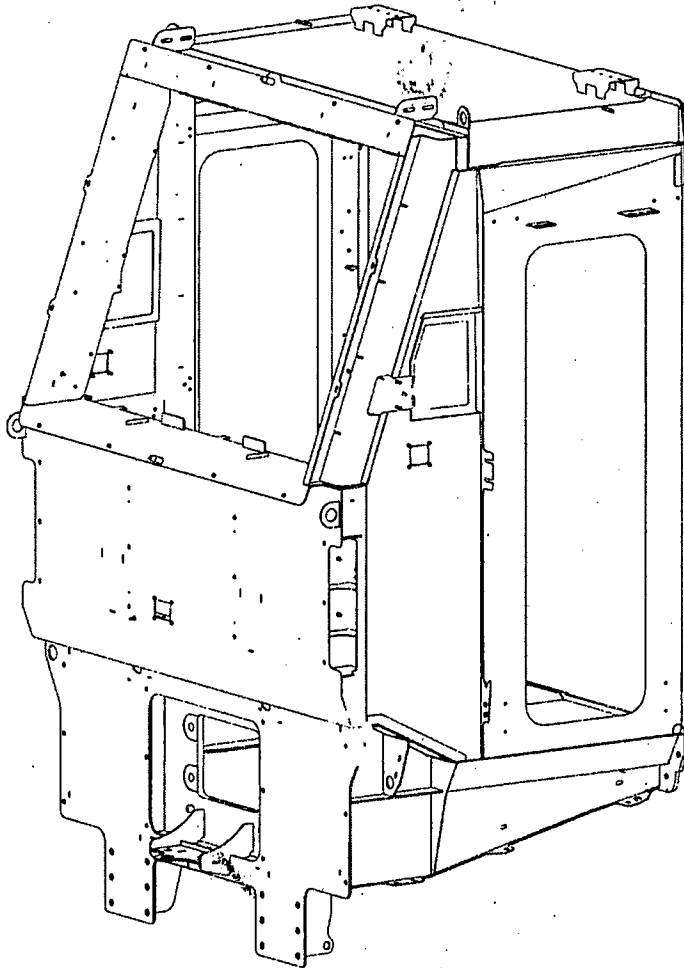


52

# GLOBAL

MANUFACTURING  
SOLUTIONS



## CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 4 7 5 \_

WEIGHT: 1 4 8 9 Kg

## RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	24/05/24	178247 107895 01	F305031	
RCS 355	2 mm				VI-EQ9055	
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	24/05/24	183653 107087 01	F207906	
RCS 355	3 mm				VHE 73052	
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	20 mm	Pegasus	24/05/2024	178458 D4640 01	P20180	
RCS 355	20 mm				VPL03542	

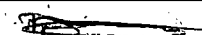
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	30 mm	Pegasus	26/05/2024			
RCS 355	30 mm					

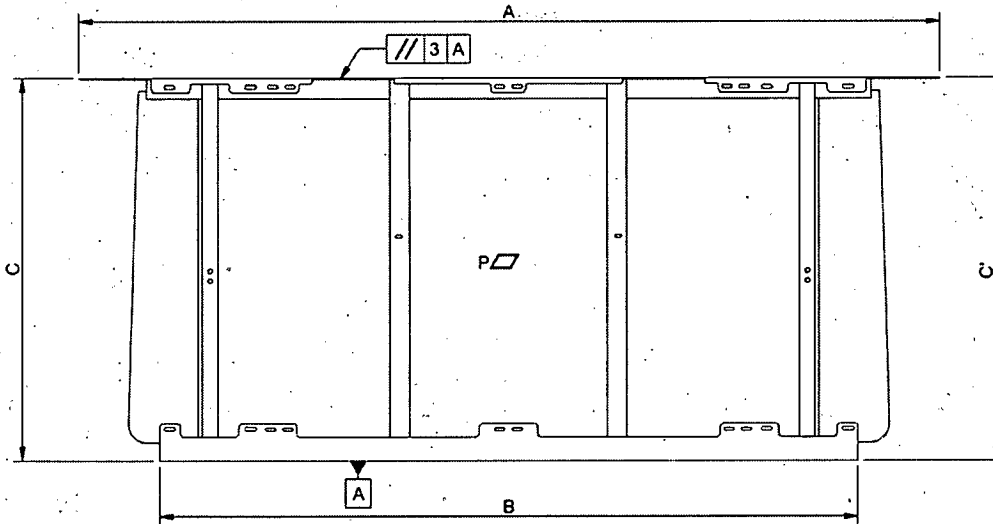
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	24/05/2024	182729 107087 01	F207906	
RCS 450	4 mm				VHL 47403	
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	24/05/2024	183446 107087 01	F207907	
RCS 450	6 mm				VHE 62375	
RCS 450	6 mm					

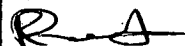
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	24/05/2024	183451 107087 01	F305031	
RCS 450	8 mm				VHS 56236	
RCS 450	8 mm					
RCS 450	8 mm					

## Cabin Roof Assembly: GN002839


Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DYLAN DAVIDS	Assembly Date:	20 24/05/07		
Sign:		Wire Batch No.:	107238201		




### Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	Riccardo	Sign:		Date:	2024/05/07

### Dimensional Control

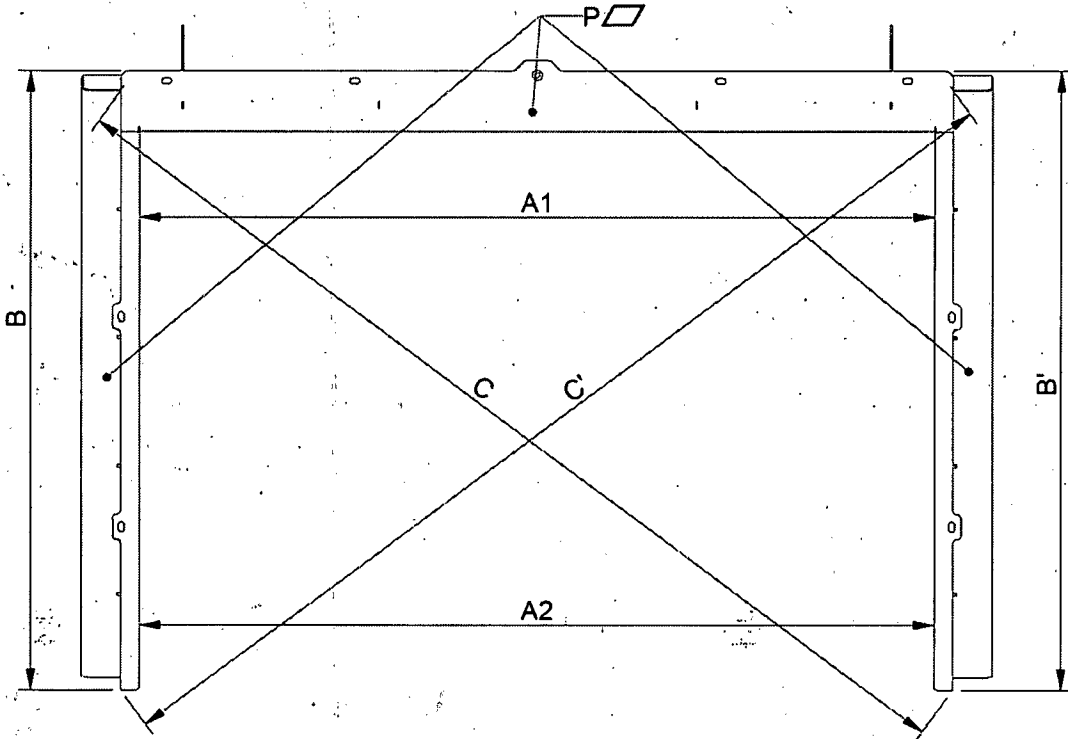
Rep		Toler.	Dimension measured		Measuring Equipment	Observations
A	2216	+5/-0	2216		Tape Measure	acceptable
B	1800	± 4	1800			acceptable
C	976	+2/-3	976	976		acceptable
QC Inspector:	Riccardo		Sign:		Date:	2024/05/07

### Geometrical Control

Nature of Checks		Dimension Measured	Measuring Equipment	Observations		
Planéité P.	6 mm	Passed	Ruler	acceptable		
//	3 A	Passed	Set Square	acceptable		
QC Inspector:	Riccardo		Sign:		Date:	2024/05/07

## Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	Bambelo G. Guan.	Assembly Date:	20 24/05/07		
Sign:		Wire Batch No.:	SS 2033		



### Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	LEON	Sign:		Date:	20 24/05/07

### Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	1910	± 2	1917		Tape Measure	Acceptable
A2	1910		1911			Acceptable
B	1475	± 1	1475	1475		Acceptable
C	Diagonals  C - C'  ≤ 3		2477	2476		Acceptable
QC Inspector:	LEON	Sign:		Date:	20 24/05/07	

### Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P : Planeity	4 mm	Passes	Acceptable
QC Inspector:	LEON	Sign:	
Date:	20 24/05/07		

### Cabin LHS/RHS Wing Mirror Plate Assembly: GN002846/GN002844

Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>TK Boonen</i>	Assembly Date:	2024/05/29			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202167			

### Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

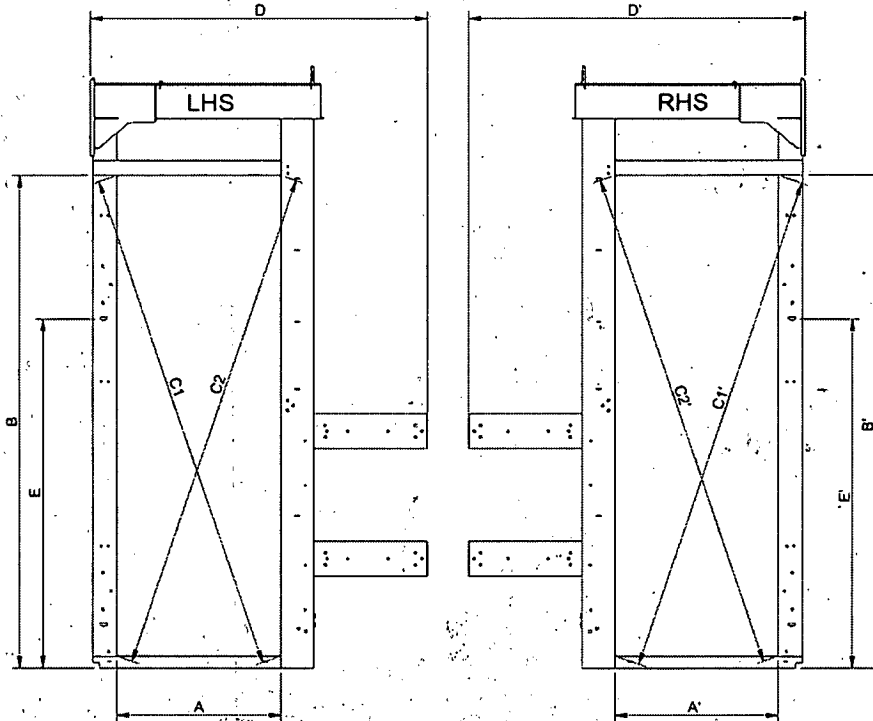
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Glenn</i>	Assembly Date:	2024/04/29			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

### Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Glenn</i>	Assembly Date:	2024/04/22			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

## Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator: <b>Glenn</b>	Assembly Date:	2024/05/06			
Sign: <i>[Signature]</i>	Wire Batch No.:	552033			



### Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
QC Inspector: <i>[Signature]</i>	Sign:	Date:	2024/05/06		

### Dimensional Control

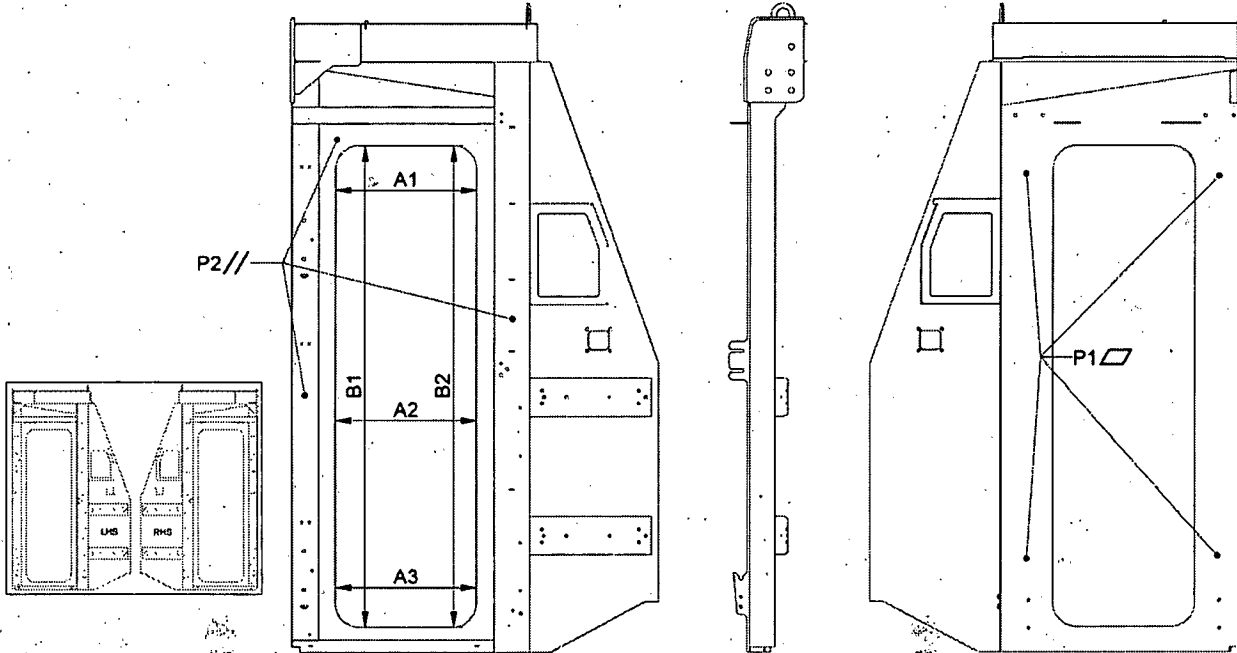
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	697	697	Tape Measure	Acceptable
B	2086	+1/-3	2086	2085		Acceptable
C1 / C2	Difference of diagonals $ C1 - C2  \leq 3$		2155	2154		Acceptable
C1 - C2			2158	2153		Acceptable
D	1438	+2/-3	1437	1439		Acceptable
E				1483		
QC Inspector:			Sign:		Date:	2024/05/07

### Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1.: planeity of 2 edges	4 mm	Ruler	
QC Inspector:		Sign:	Date: 2024/05/03

## Cabin LHS/RHS Side Assembly: GN002838/GN002837

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	TKB <i>TKB</i>	Assembly Date:	2024/05/04		
Sign:	<i>TKB</i>	Wire Batch No.:	2202167		



### Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>Leon</i>	Sign:	<i>QA</i>	Date:	2024/05/07

### Dimensional Control

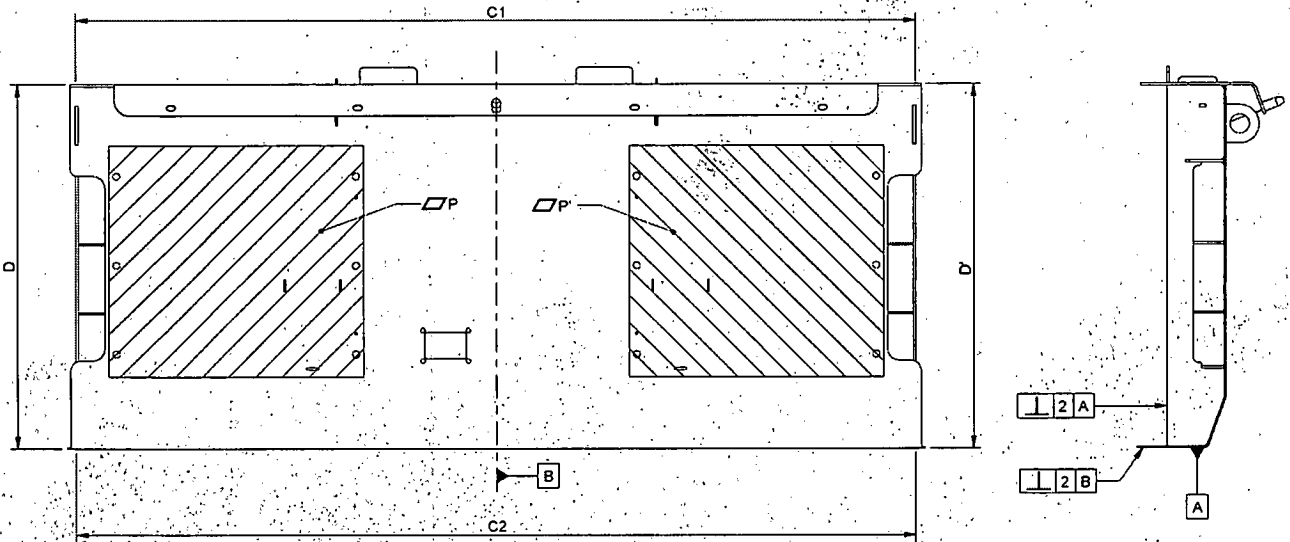
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	558	568	Tape Measure	<i>Acceptable</i>
A2			559	560		<i>Acceptable</i>
A3			559	560		<i>Acceptable</i>
B1	1900	± 2	1898	1898		<i>Acceptable</i>
B2			1898	1898		<i>Acceptable</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>QA</i>	Date:	2024/05/07	

### Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1: Planarity	4 mm	Ruler	<i>Acceptable</i>
P2: Planarity	2 mm	Ruler	<i>Acceptable</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>QA</i>
			Date: 2024/05/07

## Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes <input checked="" type="checkbox"/>	No <input type="checkbox"/>
Operator:	<i>Rambelo G. Ciani</i>	Assembly Date:	20 <u>24</u> / <u>05</u> / <u>07</u>	
Sign:	<i>[Signature]</i>	Wire Batch No.:	SS 20 35	



### Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes <input type="checkbox"/>	No <input checked="" type="checkbox"/>
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date: 20 <u>24</u> / <u>05</u> / <u>07</u>


### Dimensional Control

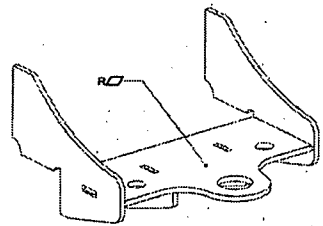
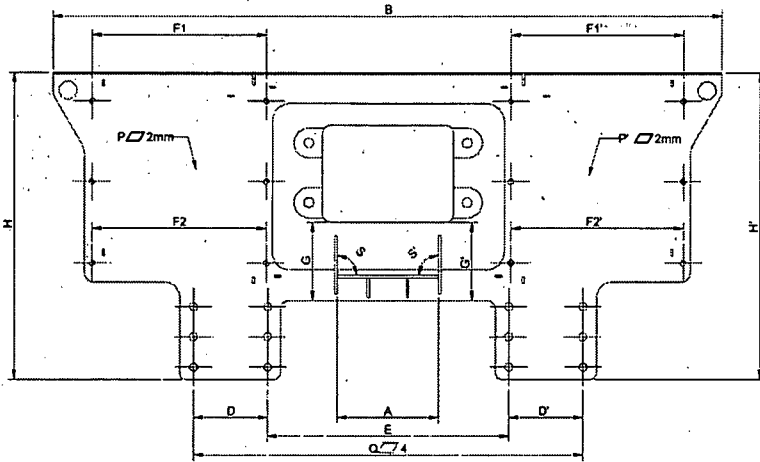
Rep	Theoretical Dim	Toler	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	<i>2210</i>	<i>2210</i>	Tape Measure	<i>Accepted</i>
D / D'	956	± 2	<i>955</i>	<i>955</i>		<i>Accepted</i>
QC Inspector:	<i>LEON</i>		Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>05</u> / <u>07</u>

### Geometrical Control

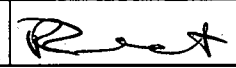
Nature of Checks		Dimension Measured		Measuring Equipment	Observations
Planeity P / P'	2 mm	<i>Passed</i>		Ruler	<i>Accepted</i>
Perpendicularity	2	A	<i>Passed</i>	Set Square	<i>Accepted</i>
	2	B	<i>Passed</i>	Set Square	
QC Inspector:	<i>LEON</i>		Sign:	<i>[Signature]</i>	Date: 20 <u>24</u> / <u>05</u> / <u>07</u>

## Cabin Front Headstock Assembly: GN002841

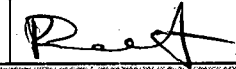
Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	DYLAN DAVIDS	Assembly Date:	2024/04/30	
Sign:		Wire Batch No.:	2202167	



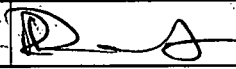
### Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	Riccardo	Sign:		Date: 2024/04/30

### Dimensional Control

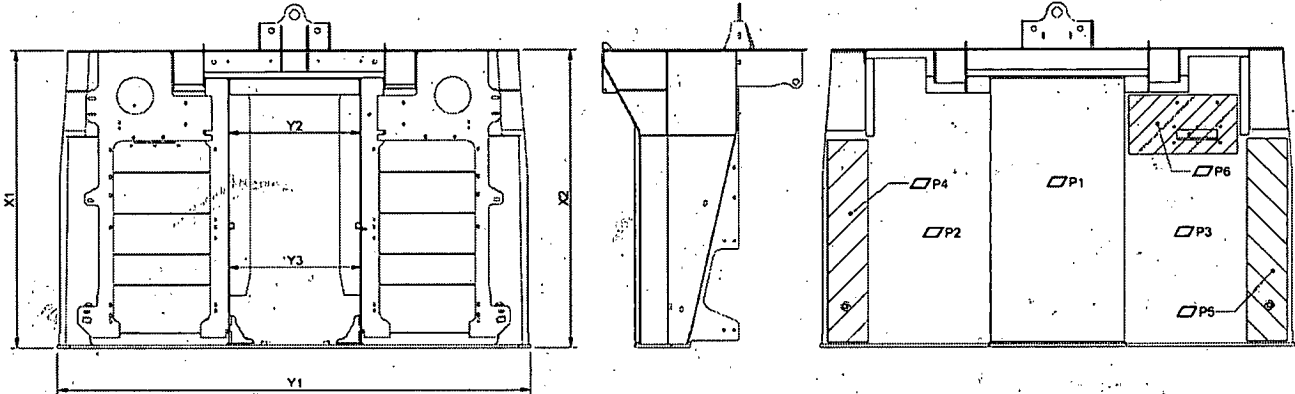
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	±1	340		Tape Measure	acceptable
B	2240	±4	2244			acceptable
D / D'	250	±1	230	250		acceptable
E	808	±2	808			acceptable
F1 / F1'	580	±1	581	581		acceptable
F2 / F2'			581	581		acceptable
G / G'	258	±1	259	259		acceptable
H / H'	1019	±2	1020	1020		acceptable
QC Inspector:	Riccardo	Sign:		Date:	2024/04/30	

### Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations		
O: Planeity of global assembly	4 mm	Passed	Ruler	acceptable	
P / P': Planeity	2 mm	Passed	Ruler	acceptable	
Q: Planeity Surface of Supports	4 mm	Passed	Ruler	acceptable	
R: Planeity Coupler Support	2 mm	Passed	Ruler	acceptable	
S: Perpendicularity coupler	1mm	Passed	Square	acceptable	
QC Inspector:	Riccardo	Sign:		Date:	2024/04/30

## Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	2024/05/01	
Sign:	<i>[Signature]</i>	Wire Batch No.:	562033	



### Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/05/01

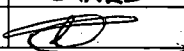
### Dimensional Control

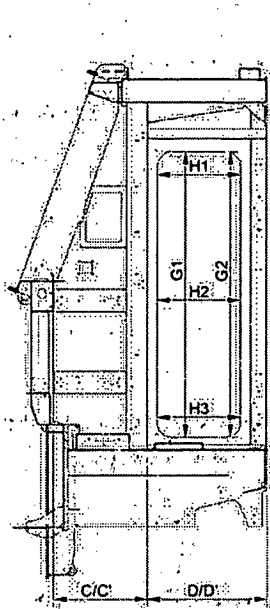
Rep.	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1486	1486	Tape Measure	acceptable
Y1	2354	± 3				
Y2 / Y3	666	± 1	666	666		acceptable
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/05/01	

### Geometrical Control

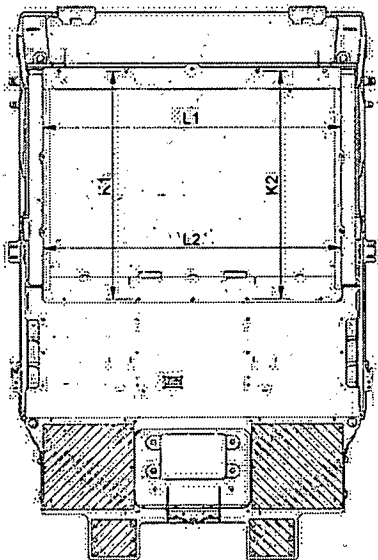
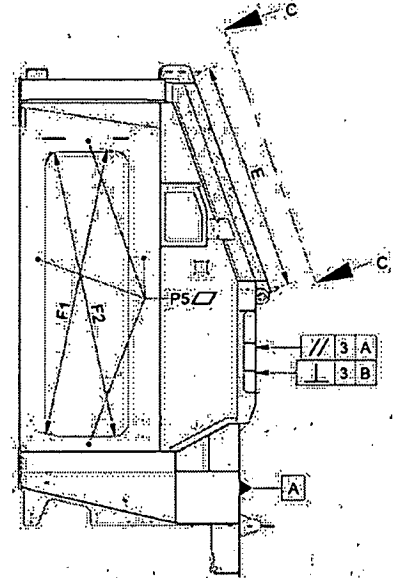
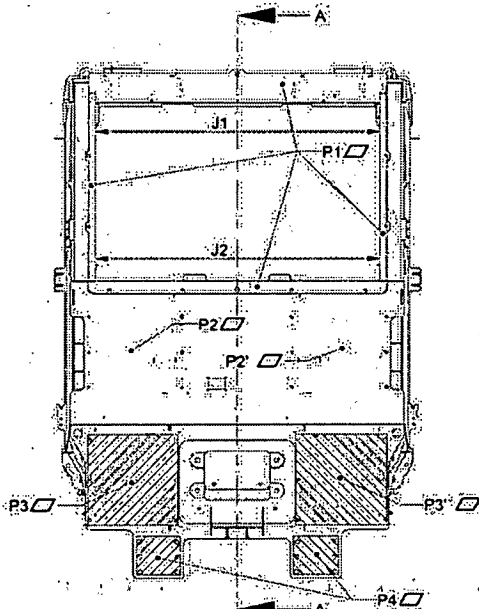
Nature of checks	Dimension Measured	Measuring Equipment	Observations		
P1 : Planéité	4 mm	Ruler	acceptable		
P2 / P3 : Planéité	4 mm	Ruler	acceptable		
P4 / P5 : Planéité	2 mm	Ruler	acceptable		
P6 : Planéité	2 mm	Ruler	acceptable		
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/05/01

# Cabin Structure Assembly: GN002834

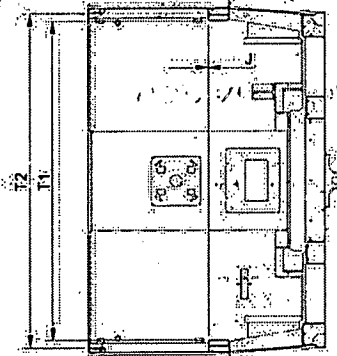
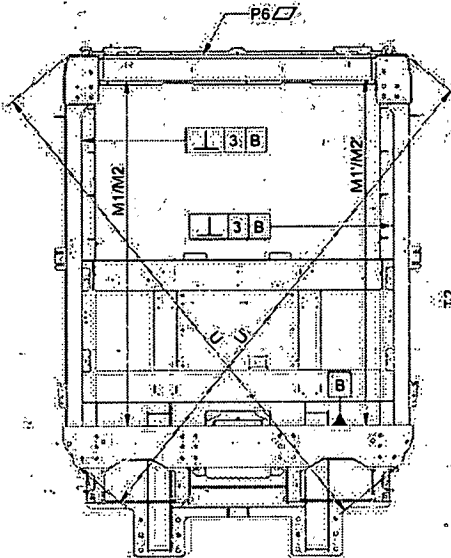
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLOEM	Assembly Date:	20 24 / 05 / 23			
Sign:		Wire Batch No.:	552033			



SECTION A-A



AUX VIEW C



SECTION B-B

### Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	No
QC Inspector: Riccardo	Sign: <i>R. A.</i>	Date: 2024/05/13		

### Dimensional Control

Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations
C / C'	625	± 2	625	625	acceptable
D / D'	813	± 2,5	815	812	acceptable
E	1531.5	± 3	1531		acceptable
G1 / G'1	Height 1900	+1	1898	1898	acceptable
G2 / G'2		-3	1898	1898	acceptable
H1 / H'1	Width 560	+1	558	558	acceptable
H2 / H'2		-3	560	560	acceptable
H3 / H'3			560	560	acceptable
F1 / F'1	Diagonals 1939		1938	1937	acceptable
F2 / F'2			1937	1937	acceptable
Difference	F1-F2 / F'1-F'2	≤ 4	1	0	acceptable
J	Gap of Doors	± 1,5	2	2	acceptable
K1 / K2	1515	± 3	1514	1515	acceptable
L1 / L2	1996	± 3	1997	1997	acceptable
M1 / M'1	2306	± 3	2465	2464	acceptable
M2 / M'2			2475	2475	acceptable
T1 / T'1	2130 Top/Bottom	± 3	2128	2130	acceptable
T2 / T'2	2230 Top/Bottom		2228	2230	acceptable
Difference	U - U' (3522)	≤ 4mm	3517	3515	acceptable
QC Inspector: Riccardo	Sign: <i>R. A.</i>	Date: 2024/05/13			

### Geometrical Control

Nature of checks		Toler.	LHS / Dimension Measured / RHS		Observations
P1 / P'1	Planeity	2 mm	Passed		acceptable
P2 / P'2	Planeity	2 mm	Passed		acceptable
P3 / P'3	Planeity	4 mm	Passed		acceptable
P4 / P'4	Planeity	4 mm	Passed		acceptable
P5 / P'5	Planeity	4 mm	Passed		acceptable
P6 Roof	Planeity	6 With 2m Ruler	Passed		acceptable
Shield	// 3 A	3	Passed		acceptable
Shield	⊥ 3 A	3	Passed		acceptable
Door Post	⊥ 3 A	Front	Passed		acceptable
		Back	Passed		acceptable
QC Inspector: Riccardo	Sign: <i>R. A.</i>	Date: 2024/05/13			

### Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>Damen</i>	Assembly Date:	2024/05/16			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

### Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>DELWYN</i>	Assembly Date:	2024/05/16			
Sign:	<i>[Signature]</i>	Wire Batch No.:				

Shot Blasting				
Shot Blasting Pre-Inspection				
All external threads masked	Confirmed	Yes	<input checked="" type="checkbox"/>	No
Fasteners positioned in all Rivnuts and Bosses	Confirmed	Yes	<input checked="" type="checkbox"/>	No
Masked as per GMS-SOS-GIBELA-CABIN-001	Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DAVID		Sign:	
Date:	2024/05/30			
Record of Shot Blasting				
Operator:			Date:	2024/05/30
Start Time:	07 H 43	End Time:	13 H 07	
Temperature ( $\geq 15^\circ$ ):	21 - 06 $^\circ$ C	Humidity ( $\leq 75\%$ ):	59 - 09 %	
Shot Blasting Self-Inspection				
Interior of Cabin: Sa 1 - Light Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.	Confirmed	Yes	<input checked="" type="checkbox"/>	No
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No
	Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DAVID		Sign:	
Date:	2024/05/30			
Shot Blasting Cleaning				
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DAVID		Sign:	
Date:	2024/05/30			
Shot Blasting Control				
Temperature $\geq 15^\circ$ :	22 - 04 $^\circ$ C	Humidity $\leq 75\%$ :	61 - 05 %	
Internal Roughness 3.2 $\leq$ Ra $\leq$ 12.5	Ra 7,483 Rz 51,256	External Roughness 3.2 $\leq$ Ra $\leq$ 12.5	Ra 7,097 Rz 43,322	
QC Inspector:	247341,256	Sign:		
Date:	30/5/24			

Ra 5,422  
 5,736  
 7,483  
 6,368  
 6,032  
 5,565  
 6,859  
 5,353  
 5,553  
 6,074

Rz 37,768  
 38,918  
 39,333  
 34,517  
 33,785  
 35,533  
 43,418  
 27,512  
 37,294  
 41,256

Ra 5,917  
 6,568  
 6,104  
 6,451  
 5,307  
 5,348  
 5,957  
 7,097  
 6,328  
 5,399

Rz 36,896  
 37,720  
 36,556  
 39,430  
 37,945  
 35,690  
 34,010  
 41,605  
 43,322  
 32,571

Record of Priming			
Start Time:	18:00	End Time:	20:00
Temperature $\geq 15^\circ$ :	25°C	Humidity $\leq 75\%$ :	40%
Paint Batch No.:	8016059	Paint Expiry Date:	08/25
Hardener Batch No.:	73-1119	Hardener Expiry Date:	01/11/24
Desolvation Start Time:	20:00	Desolvation End Time:	20:15
Stoving Start Time:	20:15	Stoving End Time:	21:15
Stoving Temp:	60°C		
Operator:	Neethu K	Sign:	
Date:	2024/05/30		Neethu K

Priming Control							
RAL							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 134	5: 137	1: 132	5: 180	1: 131	5: 187	1: 107	5: 185
2: 156	6: 92.2	2: 169	6: 93.3	2: 119	6: 59.9	2: 116	6: 97.9
3: 124	7: 100	3: 151	7: 84.0	3: 127	7: 95.0	3: 115	7: 96.9
4: 196	8: 145	4: 157	8: 83.4	4: 188	8: 86.8	4: 108	8: 148
Min:	92.2	Min:	83.4	Min:	59.9	Min:	96.9
Max:	156	Max:	180	Max:	187	Max:	185
Average:	136	Average:	131	Average:	120	Average:	122
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 163	5: 108	1: 187	5: 144	1: 122	5: 181	1: 158	5: 99.6
2: 124	6: 107	2: 163	6: 138	2: 166	6: 136	2: 131	6: 177
3: 123	7: 112	3: 178	7: 174	3: 197	7: 174	3: 132	7: 196
4: 183	8: 100	4: 140	8: 143	4: 196	8: 194	4: 130	8: 100
Min:	107	Min:	138	Min:	122	Min:	99.6
Max:	183	Max:	187	Max:	197	Max:	196
Average:	128	Average:	159	Average:	171	Average:	142
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 48.4	5: 62.8	1: 42.7	5: 71.8	1: 49.3	5: 85.3	1: 90.5	5: 93.0
2: 62.7	6: 42.6	2: 61.9	6: 55.9	2: 66.4	6: 86.2	2: 44.8	6: 38.2
3: 71.1	7: 35.6	3: 64.8	7: 72.6	3: 83.2	7: 72.5	3: 61.5	7: 48.2
4: 59.6	8: 35.6	4: 60.3	8: 65.2	4: 66.5	8: 86.2	4: 48.9	8: 62.9
Min:	35.6	Min:	42.7	Min:	49.3	Min:	38.2
Max:	71.1	Max:	72.6	Max:	86.2	Max:	93.0
Average:	52.3	Average:	61.9	Average:	75.7	Average:	61.0
Primer has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	Zothile			Sign:	H. K.		
Date:	01 June 2024						

Record of Painting NCSS3010 R90B			
Start Time:	03:00	End Time:	03:30
Temperature ≥ 15°:	27°C	Humidity ≤ 75%:	59%
Paint Batch No.:	8216294	Paint Expiry Date:	04-04-2025
Hardener Batch No.:	8138193113	Hardener Expiry Date:	11/26
Desolvation Start Time:	03:30	Desolvation End Time:	03:45
Stoving Start Time:	03:45	Stoving End Time:	04:45
Stoving Temp:	60°C		
Operator:	NTUT4010	Sign:	[Signature]
Date:	2024/06/13		

Painting NCSS3010 R90B Control				
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)
1: 1623	5: 1408	1: 8819	5: 7117	
2: 78.9	6: 142.9	2: 629	6: 152.8	
3: 611	7: 71.9	3: 144.8	7: 142.9	
4: 152.0	8: 82.9	4: 141.0	8: 84.6	
Min:	611	Min:	629	
Max:	162.3	Max:	152	
Average:	113	Average:	110	
Painting NCSS3010 R90B has been inspected and is free of defects		Confirmed	Yes	
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	32.7	
QC Inspector:	Zothide		Sign:	[Signature]
Date:	14 June 2024			

**Record of Painting Blue NCSS1565 B**

Start Time:	08:00	End Time:	08:30
Temperature ≥ 15°:	29°C	Humidity ≤ 75%:	57%
Paint Batch No.:	8216288	Paint Expiry Date:	27.03.2025
Hardener Batch No.:	8138195113	Hardener Expiry Date:	11/26
Desolvation Start Time:	08:30	Desolvation End Time:	08:45
Stoving Start Time:	08:45	Stoving End Time:	06:45
Stoving Temp:	60°C		
Operator:	Ntutho ko	Sign:	Ntutho ko
Date:	2024/06/13		

**Painting Blue NCSS1565 B Control**

DFT-Exterior Door- Aperture RHS		DFT Exterior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)				
1: 112	5: 983	1: 128	5: 100					
2: 108	6: 101	2: 161	6: 121					
3: 121	7: 147	3: 137	7: 130					
4: 129	8: 139	4: 103	8: 127					
Min: 983		Min: 100						
Max: 147		Max: 161						
Average: 120		Average: 125						
Painting NCSS3010 R90B has been inspected and is free of defects							Confirmed	Yes
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	903			
QC Inspector:	Zothile			Sign:	Zothile			
Date:	14 June 2024							

**Record of RAL 7012**

Start Time:	13:00	End Time:	15:00
Temperature ≥ 15°:	28 °C	Humidity ≤ 75%:	46%
Paint Batch No.:	8216273	Paint Expiry Date:	13-03-25
Hardener Batch No.:	8787506024	Hardener Expiry Date:	02/27
Desolvation Start Time:	15:00	Desolvation End Time:	15:15
Stoving Start Time:	15:15	Stoving End Time:	16:15
Stoving Temp:	60 °C		
Operator:	Phoka	Sign:	
Date:	2024/06/15		Phoka

**RAL 7012 Control PEIMANG CONTROL**

DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 828	5: 83.5	1: 62.1	5: 89.0	1: 50.0	5: 60.7	1: 41.8	5: 72.6
2: 74.5	6: 56.2	2: 71.6	6: 68.6	2: 62.6	6: 92.4	2: 76.9	6: 79.2
3: 50.2	7: 66.9	3: 70.9	7: 60.5	3: 76.1	7: 62.6	3: 92.0	7: 41.8
4: 58.7	8: 76.1	4: 10.4	8: 53.4	4: 49.1	8: 74.5	4: 51.4	8: 44.0
Min:	50.2	Min:	53.4	Min:	49.1	Min:	41.8
Max:	83.5	Max:	10.4	Max:	92.4	Max:	92.0
Average:	70.0	Average:	72.5	Average:	64.1	Average:	62.4
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 50.4	5: 62.6	1: 12.5	5: 47.7	1: 63.8	5: 79.6	1: 54.5	5: 76.1
2: 53.4	6: 83.5	2: 40.3	6: 12.4	2: 61.5	6: 80.6	2: 55.4	6: 76.2
3: 50.2	7: 10.7	3: 40.1	7: 55.6	3: 62.4	7: 69.9	3: 50.6	7: 76.5
4: 50.3	8: 65.3	4: 52.5	8: 96.8	4: 79.4	8: 80.6	4: 76.1	8: 50.2
Min:	50.2	Min:	40.1	Min:	61.5	Min:	50.2
Max:	10.7	Max:	12.5	Max:	80.6	Max:	76.5
Average:	58.6	Average:	73.5	Average:	72.2	Average:	64.4
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 72.6	5: 51.9	1: 45.3	5: 80.1				
2: 72.9	6: 62.5	2: 73.4	6: 80.3				
3: 12.7	7: 62.1	3: 87.1	7: 87.0				
4: 51.7	8: 74.7	4: 79.7	8: 71.7				
Min:	51.7	Min:	45.3				
Max:	12.7	Max:	87.1				
Average:	70.7	Average:	75.5				

Painting NCSS3010 R90B has been inspected and is free of defects	Confirmed	Yes	No
GMS-SOS-GIBELA-PS-002 Gloss Test	Value		
QC Inspector:	Jotrule		
Date:	09 June 2024		
	Sign:		

**SEALING OF CABIN**

All areas where there is no welding has been sealed with SIKA	Confirmed	YES	NO
All sealants have been neatly applied along joints	Confirmed	YES	NO

**SIGN OFF**

CLOCK NO:	2400	OPERATOR SIGN:	APHILE	DATE:	01/06/24
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# REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)

