

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

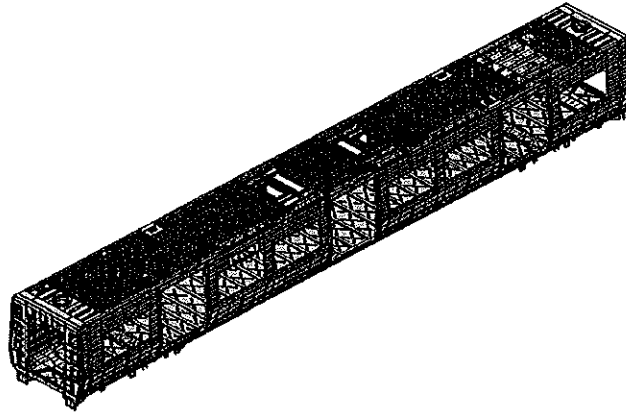
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY?	
				TC1	MA	M1	M2	M3	TC2			
<input type="checkbox"/>	DTR31374497/3	AAD0003413329	CARBODYSHELL M2 ASSEMBLY	CB1210				<input checked="" type="checkbox"/>			PRA, CB1210, DTR313744 97/3.V25	YES
<input type="checkbox"/>												

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 CB1210	APPROVER	Itumeleng Modiba	12/12/2018
			CHECKER	Nosizo Pindela	12/12/2018
			REVISED BY	Ramokone Motama	12/12/2018
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	22/01/2019
			CHECKER	Nosizo Pindela	22/01/2019
			REVISED BY	Vanessa Ntuli	22/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	21/08/2019
			CHECKER	Nosizo Pindela	21/08/2019
			REVISED BY	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021
			CHECKER	Mpho Mulaudzi	
			REVISED BY	Mpho Mulaudzi	
25	21/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	21/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlampe Amogelang	
			REVISED BY	Mohlampe Amogelang	
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023
			CHECKER	Zwane Ntokozo	
			REVISED BY	Mohlampe Amogelang	
28	07/11/2023	Addition of welder traceability	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Andani Muthelo	
			REVISED BY	Ntokozo Zwane	

TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
T3237	M2	Pentso 400164	04/07/24	SI.CB1210.247.V28	17



	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB1210.247.V28
		Date 07/11/2023	

Car: M2	HCR:	Work station: CB1210
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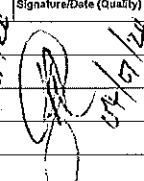
I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car					Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
	D	E	M	S	P						
DTR31374497/3			X			V28		✓		N/A	 04/07/24  04/07/24

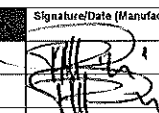
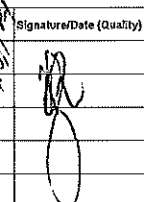
I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
WIPULAR	37803-0	15/03/05	✓		 04/07/24	 04/07/24
LASER TAPE	125125904	08/01/05	✓			
30M TAPE	618170102	18/11/24	✓			

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	314018-71097	MIG	✓		 04/07/24	 04/07/24
ER 308 L	299689-70300	TIG	✓			



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II- Self Inspection - Items to Check

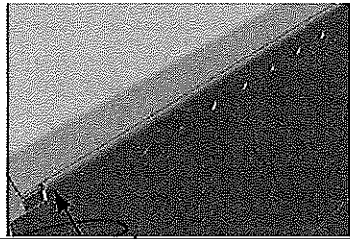
II.1 - Items to check

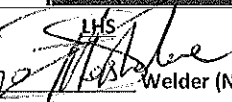



Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Not OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls, Endframes, Roof and Underframe)	AA00001375051	✓		04/07/24	04/07/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		04/07/24	04/07/24
03	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓		04/07/24	04/07/24
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		04/07/24	04/07/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		04/07/24	04/07/24
06		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓		04/07/24	04/07/24
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. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓		04/07/24	04/07/24

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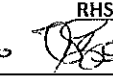

Welder traceability

Roof ring welds



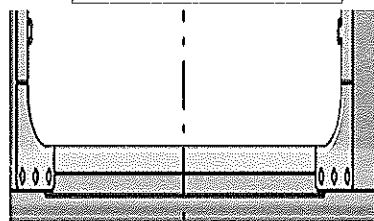
Boiler maker (Name & Sign): <u>TEBOLGO </u>	Welder (Name & Sign): <u>MITHOKOUSI </u>
LHS	
Boiler maker (Name & Sign): <u>TUNGUO </u>	Welder (Name & Sign): <u>MITHOKOUSI </u>
RHS	


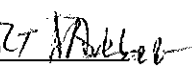
END 1


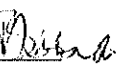
Boiler maker (Name & Sign): <u>TEBOLGO </u>	Welder (Name & Sign): <u>MITHOKOUSI </u>
LHS	
Boiler maker (Name & Sign): <u>TUNGUO </u>	Welder (Name & Sign): <u>MITHOKOUSI </u>
RHS	

END 2

Door ring welds



Boiler maker (Name & Sign): <u>TUNGUO </u>	
LHS	
Welder (Name & Sign): <u>ROBERT </u>	

Boiler maker (Name & Sign): <u>TUNGUO </u>	
RHS	
Welder (Name & Sign): <u>ROBERT </u>	



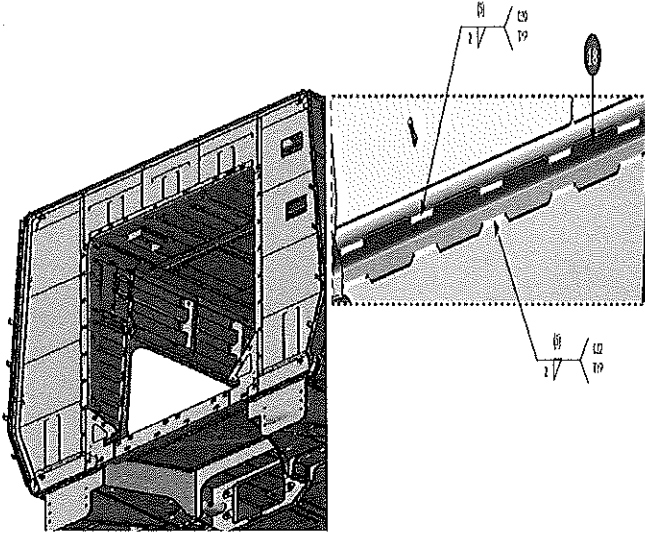


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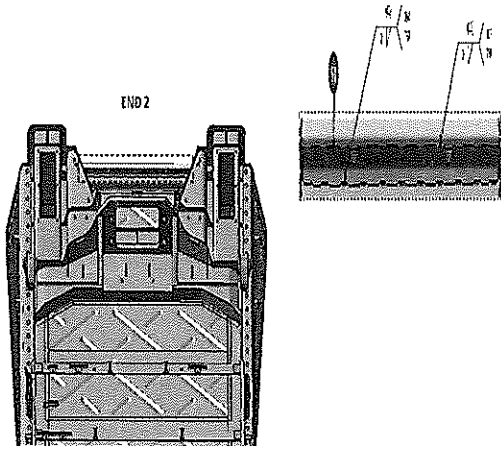
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EUF Reinforcement Plates

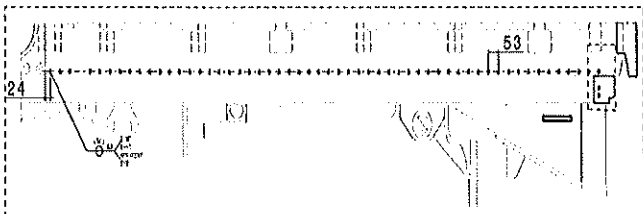


END 1
 Boiler maker (Name & Sign): GERALD Hill
 Welder (Name & Sign): M. HOKUSI




Underneath the CAR

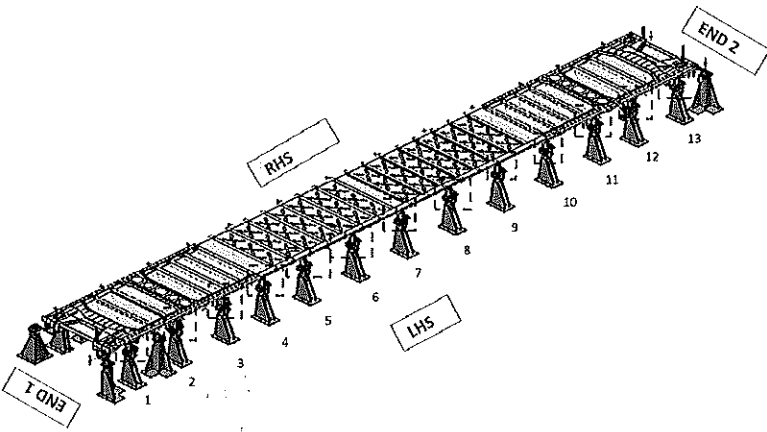
END 2
 Boiler maker (Name & Sign): Tim Puckett
 Welder (Name & Sign): FORREST M. Hill



FEDOLI
 OPERATOR: [Signature]

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Specifications of Details for CBS measurement




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

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

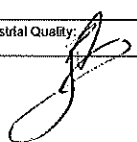
Signature Operations: 

Date: 04/07/24

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: 04/07/24

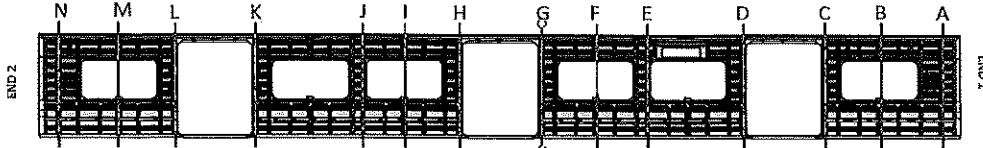


CARBODYSHELL M2 ASSEMBLY DTR31374497/3

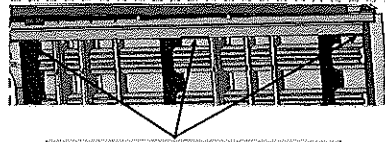
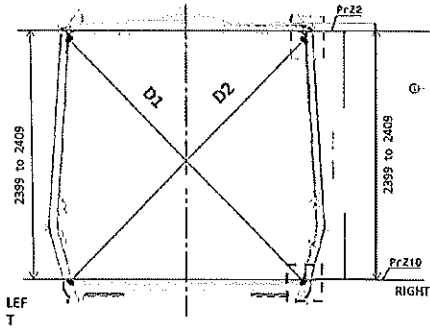
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Specifications of Details for CBS measurement



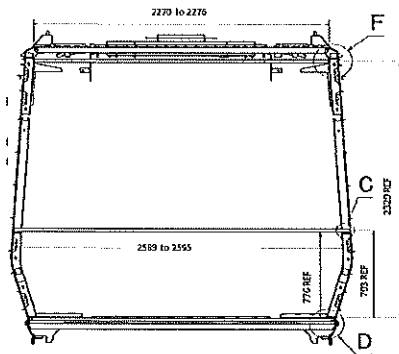
9



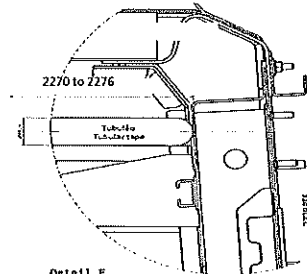
Measurement positions on roof rail and sidewall omega corner.



Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.



Detail F

Don't considering the reinforcement



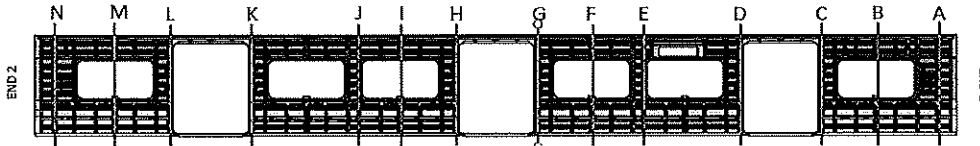
CARBODYSHELL M2 ASSEMBLY DTR31374497/3

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Specifications of Details for GBS measurement

BEFORE WELDING



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

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3269	3268	1	2404	2404	0
B	3272	3271	1	2405	2406	1
C	3270	3270	0	2404	2405	1
D	3268	3266	2	2404	2404	0
E	3220	3269	1	2406	2404	2
F	3268	3268	0	2405	2406	1
G	3269	3267	2	2404	2404	0
H	3270	3269	1	2405	2406	1
I	3266	3268	2	2404	2405	1
J	3272	3269	3	2404	2404	0
K	3268	3269	1	2405	2406	1
L	3269	3269	0	2405	2404	1
M	3271	3270	1	2406	2404	2
N	3267	3267	0	2404	2404	0

Handwritten signature and date:

 04/09/23



CARBODYSHELL M2 ASSEMBLY DTR31374497/3

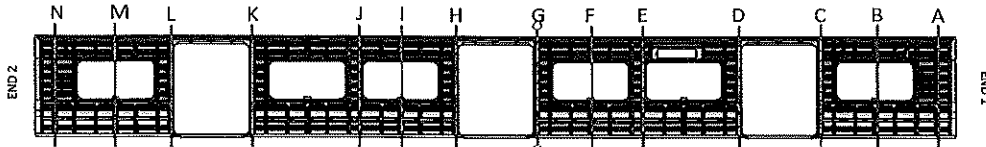
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Specifications of Details for CBS measurement

AFTER WELDING



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

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3298	3296	1	2404	2404	0
B	3269	3268	1	2406	2405	1
C	3296	3298	2	2405	2404	1
D	3298	3298	0	2406	2405	1
E	3271	3270	1	2404	2404	0
F	3269	3268	1	2405	2404	1
G	3296	3298	2	2404	2406	2
H	3296	3297	1	2405	2404	1
I	3268	3269	1	2406	2405	1
J	3270	3271	1	2404	2404	0
K	3296	3296	0	2406	2405	1
L	3298	3296	2	2404	2405	1
M	3269	3268	1	2404	2404	0
N	3295	3296	1	2406	2404	2


 409964
 04/07/24

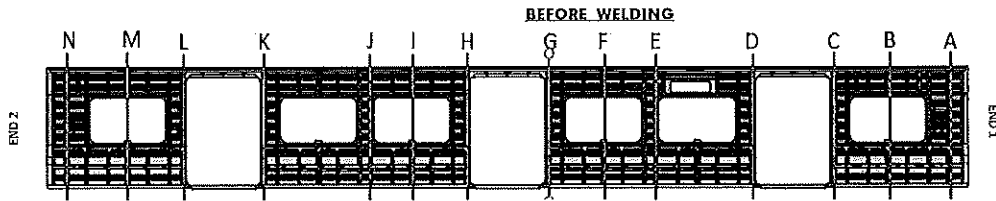


CARBODYSHELL M2 ASSEMBLY DTR31374497/3

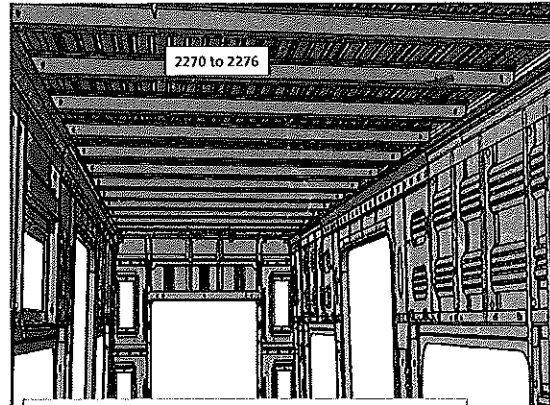
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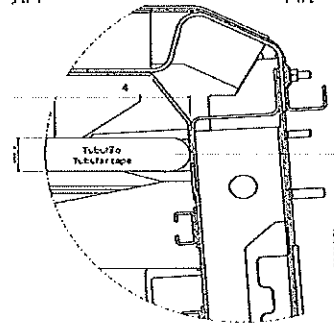
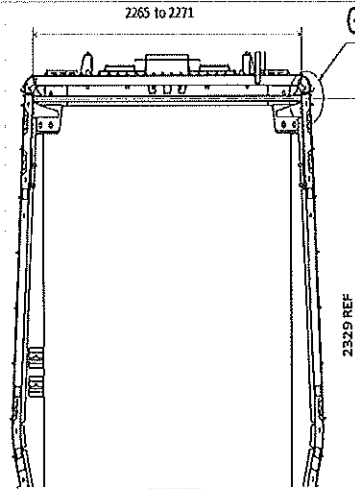
CBS measurement



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



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



Detail G
Considering the reinforcement plate

Handwritten note: *409964 04/07/24*



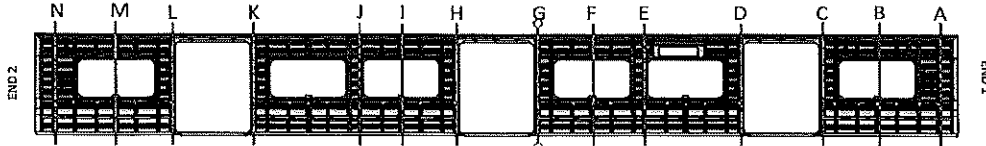
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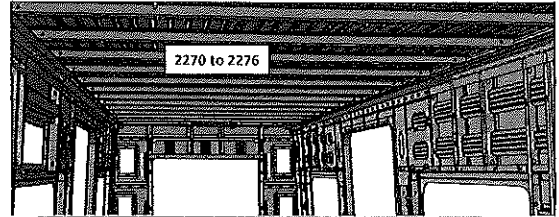
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CBS measurement

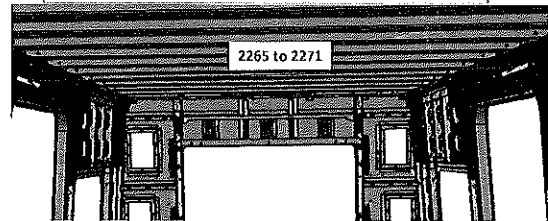
AFTER WELDING



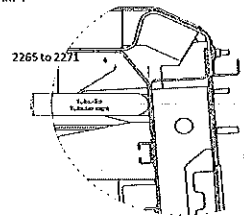
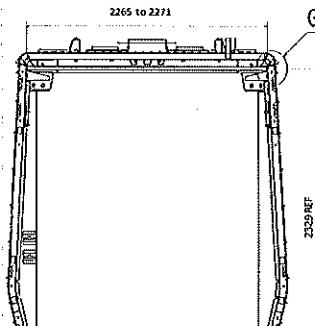
	2265 to 2271	2270 to 2276
A	2269	/
B	/	2274
C	2267	/
D	2266	/
E	/	2276
F	/	2275
G	2266	/
H	2268	/
I	/	2274
J	/	2276
K	2267	/
L	2268	/
M	/	2275
N	2267	/



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



Take measurement close to radius (considering reinforcement)



Detail G
Considering the reinforcement plate

Handwritten notes:
409964
04/07/2023



CARBODYSHELL M2 ASSEMBLY DTR31374497/3

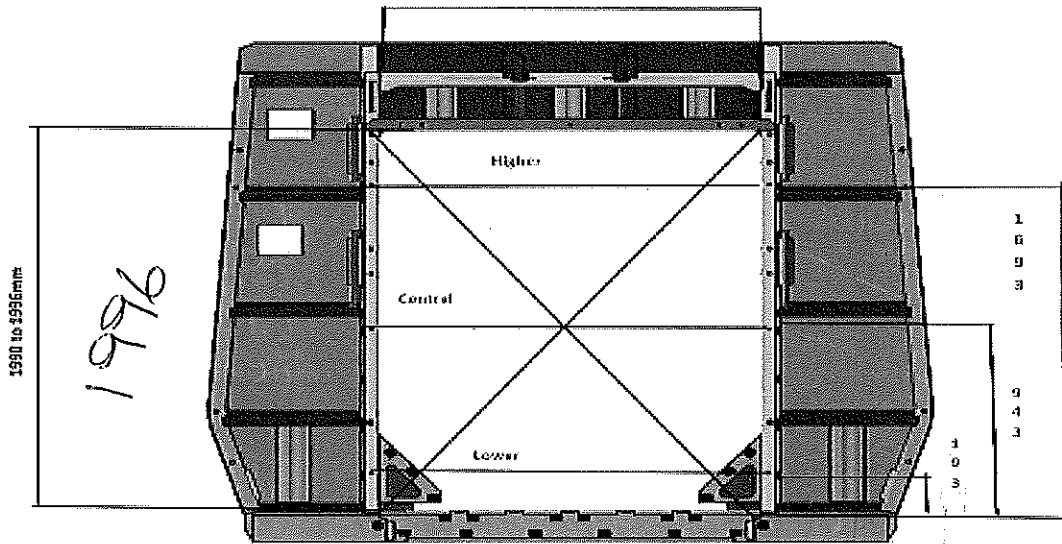
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GBS measurement

End frame 1

1380 to 1382 mm



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1380

D1

2416

Central Dimension

1381

D2

2415

Lower Dimension

1380

D1-D2

1

200996P
 04/07/24

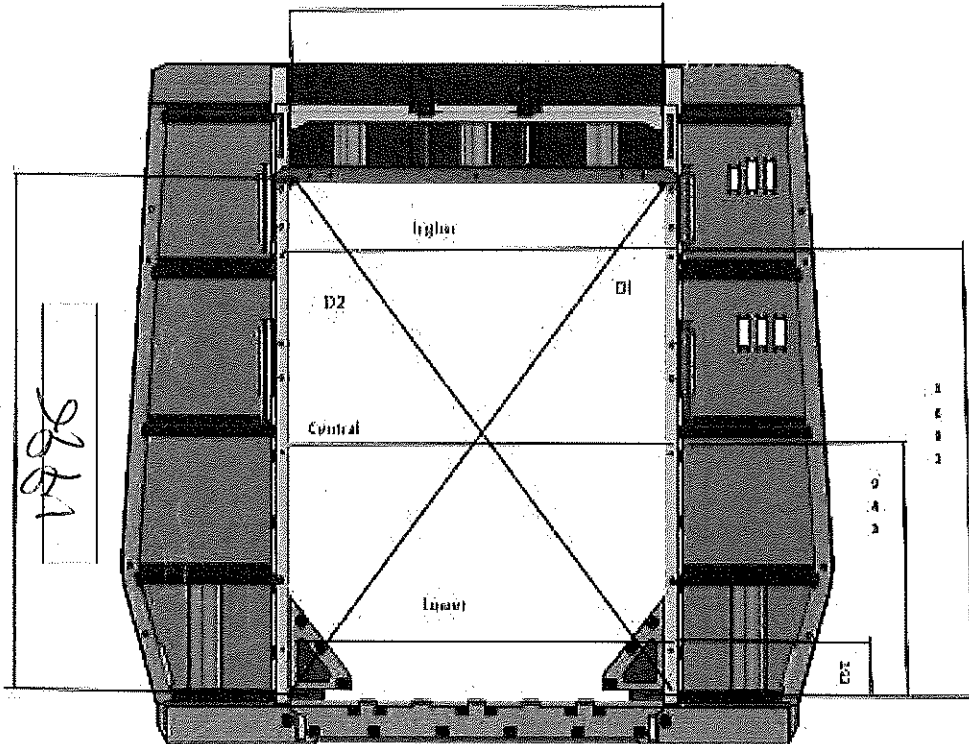


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End frame 2



1380 to 1382 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3\text{mm}$

Higher Dimension

1380

D1

2415

Central Dimension

1381

D2

2416

Lower Dimension

1380

D1-D2

1

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 04/07/24

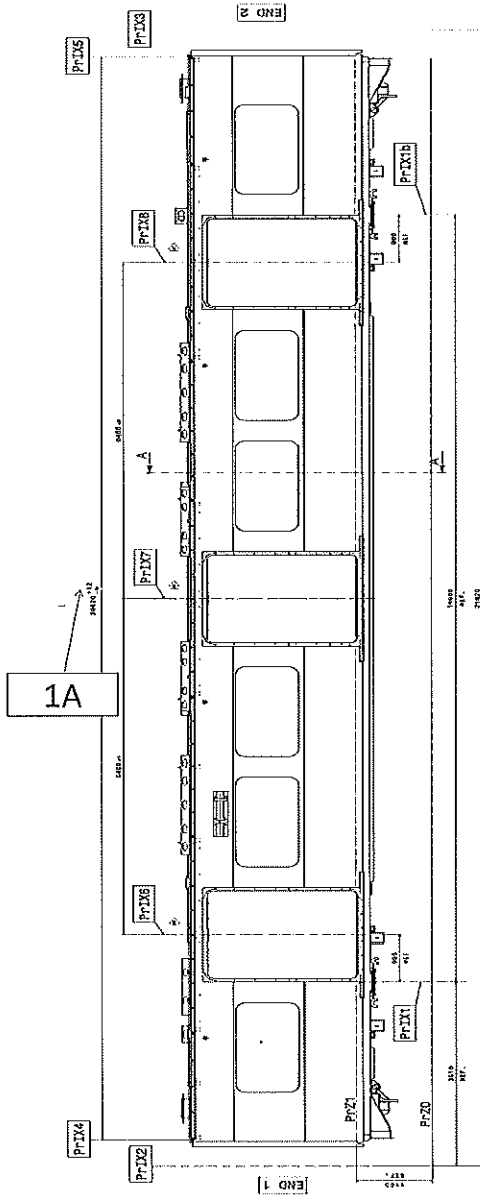


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Specifications of Details for GBS measurement



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20616


RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20616

Handwritten notes:
 409960
 04/10/24

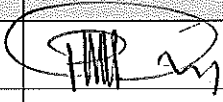
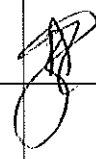
Dye penetrant test

Dye-penetration test to be performed by quality personnel



	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA
		Date 07/11/2023	SI.CB1210.247.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!)	07/11/23	Forbes Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	07/11/23	Ntokore Industrial Quality	
		There are activities pending that impact/top 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":

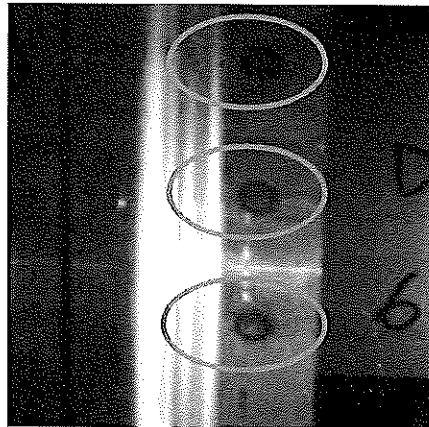
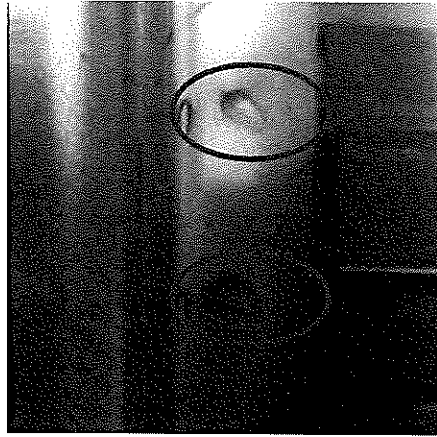
Item	Description	Responsible	Due date	Status

Operations

Quality

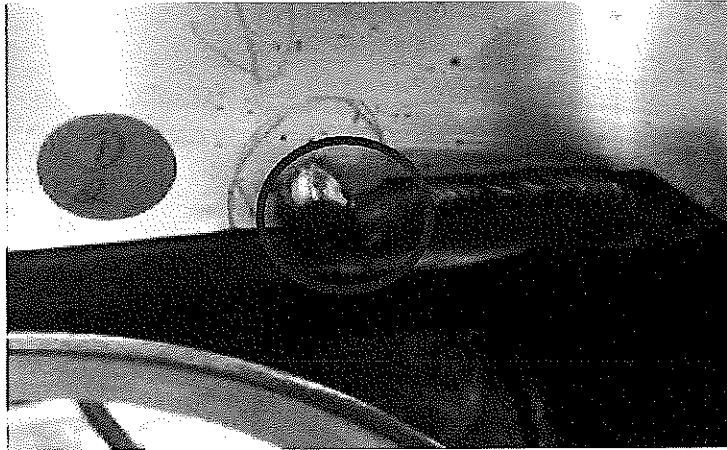
	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB1210.247.V28
		Date 07/11/2023	

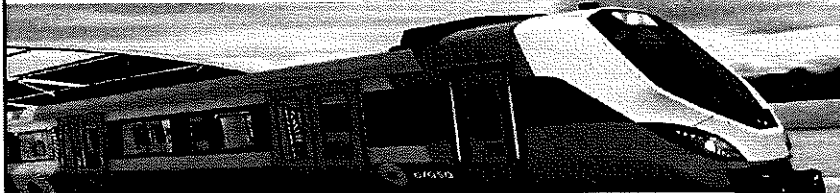
ANNEXURE A: Spot Welding Quality Acceptance Standard



	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA
		Date 07/11/2023	SI.CB1210.247.V28

ANNEXURE B: Arc Welding Quality Acceptance Standard





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 ?	
				TC	MC	ME	MF	MA	TE			
<input type="checkbox"/>	DTR000152865	AAD000413829	CARBODY/SHELL M2 ASSEMBLY	CB1210				X			PRA.CB1220.DTR31374497 /2.V21	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												

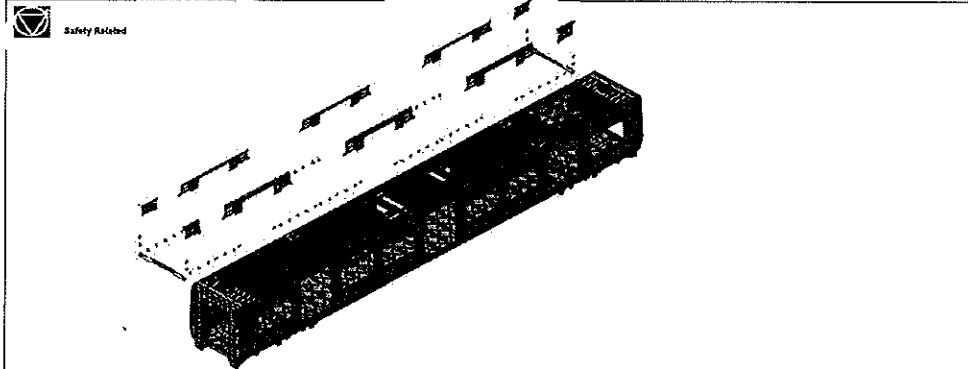
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	01/02/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	01/02/2018
			CHECKER	Nosizo Pindela	01/02/2018
			COMPILER	Thanyani Mathegu	01/02/2018
1	18/05/2018	Team leader and Quality Technician to sign. Change final signature from PME Manager to Quality 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 DT0000336600	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 Remove	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
7	27/05/2019	Removed measurement positions on the display windows	APPROVER	Itumeleng Modiba	27/05/2019
			CHECKER	Nosizo Pindela	27/05/2019
			REVISED BY	Nosizo Pindela	27/05/2019
10	22/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	22/08/2019
			CHECKER	Nosizo Pindela	22/08/2019
			REVISED BY	Nosizo Pindela	22/08/2019
15	06/08/2020	New Baseline 10.2.5	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	Mbhombi Collins	20/02/2022
			CHECKER	Andani Muthelo	20/02/2022
			REVISED BY	Andani Muthelo	20/02/2022
26	14/06/2022	Update Minimum temperature requirement for sealant application	APPROVER	Mbhombi Collins	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 and welding.	APPROVER	Mbhombi Collins	19/10/2022
			CHECKER	Ntokoza Zwane	19/10/2022
			REVISED BY	Amogelang Mchlampe	19/10/2022
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokoza Zwane	14/04/2023
			REVISED BY	Amogelang Mchlampe	14/04/2023
29	28/10/2023	Addition of bracket quantity	APPROVER	Tyson Ngobeni	28/10/2023
			CHECKER	Kelebene Mathapo	28/10/2023
			REVISED BY	Amogelang Mchlampe	28/10/2023

QUALITY

TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
237	M02	ASHIDA 90917	08-07-24	SI.CB1220.276.V29	15

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project PRASA
		29	
		Date	SI.CB1220.276.V29
		28/10/2023	

Car: M2	NCI:	Work station:	CB1220
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I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car					Revision	Observation		Signature/Data (Manufacturing)	Signature/Data (Quality)
	2	3	4	5	6					
DTR31374497/2	X					29	28-10-2023	X	N/A	[Signature]

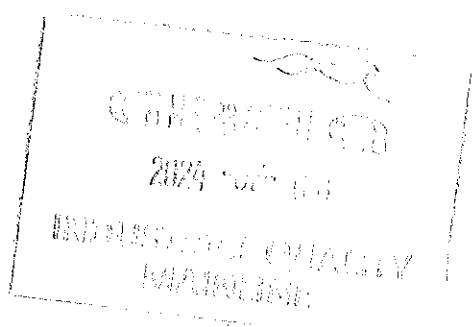
08-07-24 08/07/24

I.2 - Instruments Control

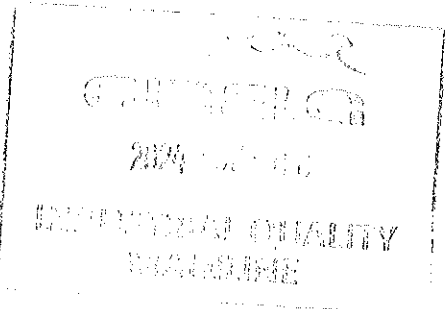
Monitoring and Measuring Instrument Control - Used for Special Process					
Instrument	Serial number	Calibration or Verification Validation Date		Signature/Data (Manufacturing)	Signature/Data (Quality)
Tubular measuring tape	318262	15-05-20	X	[Signature] 08-07-24	[Signature] 08/07/24
	618/ANWISS	17-00-20	X	[Signature] 08-07-24	[Signature] 08/07/24

I.3 Consumables

Welding Consumable Control - Used for Special Process					
Filler Material	Serial Number	Welding Process		Signature/Data (Manufacturing)	Signature/Data (Quality)
3 08	375779	MIG	X	[Signature] 08-07-24	[Signature] 08/07/24



GIBELO		CARBODYSHELL M2 ASSEMBLY DTR31374497/2		Rev. 29	Project: PRASA													
				Date 28/10/2023	SI.CB1220.276.V29													
II - Self Inspection - Items to Check																		
II.1 - Items to check																		
Item	Picture/Testing	Description	Reference (Drawing / Standard)	Pass	Signature/Date (Manufacturing)	Signature/Date (Quality)												
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1220. DTR31374497/2 Verification of fitment for all reinforcement brackets.	PRA.CB1220. DTR31374497/2	✓	08-07-24 	08/07/24 												
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210615	✓	08-07-24 	08/07/24 												
03	REFER TO ANNEXURE A	Art Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO QIB - TYPDEF - ARC - 0000	✓	08-07-24 	08/07/24 												
04		Cleaning of all Stainless Steel Surface	According TO QIB-WEL - PROC-0002	✓	08-07-24 	08/07/24 												
05		Functional dimensions Approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓	08-07-24 	NOL 08/07/24 												
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓	08-07-24 	08/07/24 												
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 <table border="1"> <tr> <td>Sealant</td> <td></td> <td>10°C -</td> </tr> <tr> <td>Temperature Min - Max (1)</td> <td>Min-Max</td> <td>34°C</td> </tr> <tr> <td>Relative Humidity Min -</td> <td>Min-Max</td> <td>25% -</td> </tr> <tr> <td>Max (1)</td> <td></td> <td>80%</td> </tr> </table>	Sealant		10°C -	Temperature Min - Max (1)	Min-Max	34°C	Relative Humidity Min -	Min-Max	25% -	Max (1)		80%	Sealant Batch No: <u>85373</u> Exp Date: <u>10/2/22</u> Actuals Temperature: <u>10</u> Humidity: <u>40</u>	✓	08-07-24 	08/07/24
Sealant		10°C -																
Temperature Min - Max (1)	Min-Max	34°C																
Relative Humidity Min -	Min-Max	25% -																
Max (1)		80%																
08	NA	Verification of sealant application in certain regions in the drawing.	AAD000143329	✓	08-07-24 	08/07/24 												



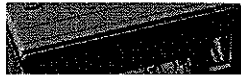


CARBODYSHELL M2 ASSEMBLY DTR31374497/2

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SEALANT APPLICATION

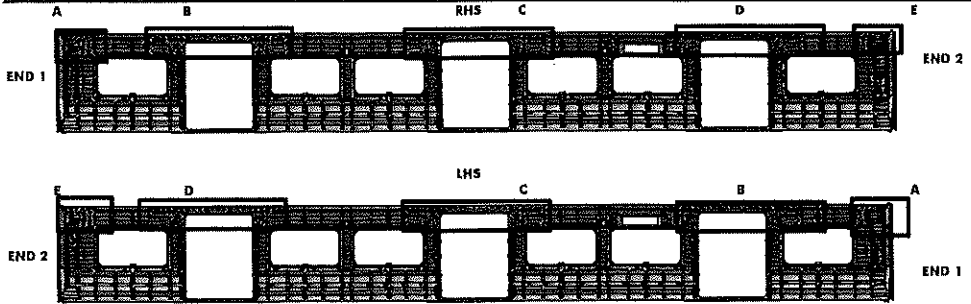


AREA 1 & 2 END 1

Operator (Name & sign): Mthokozisi
All


Operator (Name & sign): Mthokozisi
All

CREATED BY
2023-07-18
INDUSTRIAL QUALITY
MANAGEMENT

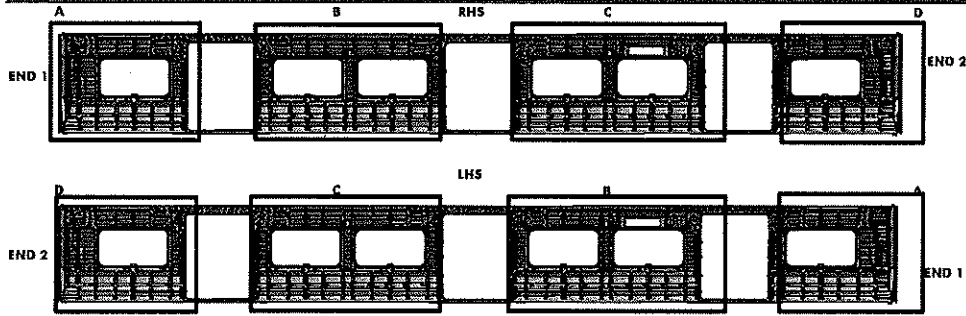


REINFORCEMENT WELDING

AREA	LHS	RHS
A	Operator (Name&sign): <u>LINDS @</u>	<u>LINDS @</u>
B	Operator (Name&sign): <u>MONTSELO IBA</u>	<u>MONTSELO IBA</u>
C	Operator (Name&sign): <u>Joshy Cao</u>	<u>Joshy Cao</u>
D	Operator (Name&sign): <u>MONTSELO IBA</u>	<u>MONTSELO IBA</u>
E	Operator (Name&sign): <u>MONTSELO IBA</u>	<u>MONTSELO IBA</u>


 MONTSELO IBA
 28/10/2023
 RESPONSIBILITY
 IBA

II - Self Inspection - Items to Check



BRACKETING

INSTALLATION

C-RAILS: Operator: Ashwini

Operator: Ashwini

DOOR MECHANISMS: Operator: Srinivas

Operator: _____

TAPPING PADS: Operator: LINDA ENDI

Operator: MADHUSRIK RAO

INSTALLATION & VERIFICATION

SEAT & LUGGAGE BRACKETS: Operator: MADHUSRIK RAO

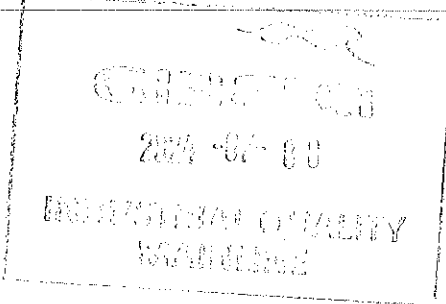
Operator: _____

SEAT BRACKETS VERIFICATION: Operator: Mechanick

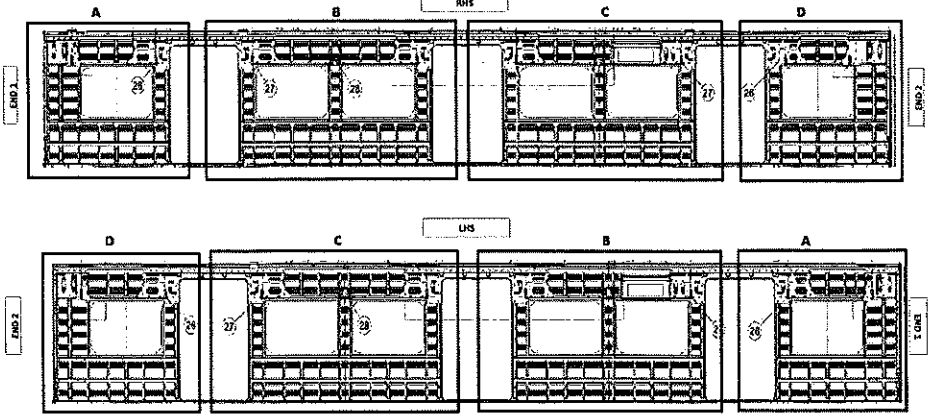
Operator: _____

WELDING

AREA	LHS	RHS
A (Seat brackets)	Operator (Name&sign): <u>[Signature]</u>	<u>LINDA ENDI</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>[Signature]</u>	<u>LINDA ENDI</u>
B (Seat brackets)	Operator (Name&sign): <u>[Signature]</u>	<u>LINDA ENDI</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>[Signature]</u>	<u>LINDA ENDI</u>
C (Seat brackets)	Operator (Name&sign): <u>MADHUSRIK RAO</u>	<u>MADHUSRIK RAO</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>Srinivas</u>	<u>MADHUSRIK RAO</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>MADHUSRIK RAO</u>
ENDS		
END 1 TAPPING PADS WELDING:	Operator (Name&sign): <u>LINDA ENDI</u>	
END 2 TAPPING PADS WELDING:	Operator (Name&sign): <u>MADHUSRIK RAO</u>	



M2 BRACKET INSTALLATION




QUANTITIES (M2)

RHS

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


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


VERIFICATION BY: *ASHER* 

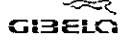
LHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	9		
	B	11		
	C	11		
	D	12		
SEAT BRACKETS	A	12		
	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: *ASHER* 

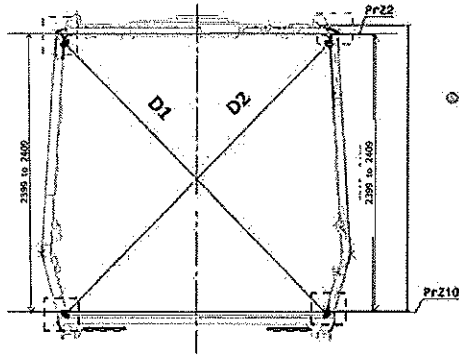

 2023-07-08
 ENGINEERING QUALITY
 CONTROL



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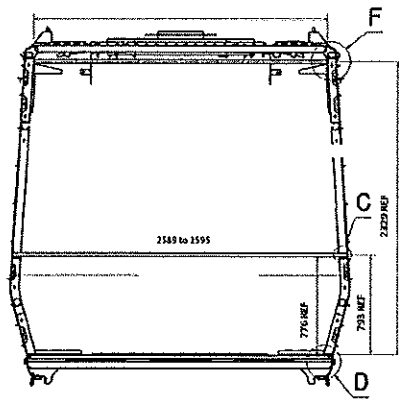
Measurement position on roof lid lid level overall drawing.



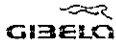
Point of contact with measurement position on roof lid measurement level.



Measurement position on overall lid lid level drawing.



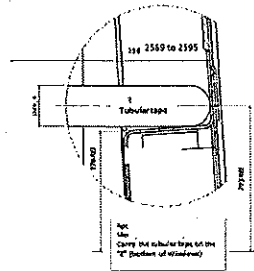
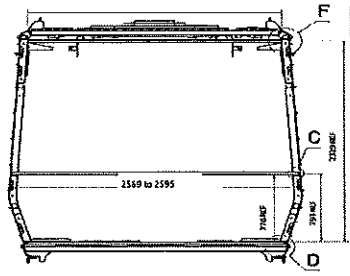
GIBELQ
2023-07-08
INDUSTRIAL GROUP
LW/RE/11/02



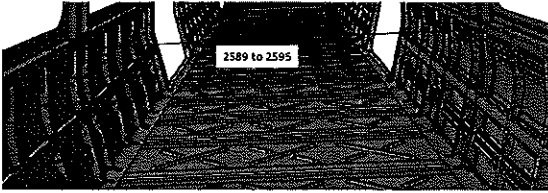
CARBODYSHELL M2 ASSEMBLY DTR31374497/2

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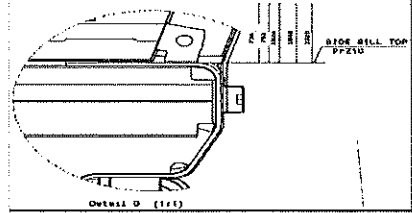
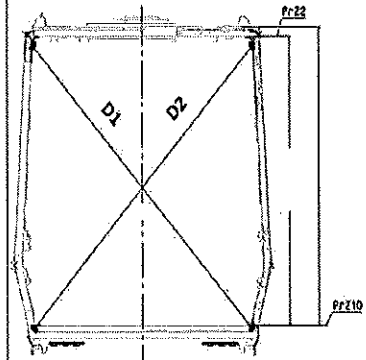
Project: PRASA
SI.CB1220.276.V29



Detail C



Take measurement close to radius



Handwritten notes:
28/10/23
2024-11-08
[Illegible]

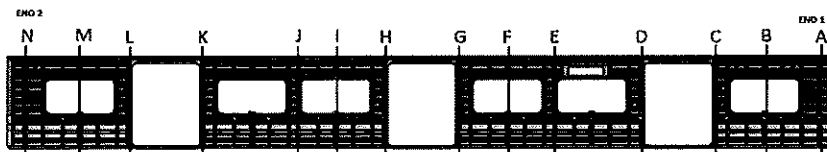


CARBODYSHELL M2 ASSEMBLY DTR31374497/2

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CBS measurement



BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	326	326	0	
B	324	322	00	
C	324	326	15	
D	326	325	0	
E	326	326	0	
F	327	327	(X)	
G	327	327	0	
H	326	326	01	
I	326	327	2	
J	326	326	01	
K	327	327	0	
L	327	327	06	
M	327	326	13	
N	329	329	06	

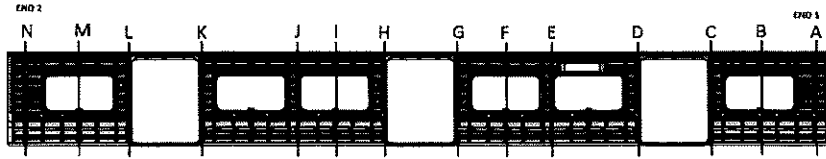
02-07-2023

GIBELA S.p.A.
 28-07-2023
 INSPECTION QUALITY
 CONTROL

231 M2

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA
		29	
		Date	SI.CB1220.276.V29
		28/10/2023	

CBS measurement



AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3295	3300	7	2595
B	3267	3261	6	2593
C	3295	3300	5	2591
D	3295	3296	1	2591
E	3267	3267	0	2595
F	3266	3266	0	2595
G	3294	3296	3	2594
H	3294	3302	7	2594
I	3266	3264	2	2595
J	3285	3272	7	2595
K	3265	3272	7	2595
L	3302	3289	10	2589
M	3275	3256	10	2591
N	3302	3295	7	2595

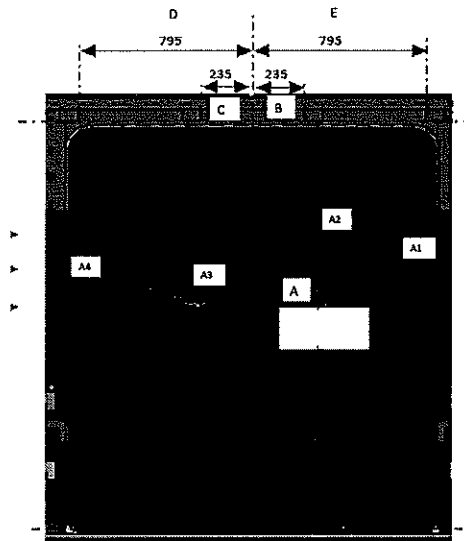
3295

PME
Use as is
From
Let few
and few
points
out
is not a
concern

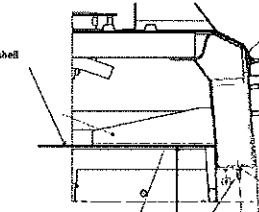
DB-07-24

Handwritten notes in a box, including dates and possibly names, which are mostly illegible due to blurring.

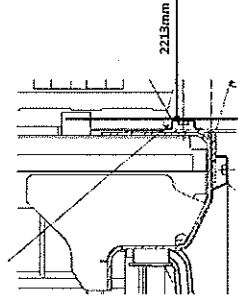
Specifications of Details for CBS measurement CB1220



Brackets Carbodyshell
U Type Supports



Brackets Carbodyshell
Channel Assy



DOOR 1 - LHS

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

DOOR 2 - LHS

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

DOOR 3 - LHS

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

DOOR 1 - RHS

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

DOOR 2 - RHS

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

DOOR 3 - RHS

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

[Handwritten signature]
08-07-24

[Handwritten text: CARBODY SHELL M2 ASSEMBLY DTR31374497/2]



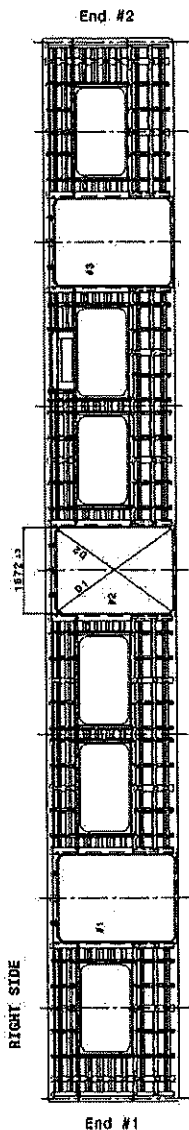
CARBODYSHELL M2 ASSEMBLY DTR31374497/2

Rev. 29
Date 28/10/2023

Project: PRA5A

SI.CB1220.276.V29

Specifications of Details for CBS measurement CB1220

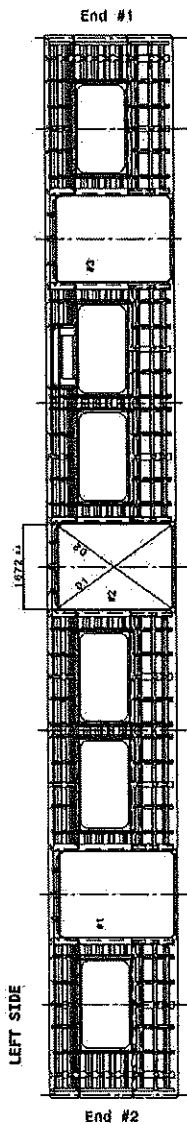


Doors diagonal D1-D2 maximum difference ≤ 4mm

D1	D2	D1-D2
2746	2743	3

Doors length = 1672 ±3mm

HIGHER DIMENSION	CENTRAL DIMENSION	LOWER DIMENSION
1673	1672	1671



4mm

D1	D2	D1-D2
2746	2742	4


Vão de Portas = 1672 ±3mm

HIGHER DIMENSION	CENTRAL DIMENSION	LOWER DIMENSION
1673	1672	1671



Handwritten signature and stamp.

08-0-F-22-4

Handwritten notes and stamps at the bottom of the page.

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev. 29	Project: PRASA SI.CB1220.276.V29
		Date 26/10/2023	

Self Inspection - Final Result

16. Is the case good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)		DATE	NAME	SIGNATURE
HOLD POINT	(If activities are not complete, the missing activities must not impact the next stage)		Operations	
	Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party)		Industrial Quality	
	There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)	08-07/23	SILVUSKI	
	There are non-conformances in the quality of the product and there is no corrective action defined yet)	08/07/23	Amogelag	

In case of "NO GO", describe blocking problems
Diagonals out of spec


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

Item	Description	Responsible	Due date	Status

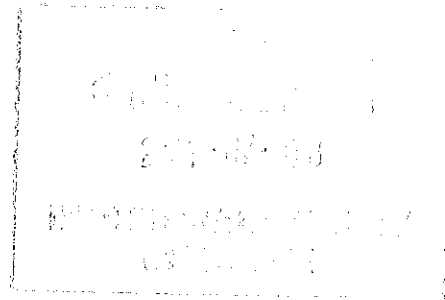
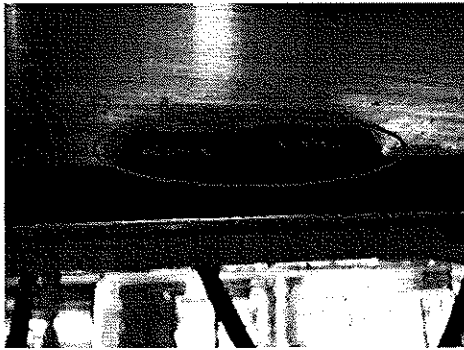
Operations

Quality

08-07-23
 08/07/23
 08/07/23

	CARBODYSHELL M2 ASSEMBLY DTR31374497Z	Rev.	Project: PRASA SI.CB1220.276.V29
		29	
		Date	
		28/10/2023	

ANNEXURE A: Arc Welding Quality Acceptance Standard






APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

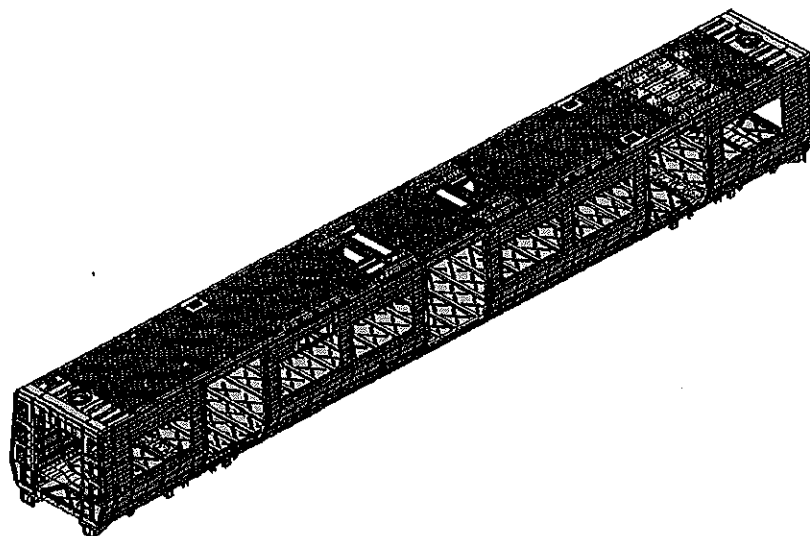
CONFIDENTIAL INFORMATION
This document and the information contemplated therein have to be considered as Confidential information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE							WORK INSTRUCTION	SAFETY ?
				TC1	MA	M1	M2	M3	TC2			
<input type="checkbox"/>	AA0000137497	AA00001413329	CARBODYSHELL M2 ASSEMBLY	CB1230				X			PRA.CB1230.AA0000137497.V20	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
RFV	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	Rantokone 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	Vanessa Ntuli	13/03/2019						
10	23/03/2019	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 Mhombhi	20/02/2022						
				CHECKER	Andani Muthelo							
				REVISED BY	Andani Muthelo							
26	14/06/2022	Update minimum temperature requirement for sealant application		APPROVER	Collins Mhombhi	14/06/2022						
				CHECKER	Andani Muthelo							
				REVISED BY	Andani Muthelo							
27	26/07/2022	Threshold measurement addition		APPROVER	Collins Mhombhi	27/07/2022						
				CHECKER	Andani Muthelo							
				REVISED BY	Andani Muthelo							
28	17/10/2022	Addition of traceability for sealant application		APPROVER	Collins Mhombhi	17/10/2022						
				CHECKER	Ntokozo Zwane							
				REVISED BY	Amogelang Mohlampe							
29	14/04/2023	Added sealant batch number & welding consumables traceability		APPROVER	Vanessa Ntuli	14/04/2023						
				CHECKER	Ntokozo Zwane							
				REVISED BY	Amogelang Mohlampe							
30	06/11/2023	Added traceability on thresholds for boiler makers and welders		APPROVER	Ngobeni Tyson	06/11/2023						
				CHECKER	Andani Muthelo							
				REVISED BY	Ntokozo Zwane							
TRAINSET	CAR	OPERATOR NAME & ALPS NO		DATE	SELF INSPECTION NUMBER		PAGES					
337	M702	Boitumelo 4269163		09/10/24	SI.CB1230.277.V29		11					

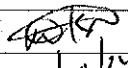
	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA SI.CB1230.277.V29
		Date 06/11/2023	

Car:	NCR:	Work station: CB1230
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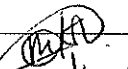
I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	NCR	Reason	Signature/Date (Operations)	Signature/Date (Quality)
	D1	M	S	M2	M4	T2							
PRA.CB1230.AA00001374497			X				29		X		N/A	BANDI SE 09/10/24	 09/01/24

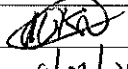
I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	NCR	Signature/Date (Operations)	Signature/Date (Quality)
Tubular	39823-3	15/03/2025	X		BANDI SE 09/10/24	
Measuring Tape	CB1A0401	22/04/2025	X		BANDI SE 09/10/24	
Combination Square	GIB500100	27/05/2025	X		BANDI SE 09/10/24	 09/01/24

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NCR	Signature/Date (Manufacturing)	Signature/Date (Quality)
308 LSi	373179	Mig Welding	X		BANDI SE 09/10/24	 09/01/24



CARBODYSHELL M2 ASSEMBLY AA00001374497

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Date

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Project: PRASA

SI.CB1230.277.V29

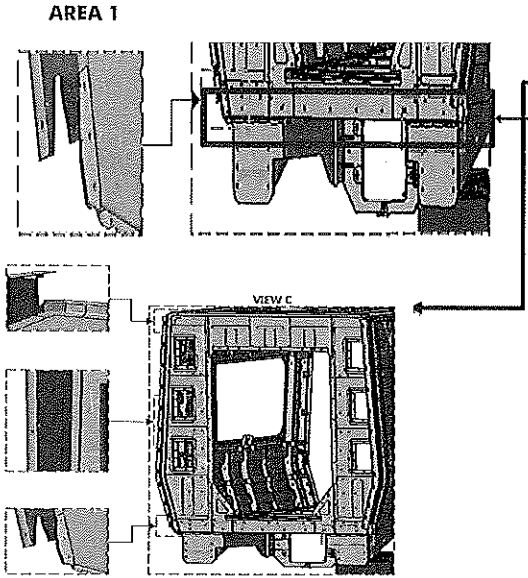
II - Self Inspection - Items to Check

II.1 - Items to check

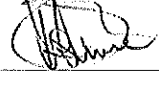
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOX	EXCPT	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering nº PRA.CB1230.AA00001374497 Verification of fitment for all brackets.	PRA.CB1230.AA00001374497	X			09/10/24	09/10/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	X			09/10/24	09/10/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	X			09/10/24	09/10/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	X			09/10/24	09/10/24
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			09/10/24	09/10/24
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS 018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	X			09/10/24	09/10/24
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: Temperature Min - Max (1) : Min-Max : 10°C - 35°C Relative Humidity Min - Max (1) : Min-Max : 25% - 80%	Sealant Batch No: <u>ISR 10-08</u> Exp Date: <u>1/02/25</u> Actuals Temperature: <u>13°C</u> Humidity: <u>45%</u>	X			09/10/24	09/10/24
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.	X			09/10/24	09/10/24

	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA SI.CB1230.277.V29
		Date 06/11/2023	
		Date 06/11/2023	

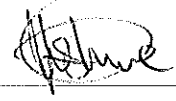
END 2 SEALANT



OPERATOR
(Name & sign):

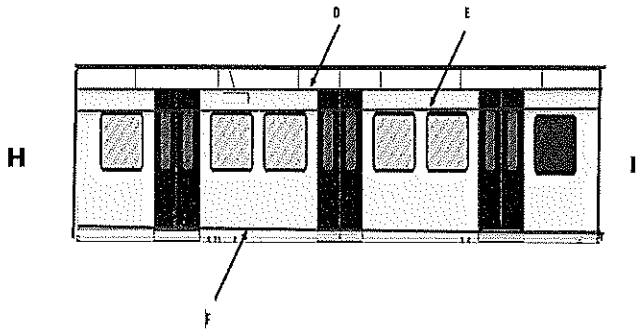
Leroy 

OPERATOR
(Name & sign):

Leroy 

OPERATOR
(Name & sign):

Leroy 




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

Operator (Name & sign):

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


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

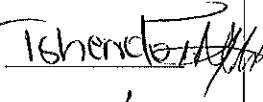
Operator (Name & sign):

Sihle 

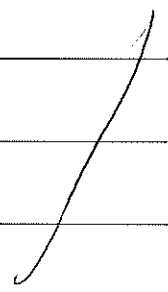
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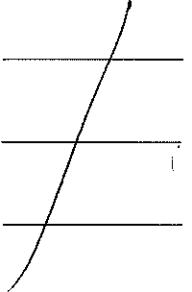
Operator (Name & sign):

Tshendo 

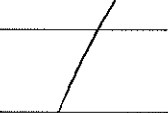
Tshendo 

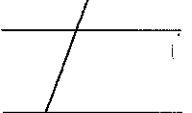
Operator (Name & sign):



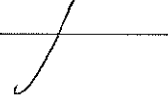


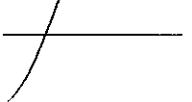
Operator (Name & sign):





Operator (Name & sign):







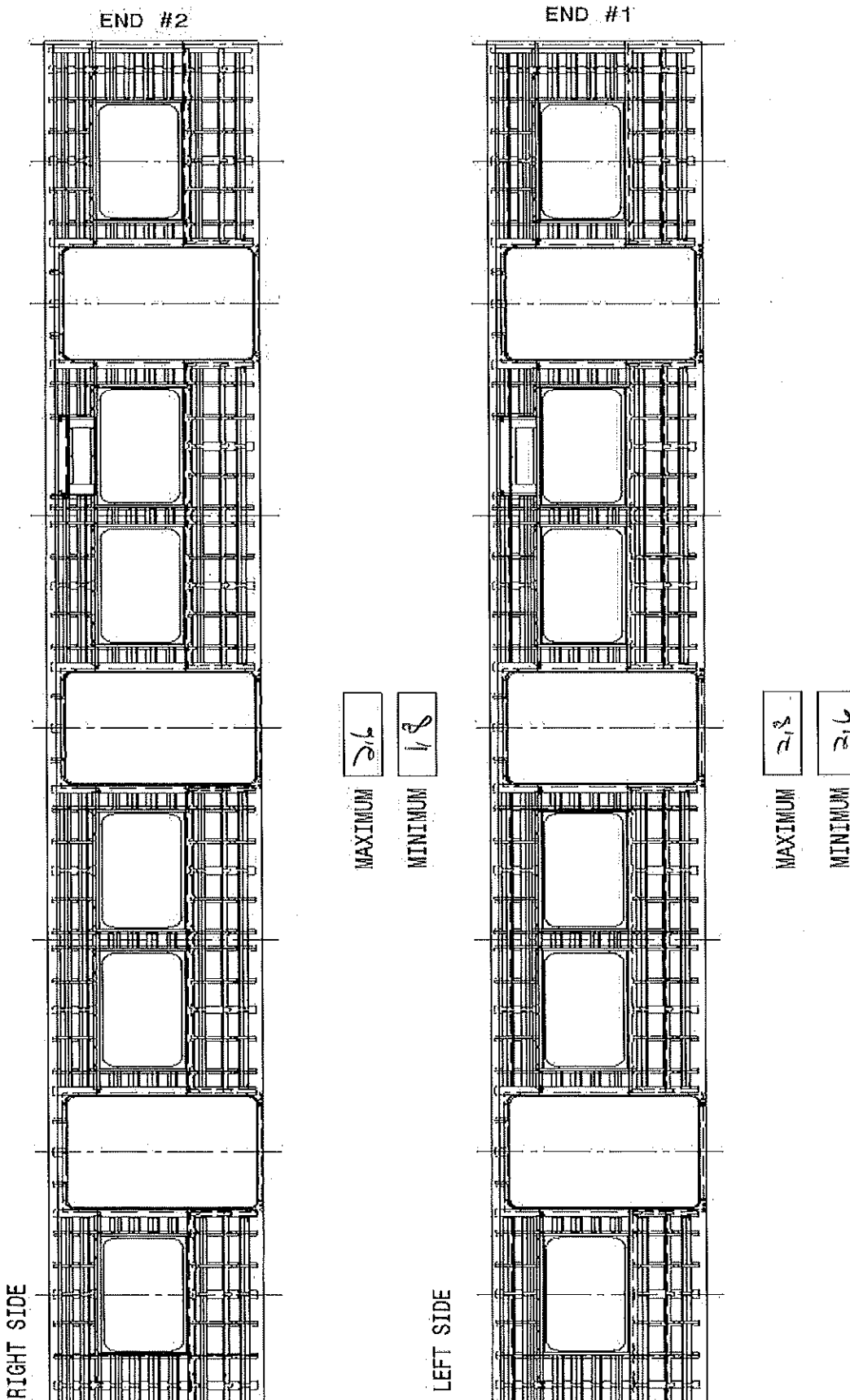
CARBODYSHELL M2 ASSEMBLY AA00001374497

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Date
06/11/2023

Project: PRASA
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Specifications of Details for CBS measurement CB1230

Flatness side left and right maximum of 2mm in the valley to peak measured in 100mm. Record the maximum and minimum value around and indicate the corresponding region.





CARBODYSHELL M2 ASSEMBLY AA00001374497

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END #1

END #2



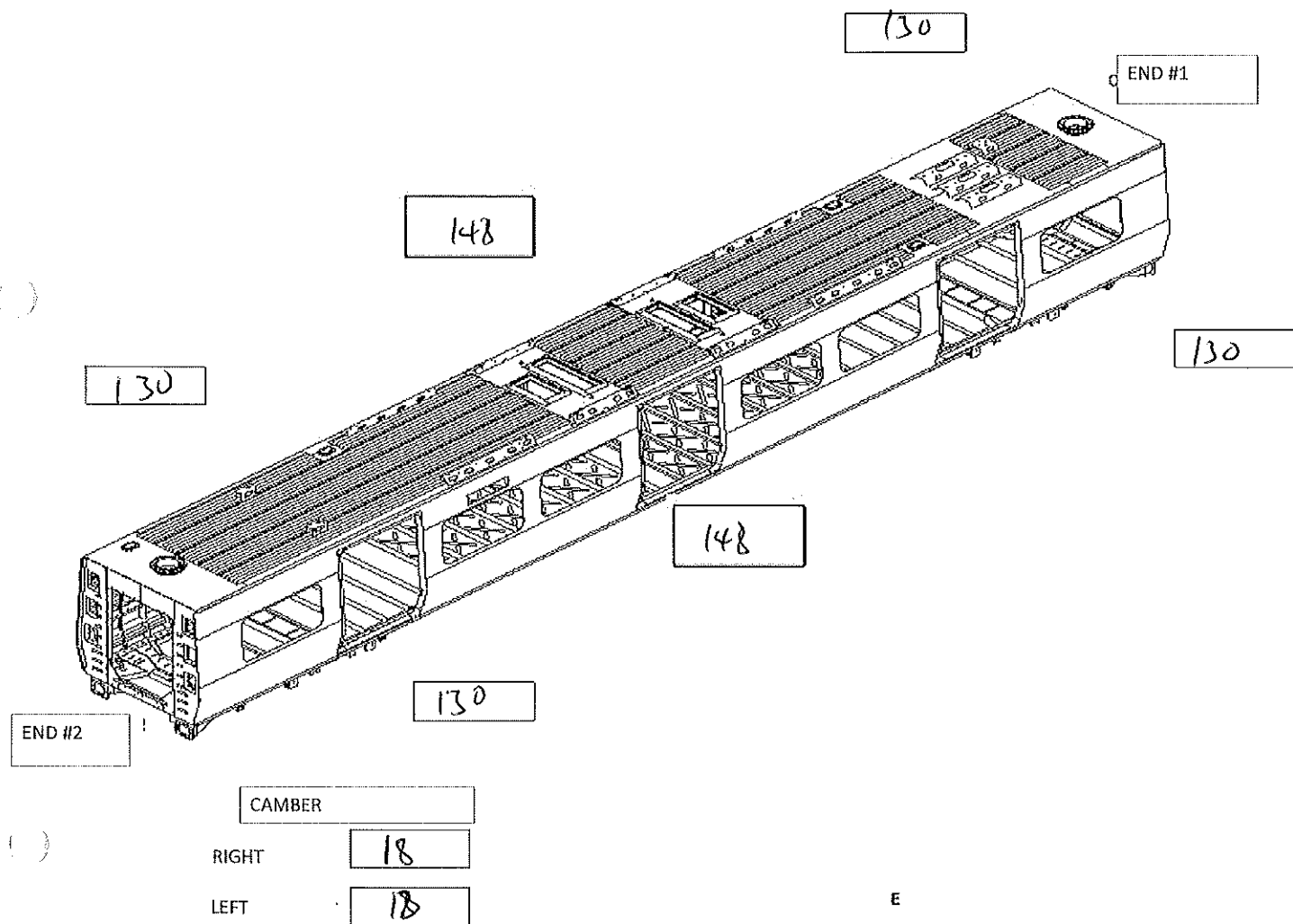
CARBODYSHELL M2 ASSEMBLY AA00001374497

Rev.
30
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06/11/2023

Project: PRASA
SI.CB1230.277.V29

Specifications of Details for CBS measurement CB1230

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





CARBODYSHELL M2 ASSEMBLY AA00001374497

Rev.
30

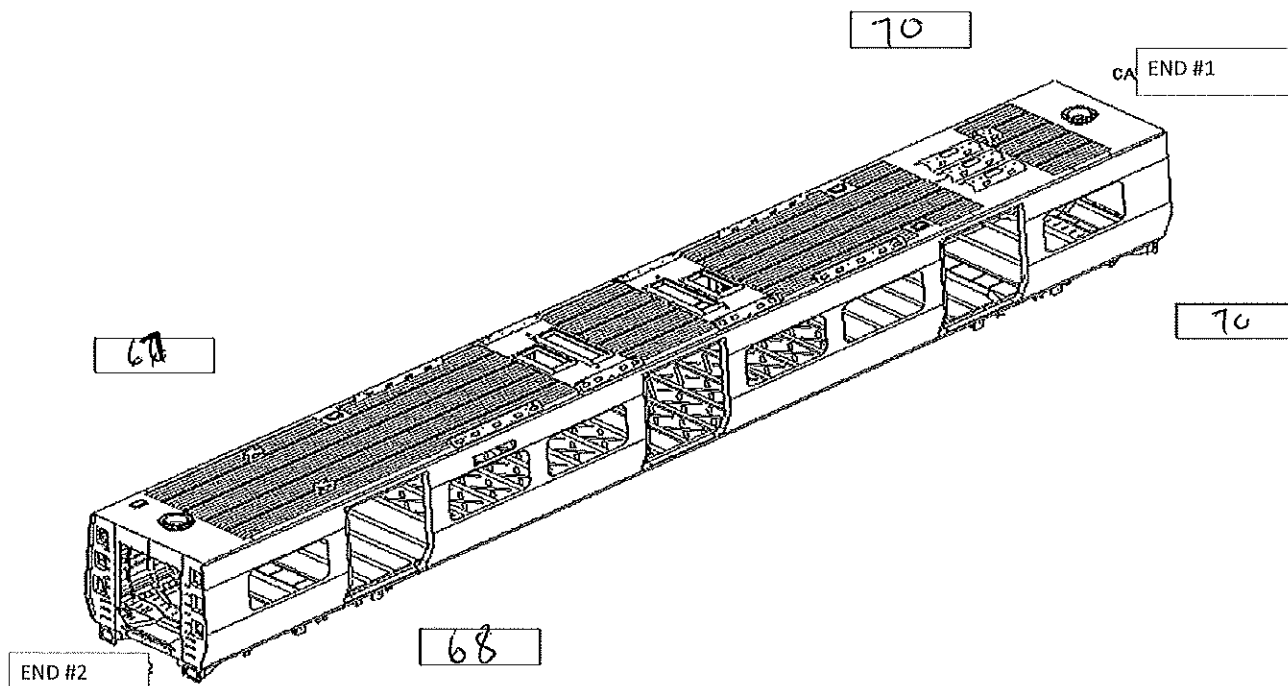
Project: PRASA

Date
06/11/2023

SI.CB1230.277.V29

Specifications of Details for CBS measurement CB1230

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



TWIST FOUND ON END 1

TRANVERSE
LONGITUDINAL

TWIST FOUND ON END 2

TRANVERSE
LONGITUDINAL



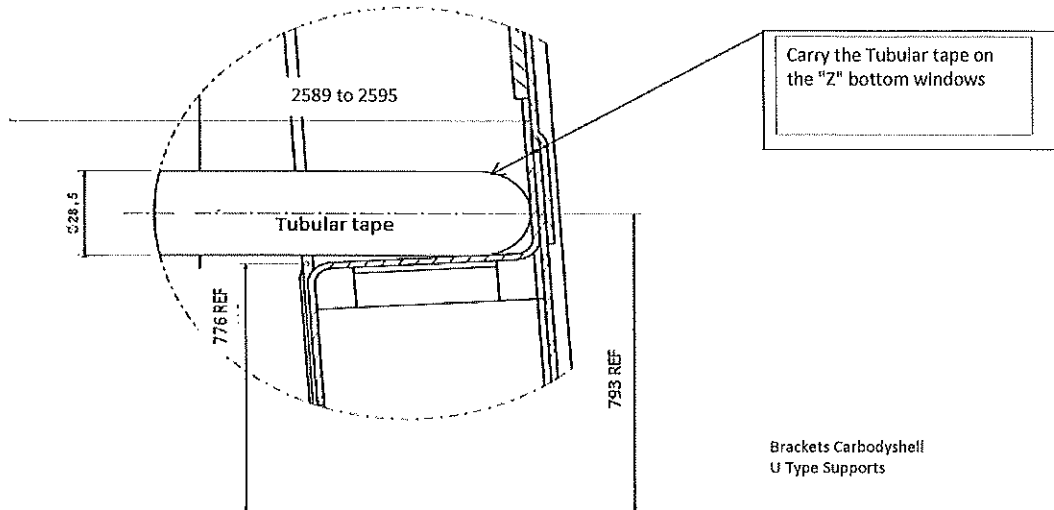
CARBODYSHELL M2 ASSEMBLY AA00001374497

Rev.	30
Date	06/11/2023

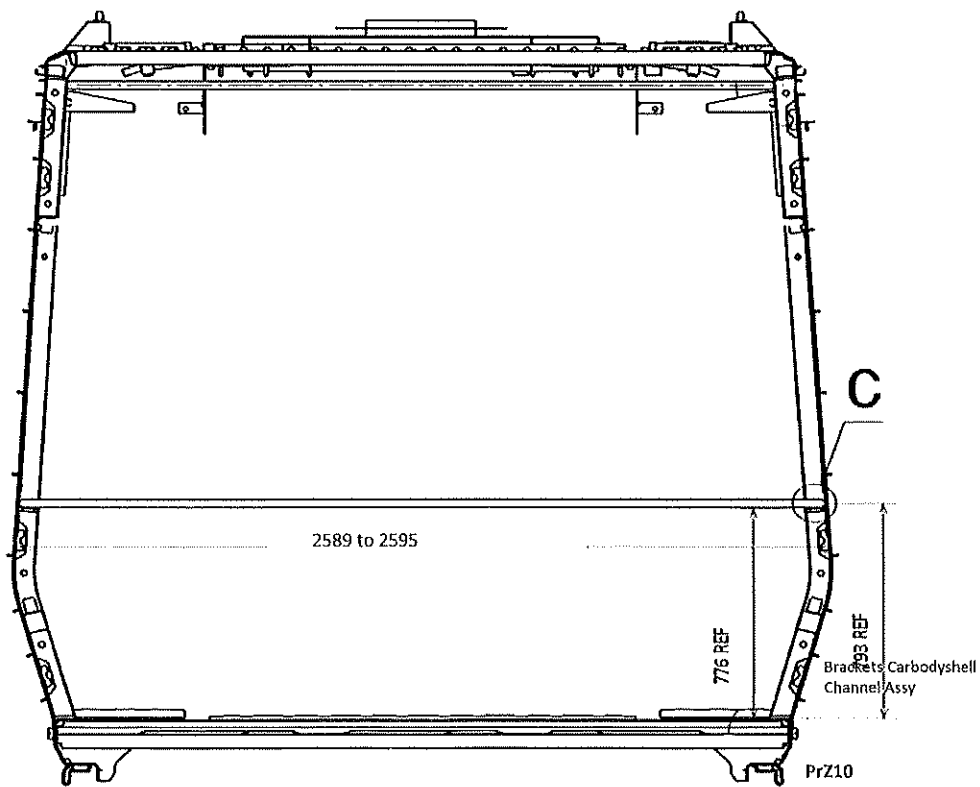
Project: PRASA

SI.CB1230.277.V29

Specifications of Details for GBS measurement CB1230



Detail C





CARBODYSHELL M2 ASSEMBLY AA00001374497

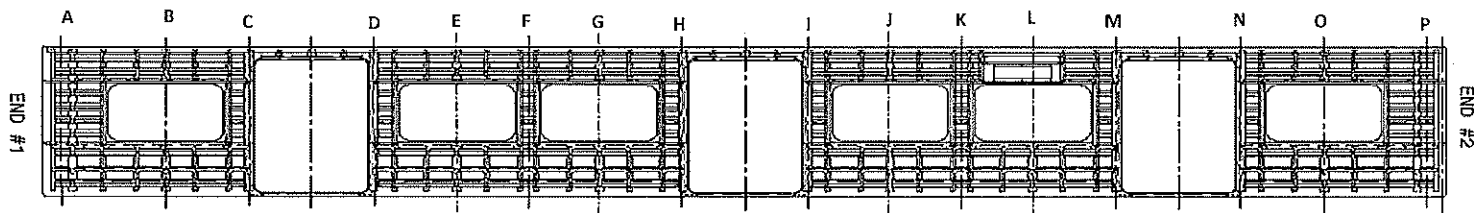
Rev.
30

Project: PRASA

Date
06/11/2023

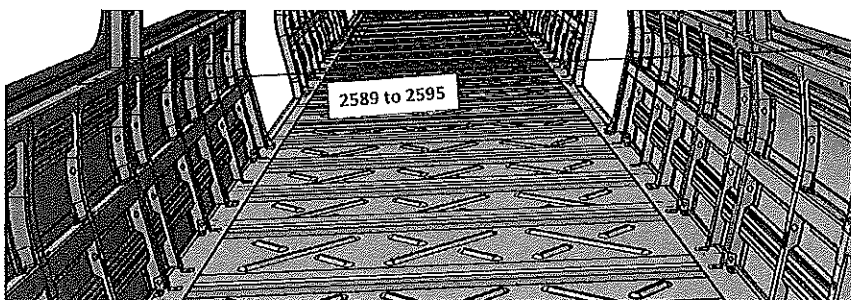
SI.CB1230.277.V29

Specifications of Details for CBS measurement GB1230

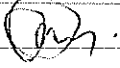



2589 to 2595mm

A	25 95
B	25 95
C	25 91
D	25 92
E	25 95
F	25 95
G	25 95
H	25 90
I	25 90
J	25 95
K	25 95
L	25 95
M	25 89
N	25 89
O	25 94
P	25 95



Threshold verification						Nominal value :38
Door 1		Door 2		Door 3		
L	R	L	R	L	R	
38	37	38	38	39	37	
Door 4		Door 5		Door 6		
L	R	L	R	L	R	
38	38	39	39	38	38	

BOILER MAKER: Nonstantia 

WELDER: Zanele 



CARBODYSHELL M2 ASSEMBLY AA00001374497

Rev.


30

Date

08/11/2023

Project: PRASA


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	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA SI.CB1230.277.V29
		Date 06/11/2023	

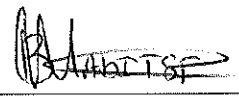
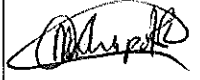
Dye penetrant test

Dye-penetration test to be performed by quality personnel



	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA SI.CB1230.277.V29
		Date 06/11/2023	


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)			
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	09/07/24	Boitumelo <small>Operations</small>	
	NO GO	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)	09/07/24	Richmond <small>Industrial Quality</small>	

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