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		DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?
				TC1	M4	M1	M2	M3	TC2		
☐	DTR3-PROCE-14	LEVELLING, WEIGHTING AND BALANCING M CAR	FT1140		1	1	1	X1		PRA.FT1140.04	YES
☐	DTR3-PROCE-14	LEVELLING, WEIGHTING AND BALANCING TC CAR	FT1140	1					1	PRA.FT1140.05	YES
☐	DTR3-PROCE-17	LEVELLING, WEIGHTING AND BALANCING TC CAR	FT1140	1	1	1	1	1	1	PRA.FT1140.05	YES
☐	DTR3-PROCE-17	LEVELLING, WEIGHTING AND BALANCING TC CAR	FT1140	1	1	1	1	1	1	PRA.FT1140.05	YES
☐											
☐											
☐											

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
7	2/11/2020	UPDATE OF AIR TIGHTNESS TEST TIME FROM 4 MIN TO 5 MIN. ADD PANTOGRAPH AIR TIGHTNESS.	APPROVER	GIVEN SILOWA	2/11/2020
			CHECKER	SIMON MOKOENA	2/11/2020
			COMPILER	COMFORT MALATJI	2/11/2020
8	9/13/2021	ADDING GAUGE MEASUREMENT CHECK ON THE SI.	APPROVER	MAKOFANE LUCY	9/13/2021
			CHECKER	RATAU EDISON	9/13/2021
			COMPILER	TSAKANI KHOSA	9/13/2021
9	5/31/2022	pressure valve (APV) Isolation	APPROVER	MAKHURUPETJI THABANG	5/31/2022
			CHECKER	HAZEL MGIBA	5/31/2022
			COMPILER	RATAU EDISON	5/31/2021

TUE	CAR	OPERATOR NAME	DATE	SELF INSPECTION NUMBER	PAGES
TS 237	M3	Andrew	25/07/24	**SI.FT1140.52**	01/08

GIBELO	SELF INSPECTION INDUSTRIAL QUALITY	Rev:09 Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

Car:	NCR:	Work Station: FT1140

Safety Related

I - Document and Instrument Control

I.1 - Documents control

Document	TC1	M1	M2	M3	M4	TC2	Revision	Remark	OK	NOK	Signature/Date
PRA.FT1140.04											
PRA.FT1140.05				✓					✓		25/07/24
PRA.FT1140.05											

I.2 - Instruments Control - Monitoring and Measuring Instrument Control (Used for all instrument with calibration needed)

Instruments description	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date
Measuring tape	CUBTA 5276	26/08/23-26/08/24	✓		25/07/24
Vernier Calliper	CUBVR 0080	06/08/23-06/08/24	✓		25/07/24
Torque Wrench 35 N.m	D25 11023	14/12/23-14/12/24	✓		25/07/24
Torque Wrench 150 N.m	D28622007	19/12/23-19/12/24	✓		25/07/24
Torque Wrench 320 N.m	A9630027	21/12/23-21/12/24	✓		25/07/24

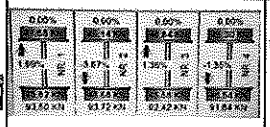
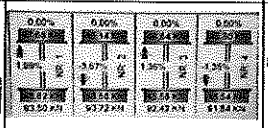
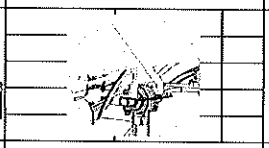
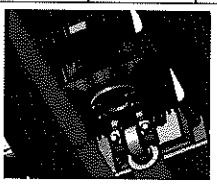
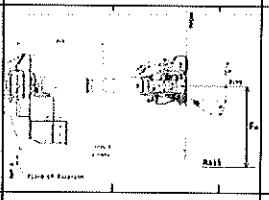
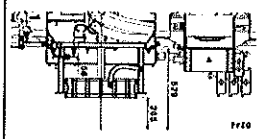
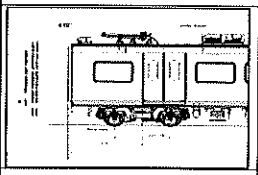
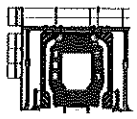
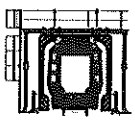
GIBELO	SELF INSPECTION INDUSTRIAL QUALITY	Rev:09 Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

II - Self Inspection - Items to Check

II.1 - Items to Check

Item	Picture/Sketch	Description	Criteria/Record	OK	N/A	Remark	Signature/Date
01		Ensure that the average pressure valve (APV) is isolated by capping the two input pipes at the fittings installing the blanking fitting on the pipes highlighted		✓			25/07/24
02		Check underframe pipe system Air tightness Test performance according to WI PRA.FT1130.15.	The test was performed and no leak was observed. Initial pressure (IP) = 10,01 bar Final pressure (FP) = 7,96 bar FP - IP = 2,05 bar APPROVAL CRITERIA: After 5 minutes the pressure cannot drops more than 0,2 bar	✓			25/07/24
03		Movement performed at least 50m to shudder the car. And position on the leveled load cell, with wheels on the center.		✓			25/07/24
04		Measurement Inspection was done with car on condition AW0 and the rail levelled. (The load cells system must be levelled and calibrated)	Calibration Validation Date 19/12/2023	✓			25/07/24
05		In case of the equipments not installed, equivalent weight of the item should be added in the same place to simulate the equipment. (Any simulated weight, add on pending list)	EQUIPMENT DESCRIPTION / WEIGHT (kg) Counterweight 360	✓			25/07/24
06		The pressure difference between air spring on each bogie when raise the pressure was maintened < 0.3 bar.		✓			25/07/24
07		Measuremet recorded with empty suspention and loaded are on conformity with tolerances of the project.		✓			25/07/24
08		All leveling measurements are according to the reference. (Values out of reference must be recorded on "Description of defects")		✓			25/07/24

GIBELO	SELF INSPECTION INDUSTRIAL QUALITY	Rev:09 Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

Item	Picture/Sketch	Description	Criteria/Record	OK	NC	N/A	Signature/Date
09		Check that the leveling rods are torqued and have torque marker.		✓			25/07/24
10		The difference of weight between the left and right wheels of each axis, must be ≤ 4%. (Verify on the T&C equipment if all arrows are in green)		✓			25/07/24
11		Remove the car, move back onto the load cells and repeat the step 09. Confirm if both are in the tolerance of ≤ 4%.		✓			25/07/24
12		1 - Record shims thickness used on rod 2 - All screws were torqued and have torque marker.	THICKNESS (mm) I 0 II 0 III 0 IV 0	✓			25/07/24
13		Pivot fixation	1- M20 x 90 screws with application of torque according to PRA.FT1140.04 / 05	✓			25/07/24
14		FOR TC CARS F= Height of the center of Automatic coupler F = 895mm (+5 / -10mm) (Using levelled rail)	TC CAB #1= _____ mm				N/A
15		FOR TC CARS Height of Eurobalise Antenna = 205mm(+/-10mm) (Using levelled rail)	TC CAB #1= _____ mm				N/A
16		Check pantograph piping air tightness. Test performance according to WI PRA.FT1140.17.	The test was performed and no leak was observed. -Roof piping connection fittings. -Room piping connection fittings(Roof arch and door trimming)				N/A
17		Pantograph does not come in contact with the higher height gauge when passing through.	No Contact with Pantograph and Gauge -GO Contact with Pantograph and Gauge - NO GO				N/A
18		Car does not come into contact with the gauge.	No Contact with Car and Gauge -GO Contact with Car and Gauge - NO GO	✓			25/07/24

GIBELO	SELF INSPECTION INDUSTRIAL QUALITY	Rev:09 Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

DRAFT TO MEASUREMENTS DURING LEVELLING (ALL UNITS MUST BE IN mm/bar/kg)

END#1

DESCRIPTION	TOLERANCE		LEFT SIDE 6	5	4	3	2	1	RIGHT SIDE 1	2	3	4	5	6	
AIR SPRING HEIGHT (EMPTY)	N/A	A`II													A`I
AIR SPRING HEIGHT (FULL)	min 254 max 261	AII					258	257	252	256					AI
FLOOR COVERING HEIGHT	min 1096 max 1116	EII													EI
AIR SPRING PRESSURE	≤ 0.3 (CI - CI)	CII					2,01	2,93	2,56	2,72					CI
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D3													D1
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D4													D2
PIVOT VERTICAL GAP	min 25 max 32	KII													KI
PIVOT LATERAL STOP GAPS DIFFERENCE	≤ 4 (JI - JI)	JII													JI
QTY OF TURNS OF LEVELLING ROD	N/A	XII						0	12						XI
SHIMS OF ANTI-ROLL BAR	N/A	YII													YI

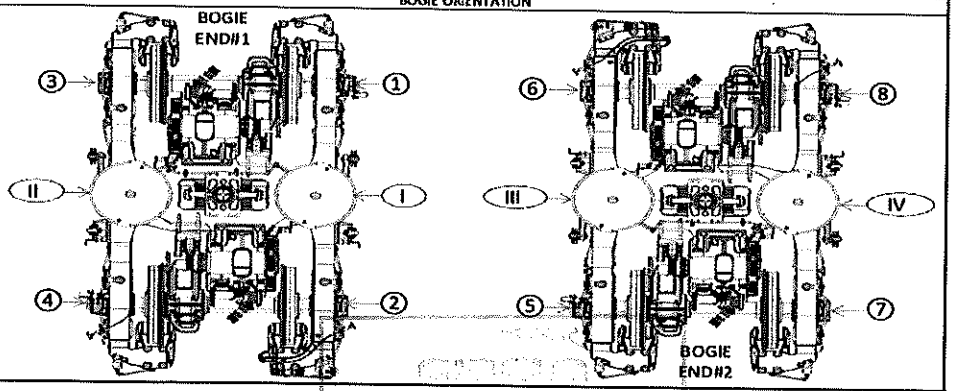
DESCRIPTION	TOLERANCE		6	5	4	3	2	1	1	2	3	4	5	6	
AIR SPRING HEIGHT (EMPTY)	N/A	A`III													A`IV
AIR SPRING HEIGHT (FULL)	min 254 max 261	AIII					256	250	255	259					AIV
FLOOR COVERING HEIGHT	min 1096 max 1116	EIII													EIV
AIR SPRING PRESSURE	≤ 0.3 (CIV - CII)	CIII					2,56	2,55	2,89	2,99					CIV
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D5													D7
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D6													D8
PIVOT VERTICAL GAP	min 25 max 32	KIII													KIV
PIVOT LATERAL STOP GAPS DIFFERENCE	≤ 4 (JIV - JII)	JIII													JIV
QTY OF TURNS OF LEVELLING ROD	N/A	XIII						12	11						XIV
SHIMS OF ANTI-ROLL BAR	N/A	YIII													YIV

LEFT SIDE — END#2 — RIGHT SIDE

COMPARE EACH TENTATIVE WITH THE TOLERANCE AND IDENTIFY EACH MEASURE AS BELOW		
GOOD	LOWER	HIGHER
✓	↓	↑

WEIGHT COMPENSATION	
EQUIPMENT	
WEIGHT	
EQUIPMENT	
WEIGHT	
SECUNDARY MEASUREMENTS (ONLY TC CARS)	
AUTOMATIC COUPLER HEIGHT	
ANTENNA HEIGHT	

BOGIE ORIENTATION



GIBELO	SELF INSPECTION INDUSTRIAL QUALITY	Rev:09 Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

DRAFT TO MEASUREMENTS DURING LEVELLING (ALL UNITS MUST BE IN mm/bar/kg)

END#1

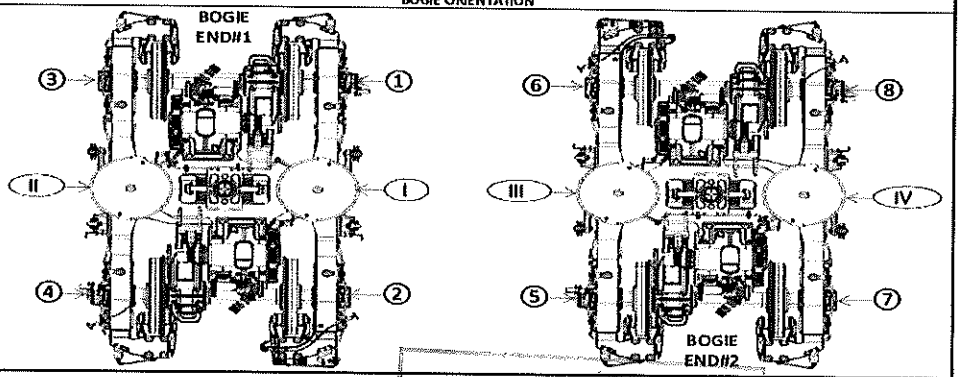
DESCRIPTION	TOLERANCE		LEFT SIDE 6	5	4	3	2	1	RIGHT SIDE 1	2	3	4	5	6	
AIR SPRING HEIGHT (EMPTY)	N/A	A`II													A`I
AIR SPRING HEIGHT (FULL)	min 254 max 261	AII													AI
FLOOR COVERING HEIGHT	min 1096 max 1116	EII													EI
AIR SPRING PRESSURE	≤ 0.3 (CI - CI)	CII													CI
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D3													D1
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D4													D2
PIVOT VERTICAL GAP	min 25 max 32	KII													KI
PIVOT LATERAL STOP GAPS DIFFERENCE	≤ 4 (JI - JI)	JII													JI
QTY OF TURNS OF LEVELLING ROD	N/A	XII													XI
SHIMS OF ANTI-ROLL BAR	N/A	YII													YI
DESCRIPTION	**TOLERANCE**		**6**	**5**	**4**	**3**	**2**	**1**	**1**	**2**	**3**	**4**	**5**	**6**	
AIR SPRING HEIGHT (EMPTY)	N/A	A`III													A`IV
AIR SPRING HEIGHT (FULL)	min 254 max 261	AIII													AIV
FLOOR COVERING HEIGHT	min 1096 max 1116	EIII													EIV
AIR SPRING PRESSURE	≤ 0.3 (CIV - CIII)	CIII													CIV
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D5													D7
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D6													D8
PIVOT VERTICAL GAP	min 25 max 32	KIII													KIV
PIVOT LATERAL STOP GAPS DIFFERENCE	≤ 4 (JIV - JIII)	JIII													JIV
QTY OF TURNS OF LEVELLING ROD	N/A	XIII													XIV
SHIMS OF ANTI-ROLL BAR	N/A	YIII													YIV

LEFT SIDE — END#2 — RIGHT SIDE

COMPARE EACH TENTATIVE WITH THE TOLERANCE AND IDENTIFY EACH MEASURE AS BELOW		
GOOD	LOWER	HIGHER
✓	↓	↑

WEIGHT COMPENSATION	
EQUIPMENT	
WEIGHT	
EQUIPMENT	
WEIGHT	
SECUNDARY MEASUREMENTS (ONLY TC CARS)	
AUTOMATIC COUPLER HEIGHT	
ANTENNA HEIGHT	

BOGIE ORIENTATION



2024 -07- 25

CONTROLLED COPY

Table 1 - Reference Values and Measurement Tolerances for the Car Levelling.

ITEM			THEORETICAL VALUES													
			TC1 CAR		M1 CAR			M2 CAR			M CAR			TC2 CAR		
			TBext	TBint	M3	M2	M1	M1	M2	M3	M1	M2	M3	TBint	TBext	
Pivot lateral stop gaps difference [mm]	$J_{n-1}-J_n$	Fig. 4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4
Air Spring height (mm)	A_n	Fig. 5	255^{-6}_{-1}	255^{-6}_{-1}	255^{-6}_{-1}	255^{-6}_{-1}	255^{-6}_{-1}	255^{-6}_{-1}	255^{-6}_{-1}	255^{-6}_{-1}	255^{-6}_{-1}	255^{-6}_{-1}	255^{-6}_{-1}	255^{-6}_{-1}	255^{-6}_{-1}	255^{-6}_{-1}
Air spring pressure at AWO [Bar]	C_n	Fig. 5	3,76	2,82	2,87	2,83	3,02	2,91	3,07	2,85	2,83	2,87	2,83	2,83	3,76	
			[Ref.]	(Ref.)	(Ref.)	(Ref.)	(Ref.)	(Ref.)	(Ref.)	(Ref.)	(Ref.)	(Ref.)	(Ref.)	(Ref.)	(Ref.)	
	C_1-C_6		0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	
	C_8-C_{10}															
Primary Suspension gaps [mm]	$D_2;D_8$	Fig. 6	35^{+12}_{+4}	35^{+12}_{+4}	35^{+12}_{+4}	35^{+12}_{+4}	35^{+12}_{+4}	35^{+12}_{+4}	35^{+12}_{+4}	35^{+12}_{+4}	35^{+12}_{+4}	35^{+12}_{+4}	35^{+12}_{+4}	35^{+12}_{+4}	35^{+12}_{+4}	
	$D_3;D_7$															
	$D_4;D_6$															
Carbody Floor height [mm]	E_n	Fig. 7	1106^{-10}_{-20}	1106^{-10}_{-20}	1106^{-10}_{-20}	1106^{-10}_{-20}	1106^{-10}_{-20}	1106^{-10}_{-20}	1106^{-10}_{-20}	1106^{-10}_{-20}	1106^{-10}_{-20}	1106^{-10}_{-20}	1106^{-10}_{-20}	1106^{-10}_{-20}	1106^{-10}_{-20}	
Bolster height [mm]	N_n	Fig. 7	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	
Coupling End height [mm]	F_1	Fig. 8	895 (Ref.)		760 (Ref.)			760 (Ref.)			760 (Ref.)			895 (Ref.)		
	F_2	Fig. 9	760 (Ref.)		760 (Ref.)			760 (Ref.)			760 (Ref.)			760 (Ref.)		
Pivot Vertical gap [mm]	K_n	Fig. 10	30^{-15}_{-3}	30^{-15}_{-3}	30^{-15}_{-3}	30^{-15}_{-3}	30^{-15}_{-3}	30^{-15}_{-3}	30^{-15}_{-3}	30^{-15}_{-3}	30^{-15}_{-3}	30^{-15}_{-3}	30^{-15}_{-3}	30^{-15}_{-3}	30^{-15}_{-3}	

GIBELA	SELF INSPECTION INDUSTRIAL QUALITY	Rev:09 Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

Leveling report from Production (Final measurements after Levelling and Weighting fine)

References for secondary suspention empty
A'n Air spring height empty

References for secondary suspention full
An Air spring height
Bn Difference between measurement A'n and An
En Floor covering height
Cn Air spring pressure
Dn Primary suspention
Kn Pivot Vertical gap
Jn Pivot Lateral stop gaps difference

Item	Reference [mm]	END#1				END#2			
		Right Side		Left Side		Left Side		Right Side	
A'n	N/A	A'I	240	A'II	244	A'III	243	A'IV	240
An	254 to 261	AI	257	AII	260	AIII	258	AIV	256
Bn = An - A'n	N/A	BI	17	BII	16	BIII	15	BIV	16
En	1106 ±10 mm	EI	1101	EII	1102	EIII	1101	EIV	1101

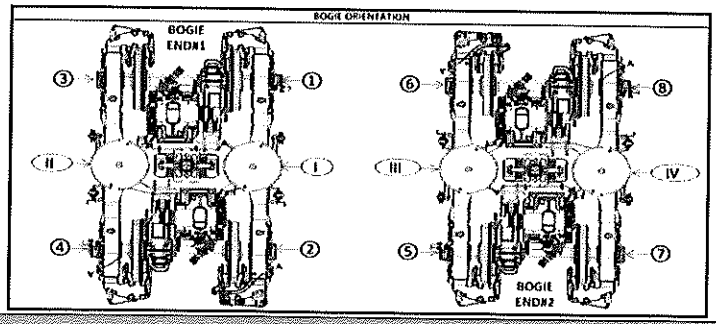
Item	Reference [bar]	END#1				END#2			
		Right Side		Left Side		Left Side		Right Side	
Cn	Table 02 (*)	CI	2,78	CII	2,75	CIII	2,80	CIV	2,73
Cn - Cn+1	Diference ≤ 0,3	CI - CII				CIII - CIV			
Gauge serial number	N/A	GIB05873		GIB05873		GIB05873		GIB05873	

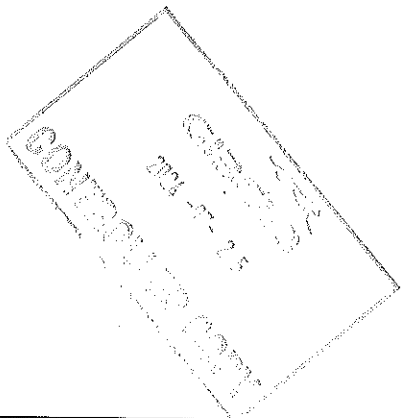
Item	Reference [mm]	END#1				END#2			
		Right Side		Left Side		Left Side		Right Side	
Dn	Table 01 (*)	D1	45,85	D3	45,32	D5	46,02	D8	45,64
		D2	45,69	D4	46,86	D6	45,17	D7	45,91
Kn	25 to 45	KI	32,44			KII	34,22		
Jn	Diference ≤ 4	JI	24,46	JII	26,45	JIII	26,02	JIV	24,53

(*) Reference, only include values, isn't approval criteria.

Table 01 D Theorethical Values	TC1		M4		M1		M2		M3		TC2	
	Tbex	TBIn	Mb1	Mb1	Mb1	Mb2	Mb2	Mb1	Mb1	Mb1	TbIn	Tbex
D=	35$^{+12}_{-5}$	35$^{+12}_{-5}$	35$^{+12}_{-5}$	35$^{+12}_{-5}$	35$^{+12}_{-5}$	35$^{+12}_{-5}$	35$^{+12}_{-5}$	35$^{+12}_{-5}$	35$^{+12}_{-5}$	35$^{+12}_{-5}$	35$^{+12}_{-5}$	35$^{+12}_{-5}$

Table 02 C Theorethical Values	TC1		M4		M1		M2		M3		TC2	
	Tbex	TBIn	Mb1	Mb1	Mb1	Mb2	Mb2	Mb1	Mb1	Mb1	TbIn	Tbex
C=	3.76	2.82	2.87	2.83	3.02	2.91	3.07	2.85	2.83	2.87	2.83	3.76





Weighting report from Test and Commissioning (Final measurements after Levelling and Weighting fine)

GIBELO	SELF INSPECTION INDUSTRIAL QUALITY	Rev:09 Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

Item	Description of defects			Signature/Date

IL2 - Check List REX

Check List Items

Item	Picture/Drawing	Descrição Description	Criteria /Record	OK	NOK	N/A	Signature/Date
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX	✓			25/07/24

Self Inspection - Final Result

			Is the car good to advance to the next workstation/process? (Approval of Operations Manager/Team Leader and Industrial Quality)	DATE	NAME	SIGNATURE
HOLD POINT		GO	If activities are not complete, the missing activities must not impact the next stage!	25/07/24	Operations Manager	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.	25/07/24	Industrial Quality	
		NO GO	There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)		Operations Manager	
			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		Status

Operations Manager / Team Leader

Quality Manager / Team Leader

Gibela Rail Transport Consortium RF (Pty)
Ltd
2 Shosholoza Avenue
Dunnottar X7
Ekurhuleni, 1590, South Africa
Reception: +27 (0)10 600 0651

TRAIN SET 237	REF: GIB00000001672_J0 PRASA WEIGHT BALANCE EN
	PC09 WEIGHING REPORT

M3	Balance across front and rear bogies	Front Bogie [Tons]	Rear Bogie [Tons]	Longitudinal Imbalance [%]	Criteria Longitudinal Imbalance ≤ 3%	
		17.83	17.83	0.00%	PASS	
	Weight Mesured vs Predicted	Weight Mesured [Tons]	Weight Predicted [Tons]	Weight Difference [%]	Tolerance [%]	Criteria Min≤Diff≤Max
		35.66	35.90	0.67%	1.36%	PASS

Test Participants				
Name	Company	Department	Signature	Date
Thato Musi	GIBELA	EOC		25/07/24