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	M4	M1	M2	M3	TC2		
☐ OTR30225487/3	AAD0001278566	CARBODYSHELL M1 ASSEMBLY	CB1210			(X)				PRA.CB1210.DTR30225487/3.V25	YES
☐											

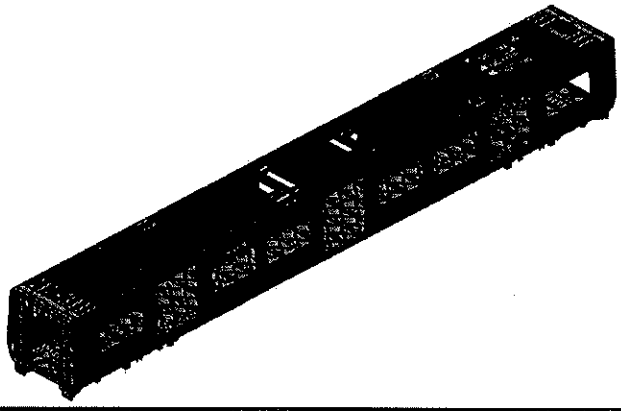
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018
			CHECKER	Nosizo Pindela	10/01/2018
			COMPILER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motarna	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 Motarna	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 Motarna	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
223	M1	LUNGA 401491	17/04/24	SI.CB1210.254.V28	17

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

Car: M1	NCR:	Work station: CB1210

Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car: TC1	M1	M2	T1	T2	TC2	Revision	Observation	OK			Signature/Date (Manufacturing)	Signature/Date (Quality)
DTR30225487/3		X							✓			17/04/24	17/04/24

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)
TUBULAR	32823-2	15/03/24	✓		17/04/24	17/04/24
30 M TAPE	GIBTP0084	14/03/24	✓		17/04/24	
LASER TAPE	12542524	08/01/24	✓		17/04/24	

1.3 Consumables

Welding Consumable Control - Used for Special Process

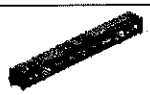
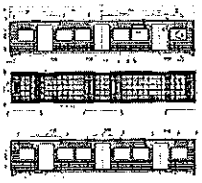
Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
AVTROD 308LSI	E221880	MIG	✓		17/04/24	17/04/24
ER 309 LSI	318394	MIG	✓		17/04/24	

GIBELA
2024 -05- 17
INDUSTRIAL QUALITY
MANAGEMENT

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

II - Self Inspection - Items to Check

II.1 - Items to check

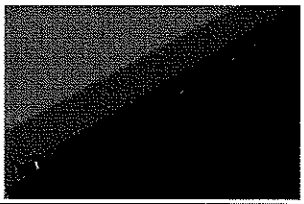
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK			Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls,Endframes,Roof and Underframe)	DT00000311225	✓			17/04/24	17/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓			17/04/24	17/04/24
03	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓			17/04/24	17/04/24
04	REFER TO ANNEXURE B;	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓			17/04/24	17/04/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓			17/04/24	17/04/24
06		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.		✓		17/04/24	17/04/24
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.	✓			17/04/24	17/04/24

GIBELA
2024 -05- 17
INDUSTRIAL QUALITY
MARITZBURG

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

Welder Traceability

Roof ring welds



END 1

LHS

Boiler maker (Name & Sign): GERALD Welder (Name & Sign): BABBEX

RHS

Boiler maker (Name & Sign): GERALD Welder (Name & Sign): BABBEX

END 2

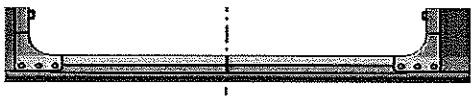
LHS

Boiler maker (Name & Sign): GERALD Welder (Name & Sign): BABBEX

RHS

Boiler maker (Name & Sign): GERALD Welder (Name & Sign): BABBEX

Door ring welds



LHS

Boiler maker (Name & Sign): GERALD

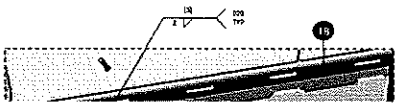
Welder (Name & Sign): KEITH K. MOYO

RHS

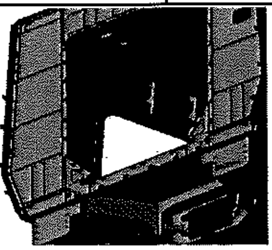
Boiler maker (Name & Sign): GERALD

Welder (Name & Sign): KEITH K. MOYO

EUF Reinforcement Plates



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

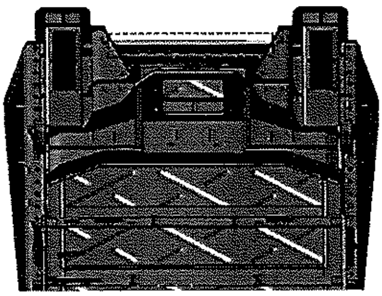


END 1

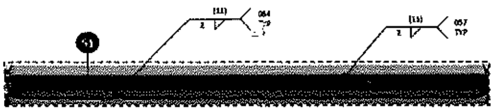
Boiler maker (Name & Sign): Lawrence

Welder (Name & Sign): Keitu

END 2



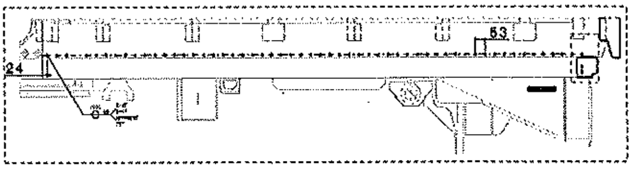
Underneath the CAR



END 2

Boiler maker (Name & Sign): Innocent

Welder (Name & Sign):



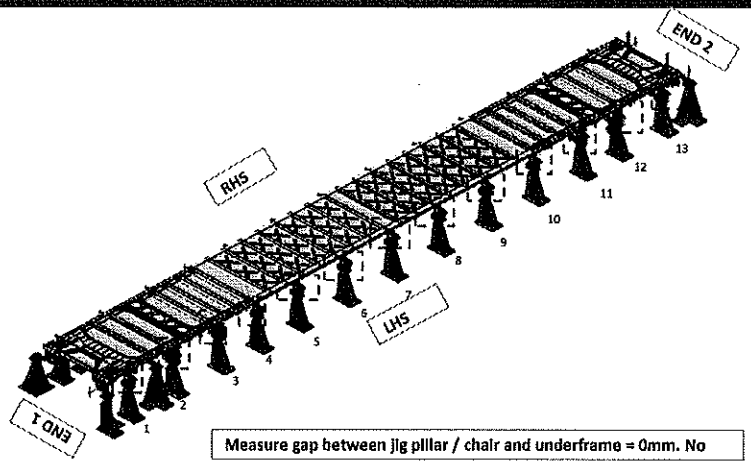
FEDOLI

OPERATOR: Bobbert

GIBELA
2024 -05- 17
INDUSTRIAL QUALITY
KWAZULU-NATAL

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

Specifications of Details for CBS measurement



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

After loading and clamping

Fill in the gap foundon 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	1	0	0	0	0	0	0	0	0	0

Signature Operations: Date: 17/04/24

After Welding.

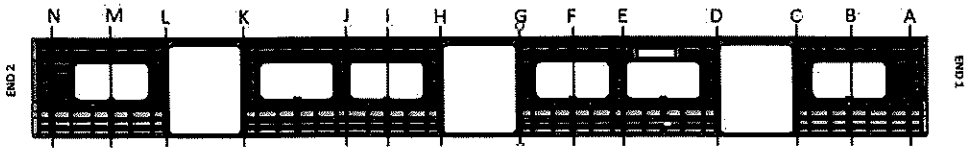
Fill in the gap found each jig pillars / chair and underframe should be 0mm.

	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

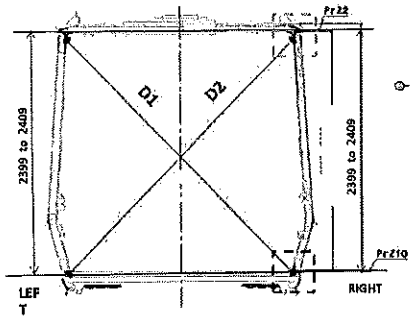
Signature Industrial Quality: Date: 17/04/24

GIBELA	CARBODYSHELL M1 ASSEMBLY DTR302254/87/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

Specifications of Details for CBS measurement



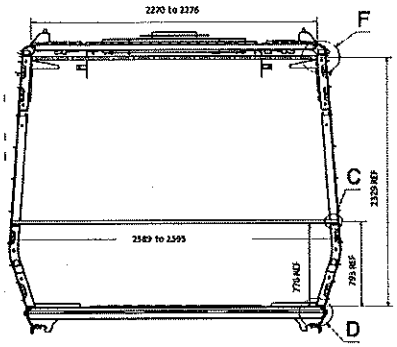
9

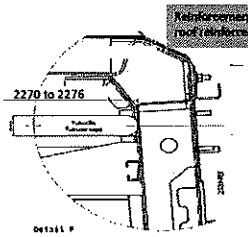


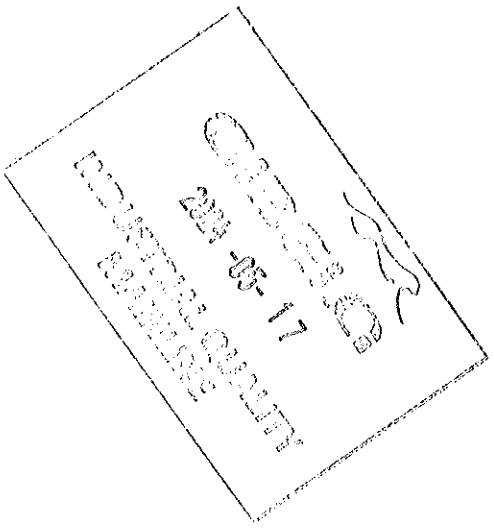
Measurement positions on roof rail and sidewall omega corner.

Measurement positions on sidewall and side sill corner.

Reinforcement area measurement positions on roof reinforcement area.

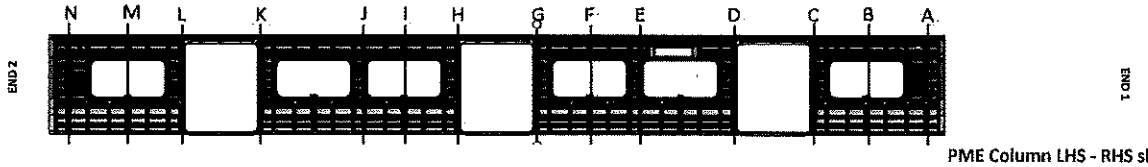






GIBELA	CARBODYSHELL M1 ASSEMBLY DTR302256487/3	Rev. 28	Project: PRASA
		Date 07/11/2023	SI.CB1210.254.V28

Specifications of Details for CBS measurement



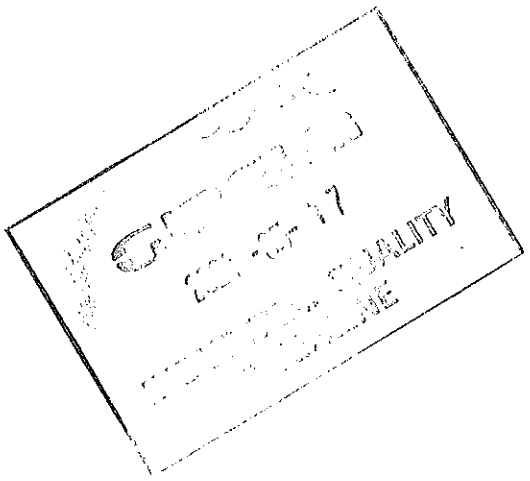
PME Column LHS - RHS should be ≤2MM on each point.

BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3269	3268	1	2408	2407	1
B	3265	3268	3	2406	2406	0
C	3269	3269	0	2405	2407	2
D	3268	3270	2	2406	2405	1
E	3266	3266	0	2405	2405	0
F	3265	3266	1	2404	2406	2
G	3268	3269	1	2405	2404	1
H	3269	3268	1	2407	2406	1
I	3266	3266	2	2406	2406	0
J	3266	3266	0	2405	2406	1
K	3267	3267	0	2406	2404	2
L	3270	3268	2	2405	2405	0
M	3269	3265	4	2406	2406	0
N	3267	3266	1	2407	2408	1

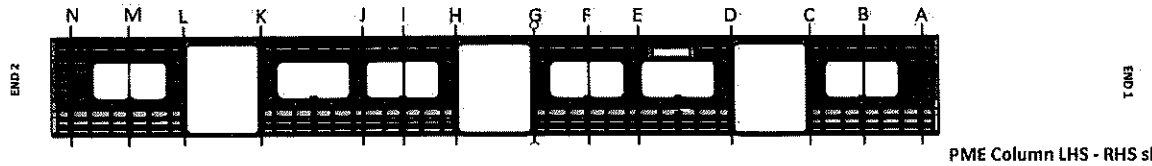
10/10

17/04/24



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

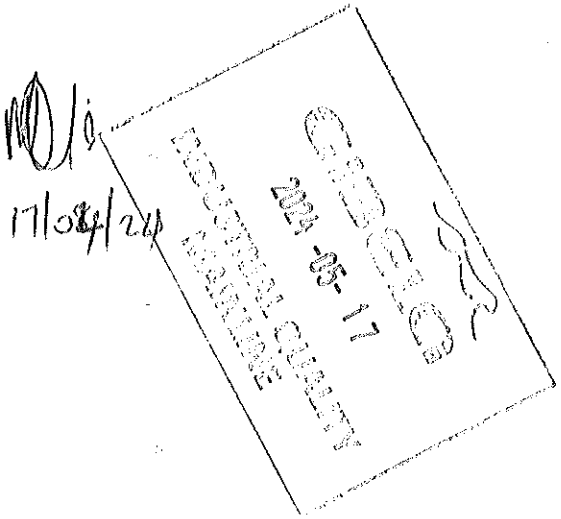
Specifications of Details for CBS measurement



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

AFTER WELDING

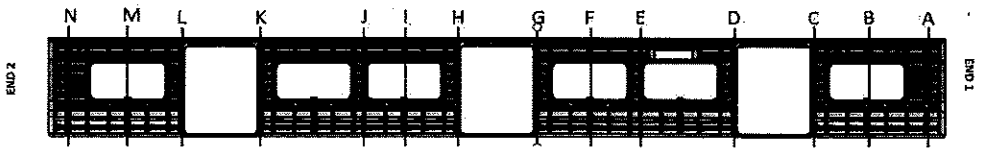
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3296	3294	2	2408	2408	0
B	3268	3266	2	2406	2407	1
C	3294	3294	0	2406	2406	0
D	3295	3293	2	2404	2405	1
E	3265	3266	1	2406	2404	2
F	3266	3264	2	2405	2405	0
G	3294	3294	0	2406	2407	1
H	3293	3294	1	2407	2405	2
I	3265	3264	1	2406	2406	0
J	3266	3266	0	2404	2405	1
K	3293	3295	2	2406	2404	2
L	3295	3294	1	2404	2405	1
M	3264	3267	3	2406	2406	0
N	3294	3294	0	2409	2408	1

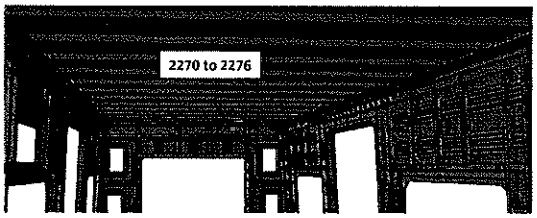


GIBELO	CARBODYSHELL M1 ASSEMBLY DTR302254B7/3	Rev. 28	Project: PRASA
		Date 07/11/2023	SI.CB1210.254.V28

CB5 measurement

BEFORE WELDING

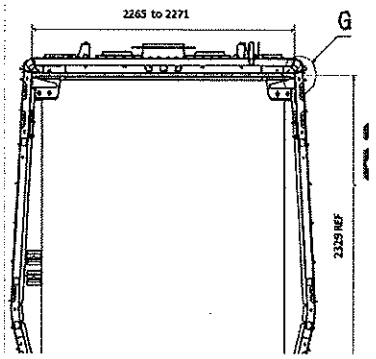


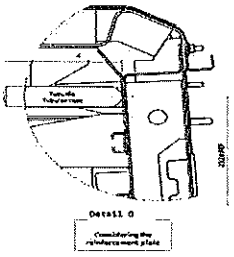


	2270 to 2276
A	2272
B	2275
C	2272
D	2271
E	2276
F	2275
G	2273
H	2272
I	2275
J	2277
K	2272
L	2270
M	2274
N	2271

1990 to

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





10/10

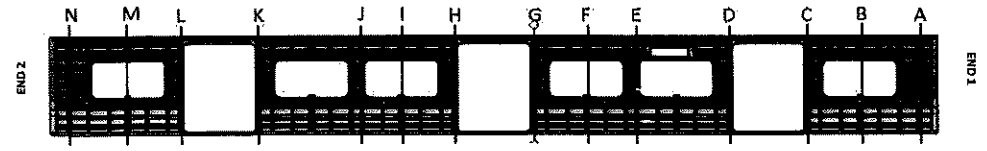
17/04/24

GIBELO
2024 -05- 17
INDUSTRIAL QUALITY
MAINLINE

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

CBS measurement

AFTER WELDING

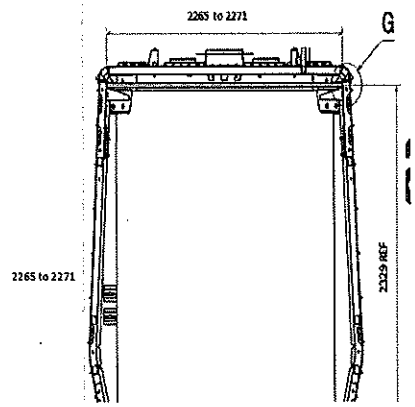


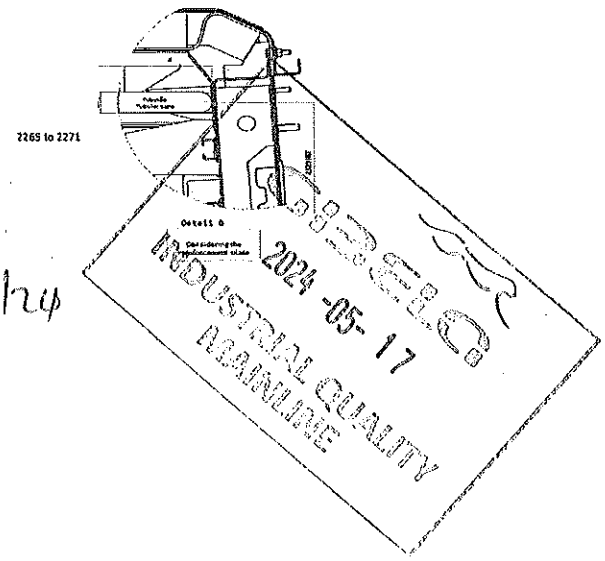
	2265 to 2271	2270 to 2276
A	2265	NA
B	NA	2270
C	2268	NA
D	2270	NA
E	NA	2276
F	NA	2276
G	2269	NA
H	2266	NA
I	NA	2274
J	NA	2276
K	2268	NA
L	2269	NA
M	NA	2273
N	2266	NA

END 2

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

Take measurement close to radius (considering reinforcement)



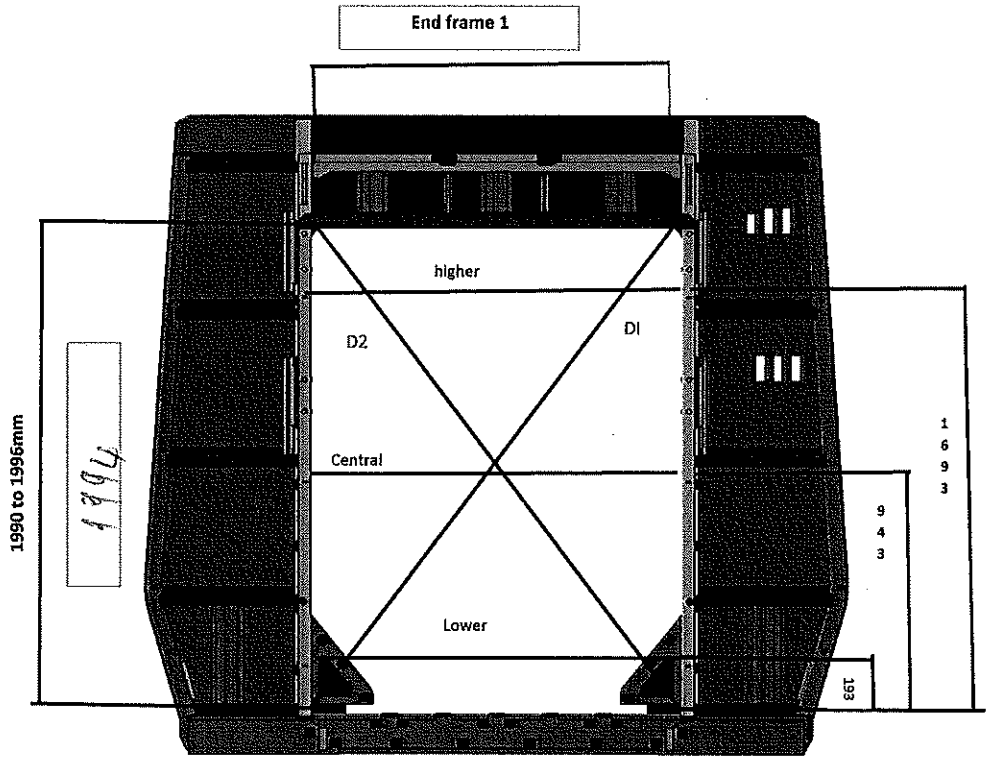


10/10

17/04/24

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

Specifications of Details for CBS measurement



1380 to 1382 mm

Higher Dimension	1382
Central Dimension	1381
Lower Dimension	1381

DIAGONAL DIFFERENCE **D1-D2** ≤ 3mm

D1	2414
D2	2414
D1-D2	0

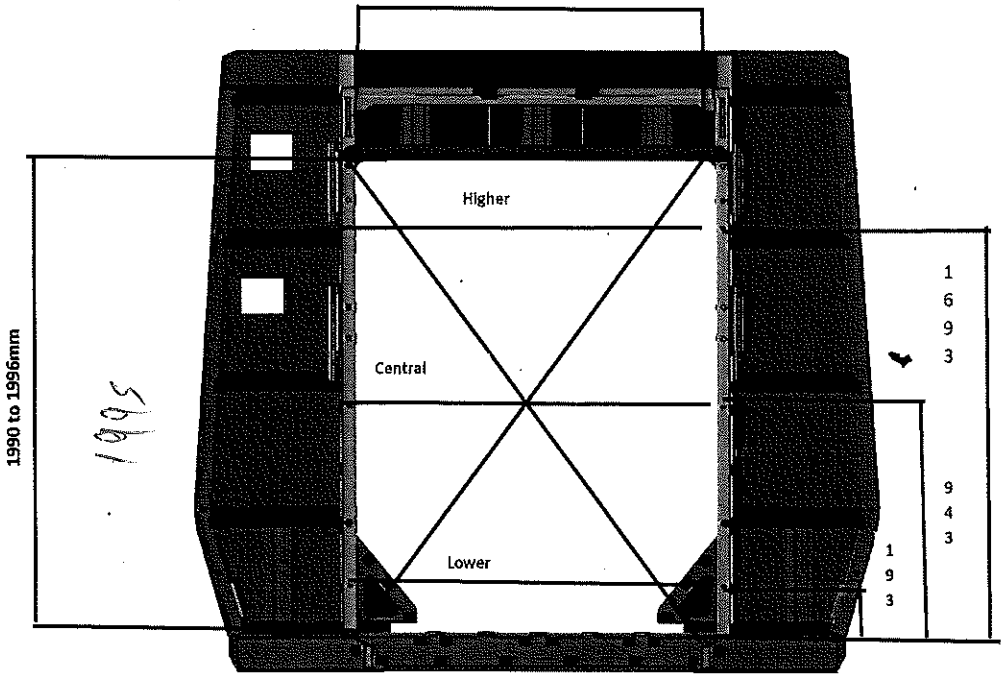
10/0
17/04/24

GIBELA	CARBODYSHELL M1 ASSEMBLY DTR302256487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

Specifications of Details for CBS measurement

Endframe 2

1380 to 1382 mm



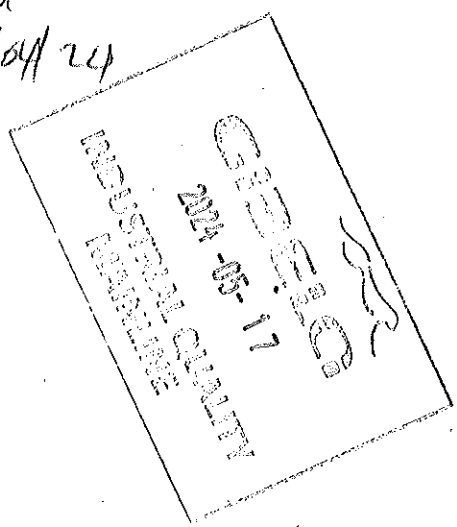
1380 to 1382 mm

DIAGONAL DIFFERENCE **D1-D2 ≤ 3mm**

Higher Dimension	1381	D1	2415
Central Dimension	1381	D2	2413
Lower Dimension	1380	D1-D2	2

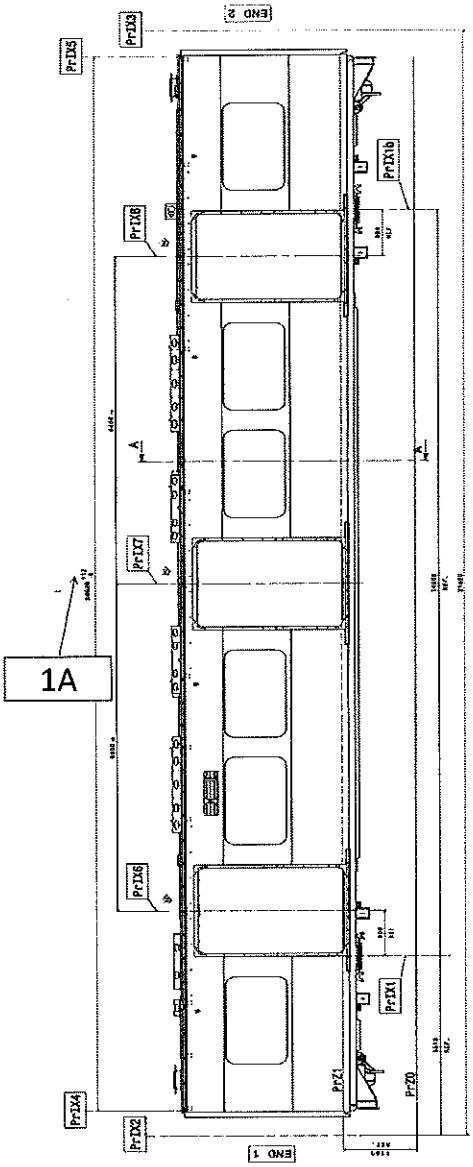
10/10

17/04/24



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

Specifications of Details for CBS measurement



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

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

Dye penetrant test

Dye-penetration test to be performed by quality personnel

GIBELA
2024 -05- 17
INDUSTRIAL QUALITY
MARELINE

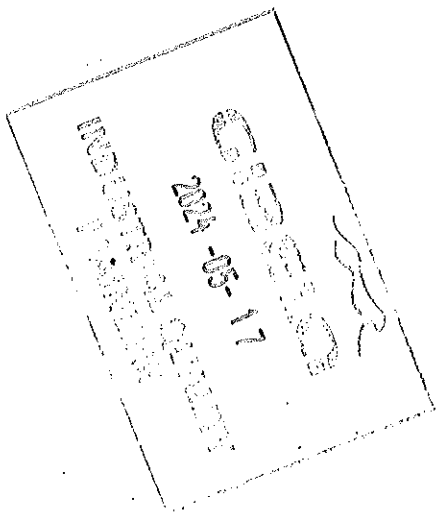
GIBELO	CARBODYSHELL M1 ASSEMBLY DTR30226487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

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

II.2 - Check List REX

Check List Items

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



GIBELA	CARBODYSHELL M1 ASSEMBLY DTR302256487/3	Rev. 28 Date 07/11/2023	Project: PRASA SI.CB1210.254.V28

Self Inspection - Final Result

				DATE	NAME	SIGNATURE
HOLD POINT			(If activities are not complete, the missing activities must not impact the next stage)	17/04/24	Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	17/04/24	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		Responsible	Due date	Status

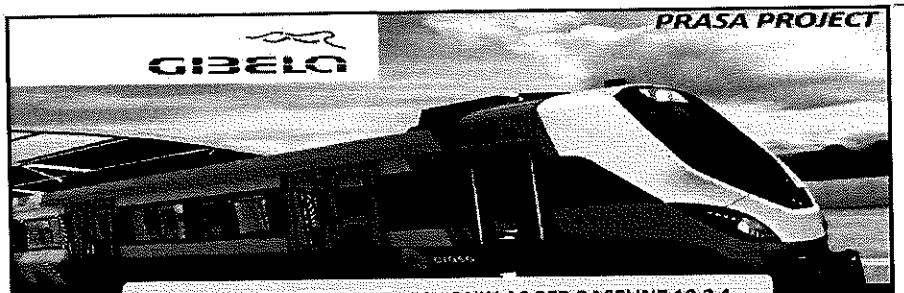
Operations

Quality

GIBELA
2024 -05- 17
INDUSTRIAL QUALITY
MANAGER

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	M1	M2	M3	M4	TC2	WORK INSTRUCTION	SAFETY ?
☐	DTR3022548?/2	AAD0001278566	CARBODYSHELL M1,M3,M4 ASSEMBLY	CB1210		X	X		X		PRA.CB1220.DTR3022548?/2.V21	YES
☐												
☐												
☐												
☐												
☐												
☐												

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	01/02/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	01/02/2018
			CHECKER	Nosizo Pindela	01/02/2018
			COMPILER	Thanyani Mathegu	01/02/2018
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	18/05/2018
			CHECKER	Nosizo Pindela	18/05/2018
			REVISED BY	Ramokone Motama	18/05/2018
2	2018/07/05	Certain dimensional checks added and others moved to CB1210	APPROVER	Itumeleng Modiba	2018/07/05
			CHECKER	Nosizo Pindela	2018/07/05
			REVISED BY	Ramokone Motama	2018/07/05
3	2018/06/12	Width tolerance as per DT0000336500	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	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	
			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	20/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombhi collins	19/02/2022
			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	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	

Remove

2024-04-17

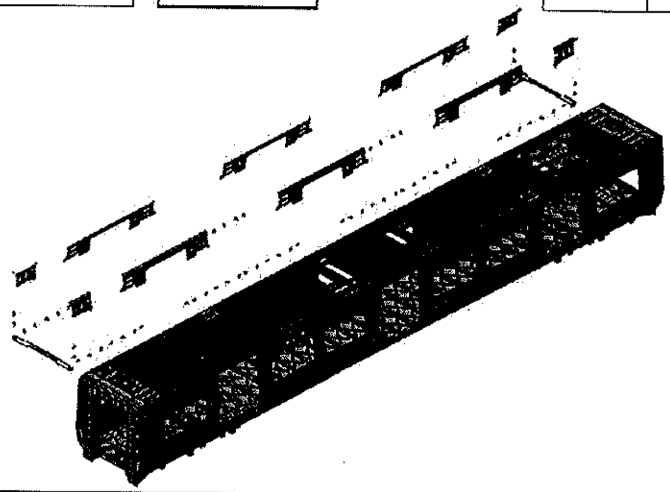
INDUSTRIAL QUALITY

TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
228	M01	Tetelo	17/04/24	SI.CB1220.250.V29	14

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

Car: M1,M3&M4 | NCR: | Work station: CB1220

Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	TC1	M1	M2	M3	M4	TC2	Revision	Observation	OK			Signature/Date (Manufacturing)	Signature/Date (Quality)
DTR30225487/2		✓					29	17/04/24	✓		N/A	[signature] 17/04/24	[signature] 17/04/24

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)
Turbular	22713	03/08/24	✓		[signature] 17/04/24	[signature] 17/04/24
Measuring Tape	GJBTA0371	05/07/24	✓			[signature]

1.3 Consumables

Welding Consumable Control - Used for Special Process

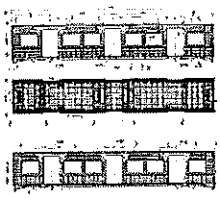
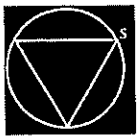
Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
Welding Wire	E231067	MIG Welding	✓		[signature] 17/04/24	[signature] 17/04/24

GIBELA
2024-04-17
INDUSTRIAL QUALITY
MAINLINE

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

II - Self Inspection - Items to Check

II.1 - Items to check

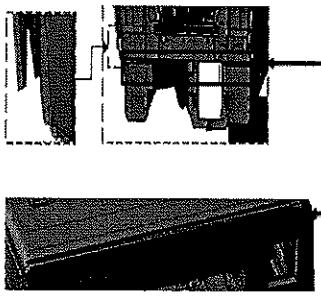
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK			Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB1220.DTR30225487/2	✓			17/04/24	17/04/24
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 REFER TO GIB - TYPDEF - ARC - 0000**	✓			17/04/24	17/04/24
04		Cleaning of all Stainless Steel Surface	**According TO GIB-WEL - PROC-0002**	✓			17/04/24	17/04/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	√			17/04/24	17/04/24
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.	✓			17/04/24	17/04/24
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 (1) Min-Max 10°C - 35°C Relative humidity Min - Max (1) Min-Max 25% - 80%	Sealant Batch No: 1SR 70 05 Exp Date: ___ / 06 / 24 Actuals Temperature: 18°C Humidity: 62%		✓			17/04/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓				17/04/24
09		Verfication of safety welds	Approved according to DTD000210658 reference and Self inspection				17/04/24	17/04/24

GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	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): Levent

Operator (Name & sign): Levent

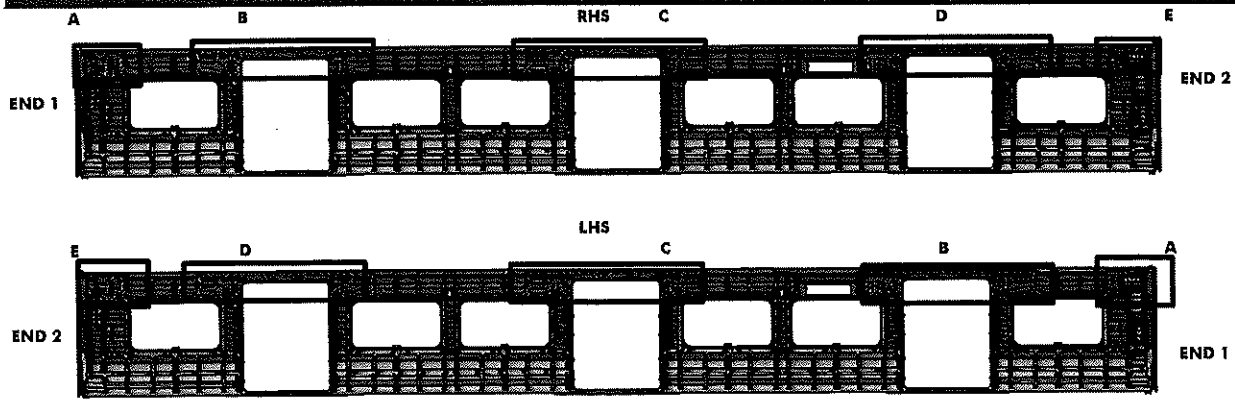
GIBELA

2024 -04- 17

INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR302254872	Rev. 29	Project: PRASA
		Date 28/10/2023	SI.CB1220.250.V29

II - Self Inspection - Items to Check



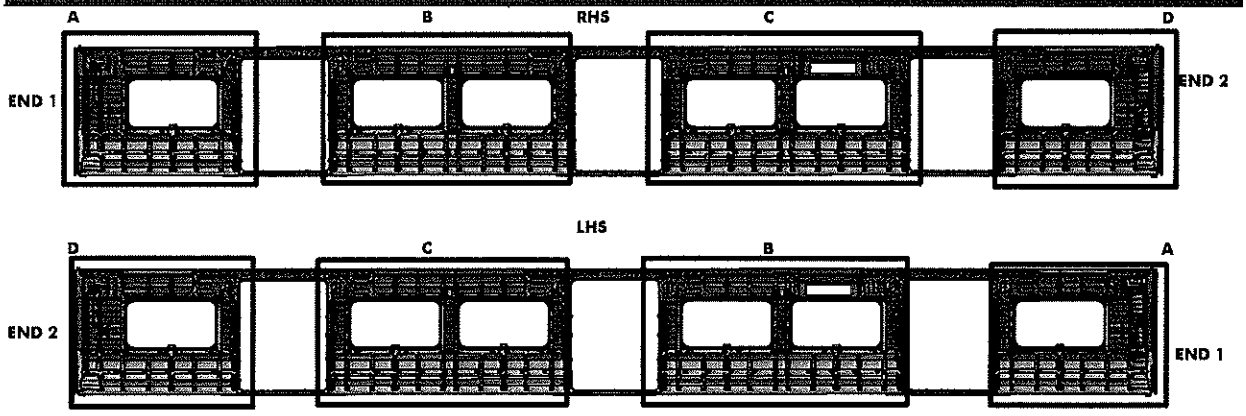
REINFORCEMENT WELDING

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

GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

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

II - Self Inspection - Items to Check



BRACKETING

INSTALLATION

C-RAILS:	Operator:	Leni
	Operator:	
DOOR MECHANISMS:	Operator:	Asanda
	Operator:	
TAPPING PADS	Operator:	Mtshaka
	Operator:	

INSTALLATION & VERIFICATION

SEAT & LUGGAGE BRACKETS:	Operator:	Tetelo
	Operator:	
SEAT BRACKETS VERIFICATION:	Operator:	Tetelo
	Operator:	

GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

WELDING

AREA		LHS	RHS
A	(Seat brackets) : Operator (Name&sign):		
	(C-rails, Luggage and earth bushes) : Operator (Name&sign):		
B	(Seat brackets) : Operator (Name&sign):		
	(C-rails, Luggage and earth bushes) : Operator (Name&sign):		
C	(Seat brackets) : Operator (Name&sign):	Sibiya	Nokulunga Dlamini
	(C-rails, Luggage and earth bushes) : Operator (Name&sign):	Sibiya	Nokulunga Dlamini
D	(Seat brackets) Operator (Name&sign):	Sibiya	Nokulunga Dlamini
	(C-rails, Luggage and earth bushes) : Operator (Name&sign):	Sibiya	Nokulunga Dlamini

ENDS

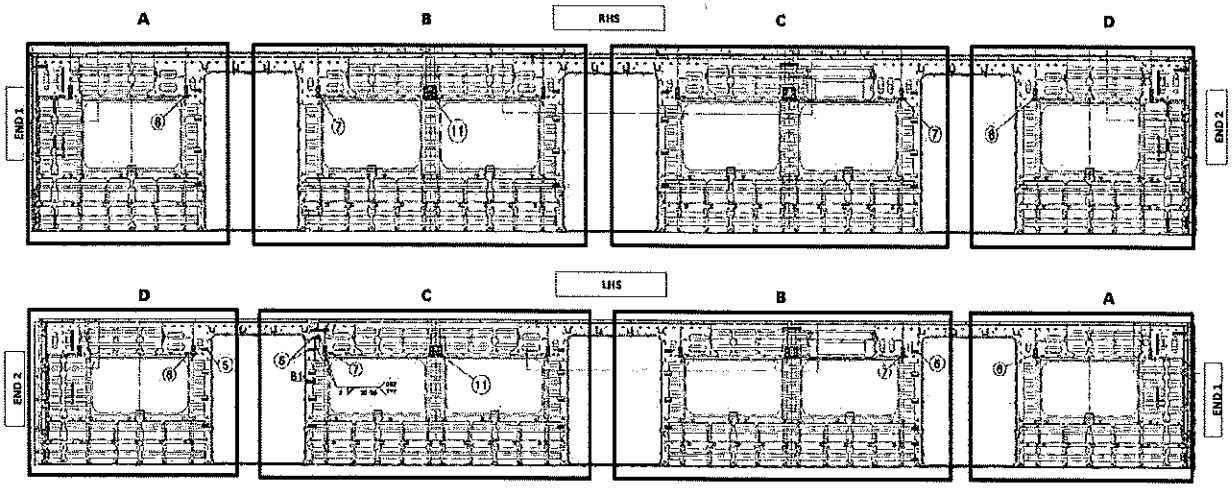
END 2 TAPPING PADS WELDING: Operator (Name&sign): Sibiya

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

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

II - Self Inspection - Items to Check

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

RHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7	✓	
	B	4	✓	
	C	8	✓	
	D	8	✓	
SEAT BRACKETS	A	13	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	3	✓	
	B	6	✓	
	C	4	✓	
	D	3	✓	

ROOF ENDS:

CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: T N/A

LHS

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

ROOF ENDS:

CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: N/A

QUANTITIES (M1)

RHS

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

ROOF ENDS:

CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: Tetelo

LHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2	✓	
	B	10	✓	
	C	11	✓	
	D	8	✓	
SEAT BRACKETS	A	13	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	3	✓	
	B	7	✓	
	C	6	✓	
	D	2	✓	

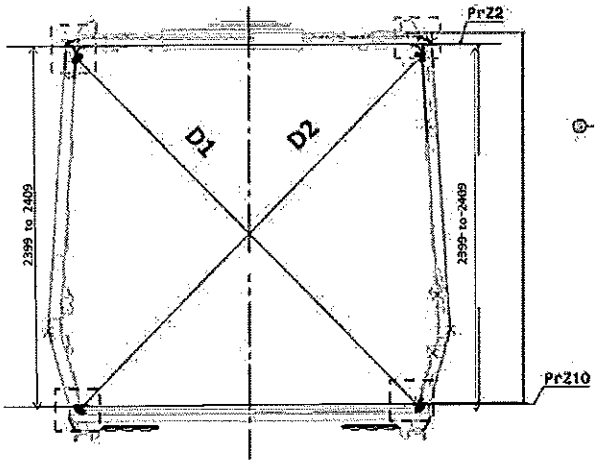
ROOF ENDS:

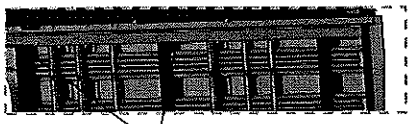
CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: Tetelo

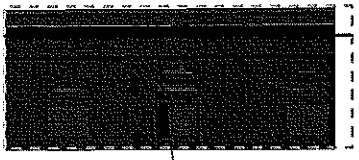
GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

Specifications of Details for CBS measurement

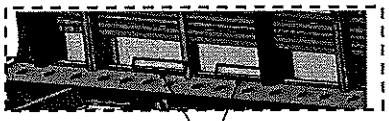




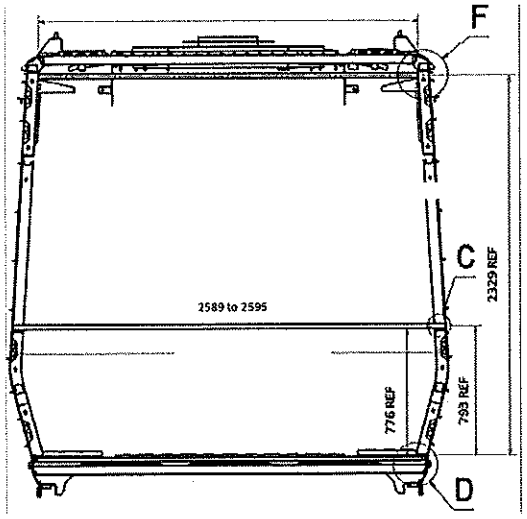
Measurement positions on roof rail and sidewall on rear corner.



Reinforcement area measurement positions on roof reinforcement area.



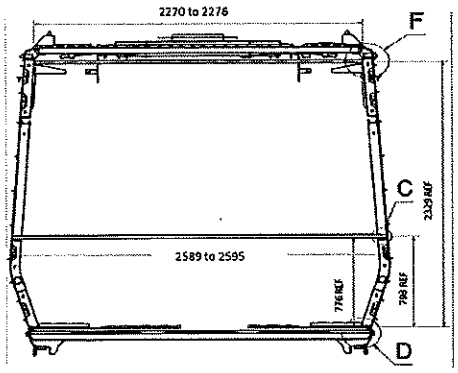
Measurement positions on sidewall and side sill corner.

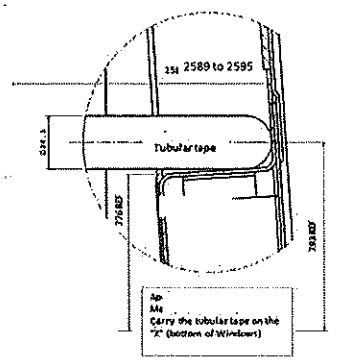


GIBELO
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

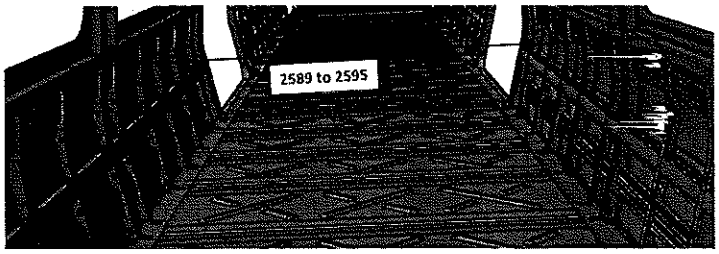
GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29	Project: PRASA
		Date 28/10/2023	SI.CB1220.250.V29

CBS measurement

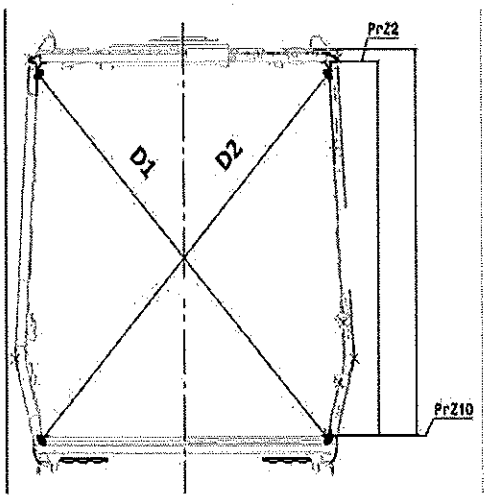


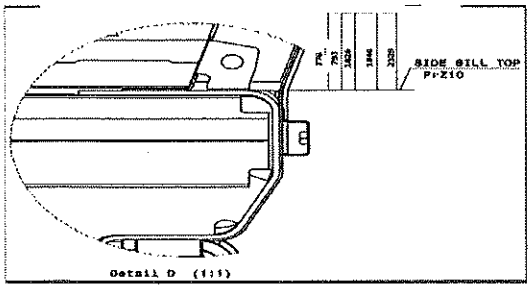


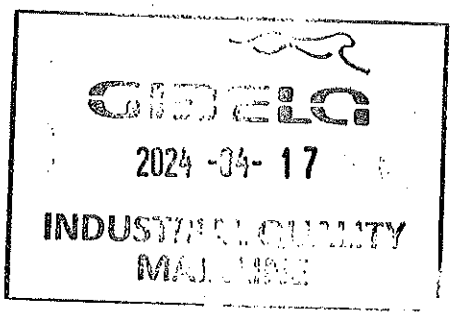
Detail C



Take measurement close to radius

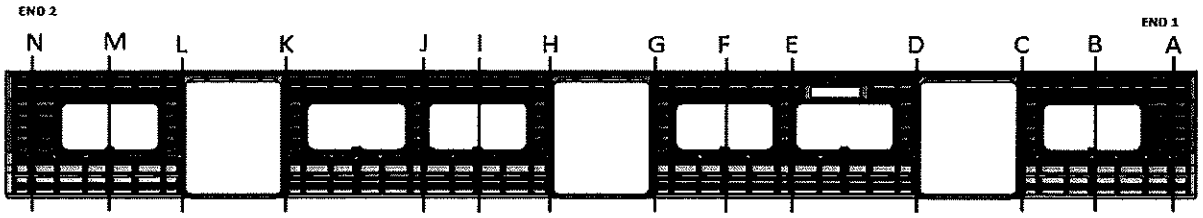






GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB1220.250.V29

CBS measurement



BEFORE WELDING

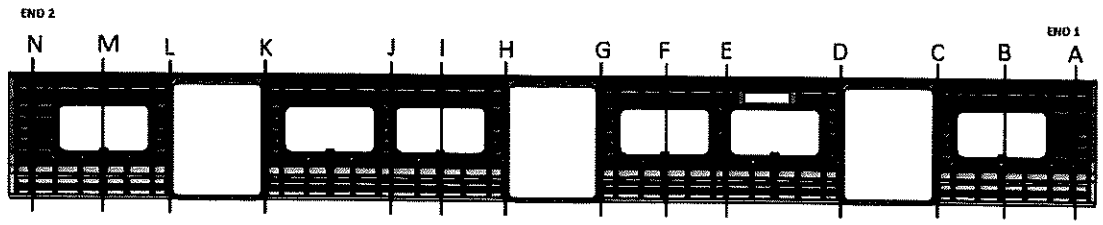
N/A

	ecord D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3297	3	
B	3265	3268	3	
C	3299	3295	4	
D	3298	3296	2	
E	3266	3268	2	
F	3269	3266	3	
G	3299	3296	3	
H	3298	3296	2	
I	3266	3260	2	
J	3269	3266	3	
K	3297	3295	2	
L	3299	3295	4	
M	3266	3268	2	
N	3300	3299	N	

GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

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

CBS measurement



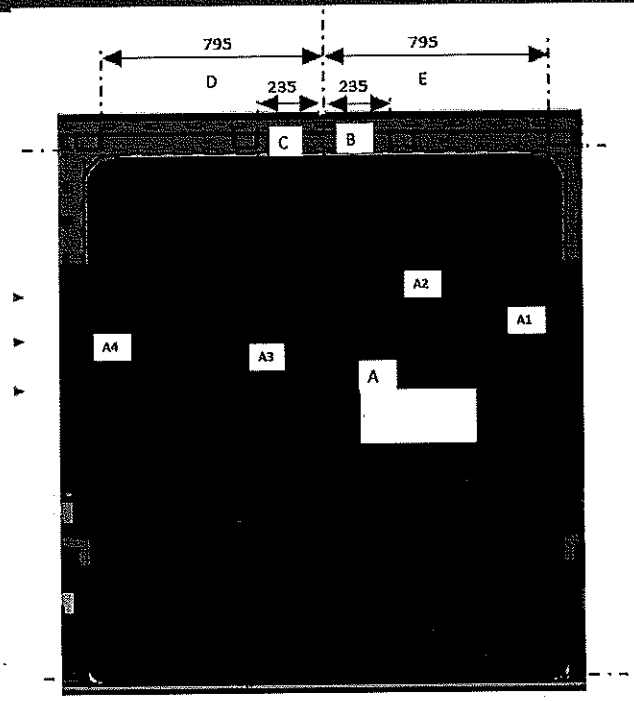
AFTER WELDING

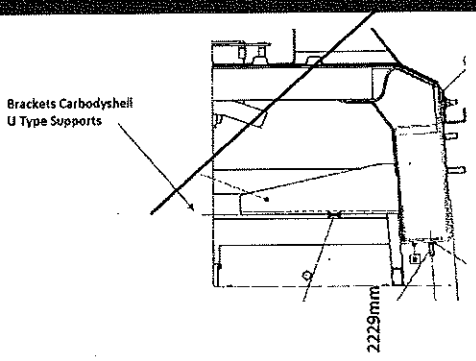
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3296	4	2590
B	3264	3267	3	2591
C	3298	3294	4	2589
D	3299	3296	3	2592
E	3268	3268	0	2593
F	3268	3267	1	2594
G	3295	3297	2	2591
H	3295	3295	0	2589
I	3266	3269	3	2590
J	3268	3269	1	2591
K	3269	3268	1	2590
L	3299	3298	1	2590
M	3264	3265	1	2592
N	3300	3298	2	2593

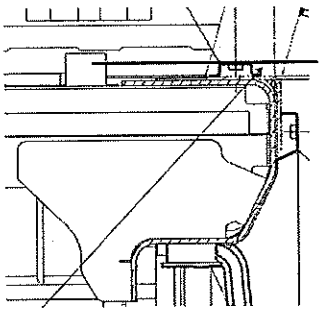
GIBELO
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA 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	2230
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	2230
A3	2230 to 2232	2231
A4	2230 to 2232	2231
B	234 to 236	235
C	234 to 236	235
D	794 to 796	794
E	794 to 796	796

DOOR 2 - LHS

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

DOOR 1 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2231
A3	2230 to 2232	2230
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	2232
A3	2230 to 2232	2232
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

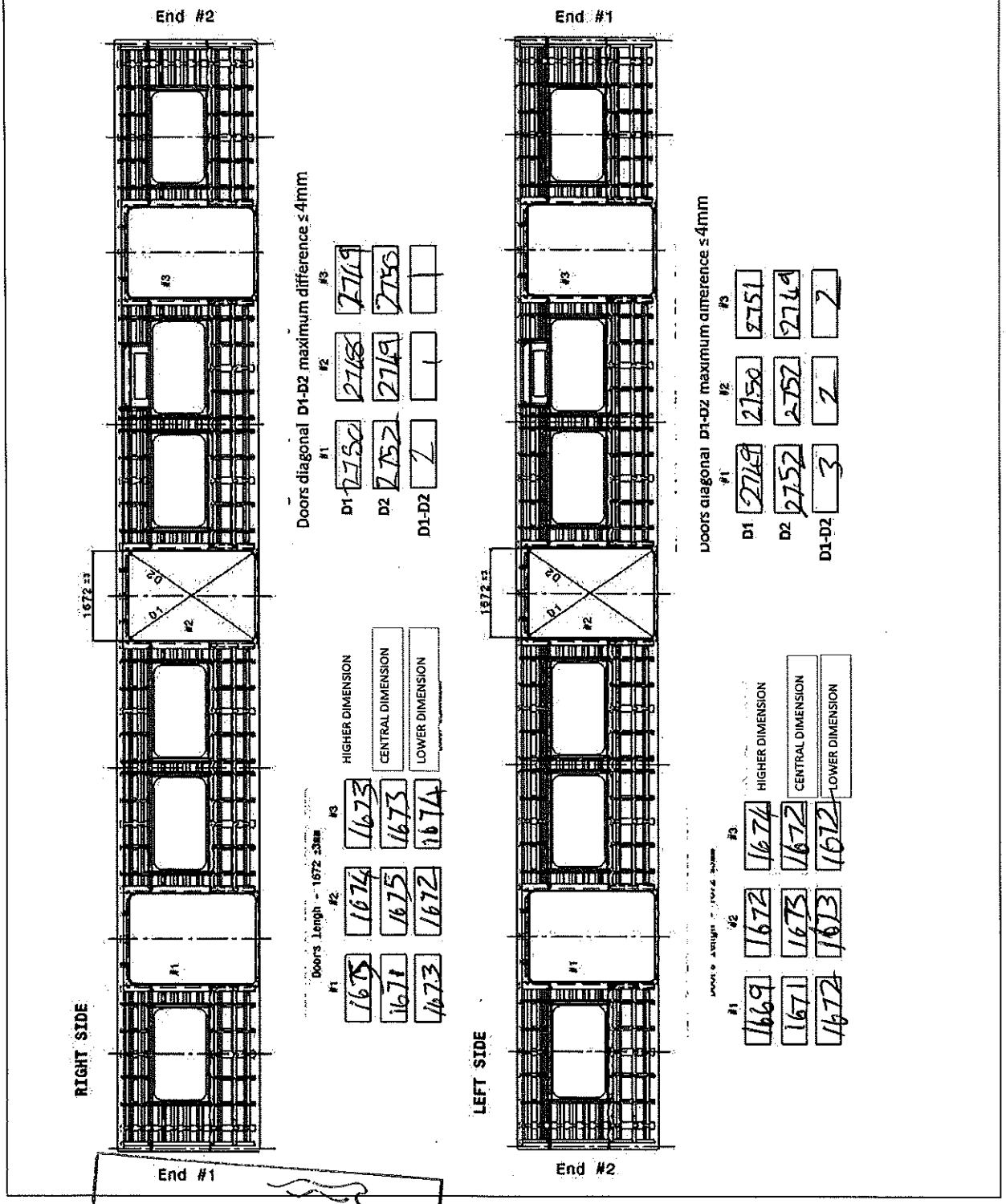
DOOR 3 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2231
A3	2230 to 2232	2230
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

GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

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

Specifications of Details for CBS measurement CB1220



GIBELO
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

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

CBS measurement (Manufacturing)

Dye penetrant test

Dye-penetration test to be performed by quality personnel

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

II.2 - Check List REX

Check List Items

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

GIBELO
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

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

Self Inspection - Final Result

Is the car good to advance to the next workstation/process? (Approval of Operations Manager and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	✓		(If f activities are not complete, the missing activities must not impact the next stage)	17/04/24	Tebelo Operations	
			Every auto inspection performed conforms to especification or in case of discrepancy the same is approved by the competent party.)	17/04/24	Amo 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	

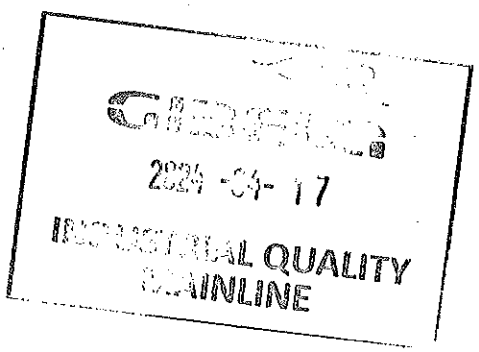
In case of "NO GO", describe blocking problems

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

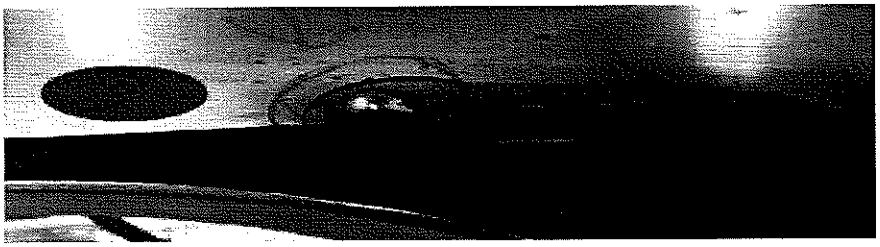
Item	Description		Responsible	Due date	Status

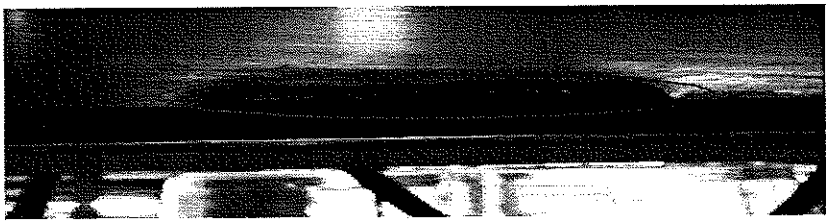
Operations

Quality

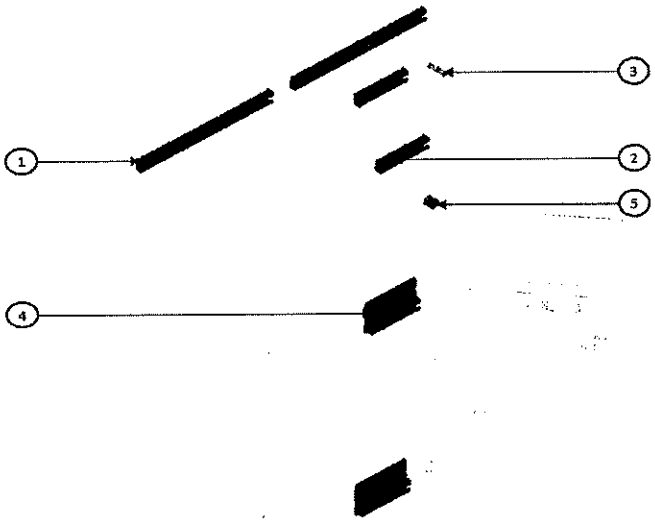


ANNEXURE A: Arc Welding Quality Acceptance Standard

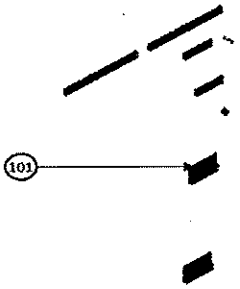




Station: CB1220-004- U108 & U107



PART NO.	ITEM NO.	QTY	DESCRIPTION	MASS (KG)
DTR0020074068	5	6	EARTH STUD 6	0.036
AA00001201848	4	6	ASSEMBLY SUPPORT	0.271
DTR0000348305	3	12	WELDING STUD ISO13918 PT – M8X20 - SST	0.007
AA00001180424	2	12	ASSEMBLY SUPPORT	0.193
AA00001184418	1	14	ASSEMBLY SUPPORT	0.522
AA00001161080	101	6	CARBODYSHELL BRACKETS CARBODYSHELL M1/M3/M4 CAR(SIDE FRAME MODULE END – OPP)	12.132



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	M1	M2	M3	TC2	WORK INSTRUCTION	SAFETY ?
☐ DT00000225487	AAD0001278566	CARBODYSHELL M1,M3,M4 ASSEMBLY	CB1230		X	(X)		X		PRA.CB1230.DT000002 25487.V20	YES
☐											
☐											

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

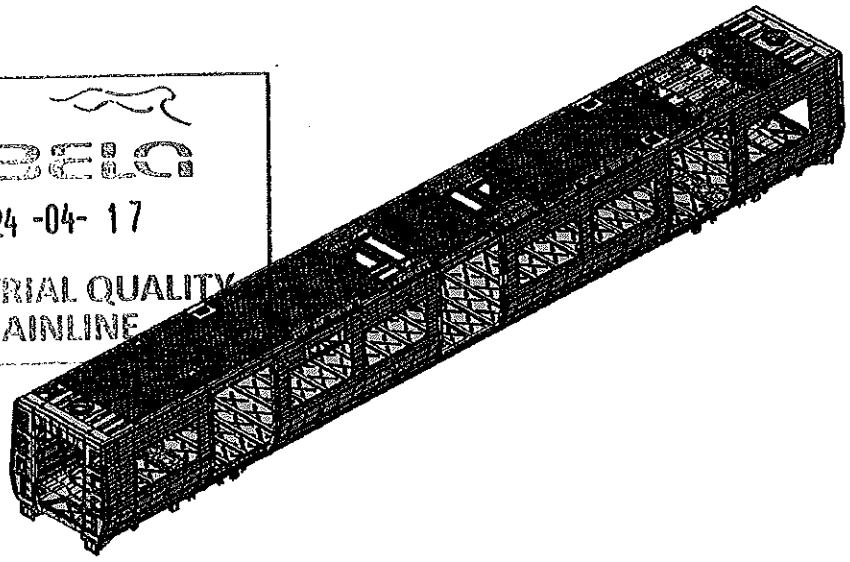
TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
223	MO 1	Zanele 48274	16/04/24	SI.CB1230.256.V28	11

GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 29 Date 06/11/2023	Project: PRASA SI.CB1230.256.V28

Car:	NCR:	Work station: CB1230

Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car M1	M2	M3	M4	TC2	Revision	Obsevation	OK	N/A	Signature/Date (Operations)	Signature/Date (Quality)
PRA.CB1230.DT00000225487	X					29		OK	N/A	18/04/24	18/04/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	N/A	Signature/Date (Operations)	Signature/Date (Quality)
Tubular	22713	26/06/24	OK		18/24	
Measuring tape	G1B0794	25/04/24	OK		18/24	18/04/24
Combination Square	G10 0072	27/07/24	OK		18/24	

1.3 Consumables

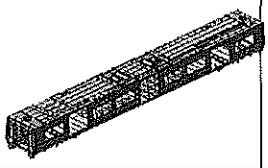
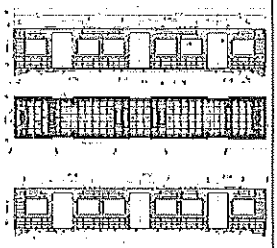
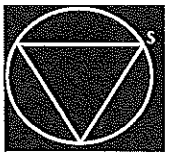
Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 L Si	310180	Mig Welding	OK		18/04/24	18/04/24

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 29 Date 06/11/2023	Project: PRASA SI.CB1230.256.V28

II - Self Inspection - Items to Check

II.1 - Items to check

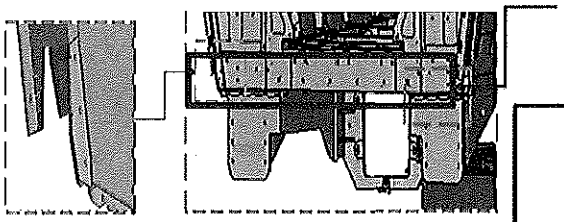
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOK	Remark	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering nº PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	OK			18/04/24	18/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	OK			18/04/24	18/04/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	**IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000**	OK			18/04/24	18/04/24
04		Cleaning of all Stainless Steel Surface	**According TO GIB-WEL - PROC-0002**	OK			18/04/24	18/04/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	OK			18/04/24	18/04/24
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.	OK			18/04/24	18/04/24
07	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 10-03 Exp Date: ___ / 07 / 06 Actuals Temparature: 19°C Humidity: 48 %	OK			18/04/24	18/04/24
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.	OK			18/04/24	18/04/24

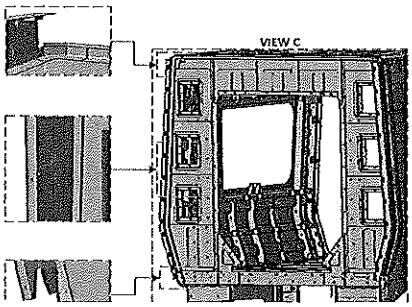
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

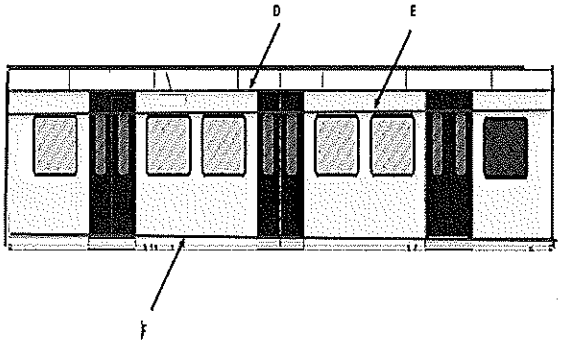
GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 29 Date 06/11/2023	Project: PRASA SI.CB1230.256.V28

END 2 SEALANT

AREA 1







H

OPERATOR (Name & sign): Leroy

OPERATOR (Name & sign): leroy

OPERATOR (Name & sign): Leroy

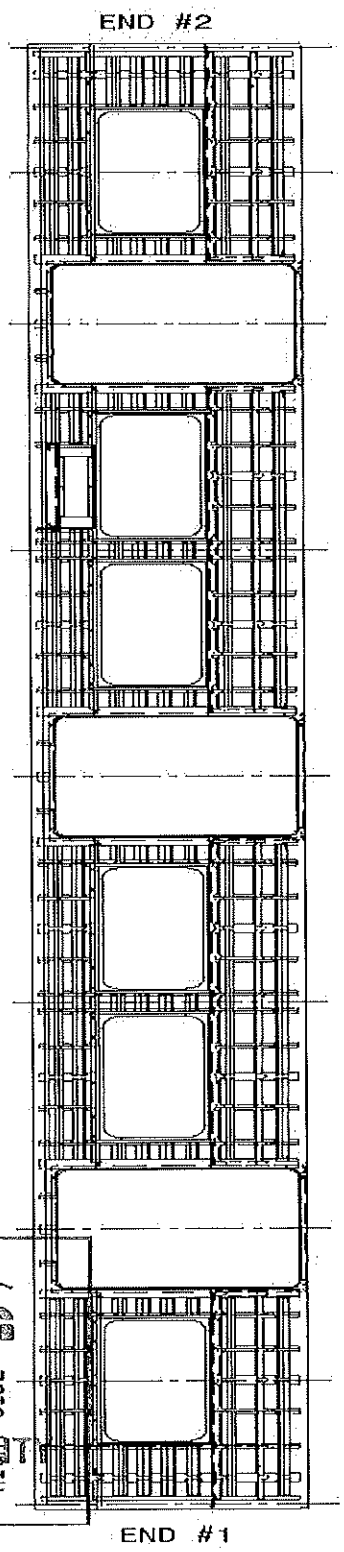
Area D,E,F,G,H,I	LHS	RHS
Operator (Name & sign) :	H1 Bottom LERATO (M)...	D,E,G,H,I LERATO (M)...
Operator (Name & sign) :	Buhle	Buhle
Operator (Name & sign) :	Mgola	Mgola
Operator (Name & sign) :	D,E,F,G,H,I (F)	Sihle
Operator (Name & sign) :	Tshenolo	Tshenolo
Operator (Name & sign) :	Sihle	

GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

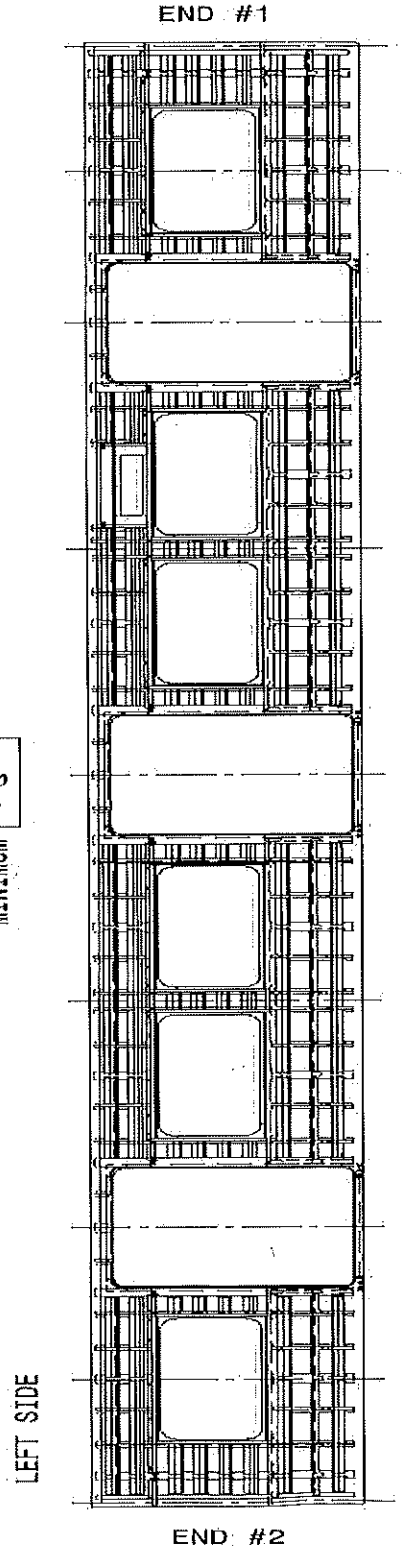
GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 29 Date 06/11/2023	Project: PRASA SI.CB1230.256.V28

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 foundand indicate the corresponding region.



MAXIMUM 2.0
MINIMUM 1.8



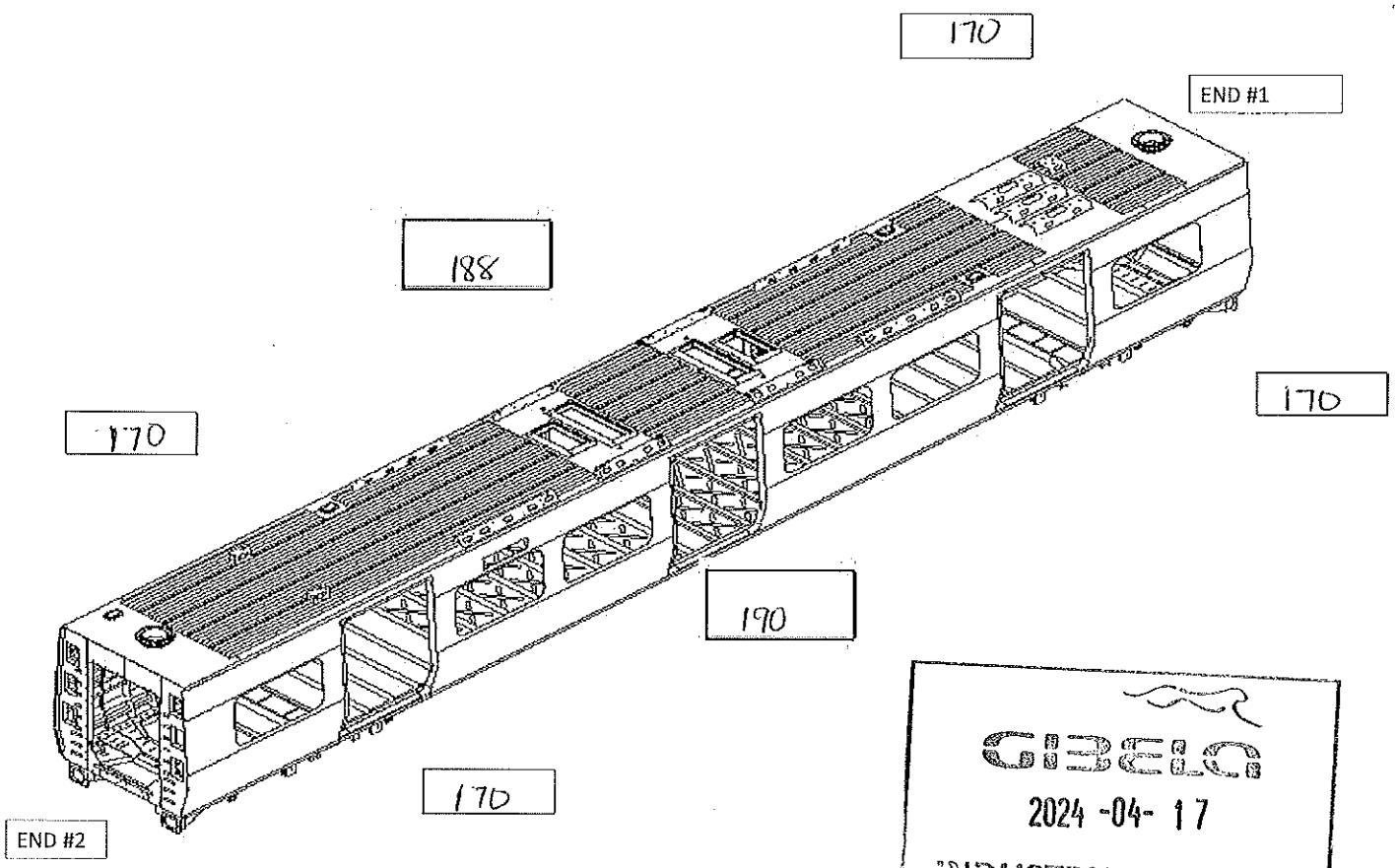
MAXIMUM 1.4
MINIMUM 1.3

GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 29 Date 06/11/2023	Project: PRASA SI.CB1230.256.V28

Specifications of Details for CBS measurement CB1230

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



GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

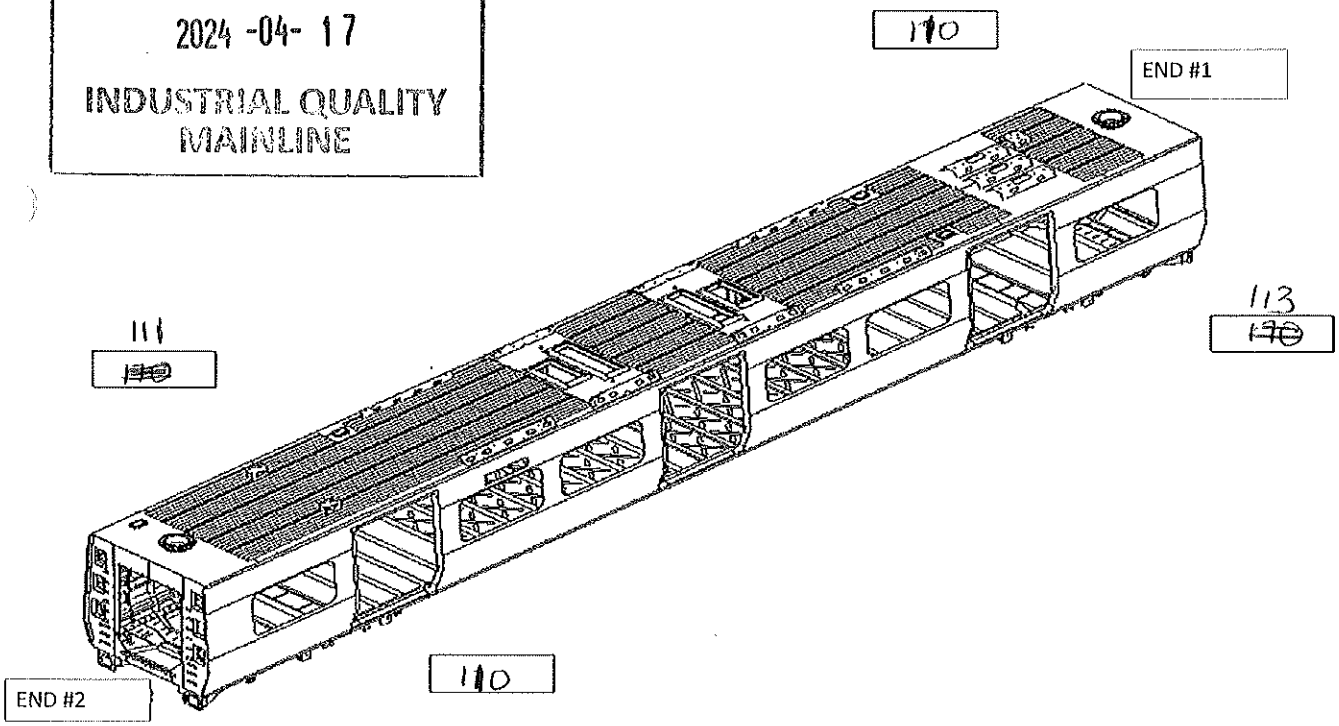
MEASURED CAMBER VALUES	
RIGHT	20
LEFT	18

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 29 Date 06/11/2023	Project: PRASA SI.CB1230.256.V28

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.

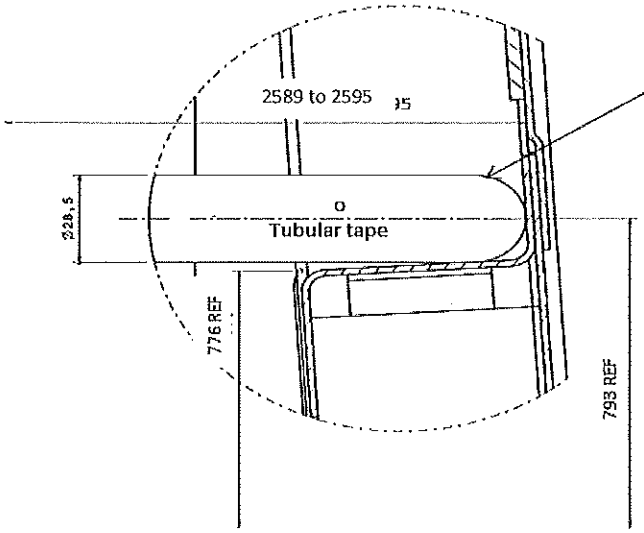
GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE



TWIST FOUND ON END 1	
TRANVERS	3
LONGITUDIN	3

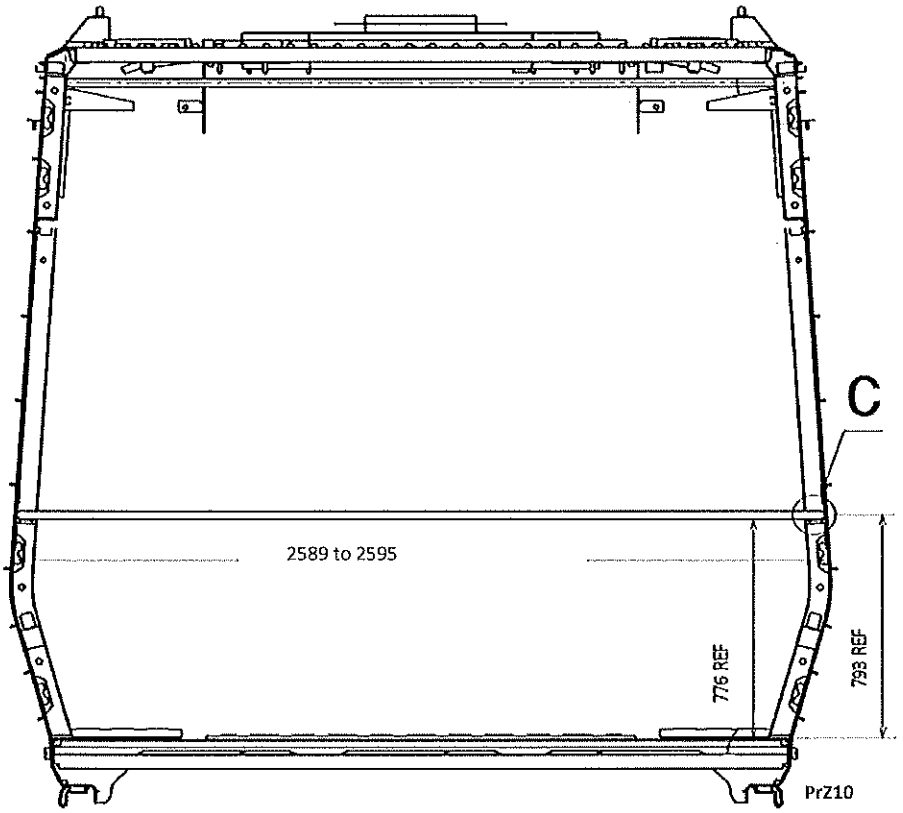
TWIST FOUND ON END 2	
TRANVERSE	1
LONGITUDINAL	1

Specifications of Details for CBS measurement CB1230



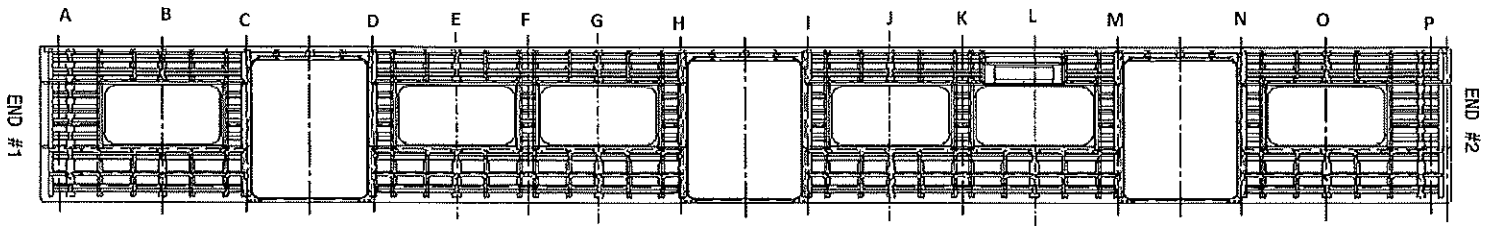
Detail C

GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE



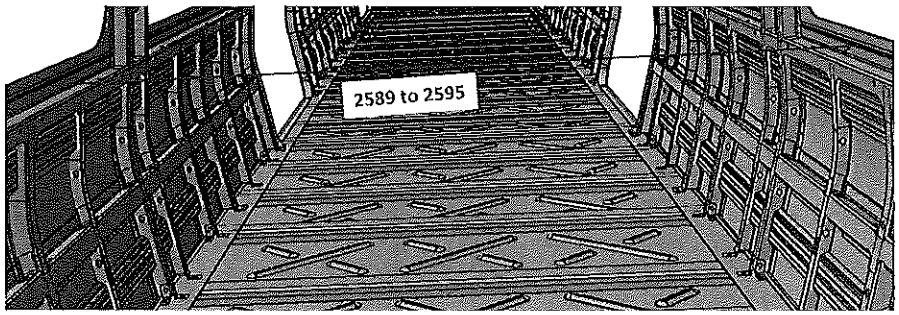
GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 29 Date 06/11/2023	Project: PRASA SI.CB1230.256.V28

Specifications of Details for CBS measurement CB1230



2589 to 2595mm

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



GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

Threashold verification

Nominal value :38

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

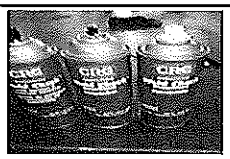
BOILER MAKER: LEROY

WELDER : Zanele

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 29 Date 06/11/2023	Project: PRASA SI.CB1230.256.V28

Dye penetrant test

Dye-penetration test to be performed by quality personnel



Specifications of Details for CBS measurement

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

GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE

II.2 - Check List REX

Check List Items

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

GIBELA
28 -04- 17
INDUSTRIAL QUALITY
Nº JBLINE

GIBELA	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
HOLD POINT		GO	(If f activities are not complete, the missing activities must not impact the next stage!	18/04/24	Silvic Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	18/04/24	Amo Industrial Quality	
		NO GO	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		Responsible	Due date	Status

Operations

Quality

GIBELA
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE