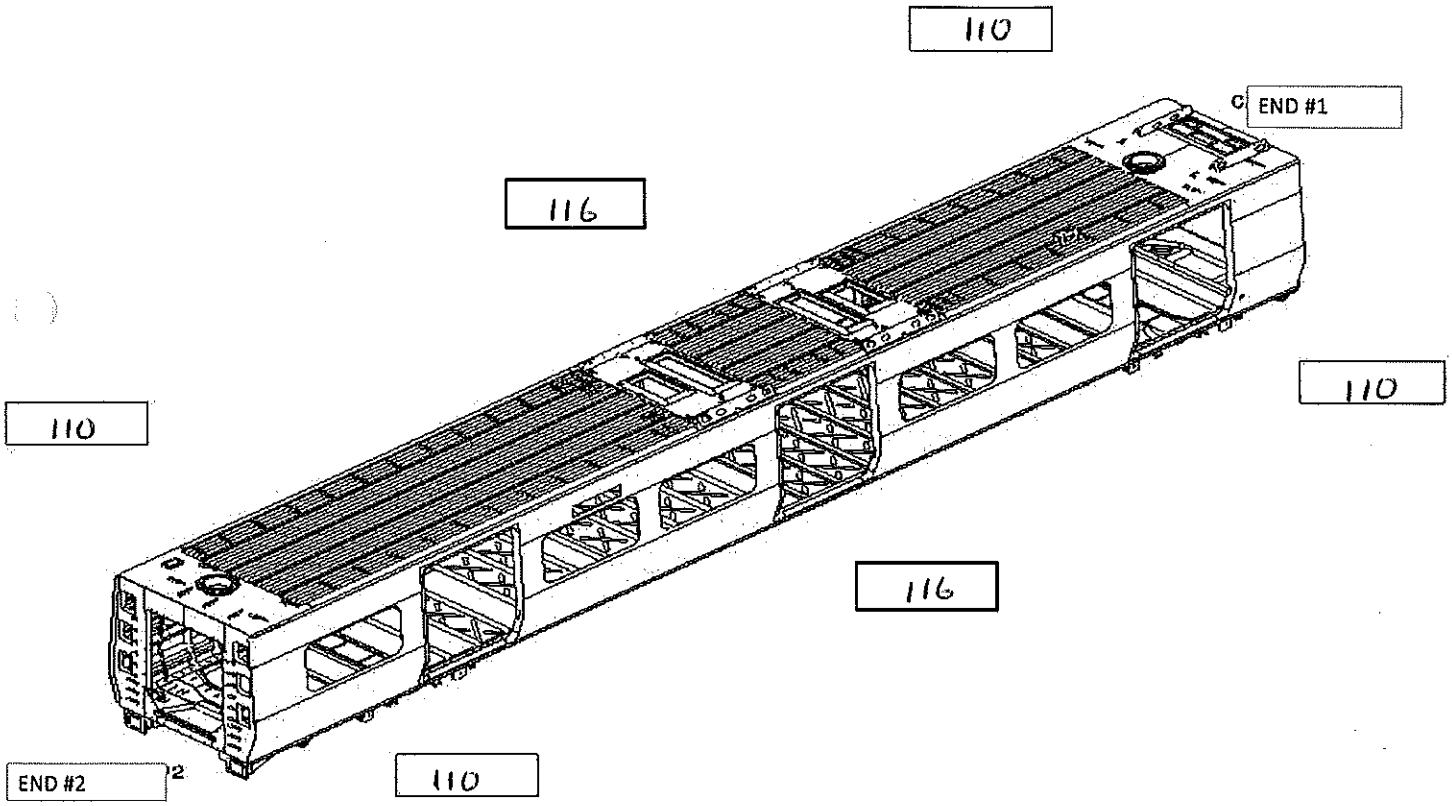


GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
		Date- 06/11/2023	SI.CB1230.324.V29

Specifications of Details for CBS measurement CB1230

Specified Camber for car out of jig is 16mm (-0mm + 2mm)



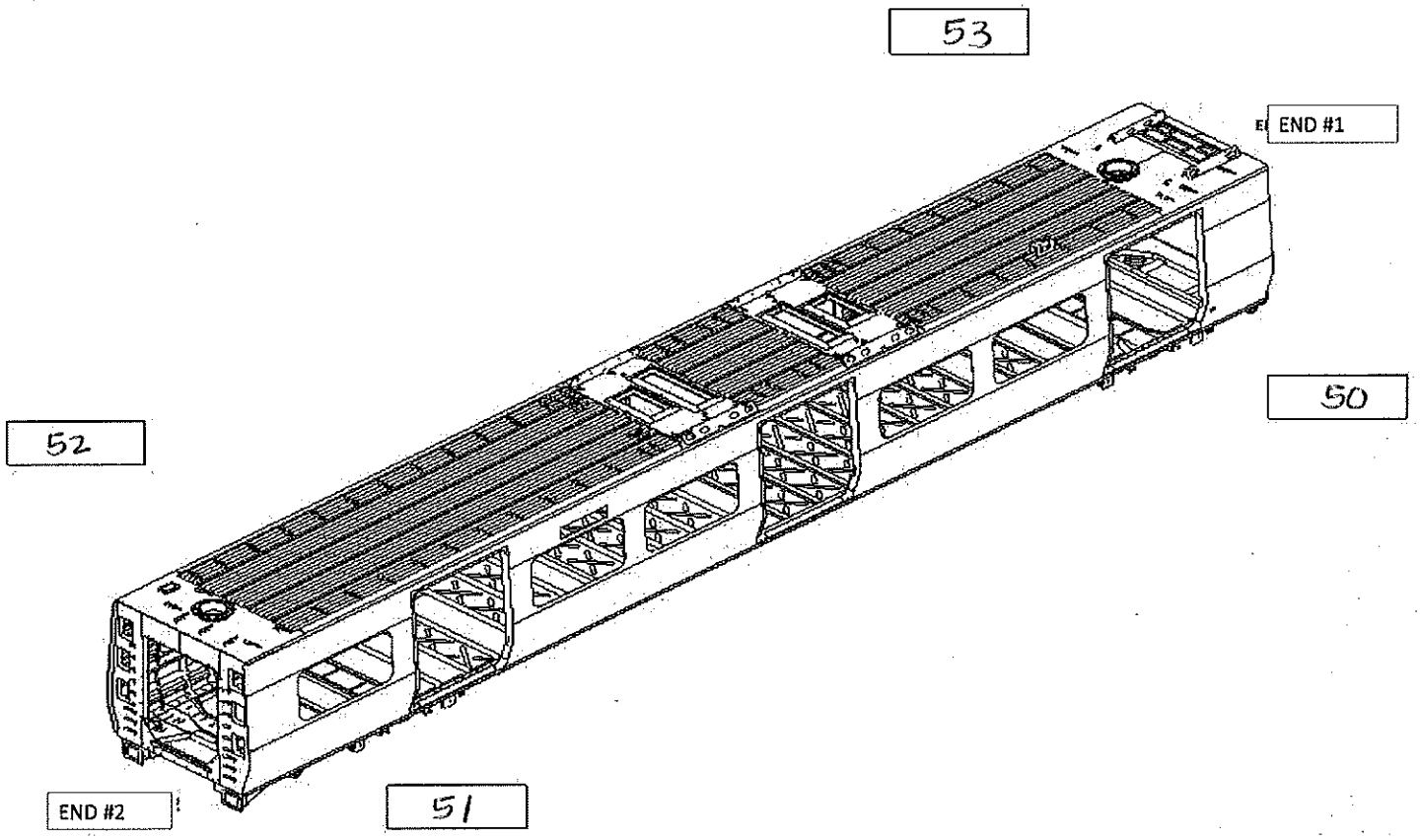
MEASURED CAMBER VALUES	
RIGHT	16
LEFT	16

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA.
		Date- 06/11/2023	SI.CB1230.324.V29

Specifications of Details for CBS measurement CB1230

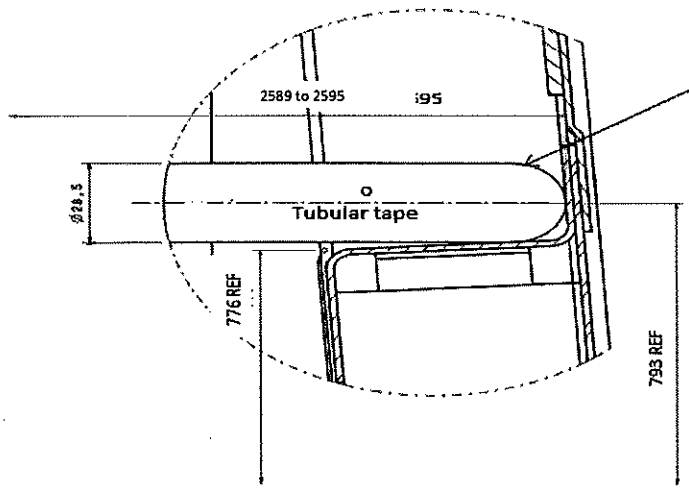
Twist measured in transversal and longitudinal = Maximum 3mm. Measure twist on air spring plates (LHS and RHS), both End 1 and End 2 folllowing twist measurement document.



MEASURED TWIST VALUES END 1		MEASURED TWIST VALUES END 2	
LATERAL	3	LATERAL	1
LONGITUDINAL	1	LONGITUDINAL	1

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

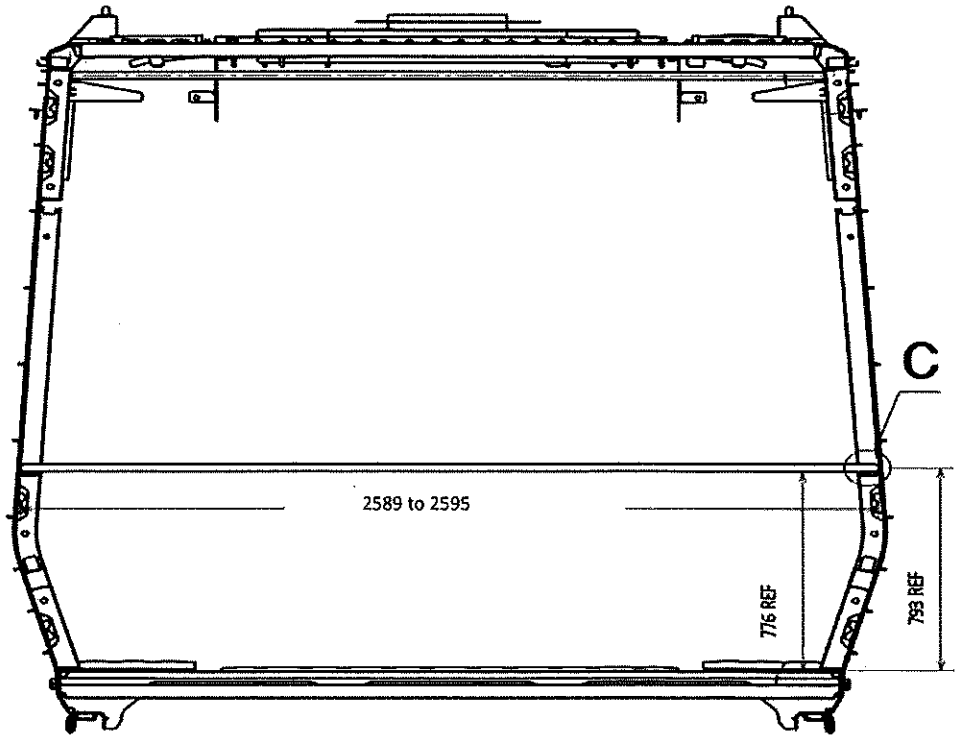
Details for measuring on the CB1230 stage, after completion of activities



A
N
Carry the tubular tape on the "Z" bottom of Windows

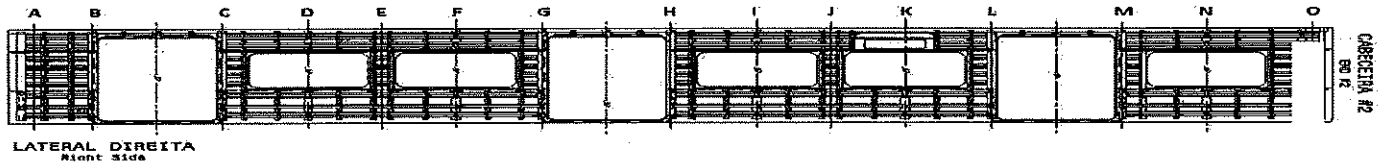
Detail C

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE



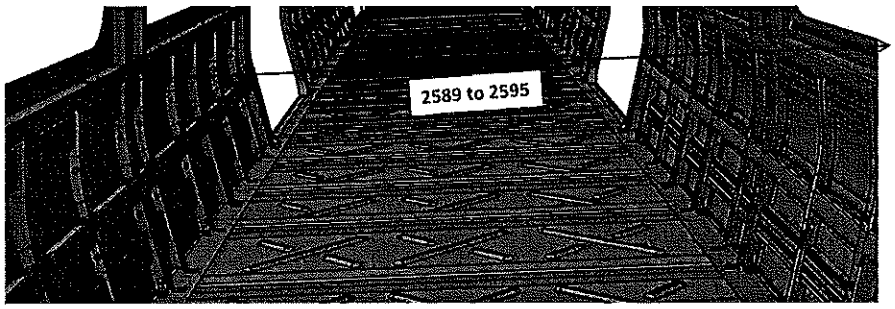
GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
		Date- 06/11/2023	SI.CB1230.324.V29

Specifications of Details for CBS measurement



2589 to 2595mm

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



GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

Threashold verification

Nominal value :38

Door 1		Door 2		Door 3	
L	R	L	R	L	R
38	38	38	39	37	38
Door 4		**Door 5**		**Door 6**	
L	R	L	R	L	R
36	37	39	38	37	38

BOILER MAKER: Buhle

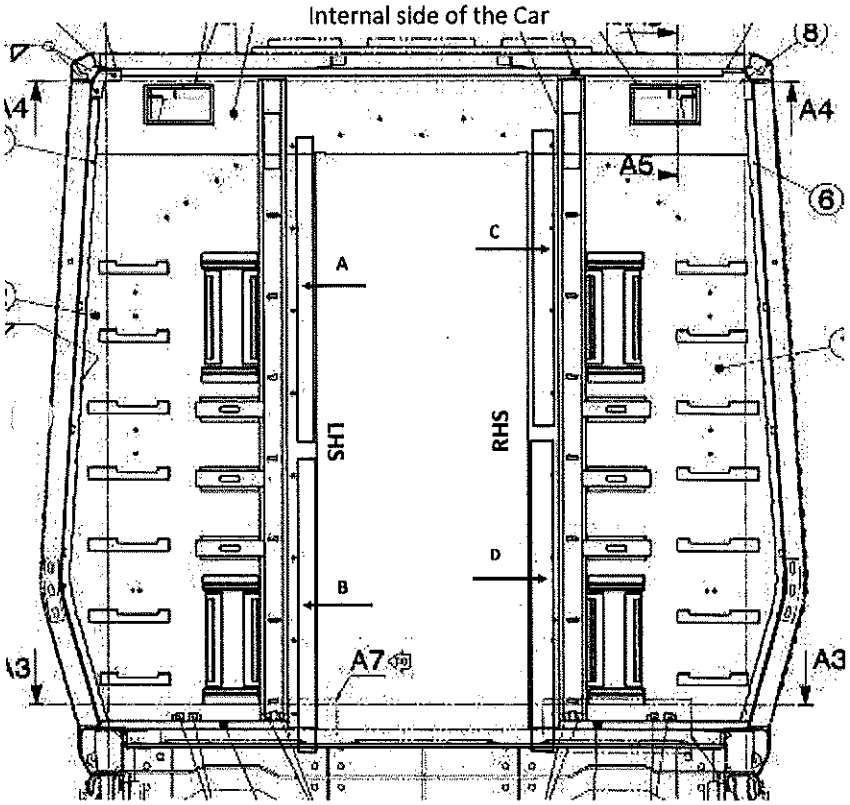
WELDER: Zanele

GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
		Date- 06/11/2023	SI.CB1230.324.V29

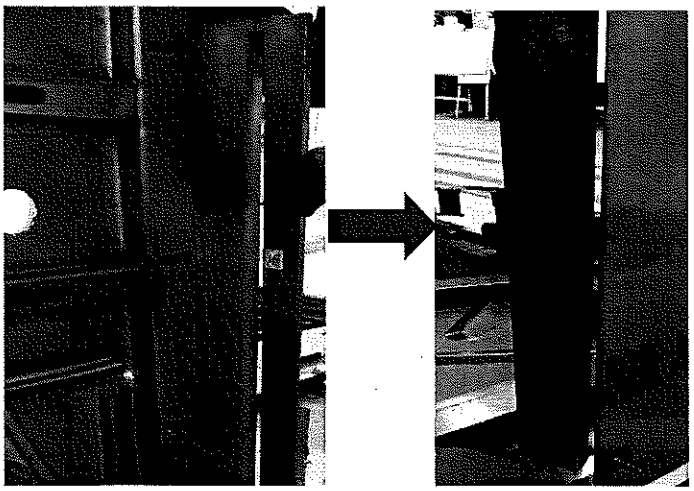
Specifications of Details for CBS measurement

Measure the flatness on the Cab Fire Barrier after installation and welding. Measure positions A, B,C and D using 1000mm flatness ruler and taper gauge.

Specified Maximum Flatness deviation on Cab Fire Barrier = 2mm



	Measured Values		
	Minimum	Maximum	Deviation
A	8.0	8.7	0.7
B	9.2	9.5	0.3
C	10.1	10.9	0.8
D	10.5	11.5	1



GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

Dye penetrant test

Dye-penetration test to be performed by quality personnel

Item	Description of the issue	OK	Signature/Date (Operations)	Signature/Date (Quality)

II.2 - Check List REX

Check List Items

Item	Picture/Drawing	Description	Criteria /Record	OK			Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX					

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
		Date- 06/11/2023	SI.CB1230.324.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!	17/04/2024	Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	17/04/2024	Industrial Quality	
			There are activities pendings 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	Action	Responsible	Due date	Status

Operations

Quality

GIBELA
2024 -04- 13
INDUSTRIAL QUALITY
MAINLINE

ANNEXURE A: Arc Welding Quality Acceptance Standard