

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 2	
				TCC	M4	M1	M2	M3	TCC2			
DTR3000152645	AAD0001241033	Carshell Assembly TC	CB1210	X						X	PRA.CB1210.DTR3022331 9/3.V25	YES

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	09/04/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	09/04/2018
			CHECKER	Nosizo Pindela	09/04/2018
			COMPILER	Thanyani Mathegu	06/04/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motama	2018/05/18
2	2018/06/18	MODIFICATION CONTENT	APPROVER	Itumeleng Modiba	2018/06/18
			CHECKER	Nosizo Pindela	2018/06/18
			REVISED BY	Ramokone Motama	2018/06/18
3	2018/12/12	Additional checkpoints	APPROVER	Itumeleng Modiba	2018/12/12
			CHECKER	Nosizo Pindela	2018/12/12
			REVISED BY	Ramokone Motama	2018/12/12
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	22/01/2019
			CHECKER	Nosizo Pindela	22/01/2019
			REVISED BY	Vanessa Ntuli	22/01/2019
6	2019/11/03	Record D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	2019/11/03
			CHECKER	Nosizo Pindela	2019/11/03
			REVISED BY	Nosizo Pindela	2019/11/03
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	21/08/2019
			CHECKER	Nosizo Pindela	21/08/2019
			REVISED BY	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	06/08/2020
20	19/04/2020	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	21/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi Collins	21/02/2022
			CHECKER	Andani Muthelo	21/02/2022
			REVISED BY	Andani Muthelo	21/02/2022
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
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023
			CHECKER	Mathapo Kelebone	27/07/2023
			REVISED BY	Mohlampe Amogelang	27/07/2023
28	07/11/2023	Addition of welding traceability	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Andani Muthelo	07/11/2023
			REVISED BY	Ntokoze Zwane	07/11/2023

QUALITY

TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
T5237	Tc1	P. MALA TJ	02/09/24	SI.CB1210.322.V28	16

401964



DTR30223319/3 Carshell Assembly TC

Rev. V28  
Date- 07/11/2023

Project: PRASA  
SI.CB1210.322.V28

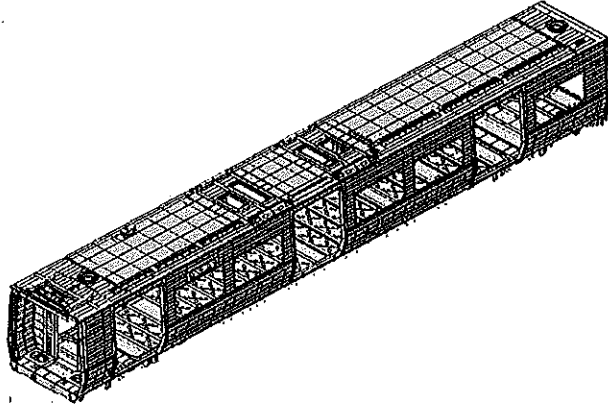
Car: TC1 & TC2

NCR:

Work station: CB1210



Safety Related



### I - Documentation and Instruments

#### I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	D	E	S	Q	M	U					
DTR30223319/3	X						28		X	N/A	<i>[Signature]</i> 02/07/24

#### I.2 - Instruments Control

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


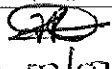


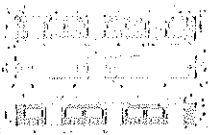

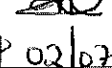




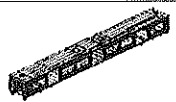

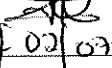
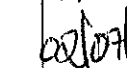
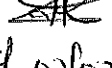
Instruments	Validation	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
LUBILAP	32803-D	15/08/25	✓	<i>[Signature]</i>	<i>[Signature]</i>
CAREP IAPG	125425924	08/01/25	✓	<i>[Signature]</i>	<i>[Signature]</i>
SDM IAPG	618770102	18/11/24	✓	<i>[Signature]</i>	<i>[Signature]</i> 02/07/24

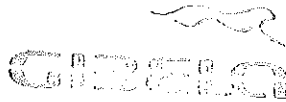
#### I.3 Consumables

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

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSI	314018-70097	MIG	✓	<i>[Signature]</i>	<i>[Signature]</i>
ER 308 L	297687-70308	MIG	✓	<i>[Signature]</i>	<i>[Signature]</i>
 2024-07-01 INDUSTRIAL QUALITY MULTIPLE					


INDUSTRIAL QUALITY  
MULTIPLE

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)	DT00000284980	✓		 02/07/24	 02/07/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓		 02/07/24	 02/07/24
03		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		 02/07/24	 02/07/24
04	REFER TO ANNEXURE A	Spot Welding inspected and approved according procedure	IND-SAL-WMS-016 e DTD0000210675	✓		 02/07/24	 02/07/24
05	REFER TO ANNEXURE B	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 02/07/24	 02/07/24
06		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 02/07/24	 02/07/24
07	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658	✓		 02/07/24	 02/07/24



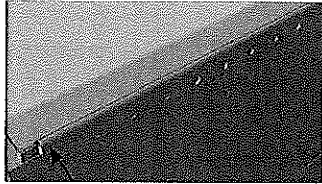
**2024 -07- 01**

**INDUSTRIAL QUALITY**  
**MANAGEMENT**

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

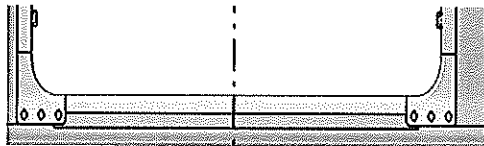
**Welder traceability**

Roof ring welds



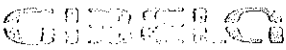
<p style="text-align: center;"><u>LHS</u></p> Boiler maker (Name & Sign): <u>Tim Rieder</u>	Welder (Name & Sign): <u>BOBBY BAKER</u>
<p style="text-align: center;"><u>RHS</u></p> Boiler maker (Name & Sign): <u>WING</u>	Welder (Name & Sign): <u>KEITH K. BAKER</u>


Door ring welds



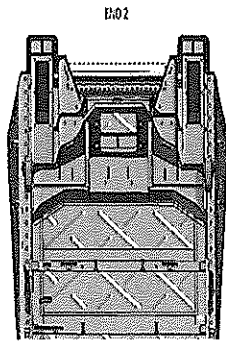
<u>LHS</u>
Boiler maker (Name & Sign): <u>Tim Rieder</u>
Welder (Name & Sign): <u>MITHOKOZISI</u>

<u>RHS</u>
Boiler maker (Name & Sign): <u>Tim Rieder</u>
Welder (Name & Sign): <u>MITHOKOZISI</u>

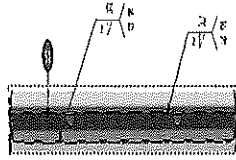
  
2024 -07- 01  
INDUSTRIAL QUALITY  
WELDING

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

EUF Reinforcement Plates



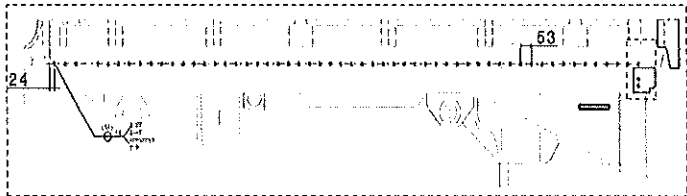
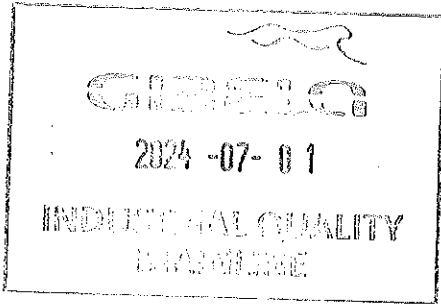
Underneath the CAR



END 2

Boiler maker (Name & Sign): Tebogo Khatube

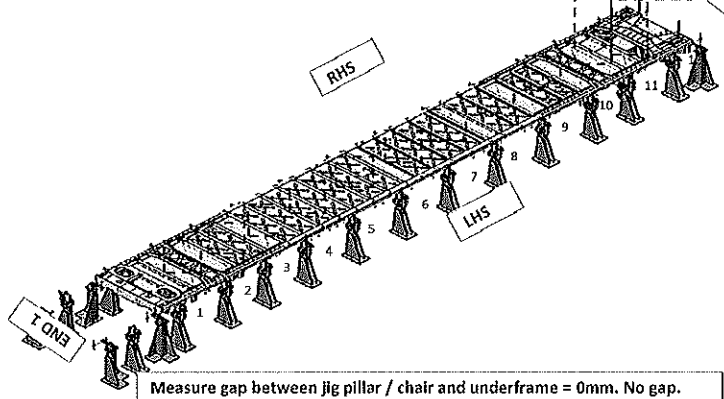
Welder (Name & Sign): Thabang Khatube



FEDOLI

Operator: Lungu

**Specifications of Details for CBS measurement**

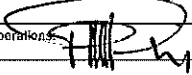


Measure gap between jig pillar / chair and underframe = 0mm. No gap.

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


After Loading Underframe and Clamping.

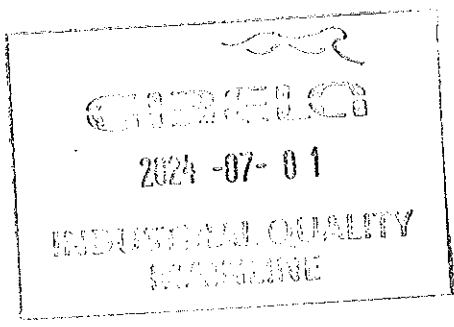
	1	2	3	4	5	6	7	8	9	10	11	12
Left Hand Side	0	0	0	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	0	0	0	0	0	0	0	0	0

Signature Operations:  Date: 02/07/2024

After Welding.

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

Signature Industrial Quality:  Date: 02/07/2024



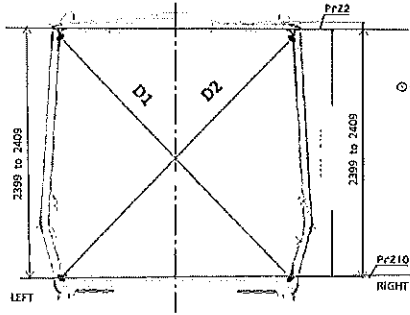
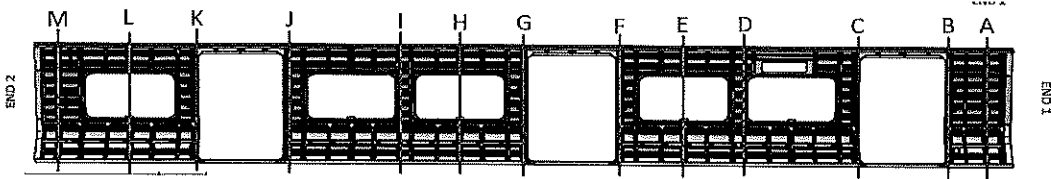


DTR30223319/3 Carshell Assembly TC

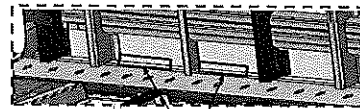
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SI.CB1210.322.V28

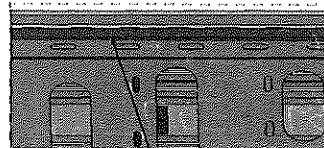
Specifications of Details for CBS measurement



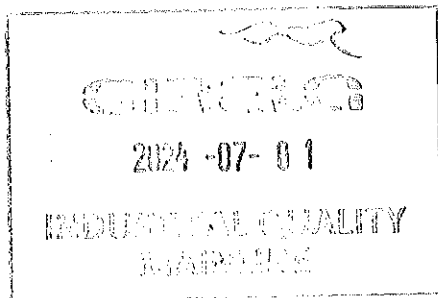
Measurement positions on roof rail and sidewall omega corner.

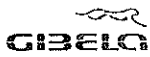


Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.





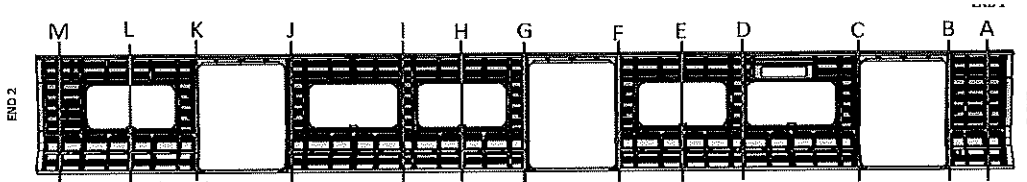
DTR30223319/3 Carshell Assembly TC

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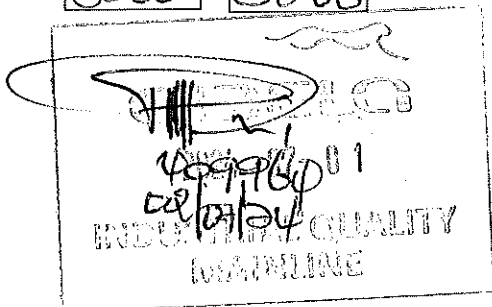
Specifications of Details for GBS measurement

BEFORE WELDING



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

	Record D1 values	Record D2 values	D1-D2 $\leq 5$ mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS $\leq 2$
A	3069	3068	1	2404	2404	0
B	3091	3071	0	2406	2405	1
C	3066	3068	2	2405	2404	1
D	3069	3070	1	2404	2404	0
E	3068	3068	0	2404	2406	2
F	3066	3068	2	2405	2406	1
G	3069	3069	0	2406	2404	2
H	3069	3071	2	2404	2405	1
I	3068	3070	2	2405	2405	0
J	3068	3068	0	2404	2406	2
K	3069	3068	1	2405	2404	1
L	3068	3066	2	2406	2404	2
M	3066	3066	0	2405	2404	1





DTR30223319/3 Carshell Assembly TC

Rev. V28

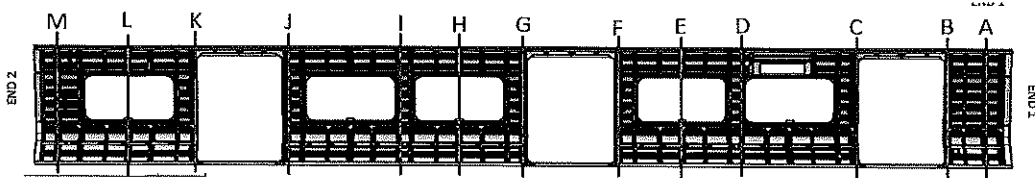
Project: PRASA

Date- 07/11/2023

SI.CB1210.322.V28

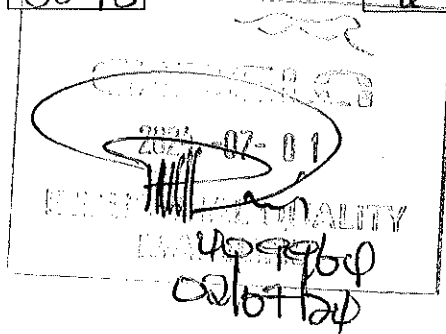
Specifications of Details for CBS measurement

AFTER WELDING



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

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3269	3269	0	2404	2405	1
B	3296	3298	2	2404	2406	2
C	3299	3297	2	2405	2404	1
D	3270	3271	1	2405	2406	1
E	3269	3268	1	2404	2404	0
F	3296	3298	2	2404	2405	1
G	3298	3298	0	2404	2406	2
H	3270	3271	1	2404	2404	0
I	3269	3268	1	2406	2404	2
J	3297	3296	1	2405	2404	1
K	3299	3298	1	2406	2406	0
L	3270	3270	0	2404	2405	1
M	3296	3298	2	2404	2404	0





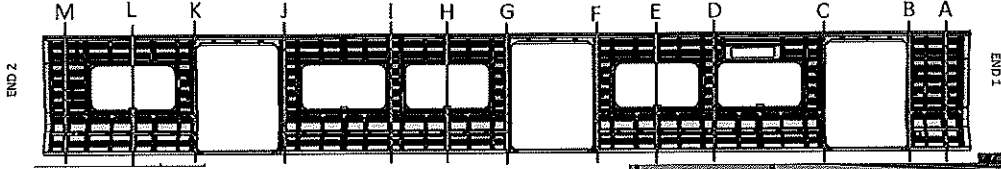
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CBS measurement

BEFORE WELDING



2270 to 2276

2268 a 2274

A 2274

B 2275

C 2278

D 2276

E 2275

F 2276

G 2274

H 2273

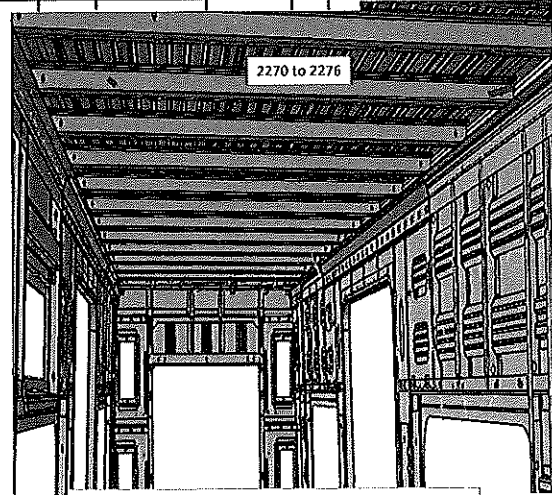
I 2276

J 2275

K 2274

L 2275

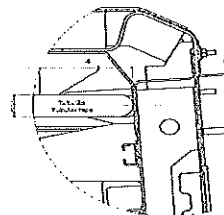
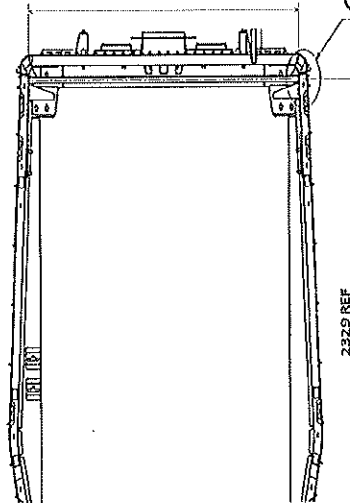
M 2274



2270 to 2276

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

2265 to 2271



Detail G  
Consider reinforcement

2265 to 2271

GIBEL  
2024-07-01  
INDUSTRIAL QUALITY  
409964  
02/07/24



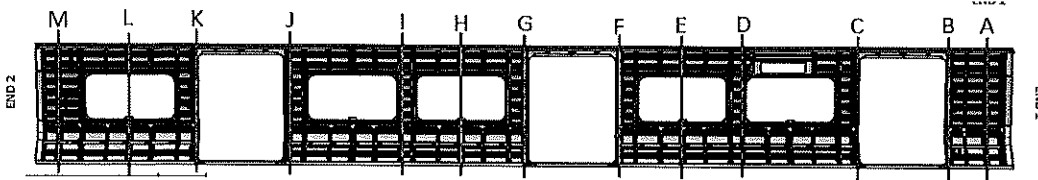
DTR30223319/3 Carshell Assembly TC

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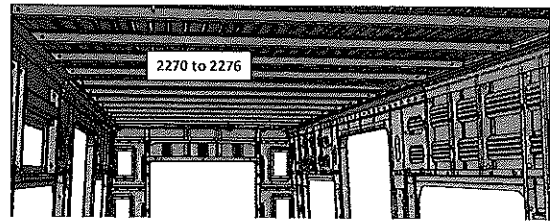
Project: PRASA  
SI.CB1210.322.V28

Specifications of Details for GBS measurement

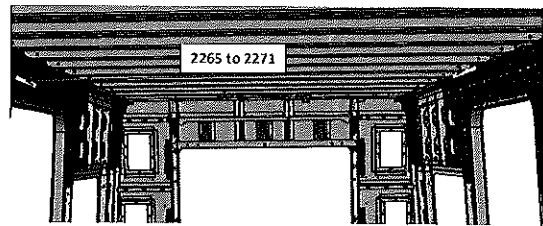
AFTER WELDING



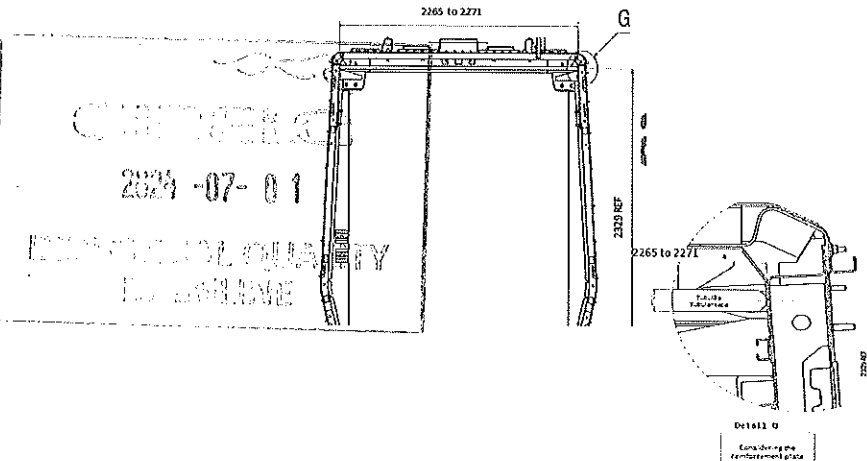
	2265 to 2271	2270 to 2276
A		2274
B	2269	
C	2267	
D		2276
E		2275
F	2266	
G	2268	
H		2275
I		2276
J	2269	
K	2266	
L		2275
M	2268	



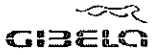
Do not consider reinforcement ( Take measurements top area of zee profile



Take measurement close to radius ( considering reinforcement)



*Handwritten signature and number 409969*



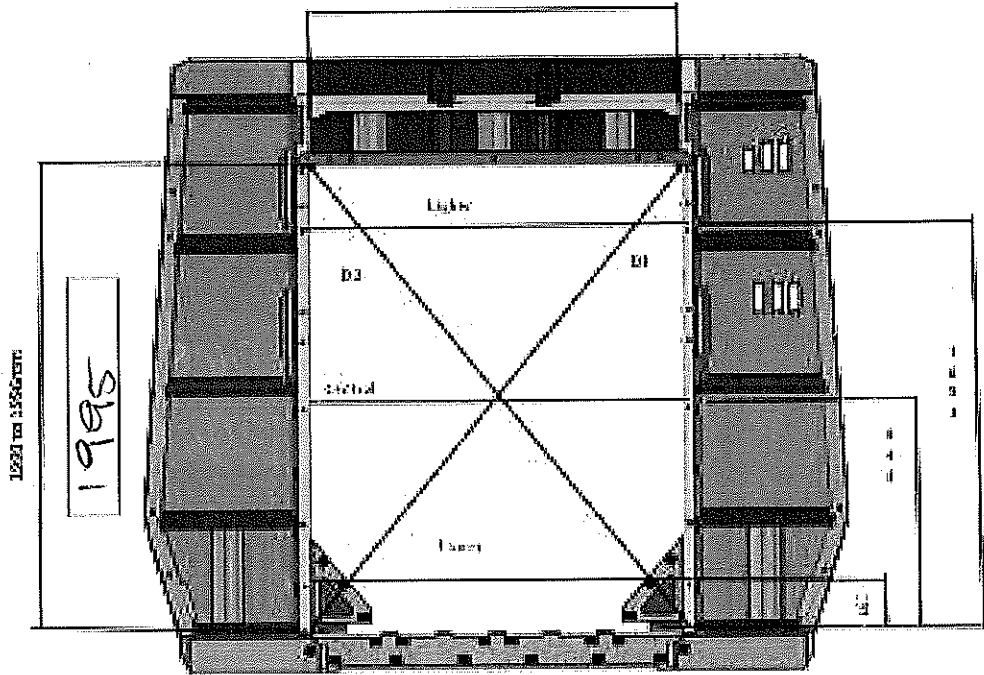
DTR30223319/3 Carshell Assembly TC

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Specifications of Details for CBS measurement

Endframe 2



Upper Diameter

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Upper Diameter

1381

D1

2416

Central Diameter

1380

D2

2415

Lower Diameter

1381

D1-D2

1



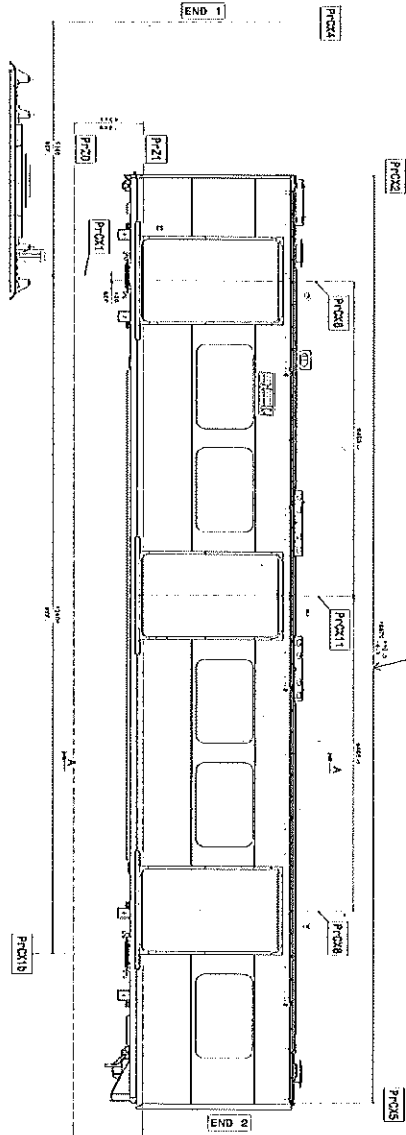


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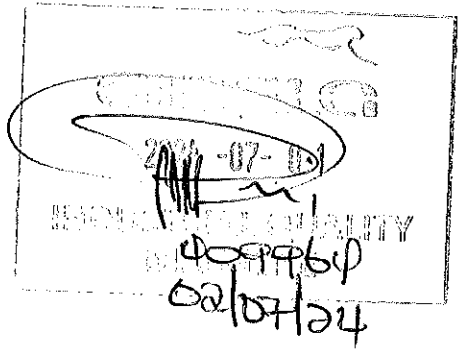
Specifications of Details for CBS measurement



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	18870 $\begin{matrix} +10.5 \\ -4.5 \end{matrix}$	18870

RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	18870 $\begin{matrix} +10.5 \\ -4.5 \end{matrix}$	18870

1A



Dye penetrant test

Dye-penetration test to be performed by quality personnel

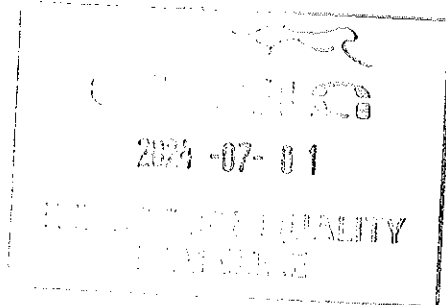





	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA			
		Date- 07/11/2023	SI.CB1210.322.V28			
<b>Self Inspection - Final Result</b>						
<b>Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)</b>		DATE	NAME	SIGNATURE		
<b>HOLD POINT</b>	<b>GO</b>	If activities are not complete, the missing activities must not impact the next stage!	02/07/24	Ponriko		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	02/07/24	Amogekong		
	<b>NO GO</b>	There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)				
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)				
In case of "NO GO", describe blocking problems						
In case of "NO GO", the operations manager must define below action plan to ensure "GO":						
Item	Description	Action	Responsible	Due date	Status	

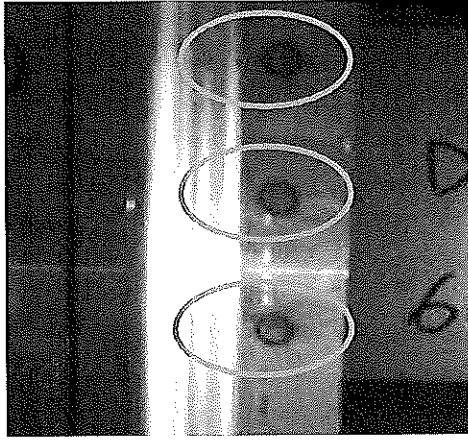
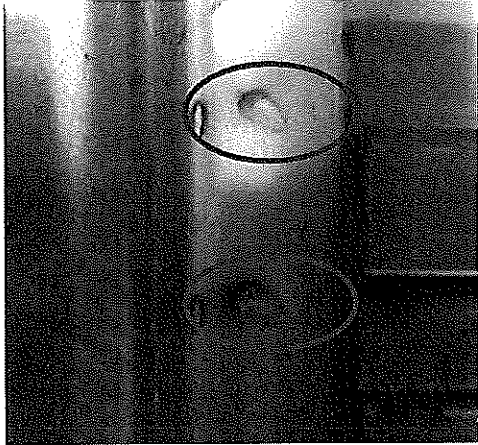
Operations

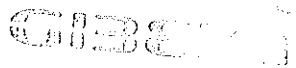
Quality

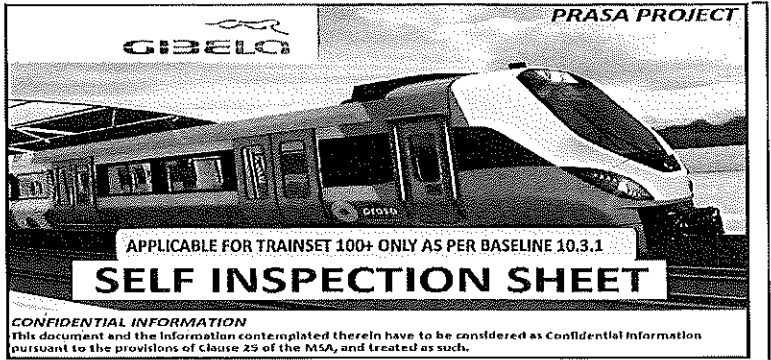


	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

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



  
2024-07-01  
INDUSTRIAL QUALITY  
MAINLINE



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

APPLICATION REFERENCE												
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY	
				TC	MA	MA	MA	MA	TE			
DIR100152064	ADD0001241031	Carpet Assembly TC	CB1210	X						X	PRA.CB1220.DTR3022 3319/2.V20	YES

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	09/04/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	09/04/2018
			CHECKER	Nosizo Pindela	09/04/2018
			COMPILER	Thanyani Mathhegu	06/04/2018
1	23/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	23/05/2018
			CHECKER	Nosizo Pindela	23/05/2018
			REVISOR BY	Ramokone Motama	23/05/2018
2	05/07/2018	Certain dimensional checks added and others moved to CB1210 and CB1230	APPROVER	Itumeleng Modiba	05/07/2018
			CHECKER	Nosizo Pindela	05/07/2018
			COMPILER	Ramokone Motama	05/07/2018
3	2018/06/12	Certain dimensional checks added and others moved to CB1210 and CB1230	APPROVER	Itumeleng Modiba	2018/06/12
			CHECKER	Nosizo Pindela	2018/06/12
			COMPILER	Ramokone Motama	2018/06/12
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			COMPILER	Vanessa Ntuli	24/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements Remove	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			COMPILER	Nosizo Pindela	13/03/2019
7	20/05/2019	Removed roof width	APPROVER	Itumeleng Modiba	20/05/2019
			CHECKER	Nosizo Pindela	20/05/2019
			REVISOR BY	Nosizo Pindela	20/05/2019
10	22/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	22/08/2019
			CHECKER	Nosizo Pindela	22/08/2019
			REVISOR BY	Nosizo Pindela	22/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Borgane Masina	
			REVISOR BY	Borgane Masina	
20	19/04/2021	New Baseline 10.2.6	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Borgane Masina	
			REVISOR BY	Borgane Masina	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mshombi Collins	17/08/2021
			CHECKER	Mulaudi Mpho	
			REVISOR BY	Mulaudi Mpho	
25	20/02/2022	New Baseline 10.2.6	APPROVER	Mshombi Collins	20/02/2022
			CHECKER	Andani Muthela	
			REVISOR BY	Andani Muthela	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Mshombi Collins	14/06/2022
			CHECKER	Andani Muthela	
			REVISOR BY	Andani Muthela	
27	17/10/2022	Addition of traceability for sealant application and welding.	APPROVER	Mshombi Collins	17/10/2022
			CHECKER	Itokoza Zwane	
			REVISOR BY	Amogelang Mhlanga	
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Itokoza Zwane	
			REVISOR BY	Amogelang Mhlanga	
29	28/10/2023	Addition of bracket quantity	APPROVER	Ngebani Tyson	28/10/2023
			CHECKER	Mathapo Kefehone	
			REVISOR BY	Amogelang Mhlanga	

TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
237	TC1	THULANI	05/10/24	SI.CB1220.323.V29	17



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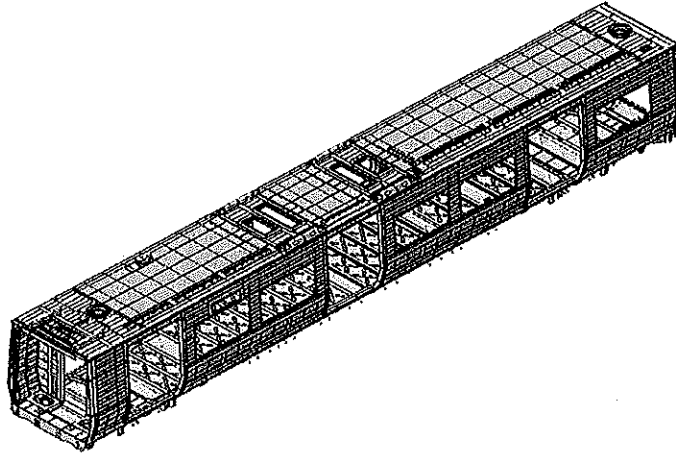
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SI.CB1220.323.V29

Carro Car: TC1, TC2

NCR:

Work station: CB1220



### I - Documentation and Instruments

#### I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	TC1	TC2	TC3	TC4	TC5	TC6					
DTR30223319/2	X						29	28/10/2023	✓	N/A	<i>[Signature]</i>

#### I.2 - Instruments Control

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

Instruments	Validation	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
TURULAR	32823-2	15/03/2024 - 15/03/2025	✓	<i>[Signature]</i>	<i>[Signature]</i>
TAPE MEASURE	GIBTA002	2024/04/17 - 2025/04/17	✓	<i>[Signature]</i>	<i>[Signature]</i>

#### 1.3 Consumables

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

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308 1MM	343779	MIG	✓	<i>[Signature]</i>	<i>[Signature]</i>



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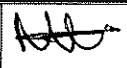
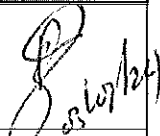
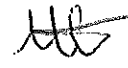
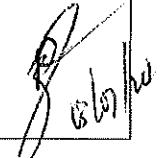
Date- 28/10/2023

SI.CB1220.323.V29

**II - Control Activities of Production**

**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.	DTR30223319/2	✓		03/07/24 	 03/07/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓		03/07/24 	 03/07/24
03	REFER TO ANNEXURE A	Spot Welding inspected and approved according procedure	IND-SAL-WMS-016 e DTD0000210675	✓		03/07/24 	 03/07/24
04	REFER TO ANNEXURE B	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		03/07/24 	 03/07/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		03/07/24 	 03/07/24
06	N/A	Functionals dimensions approved according drawing or complementary document approved by Aistom engineering and registered in this document.	Approved according specified on pages below.	✓		03/07/24 	 03/07/24
07		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	✓		03/07/24 	 03/07/24
08	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% - 60%	Sealant Batch No: <u>LSR 7003</u> Exp Date: <u>1/02/29</u> Actuals Temperature: <u>23</u> Humidity: <u>25</u>	✓		<del>Signature</del> 03/07/24	 03/07/24

		DTR30223319/2 Carshell Assembly TC		Rev.	Project: PRASA			
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				28/10/2023				
09	NA	Verification of sealant application in certain regions in the drawing.	AAD0001241033	✓			 03/10/24	 03/10/24
10	NA	Verification of sealant application on the roof and sidewall finishers	Sealant must be: -Applied straight and even (1.5mm) -Free of gaps, cracks, damage and debris (flashes, dirt, dust)  Refer to Annexure B	✓			03/10/24 	 03/10/24



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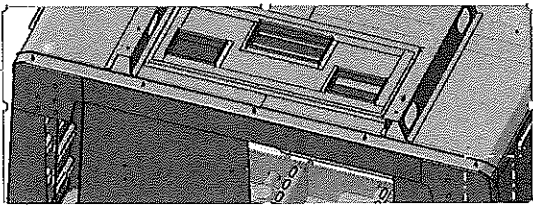
END 1  
SEALANT


OPERATOR  
(Name & sign):

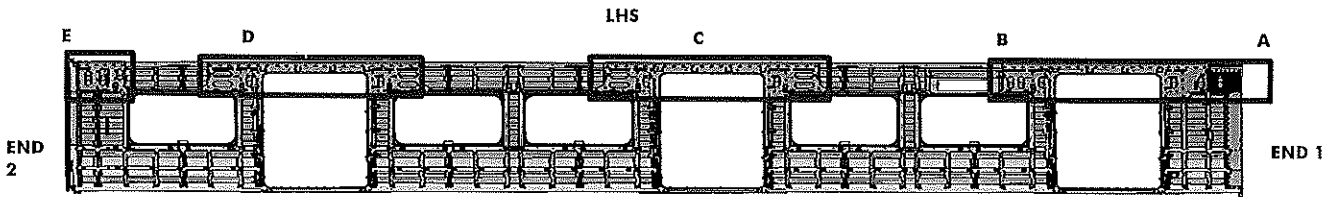
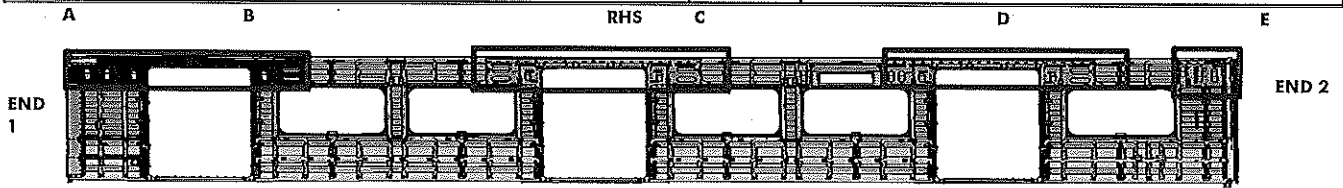
Mthokozisi *[Signature]*

OPERATOR  
(Name & sign):

Mthokozisi *[Signature]*

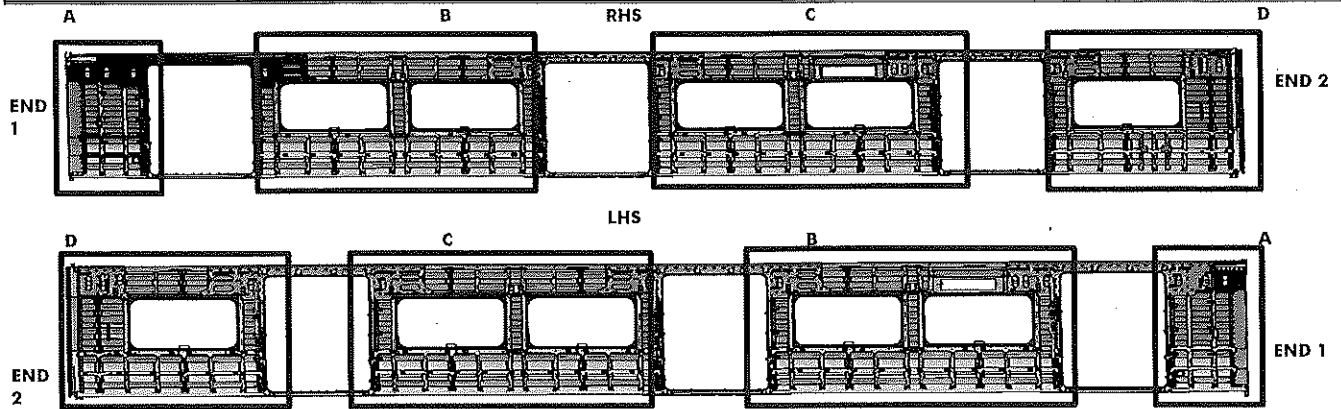


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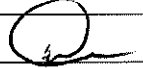

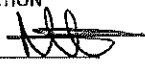
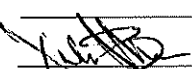
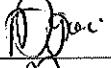
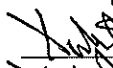
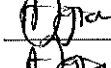



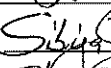
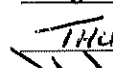




**REINFORCEMENT WELDING**

AREA	LHS	RHS
A	Operator (Name&sign): <u><i>M. Mendes</i></u>	<u><i>M. Mendes</i></u>
B	Operator (Name&sign): <u>LINDO <i>(signature)</i></u>	<u>LINDO <i>(signature)</i></u>
C	Operator (Name&sign): <u><i>(signature)</i></u>	<u><i>(signature)</i></u>
D	Operator (Name&sign): <u><i>(signature)</i></u>	<u>Minaresillo <i>(signature)</i></u>
E	Operator (Name&sign): <u><i>(signature)</i></u>	<u>Minaresillo <i>(signature)</i></u>



**BRACKETING**

		<b>INSTALLATION</b>	
C-RAILS:	Operator:	LENI	
	Operator:	THULANI	
DOOR MECHANISMS:	Operator:	THULANI	
	Operator:		
TAPPING PADS	Operator:	Dejan	
	Operator:	Dejan	
		<b>INSTALLATION &amp; VERIFICATION</b>	
SEAT & LUGGAGE BRACKETS:	Operator:	Mthokozisi	
	Operator:		
SEAT BRACKETS VERIFICATION:	Operator:		
	Operator:		
		<b>WELDING</b>	
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):	Sibusiso	THULANI
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	Sibusiso	
D (Seat brackets)	: Operator (Name&sign):	Sibusiso	THULANI
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	Sibusiso	THULANI

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		28/10/2023	

ENDS

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

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

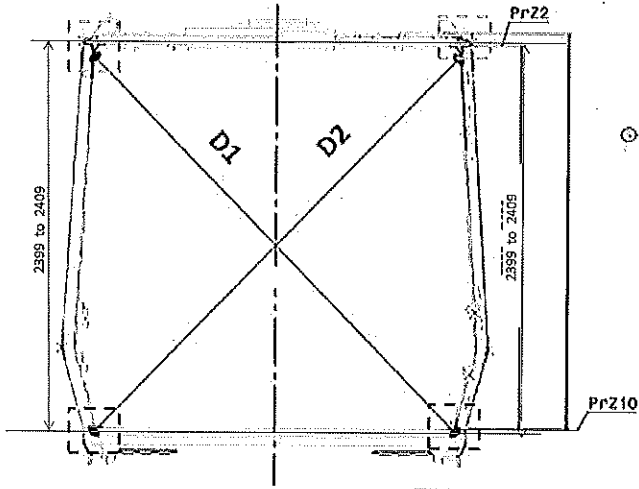




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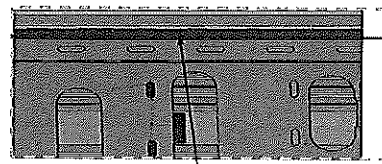
Project: PRASA  
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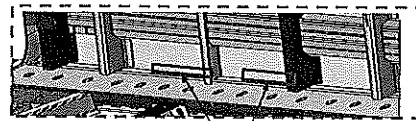
Take measurement close to radius



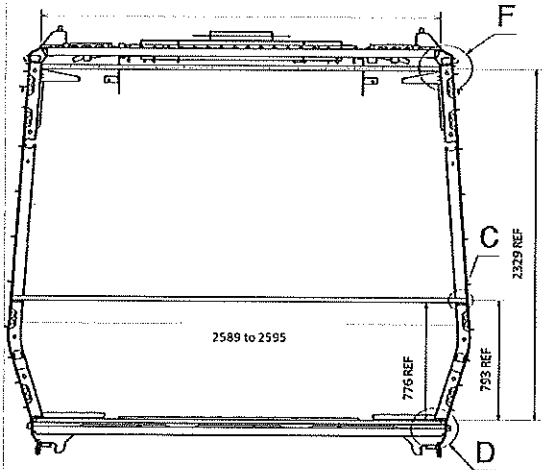
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



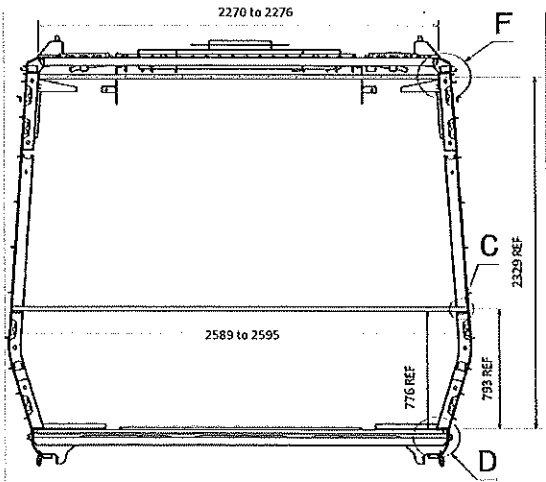
Take measurement close to radius



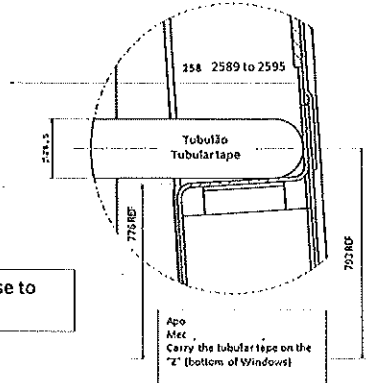
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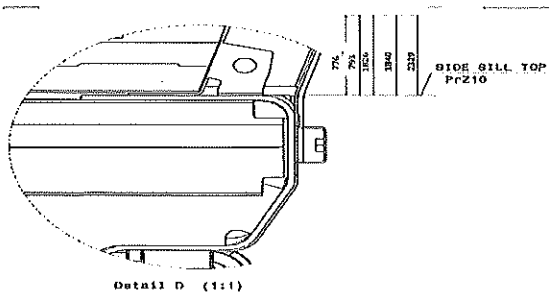
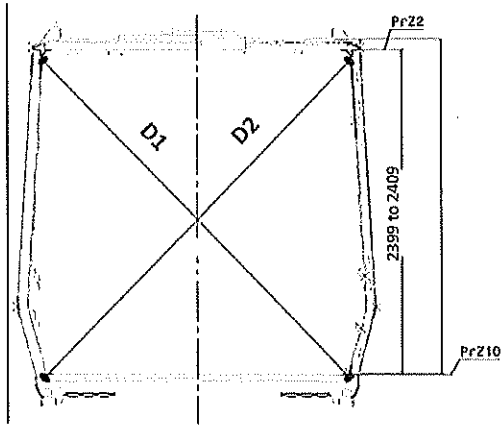
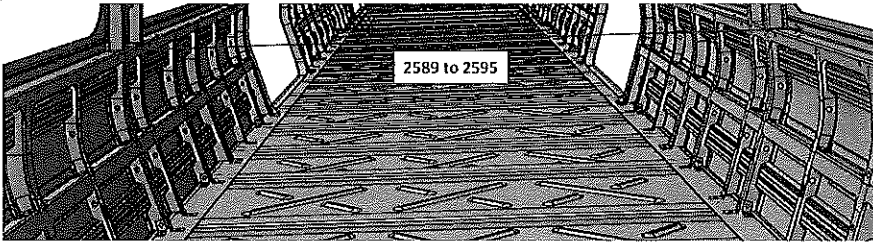
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Take measurement close to radius



Detail C

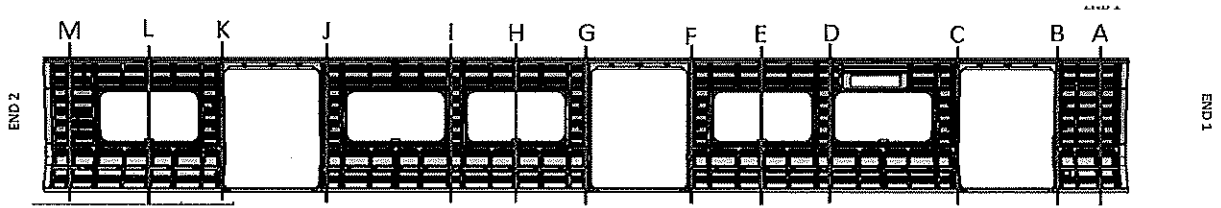




DTR30223319/2 Carshell Assembly TC

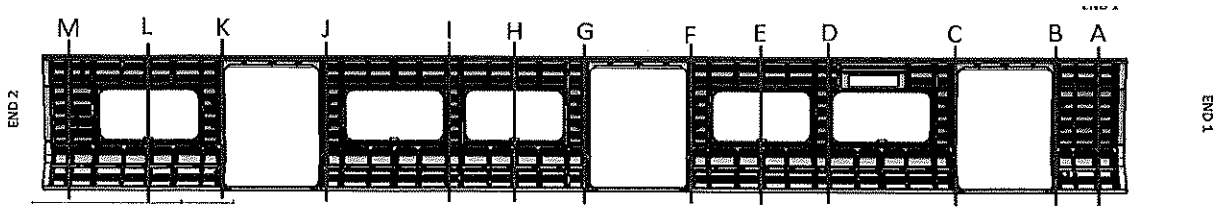
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**BEFORE WELDING**

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3296	3294	2	
B	3290	3290	0	
C	3296	3294	2	
D	3267	3265	2	
E	3265	3264	1	
F	3297	3294	3	
G	3298	3297	1	
H	3264	3262	2	
I	3265	3265	0	
J	3298	3294	4	
K	3295	3295	0	
L	3266	3266	0	
M	3295	3296	1	



**AFTER WELDING**

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3294	3292	2	2595
B	3290	3291	1	2595
C	3299	3294	5	2595
D	3265	3260	5	2595
E	3264	3261	3	2595
F	3297	3294	3	2593
G	3297	3299	2	2595
H	3262	3266	4	2595
I	3265	3260	5	2595
J	3296	3292	4	2593
K	3298	3295	3	2595
L	3266	3269	3	2595
M	3297	3295	2	2595

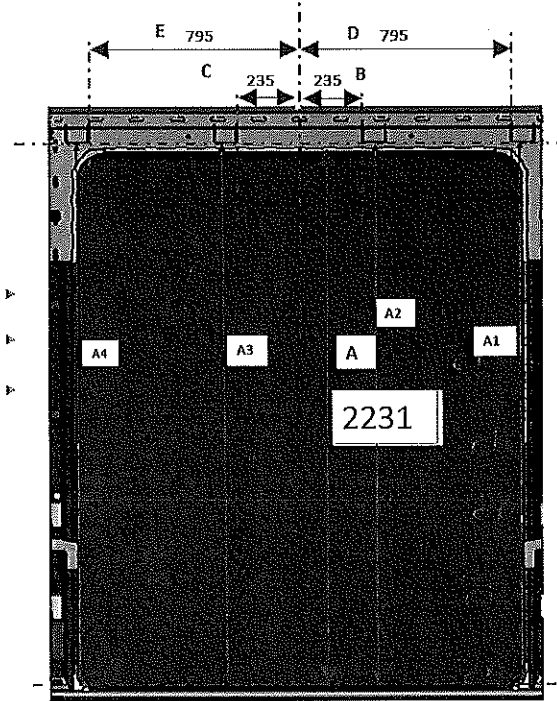


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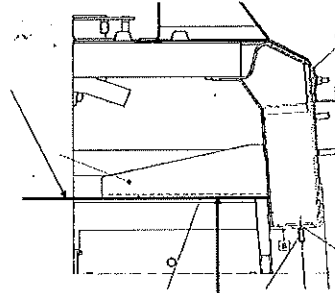
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28/10/2023

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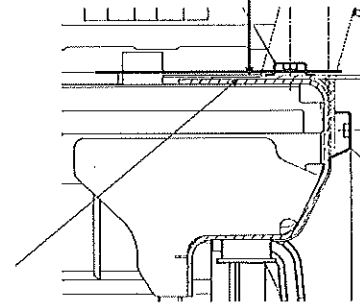
Specifications of Details for CBS measurement



Brackets Carbodyshell  
U Type Supports



Brackets Carbodyshell  
Channel Assy



DOOR 1 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2230
A3	2230 to 2232	2233
A4	2230 to 2232	2233
B	234 to 236	236
C	234 to 236	235
D	794 to 796	794
E	794 to 796	795

DOOR 2 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2232
A3	2230 to 2232	2233
A4	2230 to 2232	2230
B	234 to 236	234
C	234 to 236	235
D	794 to 796	794
E	794 to 796	795

DOOR 3 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2230
A3	2230 to 2232	2233
A4	2230 to 2232	2233
B	234 to 236	235
C	234 to 236	236
D	794 to 796	794
E	794 to 796	794

DOOR 1 - RHS

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

DOOR 2 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2230
A3	2230 to 2232	2233
A4	2230 to 2232	2233
B	234 to 236	234
C	234 to 236	235
D	794 to 796	794
E	794 to 796	795

DOOR 3 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2232
A3	2230 to 2232	2233
A4	2230 to 2232	2230
B	234 to 236	234
C	234 to 236	235
D	794 to 796	794
E	794 to 796	796



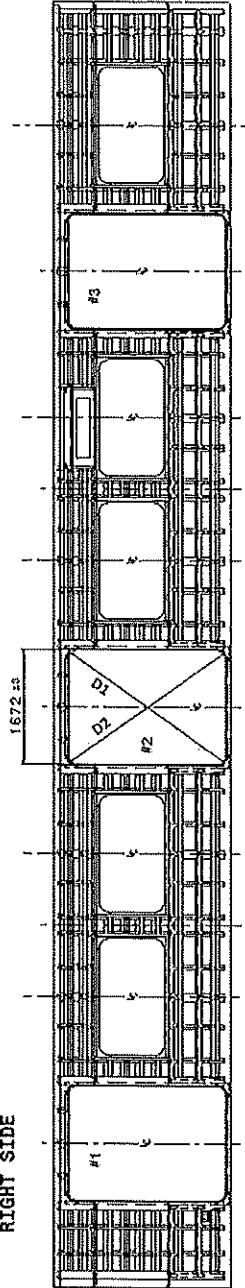
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Specifications of Details for CBS measurement

End #2



RIGHT SIDE

End #1

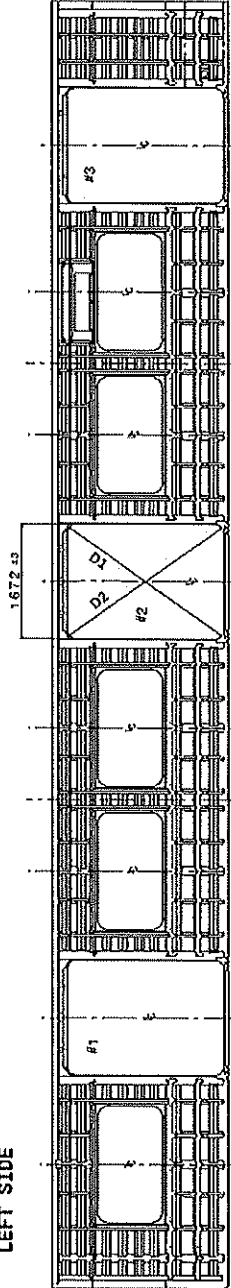
Doors diagonal D1-D2 maximum difference ≤ 4 mm

#1	#2	#3
D1	2749	2747
D2	2748	2748
D1-D2	1	1

Doors length - 1672 ±3mm

#1	#2	#3
1671	1670	1673
1671	1671	1672
1670	1671	1673
HIGHER DIMENSION		
CENTRAL DIMENSION		
LOWER DIMENSION		

End #1



LEFT SIDE


End #2

Diagonal de portas - diferença D1-D2 < 4 mm

#1	#2	#3
D1	2748	2744
D2	2749	2745
D1-D2	1	1

Vão de Portas - 1672 ±3mm

#1	#2	#3
1671	1670	1670
1670	1670	1673
1671	1672	1673
DIMENSÃO SUPERIOR		
HIGHER DIMENSION		
CENTRAL DIMENSION		
LOWER DIMENSION		

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

**Specifications of Details for CBS measurement**

**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	N/A	Review	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX					



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**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!	03/07/24	THURANI	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	03/07/24	Mdware	
		There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)				
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)				


In case of "NO GO", describe blocking problems

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

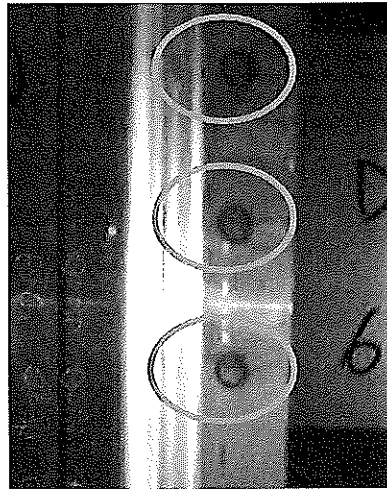
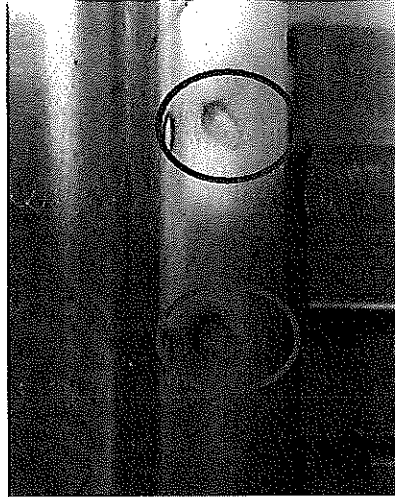
Item	Description	Action	Responsible	Due date	Status

Operations

Quality

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		28/10/2023	

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





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 ?		
				TCA	PA	MI	PI	MA	ICE				
<input type="checkbox"/>	DTRJ000131695	AAD000123653	DT00000223319 Carshell Assembly TC	CB1230	X						X	PRA.CB1230.DT0000012 23319.V20	YES

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	06/04/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	09/04/2018
			CHECKER	Nosizo Pindela	09/04/2018
			COMPILER	Thanyani Mathegu	06/04/2018
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	30/5/2018
			CHECKER	Nosizo Pindela	30/5/2018
			REVISED BY	Nosizo Pindela	30/5/2018
2	05/07/2018	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	05/07/2018
			CHECKER	Nosizo Pindela	05/07/2018
			COMPILER	Ramokone Motama	05/07/2018
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			REVISED BY	Vanessa Ntuli	24/01/2019
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			COMPILER	Nosizo Pindela	13/03/2019
7	17/09/2019	Added Cab Fire Barrier Flatness Measurements	APPROVER	Itumeleng Modiba	17/09/2019
			CHECKER	Nosizo Pindela	17/09/2019
			COMPILER	Nosizo Pindela	17/09/2019
10	20/09/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	20/09/2019
			CHECKER	Nosizo Pindela	20/09/2019
			COMPILER	Nosizo Pindela	20/09/2019
15	28/01/2021	New Baseline 10.2.6	APPROVER	Timothy Maimela	28/01/2021
			CHECKER	Bongane Masina	28/01/2021
			COMPILER	Bongane Masina	28/01/2021
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			COMPILER	Bongane Masina	19/04/2021
25	20/04/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	20/02/2022
			CHECKER	Andani Muthelo	20/02/2022
			COMPILER	Andani Muthelo	20/02/2022
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbhombhi	14/06/2022
			CHECKER	Andani Muthelo	14/06/2022
			COMPILER	Andani Muthelo	14/06/2022
27	26/07/2022	Threshold measurements addition	APPROVER	Collins Mbhombhi	26/07/2022
			CHECKER	Andani Muthelo	26/07/2022
			COMPILER	Andani Muthelo	26/07/2022
28	17/10/2022	Addition of traceability for sealant application	APPROVER	Collins Mbhombhi	17/10/2022
			CHECKER	Ntokozo Zwane	17/10/2022
			COMPILER	Amogelang Mohlampe	17/10/2022
29	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	14/04/2023
			COMPILER	Amogelang Mohlampe	14/04/2023
30	06/11/2023	Added traceability for thresholds for boiler makers and welders	APPROVER	Tyson Ngobeni	06/11/2023
			CHECKER	Andani Muthelo	06/11/2023
			COMPILER	Ntokozo Zwane	06/11/2023



TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
237	101	Ikshendo urosy	08/07/23	SI.CB1230.324.V28	14



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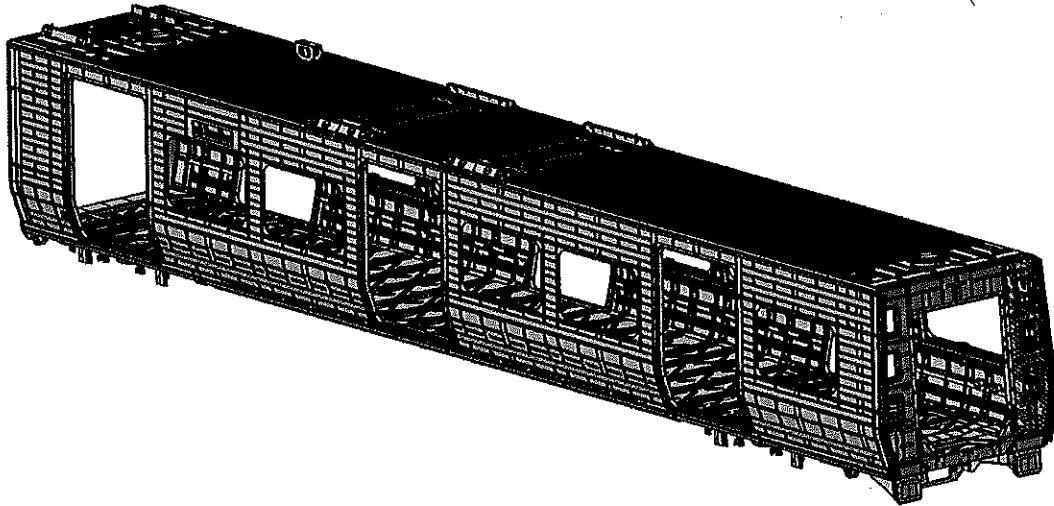
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Carro  
Car:

NCR:

Work station: CB1230



I - Documentation and Instruments

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
	TC1	M1	M2	M3	M4	TC2						
DT00000223319	X						30		OK		N/A	<i>[Signature]</i>

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Validation	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
rubrica	22113	26/07/24	OK		<i>[Signature]</i> 06/11/23	<i>[Signature]</i> 06/11/23
tape Measure	Gibou14	25/07/24	OK		<i>[Signature]</i> 06/11/23	<i>[Signature]</i> 06/11/23
Combination square.	Gibou12	07/07/24	OK		<i>[Signature]</i> 06/11/23	<i>[Signature]</i> 06/11/23

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSi	310180	Mig welding	OK		<i>[Signature]</i> 06/11/23	<i>[Signature]</i> 06/11/23
ER 308 Ls	227241	Tig welding	OK		<i>[Signature]</i> 06/11/23	<i>[Signature]</i> 06/11/23



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**II - Control Activities of Production**

**II.1 - Items to check**

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Not OK	Not Done	Signature/Date (Operations)	Signature/Date (Quality)						
01	N/A	Assembly according to Instruction Engineering n° DT00000223319	DT00000223319	OK			<i>[Signature]</i> 04/10/24	<i>[Signature]</i> 04/10/24						
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	OK			<i>[Signature]</i> 04/10/24	<i>[Signature]</i> 04/10/24						
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 DTD0000210675	OK			<i>[Signature]</i> 04/10/24	<i>[Signature]</i> 04/10/24						
04	N/A	Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	OK			<i>[Signature]</i> 04/10/24	<i>[Signature]</i> 04/10/24						
05	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658	OK			<i>[Signature]</i> 04/10/24	<i>[Signature]</i> 04/10/24						
06	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified:  <table border="1" style="font-size: small;"> <tr> <td>Temperature Min - Max (I)</td> <td>Min-Max</td> <td>10°C - 35°C</td> </tr> <tr> <td>Relative humidity Min - Max (I)</td> <td>Min-Max</td> <td>25% - 80%</td> </tr> </table>	Temperature Min - Max (I)	Min-Max	10°C - 35°C	Relative humidity Min - Max (I)	Min-Max	25% - 80%	Sealant Batch No: <u>ISR 70-03</u> Exp Date: <u>   </u> / <u>09</u> / <u>24</u>  Actuals Temperature: <u>14°C</u> Humidity: <u>32%</u>	OK			<i>[Signature]</i> 04/10/24	<i>[Signature]</i> 04/10/24
Temperature Min - Max (I)	Min-Max	10°C - 35°C												
Relative humidity Min - Max (I)	Min-Max	25% - 80%												
07	N/A	Verification of sealant application in regions of roof and sideframe finishers.	Sealant must be: -Applied straight and even (1.5mm) -Free of gaps, cracks, damage and debris (flashes, dirt, dust)  Refer to Annexure B	OK			<i>[Signature]</i> 04/07/24	<i>[Signature]</i> 04/07/24						

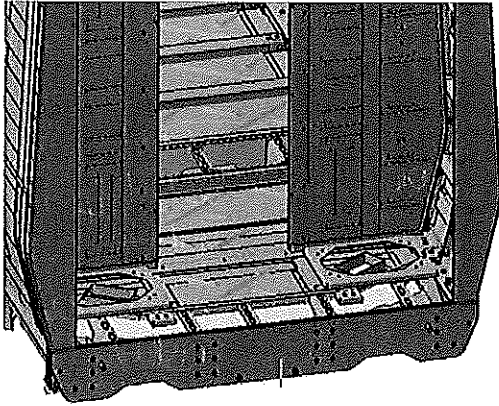


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VIEW A



**END 1  
SEALANT**

LHS

RHS

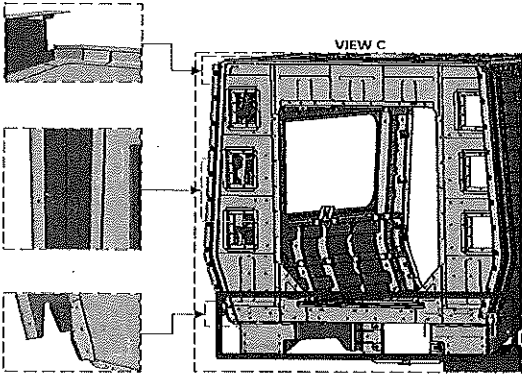
OPERATOR  
(Name & sign):

Gihle

Boitumelo

OPERATOR  
(Name & sign):

Buhle



OPERATOR  
(Name&sign):

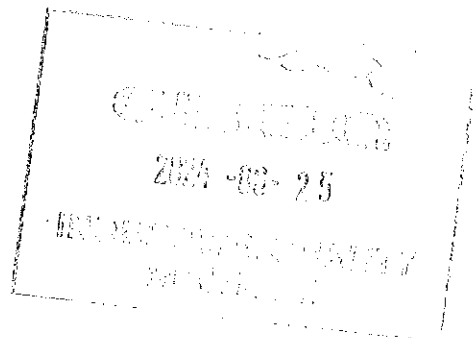
Zanck

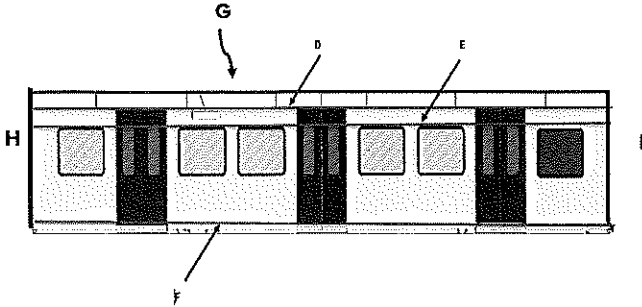
OPERATOR  
(Name&sign):

Zanck

OPERATOR  
(Name&sign):

Zanck





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

Operator (Name & sign):

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

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

Operator (Name & sign):

Ishendo

Boitumelo

Operator (Name & sign):

[Signature]

[Signature]

Operator (Name & sign):

Sine

Buhle

Operator (Name & sign):

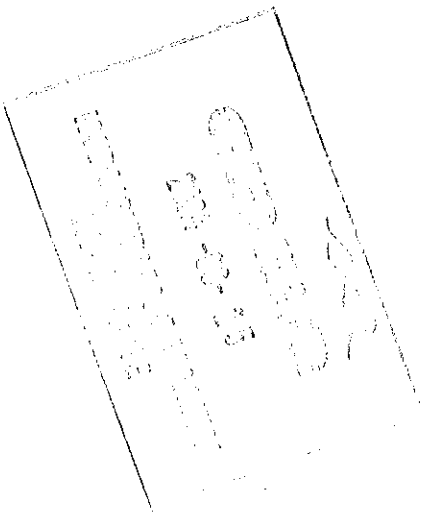
[Signature]

[Signature]

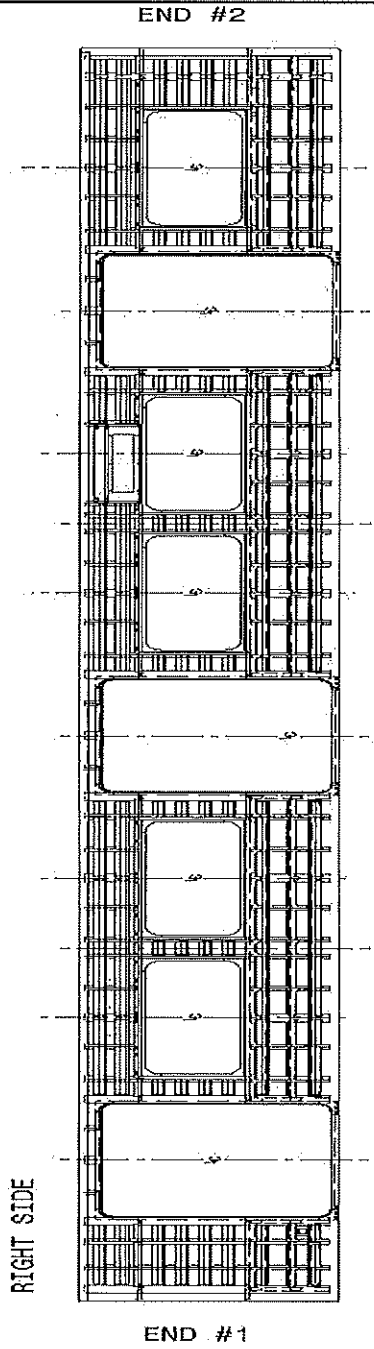
Operator (Name & sign):

[Signature]

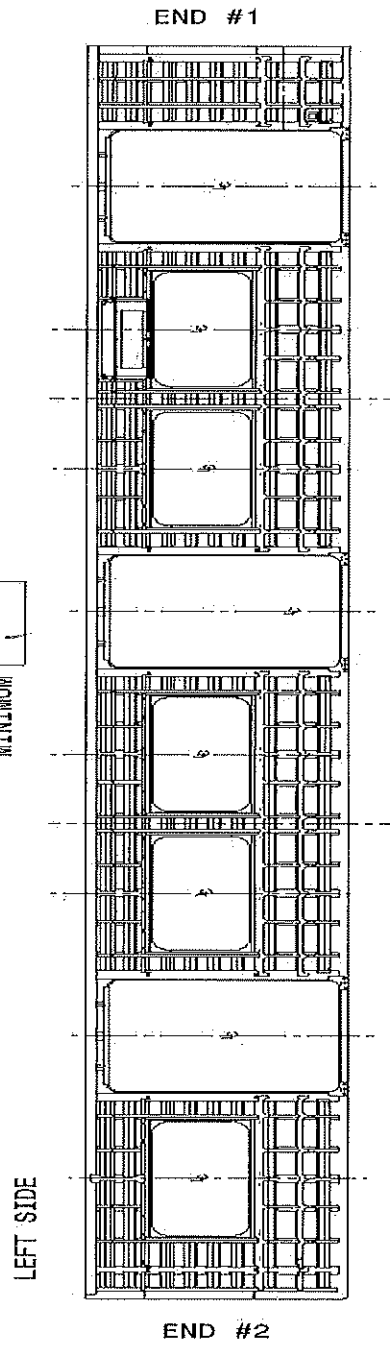
[Signature]



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.



1.2
MAXIMUM
1
MINIMUM

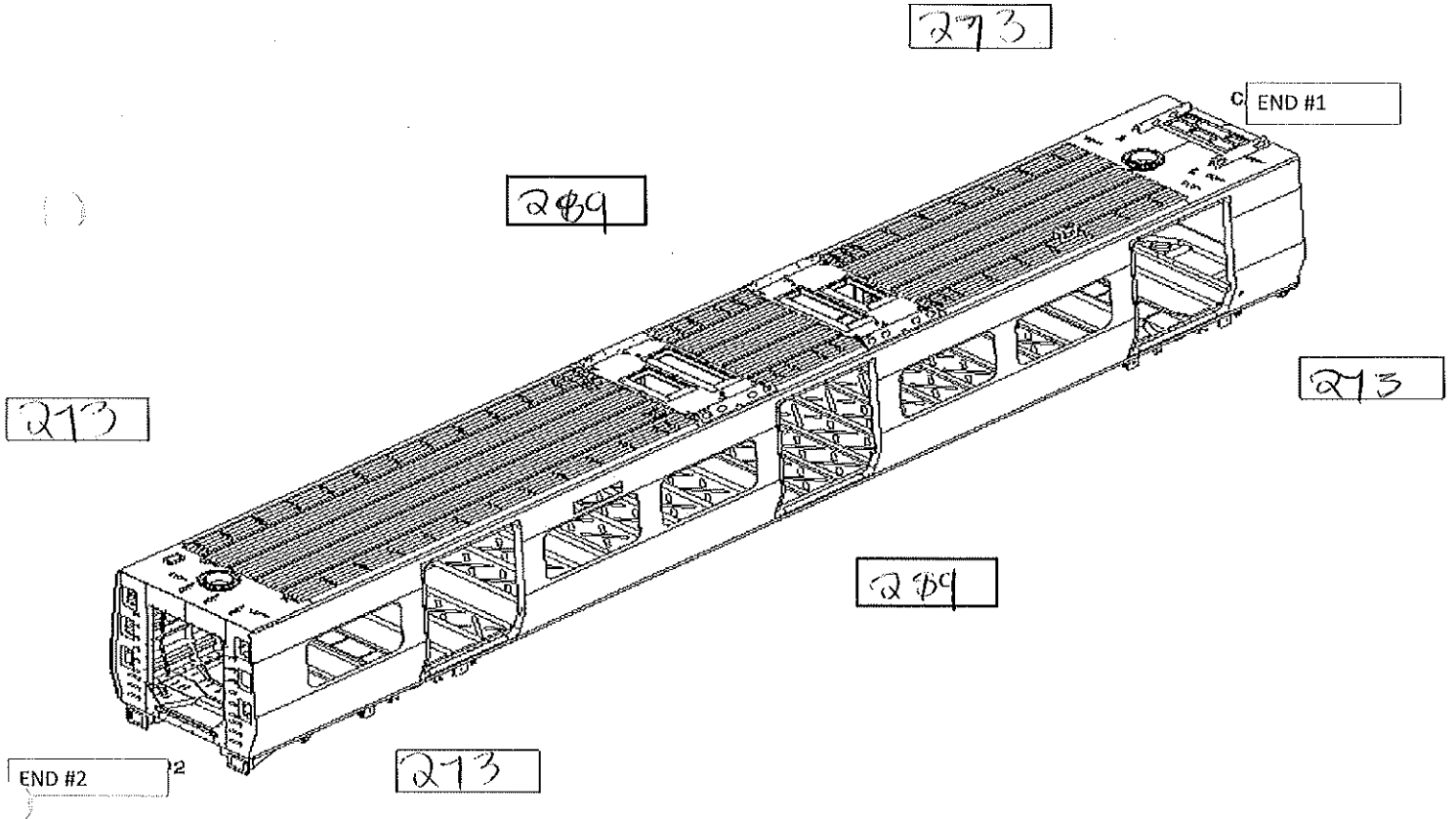


0.2
MAXIMUM
1
MINIMUM

Handwritten notes and stamps, including a date stamp: 2024-08-25.

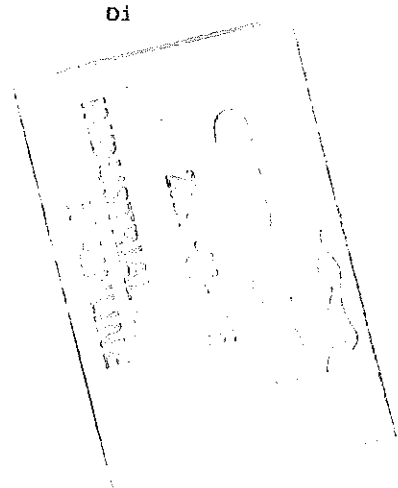
**Specifications of Details for CBS measurement CB1230**

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



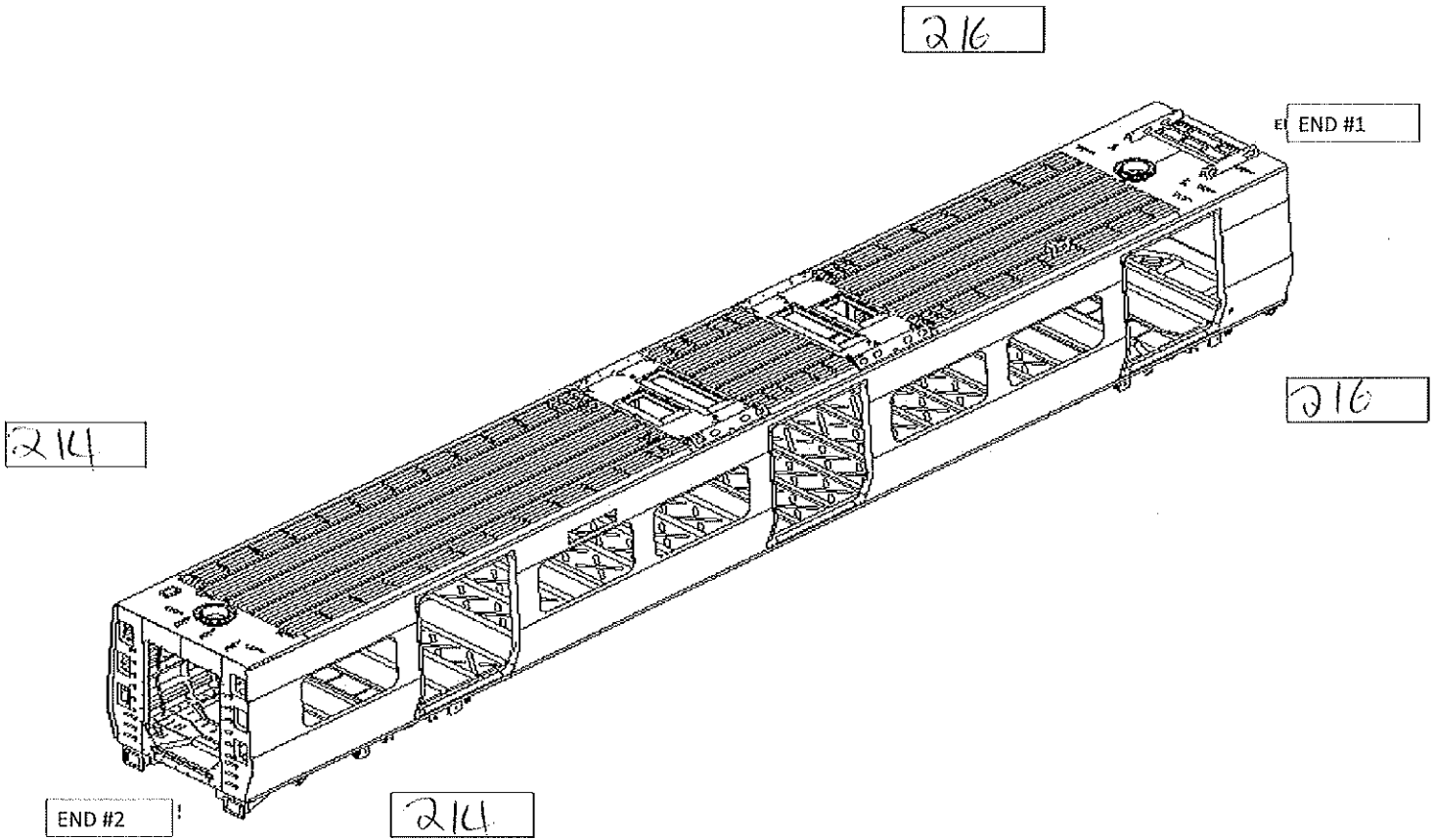
**MEASURED CAMBER VALUES**

RIGHT	+	16
LEFT	-	16



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.



MEASURED TWIST VALUES END 1

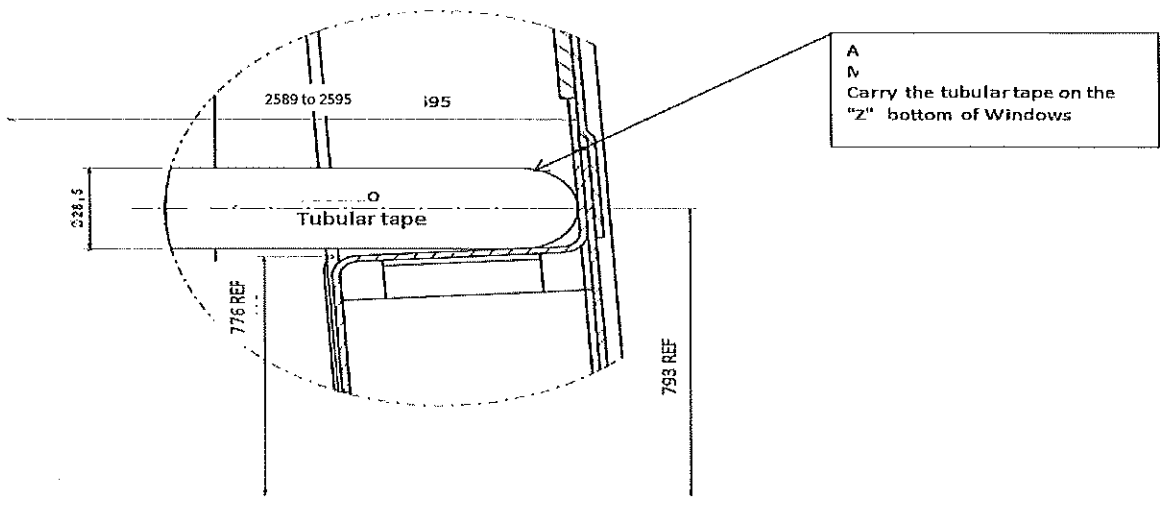
LATERAL   
LONGITUDINAL <sup>1</sup>

MEASURED TWIST VALUES END 2

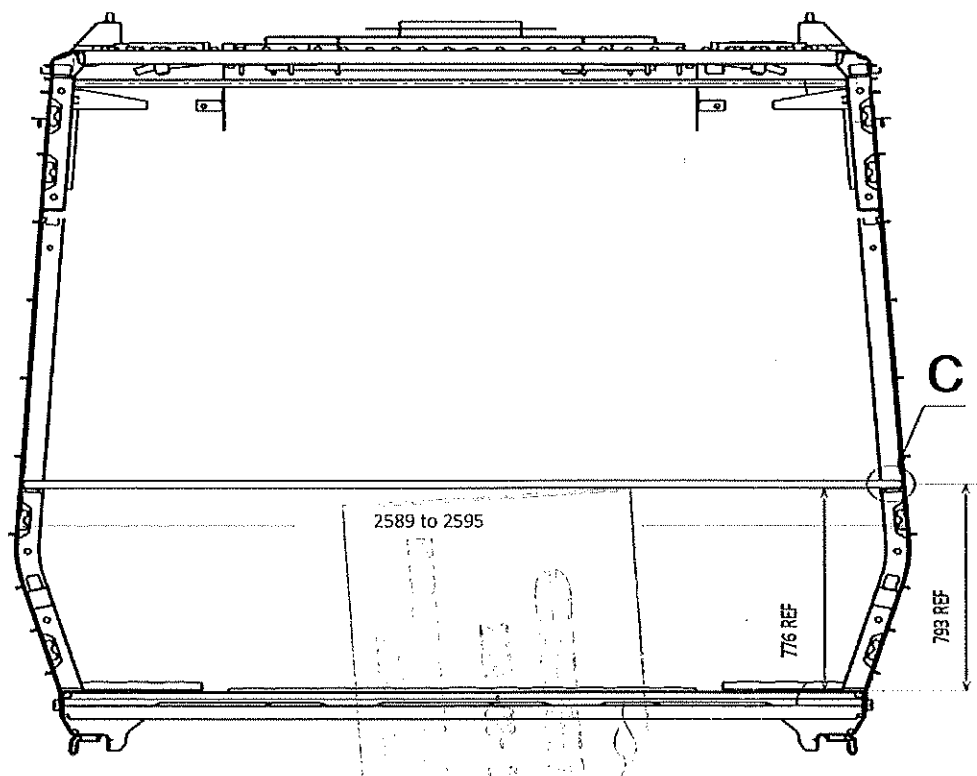
LATERAL   
LONGITUDINAL

2024-03-25  
INSTRUMENTS & EQUIPMENT  
DIVISION

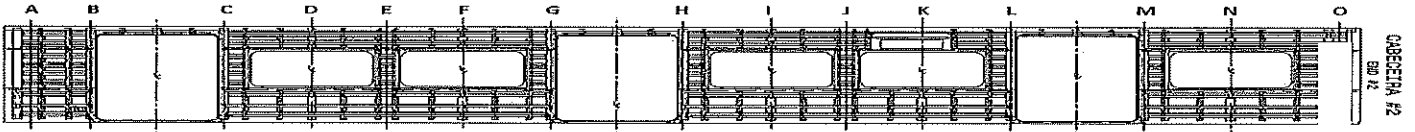
Details for measuring on the CB1230 stage, after completion of activities



Detail C



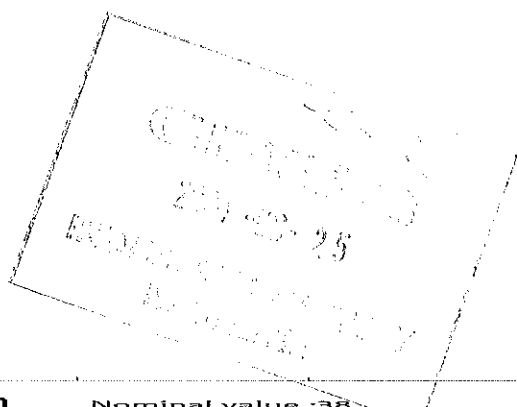
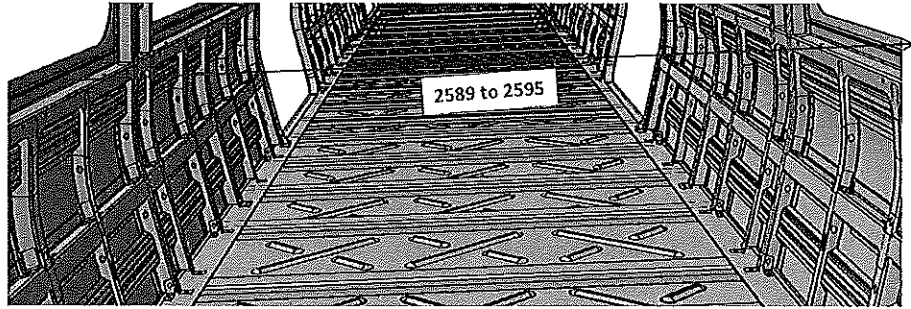
Specifications of Details for CBS measurement



LATERAL DIREITA  
lado 03do

2589 to 2595mm

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



Threshold verification

Nominal value :38

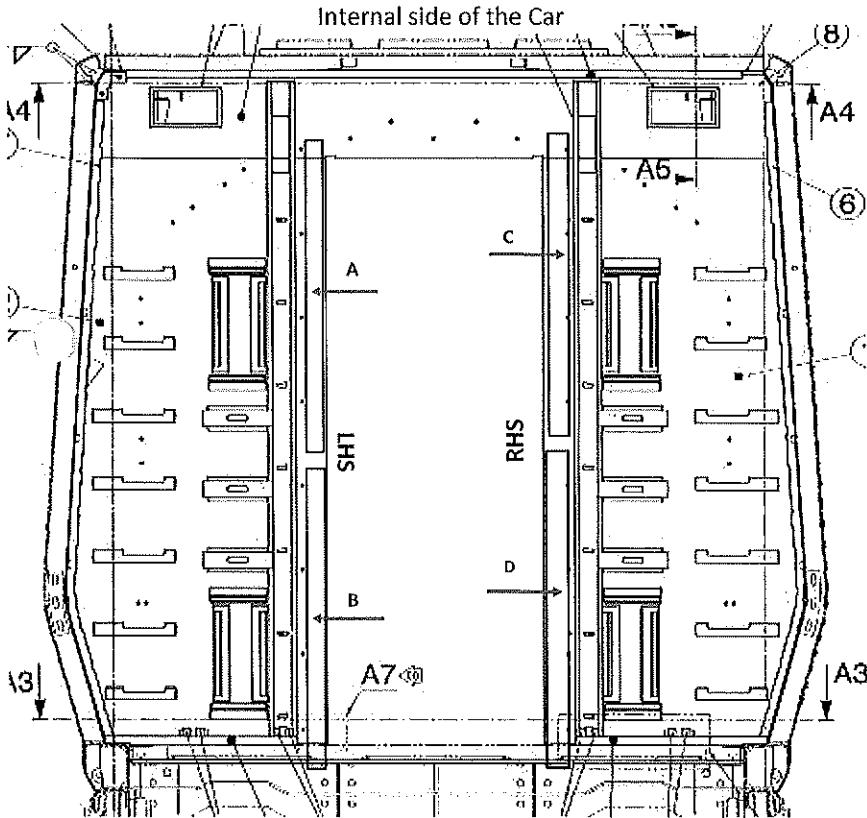
Door 1		Door 2		Door 3	
L	R	L	R	L	R
38	38	38	39	38	39
Door 4		Door 5		Door 6	
L	R	L	R	L	R
38	38	38	38	38	38

BOILER MAKER: Kerato *(Signature)*  
WELDER: *(Signature)*

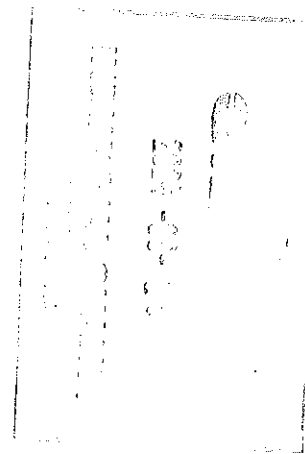
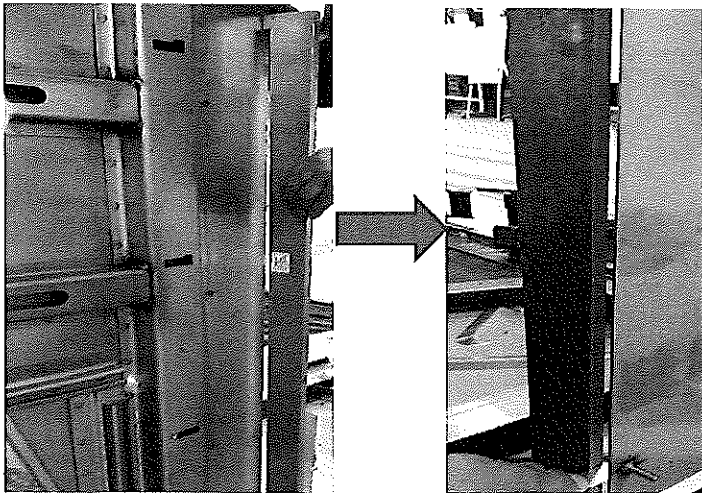
**Specifications of Details for CBS measurement**

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

Specified Maximum Flatness deviation on Cab Fire Barrier = 2mm



Measured Values			
	Minimum	Maximum	Deviation
A	9.1	9.8	0.7
B	10.1	10.8	0.7
C	9.8	9.3	0.5
D	9.7	9.6	0.1





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### Dye penetrant test

Dye-penetration test to be performed by quality personnel

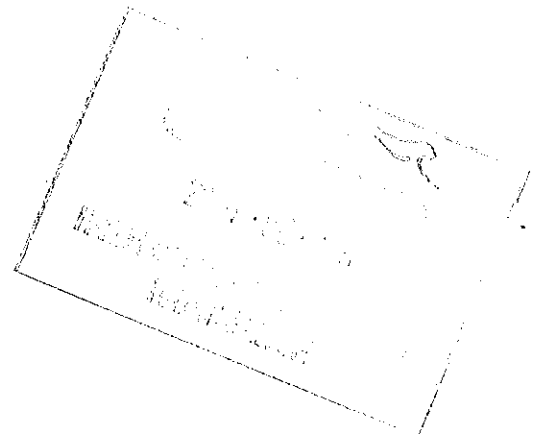


Item	Description of the issue	OK	Signature/Date (Operations)	Signature/Date (Quality)

II.2 - Check List REX

Check List Items

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





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**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!	04/07/24	Ishenoto Operations	
	GO	Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	04/09/24	Androni 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	

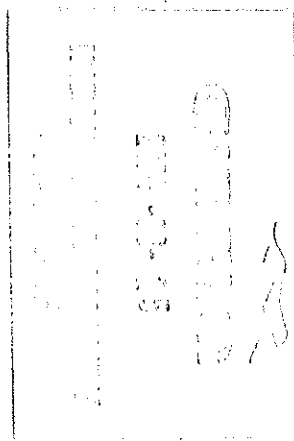
In case of "NO GO", describe blocking problems

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

Item	Description	Action	Responsible	Due date	Status

Operations

Quality



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

