

GIBELA

PRASA PROJECT



APPLICABLE FROM TRAINSET 190+ AS PER BASELINE 10.4

SELF INSPECTION SHEET

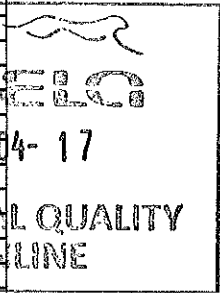
CONFIDENTIAL INFORMATION

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

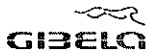
APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY?		
				TC1	M6	M1	M2	M3	TC2				
<input type="checkbox"/>	DTR30225487/3	AAD0001278566	CARBODYSHELL M3,M4 ASSEMBLY	CB2210		X				X		PRA.CB2210.DTR30225487/3.V30	YES

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018
			CHECKER	Nosizo Pindela	10/01/2018
			COMPILER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motama	2018/05/18
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230	APPROVER	Itumeleng Modiba	2018/07/04
			CHECKER	Nosizo Pindela	2018/07/04
			REVISED BY	Ramokone Motama	2018/07/04
3	2018/12/12	Added dimensional check points to CB2210	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	20/01/2019
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	06/08/2020
			REVISED BY	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			REVISED BY	Bongane Masina	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISED BY	Mpho Mulaudzi	17/08/2021
25	19/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	19/02/2022
			CHECKER	Andani Muthelo	19/02/2022
			REVISED BY	Andani Muthelo	19/02/2022
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlampe Amogelang	14/04/2023
			REVISED BY	Mohlampe Amogelang	14/04/2023
30	20/07/2023	New Baseline change 10.4	APPROVER	Ngobeni Tyson	28/07/2023
			CHECKER	Mohlampe Amogelang	28/07/2023
			REVISED BY	Mohlampe Amogelang	28/07/2023
31	07/11/2023	Added traceability for welding sections	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Mohlampe Amogelang	07/11/2023
			REVISED BY	Ntokozo Zwane	07/11/2023



TRAINSET	CAR	OPERATOR NAME&ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
223	M3	Tim - 418354	18/04/24	SI.CB2210.254.V30	17



CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev. 31
Date 07/11/2023

Project: PRASA
SI.CB2210.254.V30

Car: M3 & M4

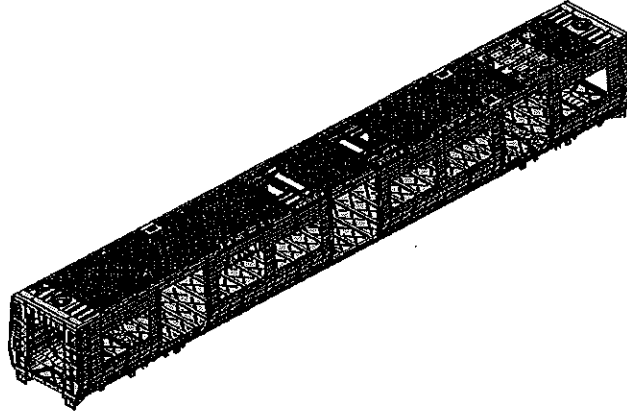
NCR:

Work station:

CB2210



Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	D	M	SI	SE	MA	SP					
DTR30225487/3				✓			31		✓	<i>[Signature]</i> 18/01/24	<i>[Signature]</i> 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	Signature/Date (Manufacturing)	Signature/Date (Quality)
MEASURING TAPE	G187PC084	31/03/25	✓	<i>[Signature]</i> 18/01/24	<i>[Signature]</i> 18/04/24
LASER TAPE	12542594	07/02/25	✓	<i>[Signature]</i> 18/01/24	<i>[Signature]</i> 18/04/24
TUBULAR	32823-2	15/03/25	✓	<i>[Signature]</i> 18/01/24	<i>[Signature]</i> 18/04/24

I.3 Consumables




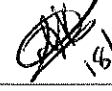


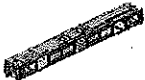
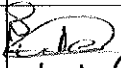
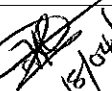
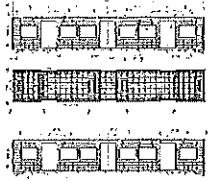
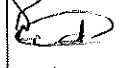

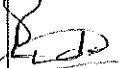

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 L	310440-73092	Tig	✓	<i>[Signature]</i> 18/01/24	<i>[Signature]</i> 18/04/24
ER 308 LSi	327730-74791	Mig	✓	<i>[Signature]</i> 18/01/24	<i>[Signature]</i> 18/04/24
ER 309 LSi	318394-74708	Mig	✓	<i>[Signature]</i> 18/01/24	<i>[Signature]</i> 18/04/24



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


II - Self Inspection - Items to Check

II.1 - Items to check							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		 18/04/24	 18/04/24
02	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓		 18/04/24	 18/04/24
03	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 18/04/24	 18/04/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 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.	✓		 18/04/24	 18/04/24
06	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓		 18/04/24	 18/04/24



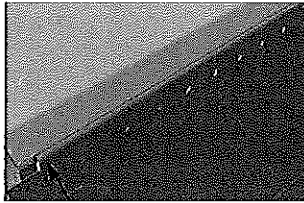
2024 -04- 17

**INDUSTRIAL QUALITY
MAINLINE**

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

Welding Traceability

Roof ring welds



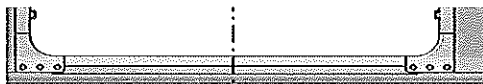
LHS	
Boiler maker (Name & Sign): <u>WINGA [Signature]</u>	Welder (Name & Sign): <u>SIPHOKAZI [Signature]</u>
RHS	
Boiler maker (Name & Sign): <u>Tebogo [Signature]</u>	Welder (Name & Sign): <u>MTHOKOZISI [Signature]</u>

END 1

LHS	
Boiler maker (Name & Sign): <u>WINGA [Signature]</u>	Welder (Name & Sign): <u>SIPHOKAZI [Signature]</u>
RHS	
Boiler maker (Name & Sign): <u>Tebogo [Signature]</u>	Welder (Name & Sign): <u>MTHOKOZISI [Signature]</u>

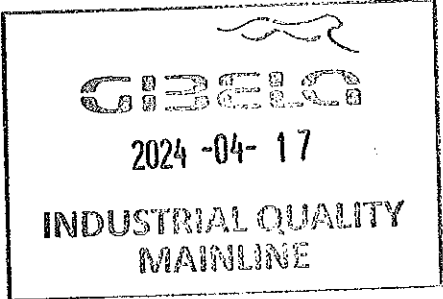
END 2


Door ring welds



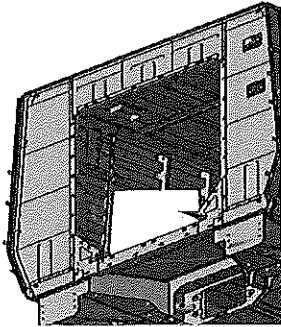
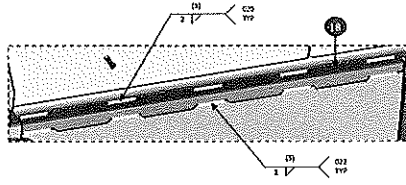
LHS
Boiler maker (Name & Sign): <u>Innocent [Signature]</u>
Welder (Name & Sign): <u>ROBERT [Signature]</u>

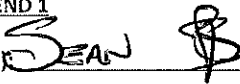
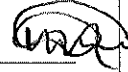
RHS
Boiler maker (Name & Sign): <u>Innocent [Signature]</u>
Welder (Name & Sign): <u>ROBERT [Signature]</u>

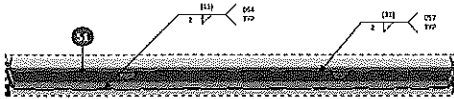


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		Date 07/11/2023	

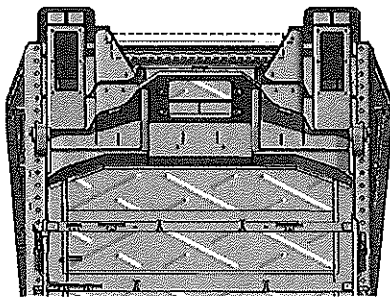
EUF Reinforcement Plates




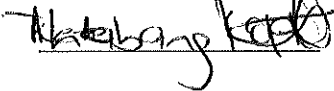
END 1
 Boiler maker (Name & Sign): SEAN 
 Welder (Name & Sign): Mthokozisi 

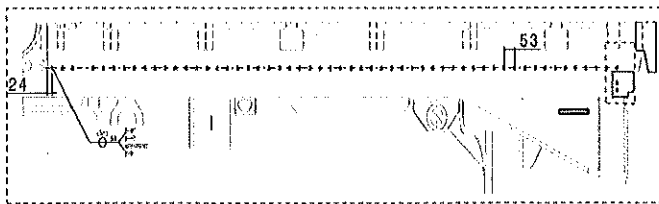


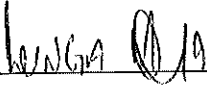
END 2

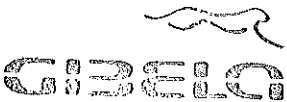



Underneath the CAR

END 2
 Boiler maker (Name & Sign): INNOCENT 
 Welder (Name & Sign): Mthabang 

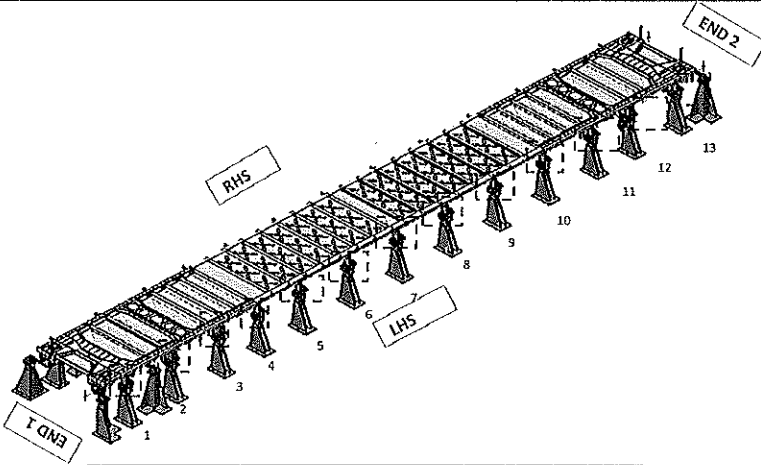


FEDOLI
 Operator: WENGA 


 2024 -04- 17
 INDUSTRIAL QUALITY
 MAINLINE

	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	

Specifications of Details for CBS measurement



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

After loading and clamping

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


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

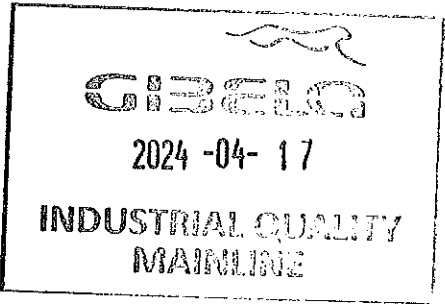
Signature Operations:  Date: 18/04/24

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: 18/04/24



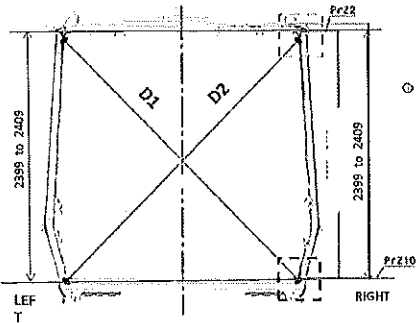
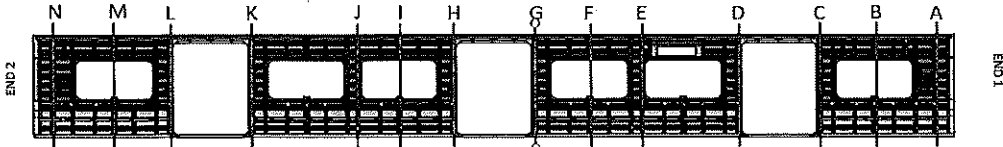


CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

Rev. 31
Date 07/11/2023

Project: PRASA
SI.CB2210.254.V30

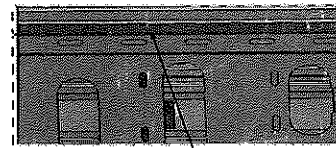
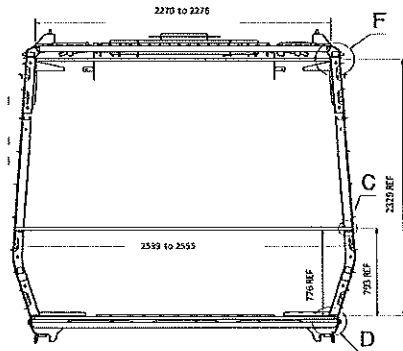
Specifications of Details for CBS measurement



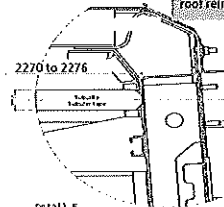
Measurement positions on roof rail and sidewall omega carrier.



Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.



Detail F
Roof Reinforcement

GIBELQ
2024-04-17
INDUSTRIAL QUALITY
MAINLINE
18/04/24

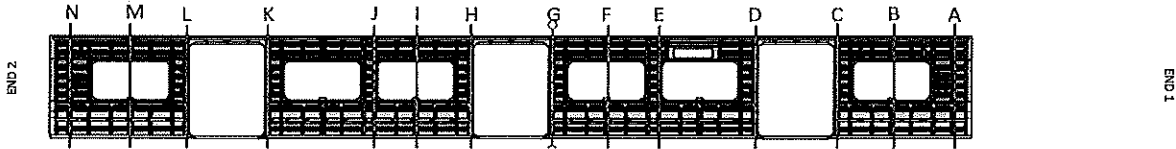


CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

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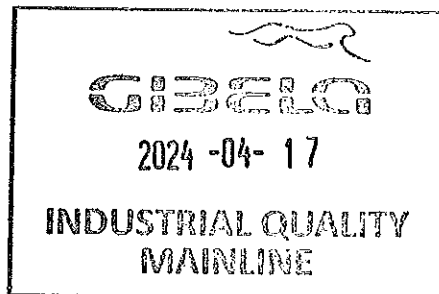
Specifications of Details for CBS measurement



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

BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3265	3266	1	2406	2405	1
B	3264	3266	2	2407	2406	1
C	3268	3267	1	2405	2405	0
D	3267	3269	2	2405	2404	1
E	3269	3265	4	2406	2406	0
F	3265	3268	3	2406	2404	2
G	3269	3269	0	2404	2405	1
H	3263	3264	1	2407	2406	1
I	3263	3265	2	2405	2407	2
J	3266	3268	2	2404	2406	2
K	3264	3264	0	2403	2403	0
L	3266	3268	2	2406	2405	1
M	3268	3265	3	2405	2406	1
N	3262	3265	3	2405	2407	2



18/04/24

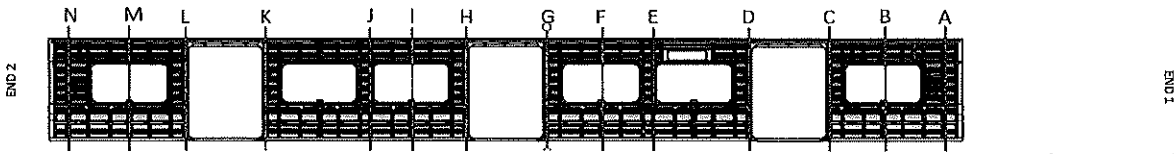


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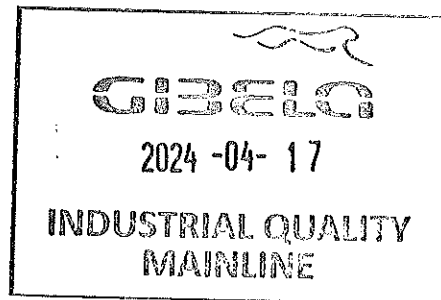
Specifications of Details for CBS measurement



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

AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5 mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3295	3296	1	2406	2405	1
B	3264	3266	2	2407	2406	1
C	3298	3297	1	2405	2405	0
D	3297	3299	2	2405	2404	1
E	3269	3265	4	2406	2406	0
F	3265	3268	3	2406	2404	2
G	3299	3299	0	2404	2405	1
H	3293	3294	1	2407	2406	1
I	3263	3265	2	2405	2407	2
J	3266	3268	2	2404	2406	2
K	3294	3294	0	2403	2403	0
L	3296	3298	2	2406	2405	1
M	3268	3265	3	2405	2406	1
N	3292	3295	3	2405	2407	2



P. Ledeb
18/04/24



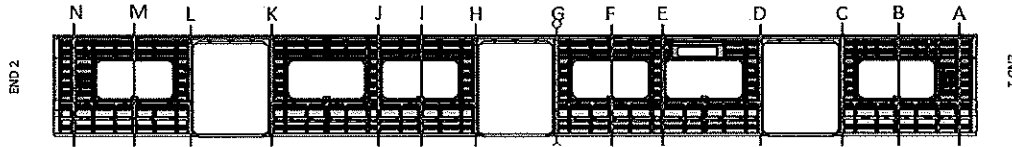
CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

Rev. 31
Date 07/11/2023

Project: PRASA
SI.CB2210.254.V30

GBS measurement

BEFORE WELDING



2270 to 2276

A. 2275

B. 2273

C. 2276

D. 2274

E. 2276

F. 2273

G. 2271

H. 2272

I. 2275

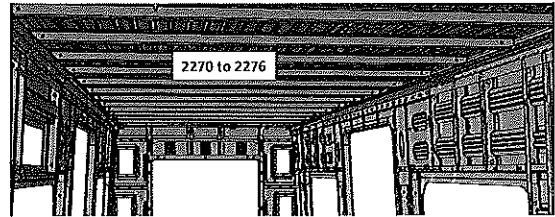
J. 2272

K. 2273

L. 2274

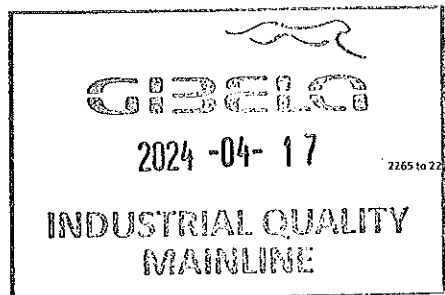
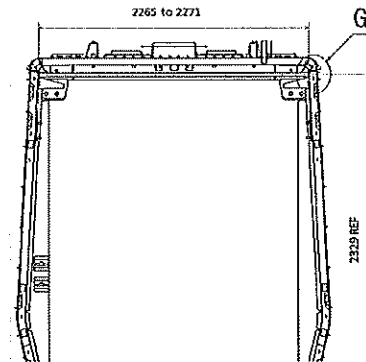
M. 2275

N. 2276

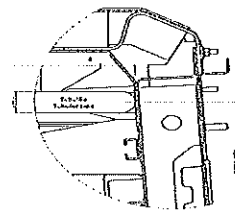


Do not consider reinforcement (Take measurements top area of zee profile

2265 to 2271



2265 to 2271



Detail 0

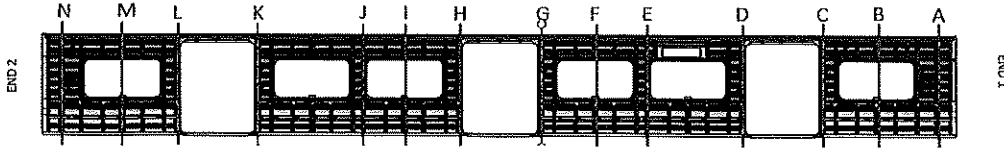
Consider the reinforcement plate

Redeb

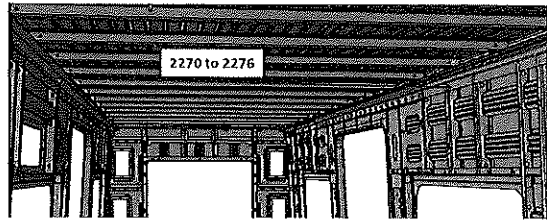
18/04/24

CBS measurement

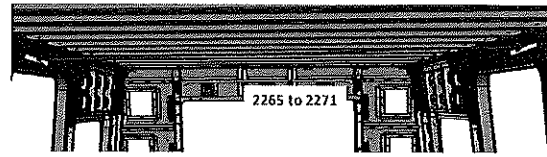
AFTER WELDING



	2265 to 2271	2270 to 2276
A	2268	
B		2273
C	2269	
D	2265	
E		2276
F		2273
G	2267	
H	2265	
I		2275
J		2272
K	2269	
L	2265	
M		2275
N	2266	



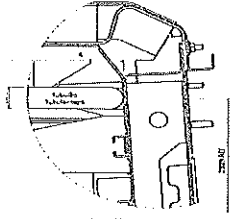
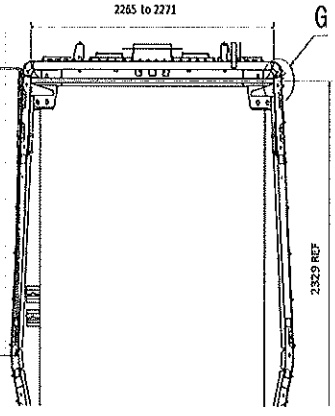
Do not consider reinforcement (Take measurements top area of zee profile



Take measurement close to radius (considering reinforcement)

2024-04-17

INDUSTRIAL QUALITY
MAINLINE



2265 to 2271
Detail 0
Considering the reinforcement plate

B. Leeder
18/04/24

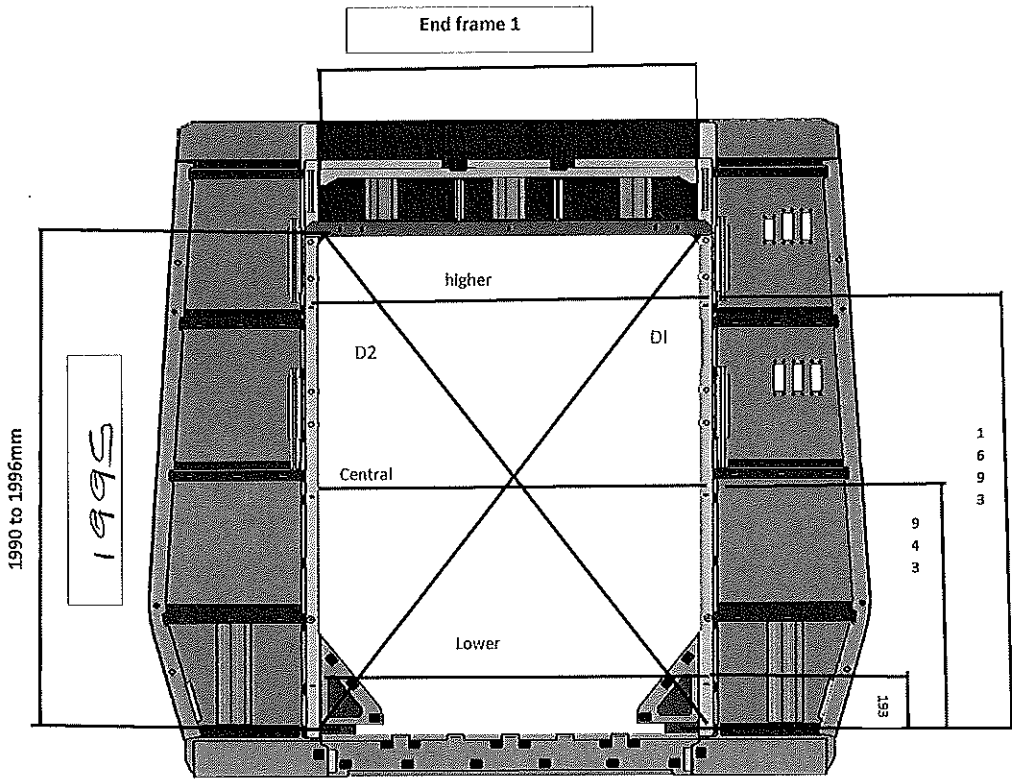


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev. 31
Date 07/11/2023

Project: PRASA
SI.CB2210.254.V30

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3mm$

Higher Dimension

1382

D1

2415

Central Dimension

1381

D2

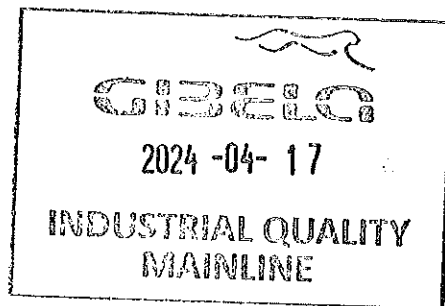
2416

Lower Dimension

1381

D1-D2

1



[Handwritten signature]
18/04/24



CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

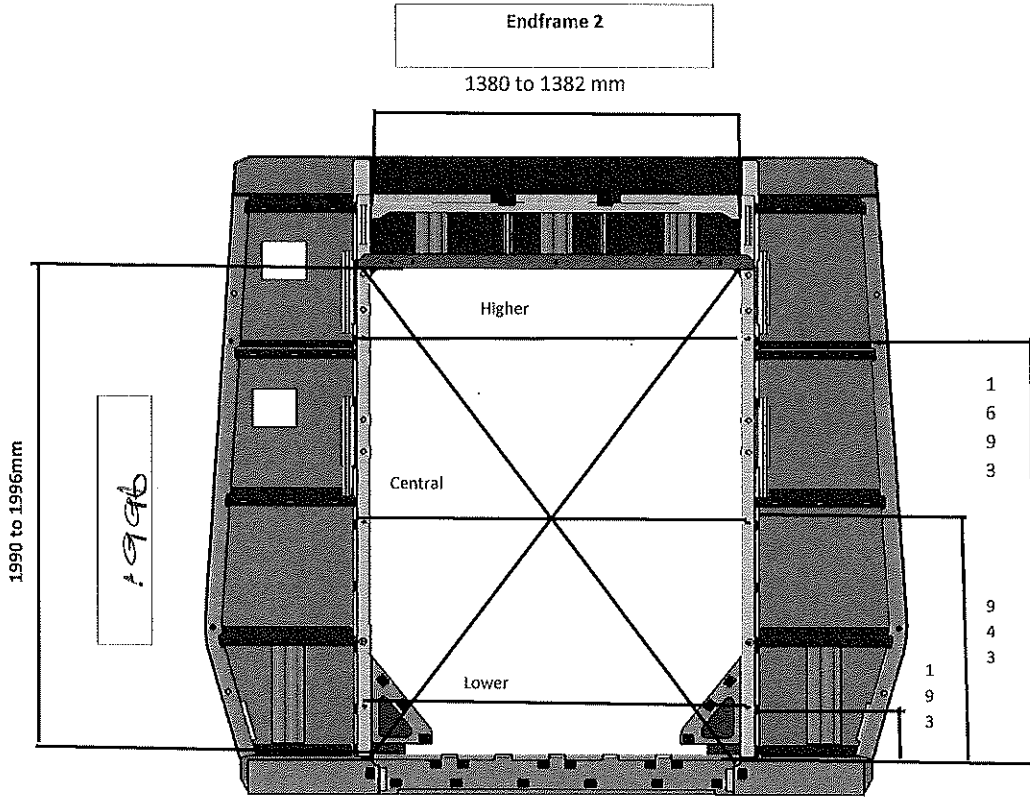
Rev. 31

Project: PRASA
SI.CB2210.254.V30

Date

07/11/2023

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3mm$

Higher Dimension

1381

D1

2411

Central Dimension

1381

D2

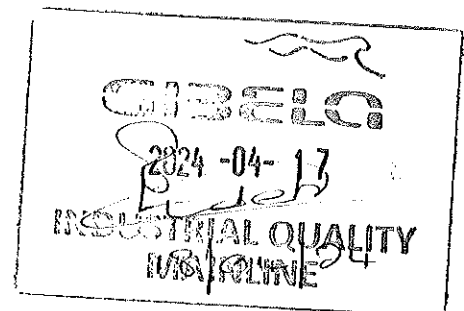
2413

Lower Dimension

1382

D1-D2

2





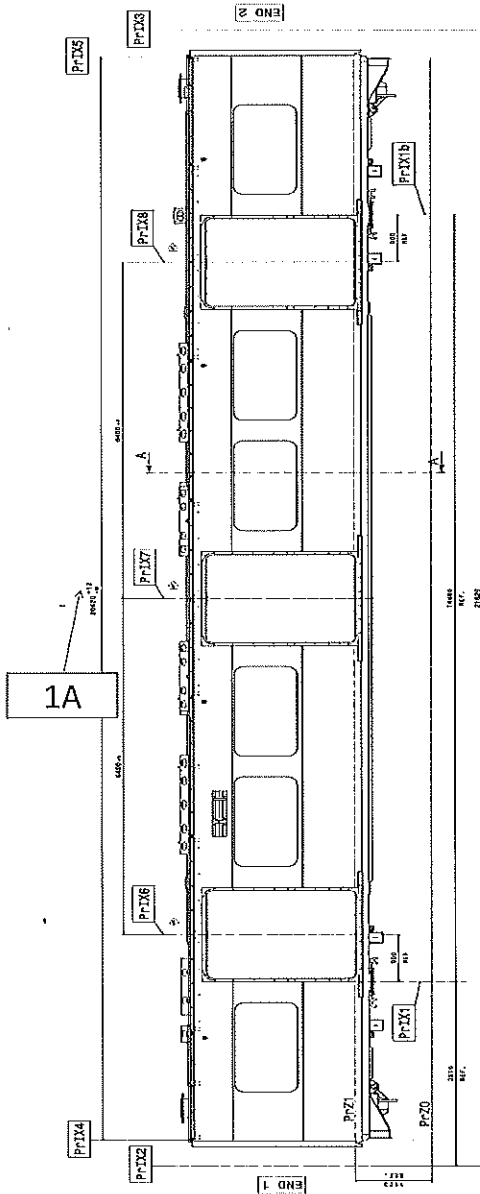
CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev. 31

Project: PRASA
SI.CB2210.254.V30

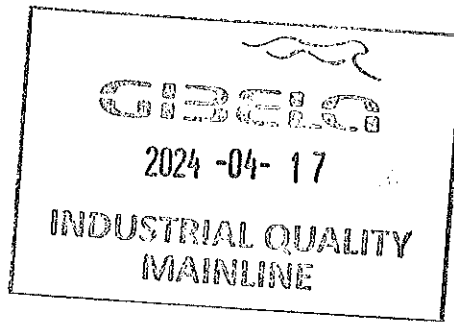
Date
07/11/2023

Specifications of Details for CBS measurement



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20628

RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20628




Dye penetrant test

Dye-penetration test to be performed by quality personnel





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18/04/24

	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	

Self Inspection - Final Result

			DATE	NAME	SIGNATURE	
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)	18/04/24	Timothy 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

PRASA PROJECT



APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

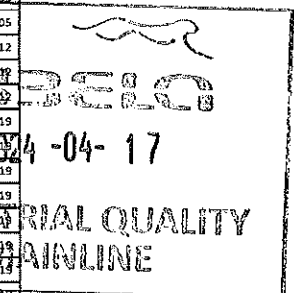
SELF INSPECTION SHEET

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


APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?
				TCL	MA	MS	MR	MD	TCS		
<input type="checkbox"/>	OTR302254872	AAD0001278556 CARBODYSHELL M1,M3,M4 ASSEMBLY	CB2220		X	X		X		PRA.CB2220.DTR3022548 7/2.V21	YES
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<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											

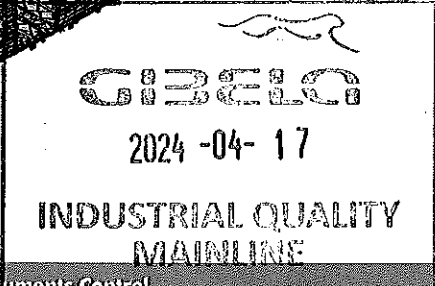
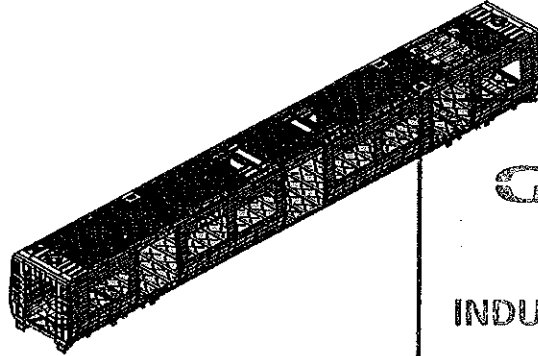
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	01/02/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	01/02/2018
			CHECKER	Nosizo Pindela	01/02/2018
			COMPILER	Thanyani Mathegu	01/02/2018
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	18/05/2018
			CHECKER	Nosizo Pindela	18/05/2018
			REVISED BY	Ramokone Motama	18/05/2018
2	2018/07/05	Certain dimensional checks added and others moved to CB1210	APPROVER	Itumeleng Modiba	2018/07/05
			CHECKER	Nosizo Pindela	2018/07/05
			REVISED BY	Ramokone Motama	2018/07/05
3	2018/06/12	Width tolerance as per 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	19/04/2021
			REVISED BY	Bongane Masina	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi Collins	17/08/2021
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISED BY	Mpho Mulaudzi	17/08/2021
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	19/02/2022
			CHECKER	Andani Muthelo	19/02/2022
			REVISED BY	Andani Muthelo	19/02/2022
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbhombhi	14/06/2022
			CHECKER	Andani Muthelo	14/06/2022
			REVISED BY	Andani Muthelo	14/06/2022
27	19/10/2022	Addition of traceability for sealant application & welding	APPROVER	Collins Mbhombhi	19/10/2022
			CHECKER	Ntokozo Zwane	19/10/2022
			REVISED BY	Amogelang Mohlampe	19/10/2022
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	14/04/2023
			REVISED BY	Amogelang Mohlampe	14/04/2023
29	28/10/2023	Addition of bracket quantity	APPROVER	Ngobeni Tyson	28/10/2023
			CHECKER	Ntokozo Zwane	28/10/2023
			REVISED BY	Amogelang Mohlampe	28/10/2023



TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
223	M03	Tetela	19/10/2024	SI.CB2220.250.V29	13

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

Car: M1,M3&M4	NGR:	Work station:	CB2220
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I - Documentation and Instruments Control

1.1 - Documentation Control

Document	Type of car					Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	D	M	A	M	B					
DTR30225487/2			✓			29	19/04/24	✓	N/A	19/04/2024

1.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Tubular	22113	03/09/2024	✓		
Measuring Type	GIB7A091	05/05/2024	✓	19/04/24	19/04/24

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Welding wire	E23106	MIG Welding	✓	19/04/24	19/04/24

II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB2220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB2220.DTR30225487/2	✓		 19/04/24	 19/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		 19/04/24	 19/04/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 19/04/24	 19/04/24
04		Cleaning of all Stainless Steel Surface	According to GIB-WEL - PROC-0002	✓		 19/04/24	 19/04/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		 19/04/24	 19/04/24
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-016. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-016 and DTD0000210658.	✓		 19/04/24	 19/04/24
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 (I) Min - Max 10°C - 35°C Relative humidity Min - Max (I) Min - Max 25% - 60%	Segment Batch No: <u>200925P</u> Exp Date: <u>10/01/26</u> Actuals Temperature: <u>17</u> Humidity: <u>61</u>	✓		 19/04/24	 19/04/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓		 19/04/24	 19/04/24
09		Verification of safety welds	Approved according to DTD000210658 reference and Self inspection	✓		 19/04/24	 19/04/24

2024-04-17
INDUSTRIAL QUALITY
MAINLINE



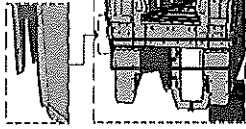
CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

Rev.
29
Date
28/10/2023

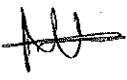
Project: PRASA
SI.CB2220.250.V29

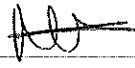
II - Self Inspection - Items to Check

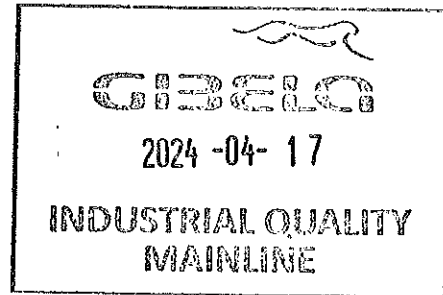
SEALANT APPLICATION




AREA 1 & 2 END 1

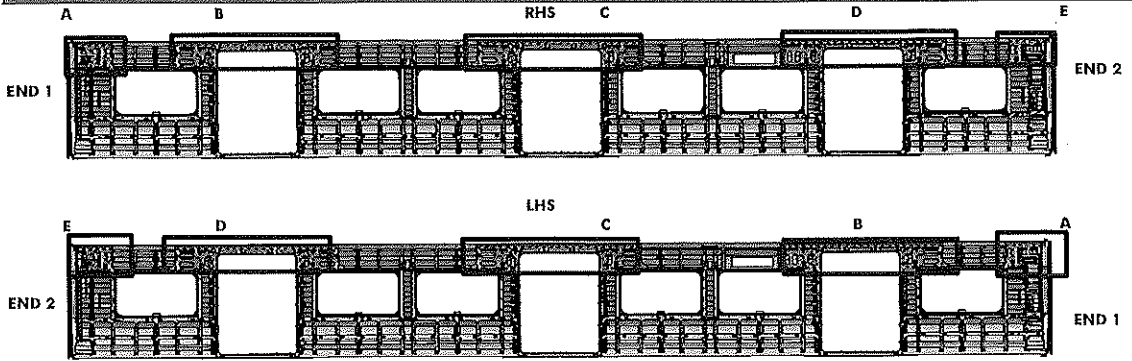
Operator (Name & sign):
MTHOKOZISI 

Operator (Name & sign):
MTHOKOZISI 



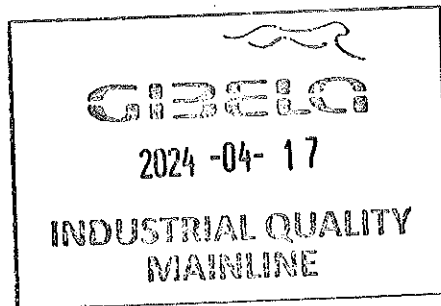
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	


II - Self Inspection - Items to Check

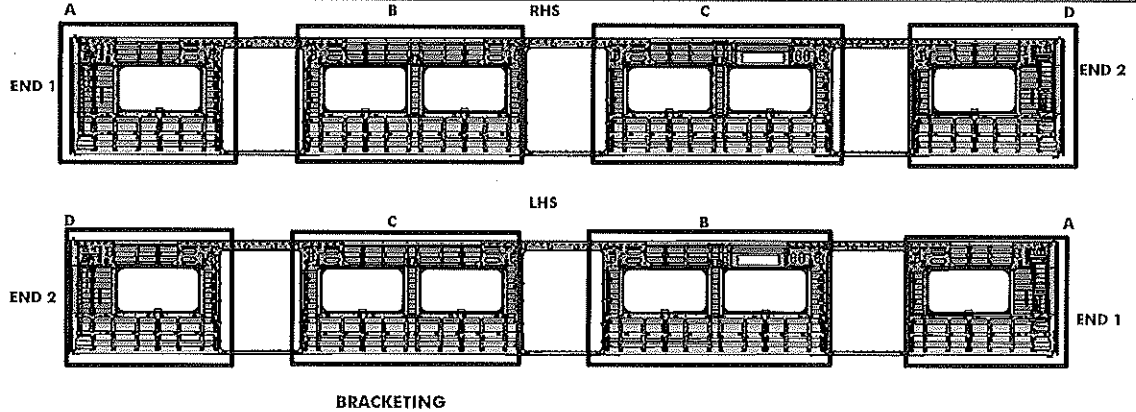


REINFORCEMENT WELDING

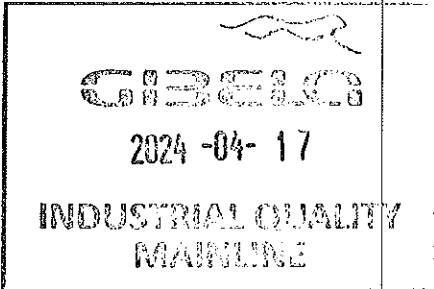
AREA	LHS	RHS
A	Operator (Name&sign): <u>LINDO [Signature]</u>	<u>[Signature]</u>
B	Operator (Name&sign): <u>LINDO [Signature]</u>	<u>[Signature]</u>
C	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>
D	Operator (Name&sign): <u>[Signature]</u>	<u>MIMATSHETIO [Signature]</u>
E	Operator (Name&sign): <u>[Signature]</u>	<u>MIMATSHETIO [Signature]</u>



	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev. 29	Project: PRA5A SI.CB2220.250.V29
		Date 28/10/2023	
		II - Self Inspection - Items to Check	



INSTALLATION		
C-RAILS:	Operator: <u>Mkhize</u>	
	Operator: _____	
DOOR MECHANISMS:	Operator: <u>Asanda</u>	
	Operator: _____	
TAPPING PADS	Operator: <u>LINDO</u>	
	Operator: <u>MKHIZE (END 2)</u>	
INSTALLATION & VERIFICATION		
SEAT & LUGGAGE BRACKETS:	Operator: <u>[Signature]</u>	
	Operator: <u>[Signature]</u>	
SEAT BRACKETS VERIFICATION:	Operator: <u>Frisilla</u>	
	Operator: _____	
WELDING		
AREA	LHS	RHS
A (Seat brackets)	Operator (Name&sign): <u>LINDO</u>	<u>LINDO</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>Nokukhanya</u>	<u>[Signature]</u>
B (Seat brackets)	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>Nokukhanya</u>	<u>[Signature]</u>
C (Seat brackets)	Operator (Name&sign): <u>MKHIZE</u>	<u>Mkhize</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>
D (Seat brackets)	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>
ENDS		
END 1 TAPPING PADS WELDING:	Operator (Name&sign): <u>LINDO</u>	
END 2 TAPPING PADS WELDING:	Operator (Name&sign): <u>MKHIZE</u>	





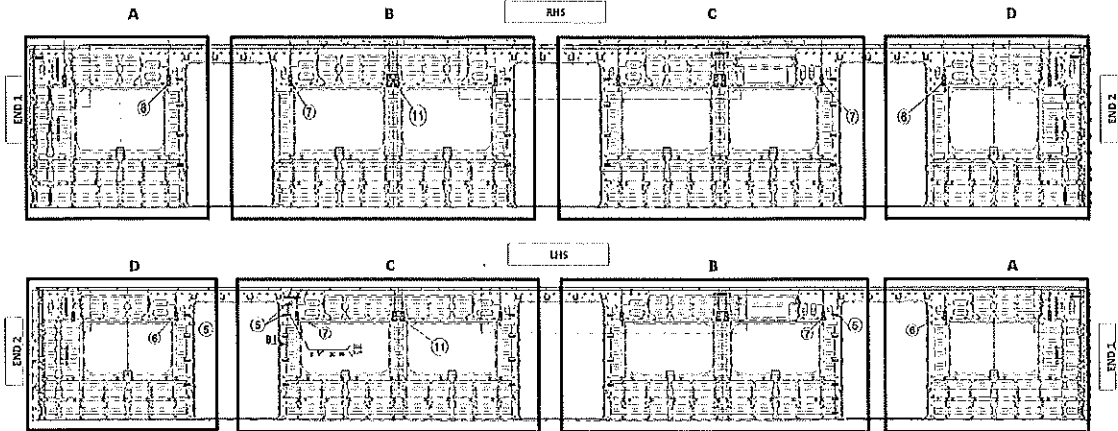
CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30226487/2

Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB2220.250.V29

II - Self Inspection - Items to Check

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

RHS

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

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

VERIFICATION BY: Tetelo

LHS

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

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

VERIFICATION BY: Tetelo

QUANTITIES (M1)

RHS

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

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

VERIFICATION BY: N/A

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: N/A

GIBELO
 2024-04-17
 INDUSTRIAL QUALITY
 MAINLINE

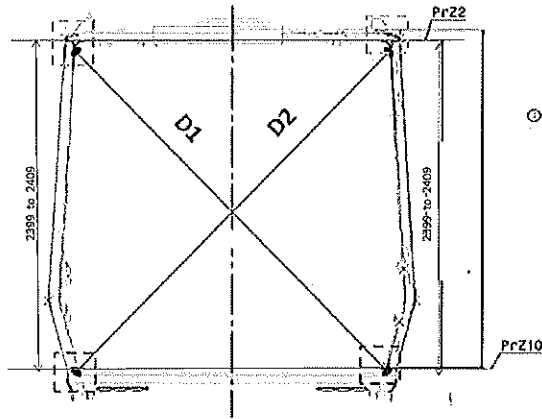


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB2220.250.V29

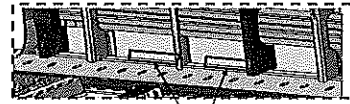
Specifications of Details for CBS measurement



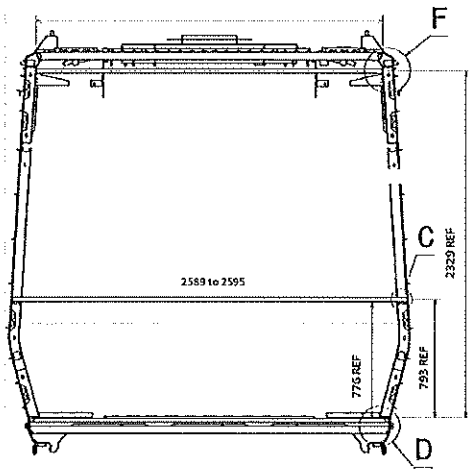
Measurement positions on roof rail and sidewall one ga corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



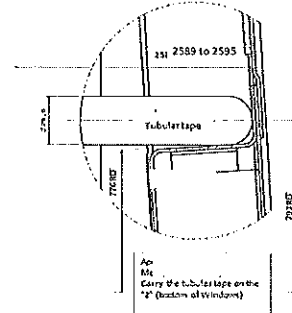
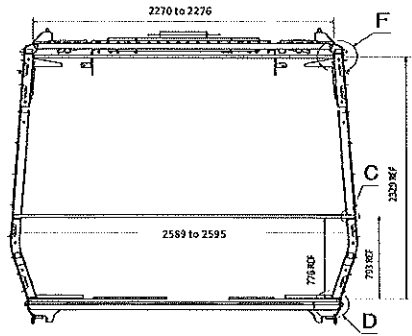


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30226487/2

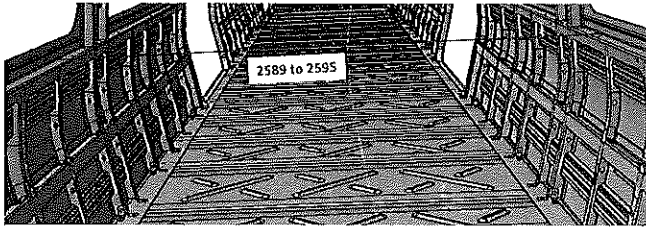
Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB2220.250.V29

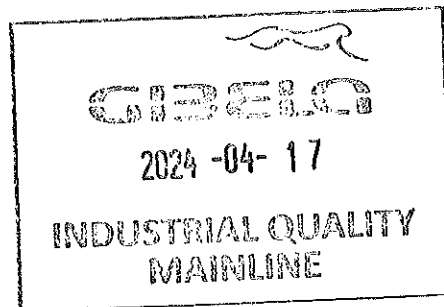
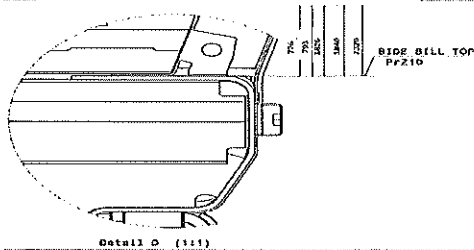
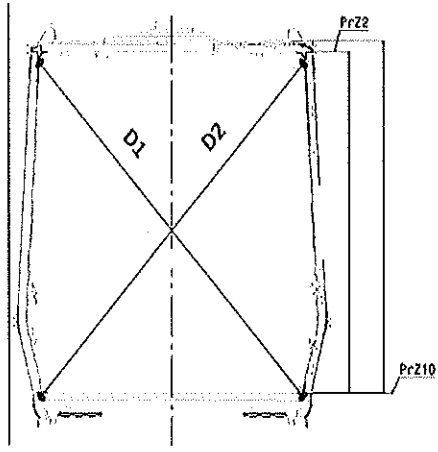
CBS measurement

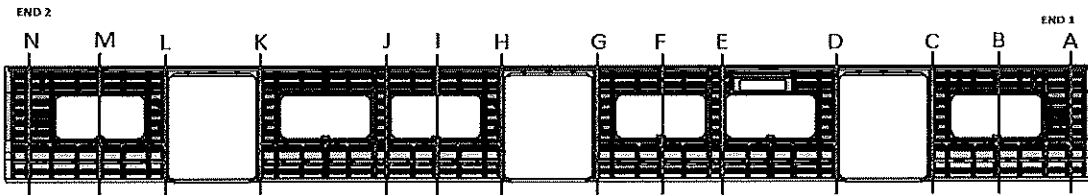


Detail C



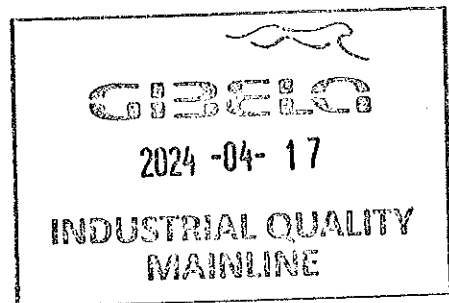
Take measurement close to radius

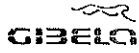




BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595 <i>N/A</i>
A	3300	3299	1	
B	3269	3266	3	
C	3299	3297	2	
D	3300	3300	0	
E	3269	3266	3	
F	3268	3266	2	
G	3300	3298	2	
H	3299	3300	1	
I	3269	3268	1	
J	3269	3268	1	
K	3299	3298	1	
L	3298	3297	1	
M	3268	3266	2	
N	3299	3300	1	



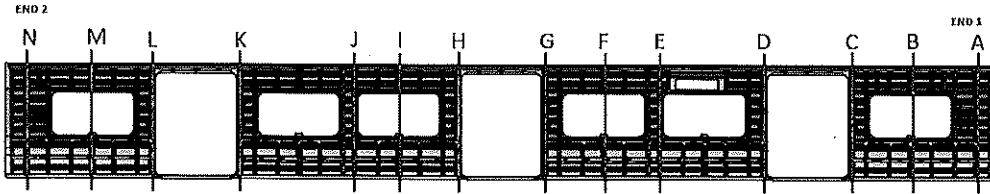


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30226487/2

Rev.
29
Date
28/10/2023

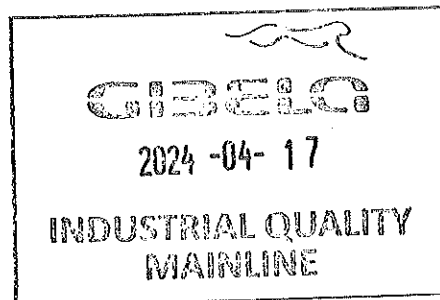
Project: PRASA
SI.CB2220.250.V29

CBS measurement



AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3247	3	2590
B	3268	3366	2	2591
C	3300	3298	2	2592
D	3297	3298	1	2593
E	3268	3266	2	2591
F	3269	3268	1	2592
G	3297	3299	2	2593
H	3298	3296	2	2591
I	3268	3266	2	2592
J	3268	3266	2	2593
K	3299	3297	2	2594
L	3300	3298	2	2591
M	3268	3266	2	2592
N	3298	3299	1	2593

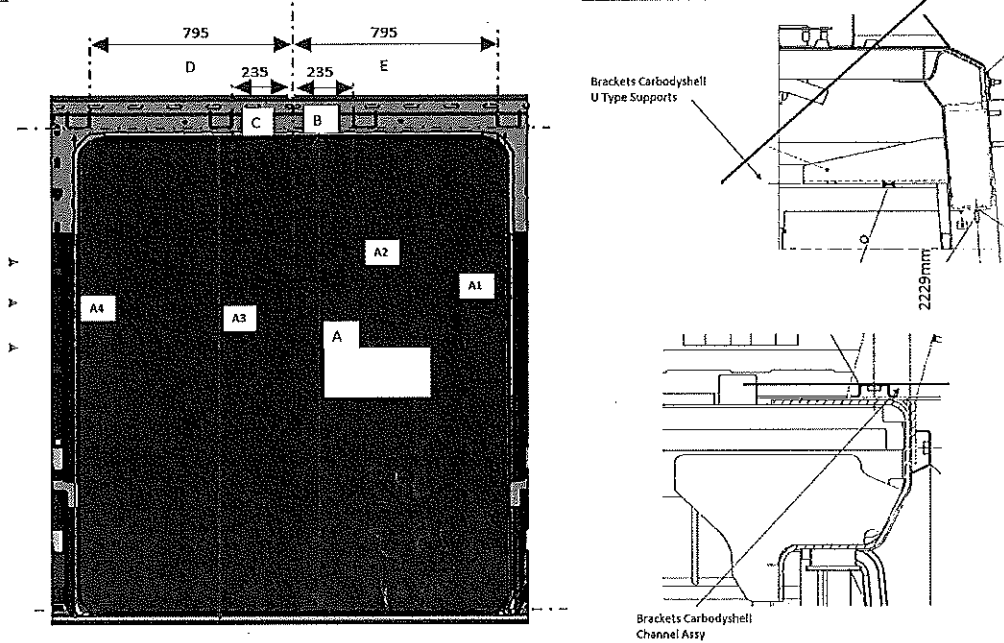




CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

Rev. 29 Project: PRASA
Date 28/10/2023 SI.CB2220.250.V29

Specifications of Details for GBS measurement GB1220



DOOR 1 - 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	234
D	794 to 796	794
E	794 to 796	796

DOOR 2 - LHS

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

DOOR 2 - 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	794
E	794 to 796	795

DOOR 1 - RHS

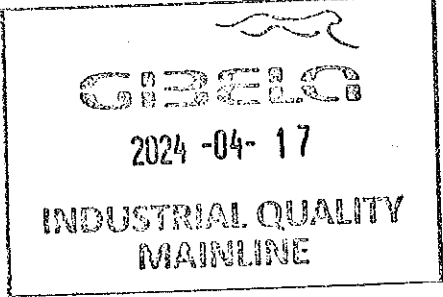
	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2230
A3	2230 to 2232	2232
A4	2230 to 2232	2232
B	234 to 236	235
C	234 to 236	236
D	794 to 796	795
E	794 to 796	796

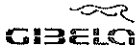
DOOR 2 - RHS

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

DOOR 3 - RHS

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





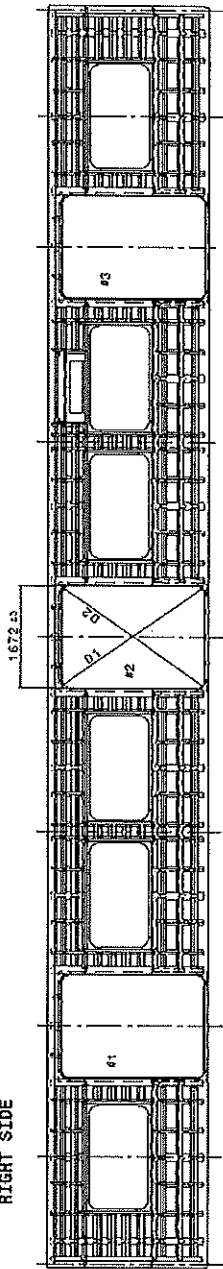
CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30226487/2

Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB2220.250.V29

Specifications of Details for CBS measurement CB1220

End #2



RIGHT SIDE

End #1

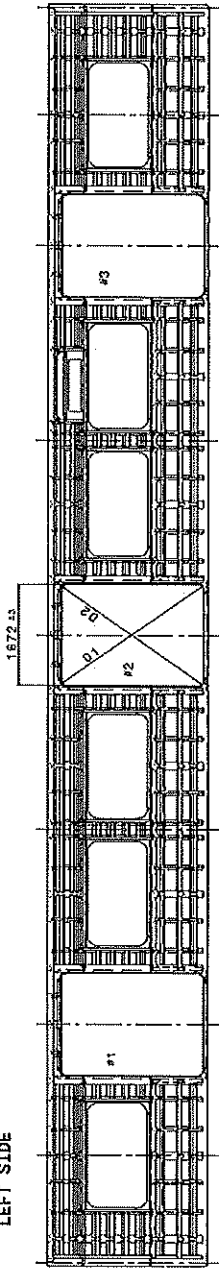
Doors diagonal D1-D2 maximum difference ≤ 4 mm

#1	#2	#3
D1 2756	2749	2751
D2 2751	2752	2749
D1-D2	3	2

Doors length - 1672 ± 3 mm

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

End #1



LEFT SIDE

End #2

Doors diagonal D1-D2 maximum difference ≤ 4 mm

#1	#2	#3
D1 2749	2758	2751
D2 2751	2752	2750
D1-D2	2	1

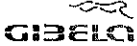
Doors length - 1672 ± 3 mm



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



2024-04-17

INDUSTRIAL QUALITY
MAINLINE

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev. 29	Project: PRASA SI.CB2220.250.V29
		Date 28/10/2023	
		Self Inspection - Final Result	


Is the car good to advance to the next workstation/process? (Approval of Operations Manager and Industrial Quality)			DATE	NAME	SIGNATURE	
HOLD POINT	<input checked="" type="checkbox"/>	GO	(If activities are not complete, the missing activities must not impact the next stage)	19/04/24	Tetelo Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party)	19/04/24	Anno Industrial Quality	
			There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			
			There are non-conformities that impact the quality of the product and there is no corrective action defined yet)			

In case of "NO GO", describe blocking problems

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


Item	Description	Responsible	Due date	Status

Tetelo
Operations

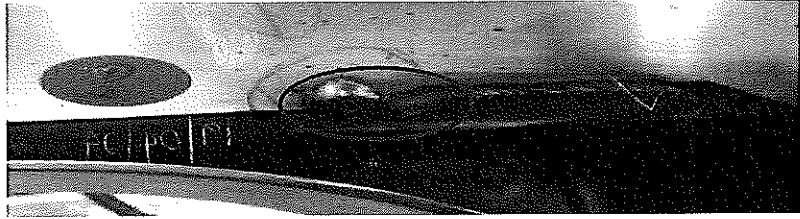



Quality



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

ANNEXURE A: Arc Welding Quality Acceptance Standard




GIBELO
2024 -04- 17
INDUSTRIAL QUALITY
MAINLINE



APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

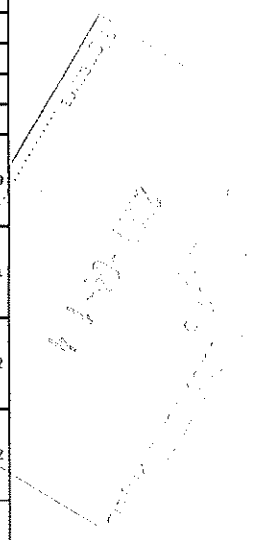
CONFIDENTIAL INFORMATION

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

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?		
				TCA	M4	M1	M2	M3	TCA				
<input type="checkbox"/>	DT00000225487	AAD0001278566	CARBOOYSHELL M1,M3,M4 ASSEMBLY	CB1230		X	X			X		PRA.CB1230.DT000002 25487.V20	YES

Rev	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	2018/08/02	GIBELA NEW CREATION	APPROVER	Philippe Marques	2018/08/02
			CHECKER	Nosizo Pindela	2018/08/02
			COMPILER	Nosizo Pindela	2018/08/02
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	30/5/2018
			CHECKER	Nosizo Pindela	30/5/2018
			REVISED BY	Nosizo Pindela	30/5/2018
2	2018/05/07	Certain dimensional checks moved to CB1220 .	APPROVER	Itumeleng Modiba	2018/05/07
			CHECKER	Nosizo Pindela	2018/05/07
			REVISED BY	Ramokone Motama	2018/05/07
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			REVISED BY	Vanessa Ntuli	24/01/2019
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	23/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	23/08/2019
			CHECKER	Nosizo Pindela	23/08/2019
			REVISED BY	Nosizo Pindela	23/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	20/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbhombhi	14/06/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
27	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	M3	Zanele 482774	22/04/24	SI.CB1230.256.V28	11





CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
29

Project: PRASA

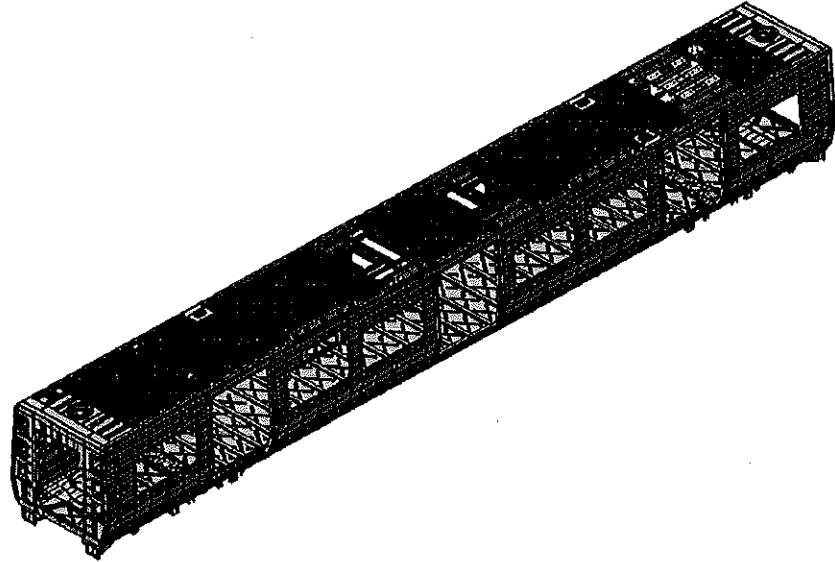
Date

SI.CB1230.256.V28

06/11/2023

Car: _____ NCR: _____

Work station: _____ CB1230



I - Documentation and Instruments Control

1.1 - Documentation Control

Document	Type of car					Revision	Obsevation	OK	NOK	How/ok	Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4	TC2							
PRA.CB1230.DT00000225487						29		X		N/A	AR 22/04/24	EB 22/04/24

1.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
Tubular	22016	2024/07/04	X		AR 22/04/24	EB 22/04/24
Combination square	GIBELQ 0387	2024/10/11	X		AR 22/04/24	EB 22/04/24
Tape measurement	GIBELQ 0394	2024/07/05	X		AR 22/04/24	EB 22/04/24

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308 Lsi	423167	mig	X		AR 22/04/24	EB 22/04/24





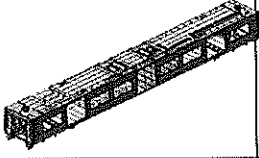
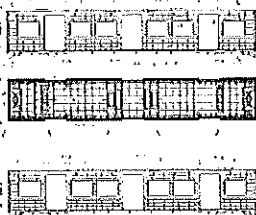
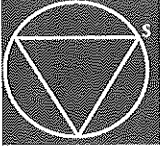
CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

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	NOX	Rework	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	X			[Signature] 22/04/24	[Signature] 22/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	X			[Signature] 22/04/24	[Signature] 22/04/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	X			[Signature] 22/04/24	[Signature] 22/04/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	X			[Signature] 22/04/24	[Signature] 22/04/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	X			[Signature] 22/04/24	[Signature] 22/04/24
06		Perform visual inspection or welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	X			[Signature] 22/04/24	[Signature] 22/04/24
07	N/A	Before appplication 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: 205189 Exp Date: 05/26 Actuals Temperature: 19°C Humidity: 30%	X			[Signature] 22/04/24	[Signature] 22/04/24
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.	X			[Signature] 22/04/24	[Signature] 22/04/24



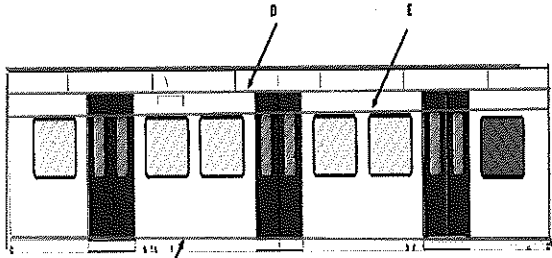
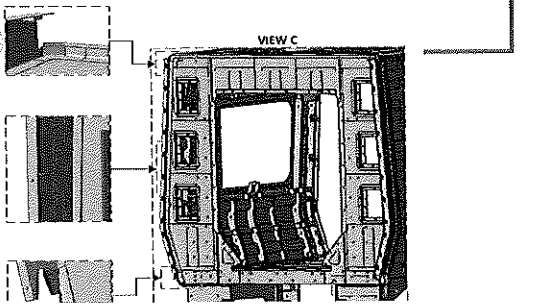
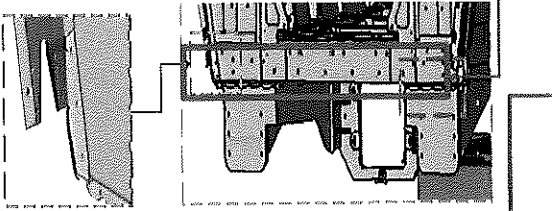


CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
29
Date
06/11/2023

Project: PRASA
SI.CB1230.256.V28

AREA 1



END 2 SEALANT

OPERATOR
(Name & sign):

Levey

OPERATOR
(Name & sign):

Levey

OPERATOR
(Name & sign):

Levey

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

Operator (Name & sign):

LHS
DEFGHI

RHS
DEFGHI

Operator (Name & sign):

Shenolo

Levalo

Operator (Name & sign):

Levey

Levey

Operator (Name & sign):

Operator (Name & sign):

Operator (Name & sign):





CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
29

Project: PRASA

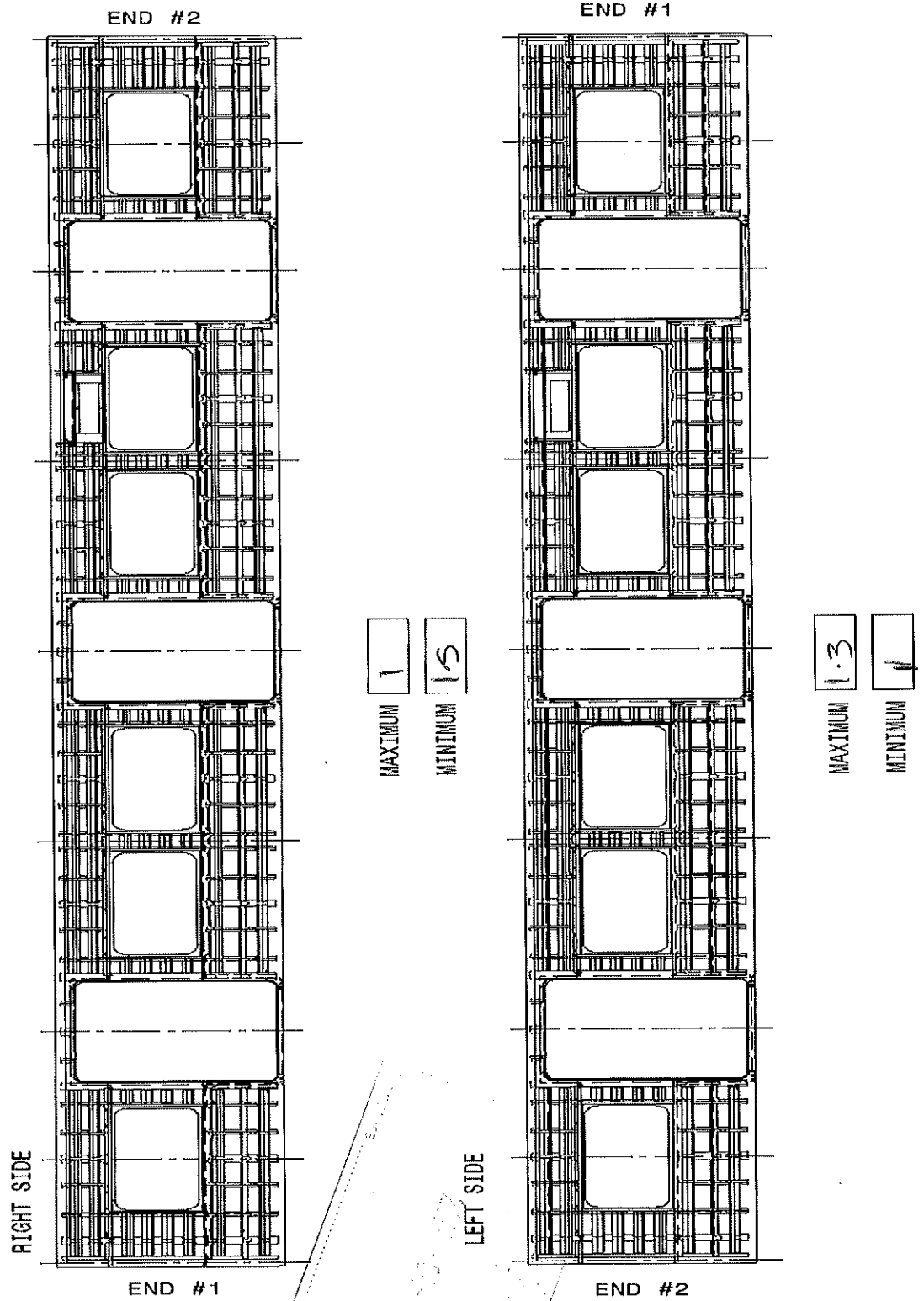
Date

06/11/2023

SI.CB1230.256.V28

Specifications of Details for CBS measurement CB1230

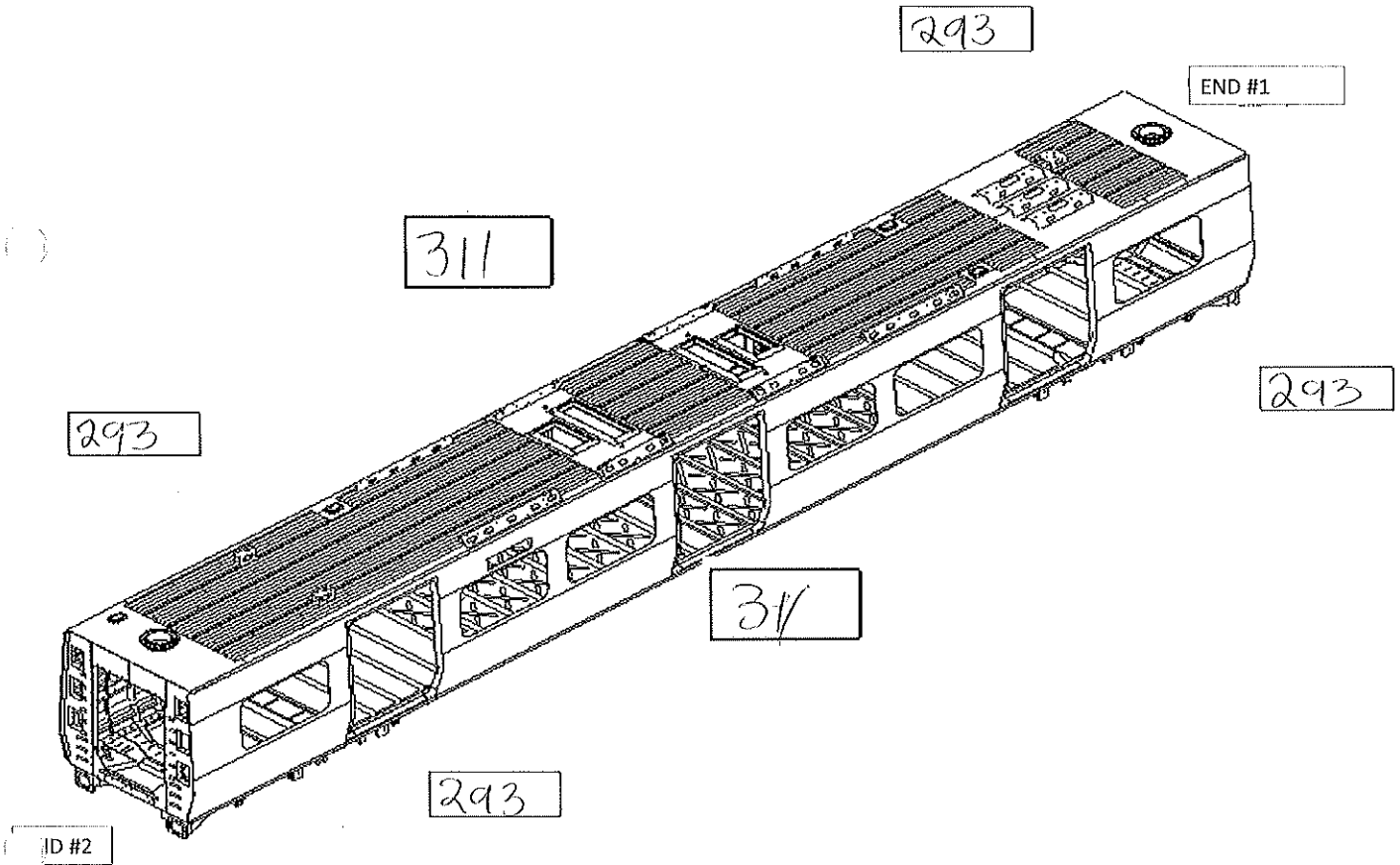
Flatness side left and right maximum of 2mm in the valley to peak measured in 900mm. Recod the maximum and minimum value found and indicate the corresponding region.





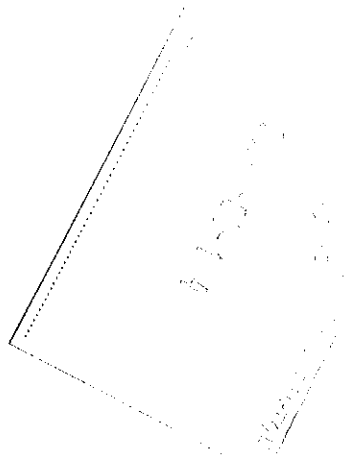
Specifications of Details for CBS measurement CB1230

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



MEASURED CAMBER VALUES

RIGHT	e^1	17
LEFT	$a1$	17







CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
29

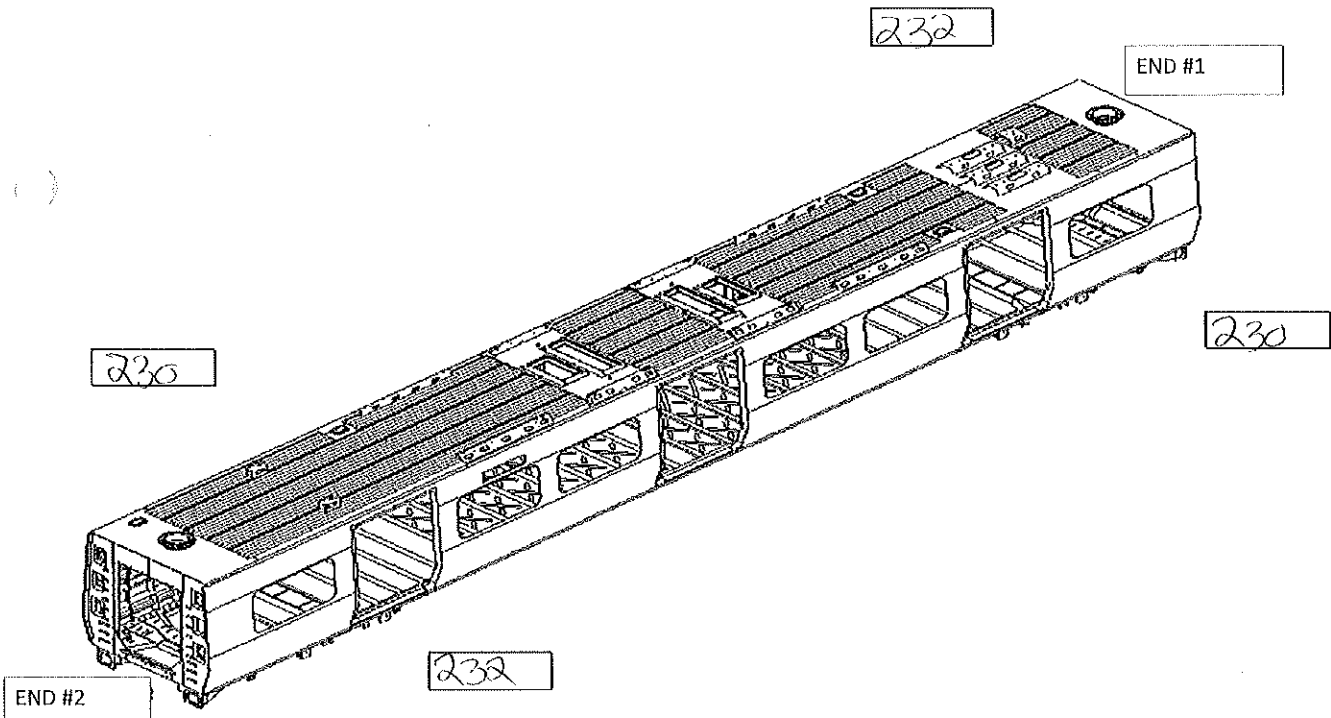
Project: PRASA

Date
06/11/2023

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 following twist measurement document.



TWIST FOUND ON END 1

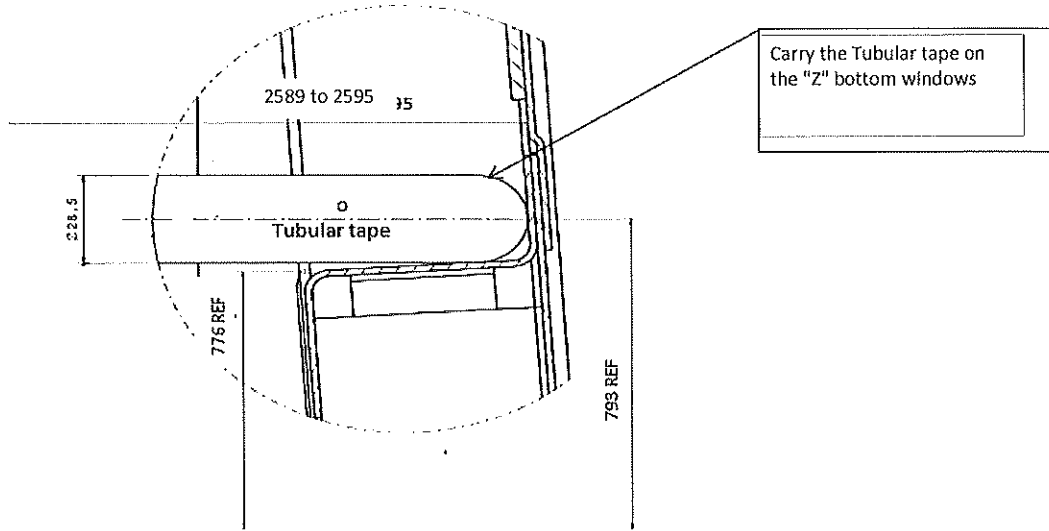
TRANVERS
LONGITUDIN

TWIST FOUND ON END 2

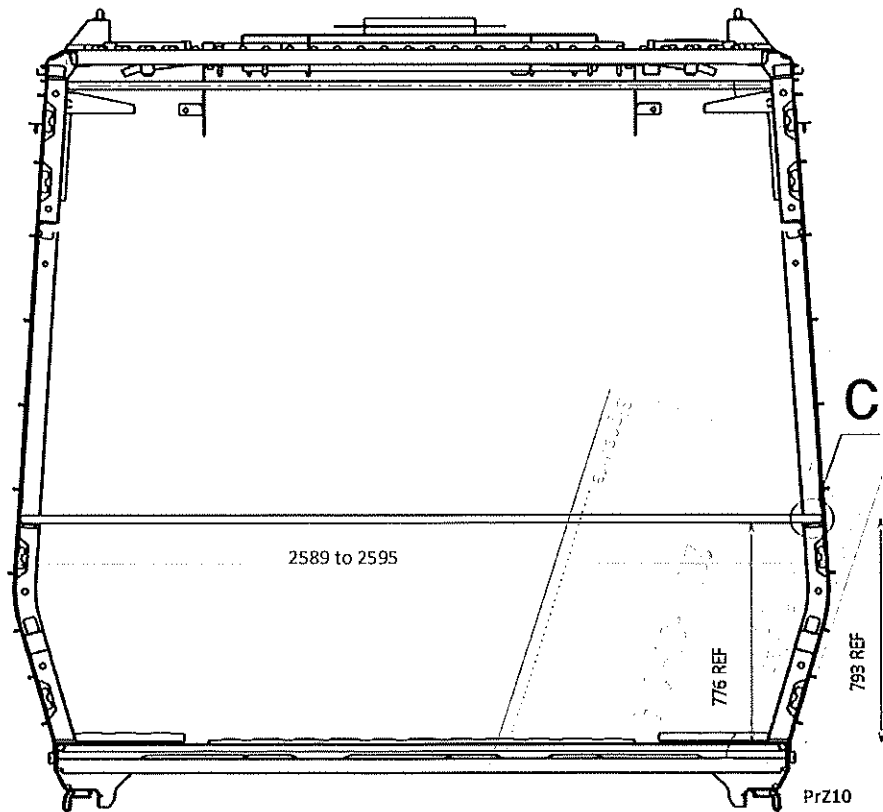
TRANVERSE
LONGITUDINAL



Specifications of Details for CBS measurement CB1230



Detail C







CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
29

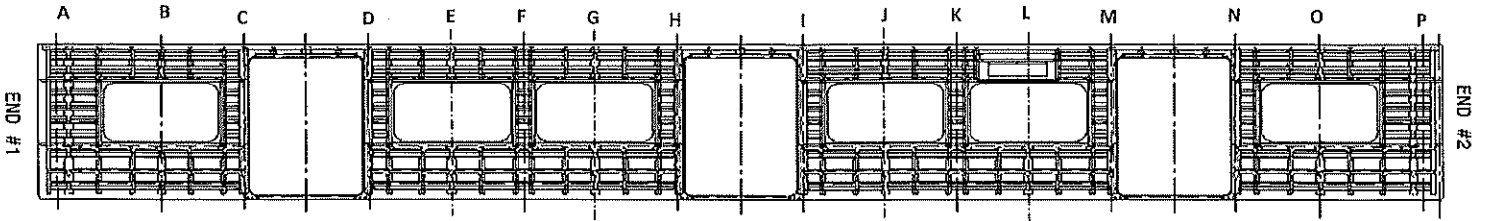
Project: PRASA

Date

06/11/2023

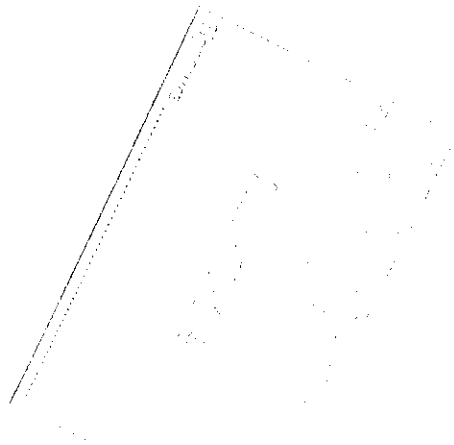
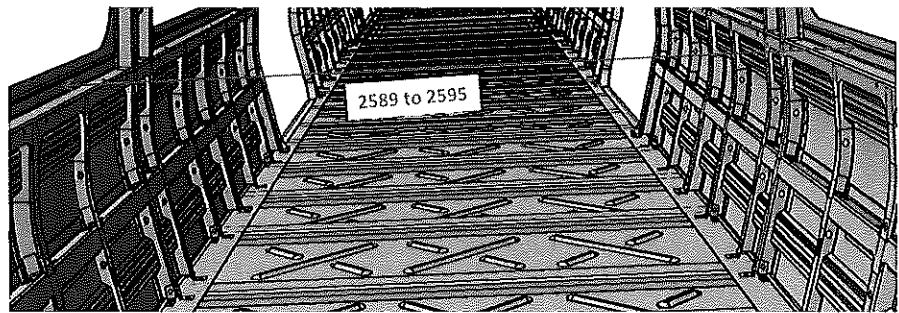
SI.CB1230.256.V28

Specifications of Details for CBS measurement CB1230



2589 to 2595mm

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

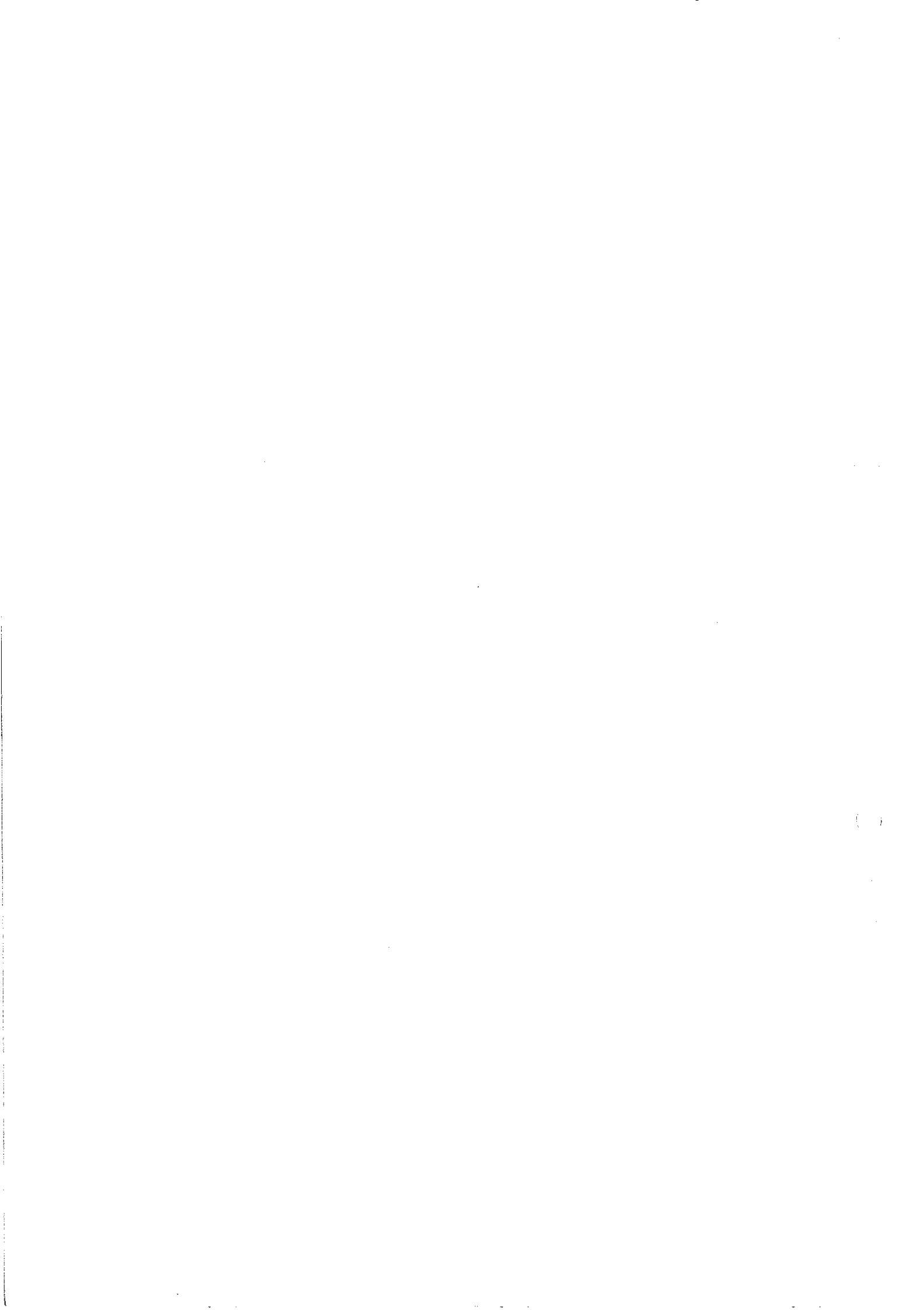


Threshold verification

Nominal value :38

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

BOILER MAKER: mmathapero
Nanhiambha





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 activities are not complete, the missing activities must not impact the next stage)	22/04/24	Zenele Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	22/04/24	Arbani Industrial Quality	
	NO GO	There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)		Operations	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)		Industrial Quality	

In case of "NO GO", describe blocking problems

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

Item	Description	Responsible	Due date	Status

Operations

Quality

