



APPLICABLE FROM TRAINSET 190+ AS PER BASELINE 10.4

SELF INSPECTION SHEET

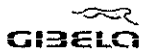
CONFIDENTIAL INFORMATION

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

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?	
				TCL	M1	M2	M3	M4	TC2			
<input type="checkbox"/>	DTR3000152644	AAD0001278566	CARBODYSHELL M3,M4 ASSEMBLY	CB2210		X					PRA.CB2210.DTR30225 487/3.V30	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 CB2210	APPROVER	Itumeleng Modiba	2018/12/12
			CHECKER	Nosizo Pindela	2018/12/12
			REVISED BY	Ramokone Motama	2018/12/12
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	22/01/2019
			CHECKER	Nosizo Pindela	22/01/2019
			REVISED BY	Vanessa Ntuli	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	19/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	19/02/2022
			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	
30	20/07/2023	New Baseline change 10.4	APPROVER	Ngobeni Tyson	28/07/2023
			CHECKER	Mohlampe Amogelang	
			REVISED BY	Mohlampe Amogelang	
31	07/11/2023	Added traceability for welding sections	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Mohlampe Amogelang	
			REVISED BY	Ntokozi Zwane	
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
237	M3	LUNGA 471497	05/07/24	SI.CB2210.254.V30	17



CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev. 31
Date 07/11/2023

Project: PRASA
SI.CB2210.254.V30

Car: M3 & M4

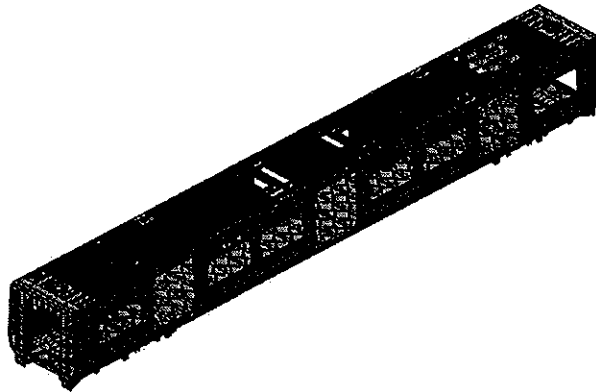
NCR:

Work station:

CB2210



Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car						Revision	Observation	✓	Signature/Date (Manufacturing)	Signature/Date (Quality)
	2	3	4	5	1	6					
DTR30225487/3				✓			51		✓	[Signature] 05/07/23	[Signature] 05/07/23

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification (Expiry Date)	✓	Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULAR	52825-2	15/05/24	✓	[Signature] 05/07/23	[Signature] 05/07/23
30M TAPC	618120084	14/05/24	✓	[Signature] 05/07/23	[Signature] 05/07/23
LACER TAPC	135625924	08/01/24	✓	[Signature] 05/07/23	[Signature] 05/07/23

I.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	✓	Signature/Date (Manufacturing)	Signature/Date (Quality)
MIG 308 LSI	5701820	MIG	✓	[Signature] 05/07/23	[Signature] 05/07/23
ETL 309 LSI	518394	MIG	✓	[Signature] 05/07/23	[Signature] 05/07/23



CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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SI.CB2210.254.V30

Date

07/11/2023

II - Self Inspection - Items to Check

II.1 - Items to check

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

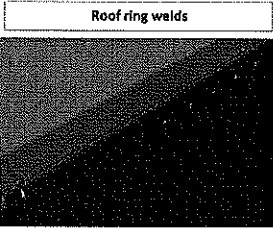


CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

Rev. 31
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Welding Traceability



Roof ring welds

Boiler maker (Name & Sign): Justice *Al* ^{LHS} Welder (Name & Sign): MTHOLUZI *g*

Boiler maker (Name & Sign): Lawrence *W* ^{RHS} Welder (Name & Sign): GIFT *g*

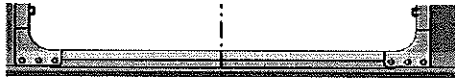
END 1

Boiler maker (Name & Sign): Justice *Al* ^{LHS} Welder (Name & Sign): MTHOLUZI *g*

Boiler maker (Name & Sign): Lawrence *W* ^{RHS} Welder (Name & Sign): GIFT *g*

END 2

Door ring welds



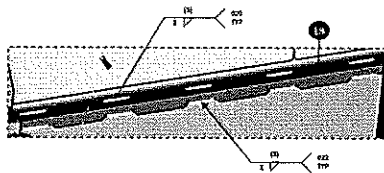
Boiler maker (Name & Sign): Leboya *Mastabe* ^{LHS}

Welder (Name & Sign): GIFT *g*

Boiler maker (Name & Sign): GERRIT ^{RHS}

Welder (Name & Sign): GIFT *g*

EU Reinforcement Plates

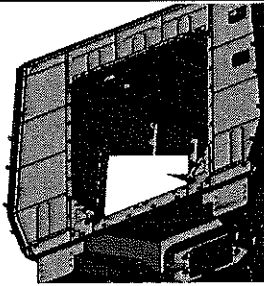




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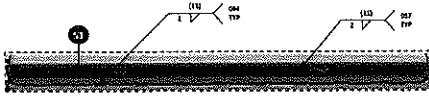
END 1

Boiler maker (Name & Sign):

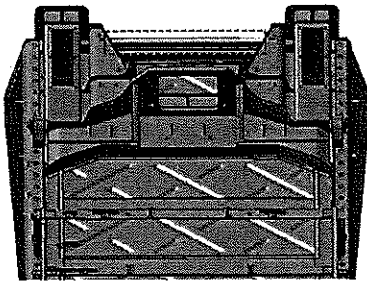
SEAN B

Welder (Name & Sign):

Thabang



END 2



Underneath the CAR

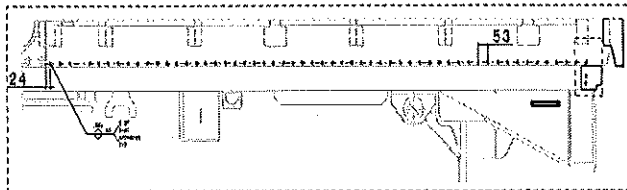
END 2

Boiler maker (Name & Sign):

Imoat

Welder (Name & Sign):

SIPHOKAZI



FEDOLI

Operator:

Vedogo

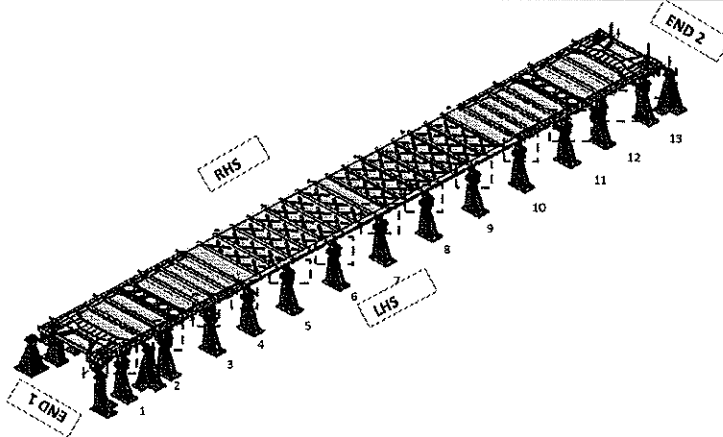


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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Specifications of Details for CBS measurement



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

After loading and clamping

Fill in the gap found on each Jlg 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: 05/01/21

After Welding.

Fill in the gap found each Jlg 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	3	2	3	0	0

Signature Industrial Quality: Date: 05/07/24

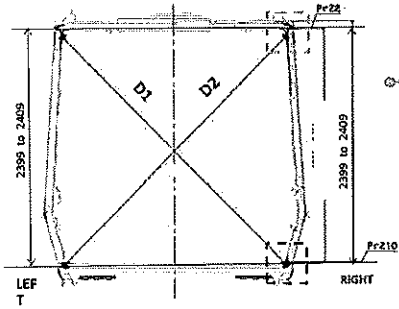
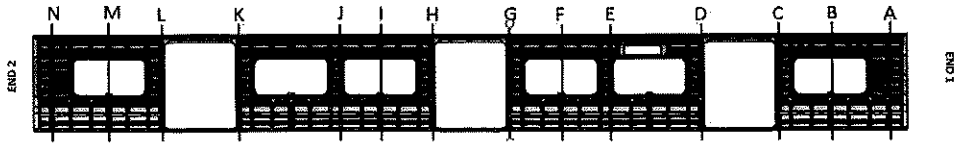


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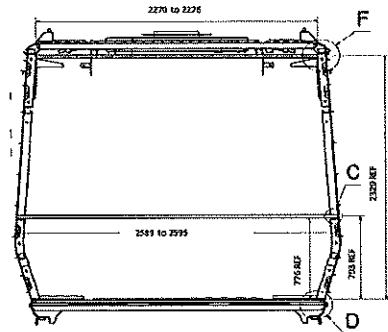
Specifications of Details for CBS measurement



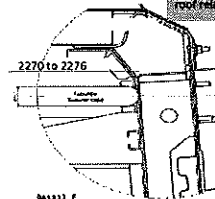
Measurement positions on roof rail and sidewall



Measurement positions on sidewall and side sill corner



Reinforcement area measurement positions on roof reinforcement area



Detail of reinforcement area

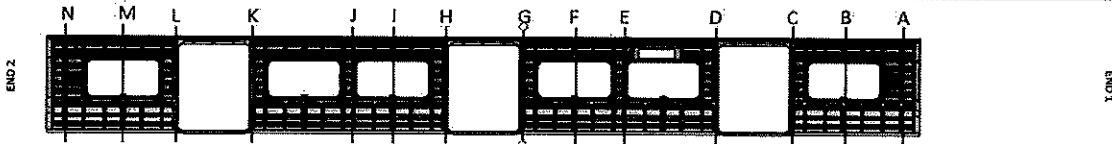


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Specifications of Details for CBS measurement



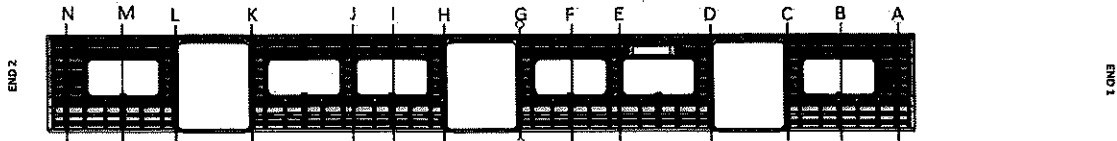
PME Column LHS - RHS should be $\leq 2\text{MM}$ on each point.

BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	5268	5268	0	2408	2408	2
B	5268	5268	0	2408	2408	0
C	5268	5268	0	2408	2408	2
D	5269	5270	1	2408	2408	1
E	5268	5268	0	2408	2408	0
F	5268	5268	1	2408	2408	1
G	5268	5268	1	2408	2408	1
H	5267	5267	0	2408	2408	0
I	5268	5268	1	2408	2408	1
J	5268	5268	0	2408	2408	2
K	5268	5268	0	2408	2408	0
L	5270	5268	2	2408	2408	1
M	5268	5268	3	2408	2408	0
N	5268	5268	1	2408	2408	1

Handwritten signature and date: 05/07/2023

Specifications of Details for CBS measurement


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

AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3296	3296	2	2408	2407	1
B	3266	3267	3	2408	2406	0
C	3294	3295	1	2407	2405	1
D	3296	3295	1	2405	2406	1
E	3265	3265	0	2405	2405	0
F	3265	3266	1	2405	2405	0
G	3296	3295	1	2407	2406	1
H	3295	3295	0	2405	2404	1
I	3266	3265	1	2406	2406	0
J	3266	3266	0	2405	2407	2
K	3295	3294	1	2406	2405	1
L	3294	3294	0	2404	2405	1
M	3265	3265	3	2406	2406	0
N	3294	3295	1	2407	2406	1

 05/07/24



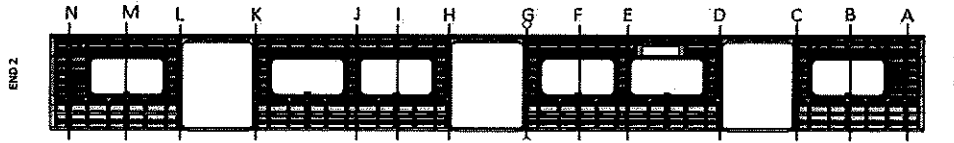
CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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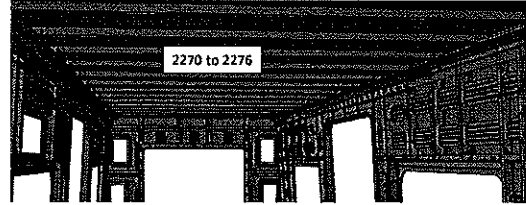
CBS measurement

BEFORE WELDING

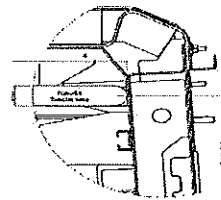
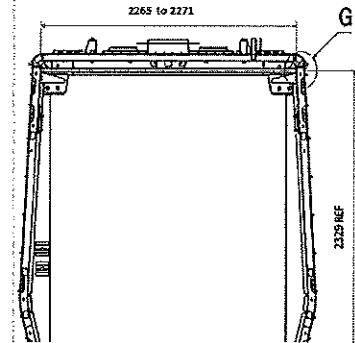


2270 to 2276

- A: 2271
- B: 2276
- C: 2273
- D: 2272
- E: 2278
- F: 2276
- G: 2272
- H: 2271
- I: 2274
- J: 2271
- K: 2273
- L: 2272
- M: 2274
- N: 2271



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



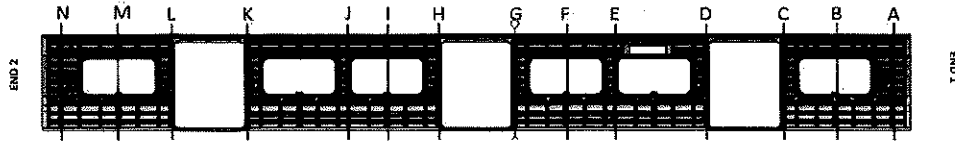
2265 to 2271

DETAIL 4
Considering the relative movement of the

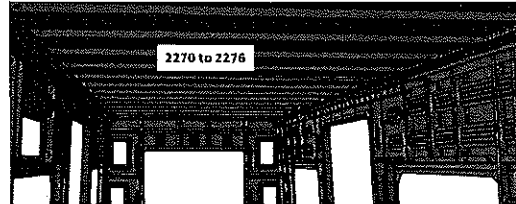
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05/07/24

CBS measurement

AFTER WELDING



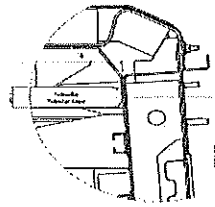
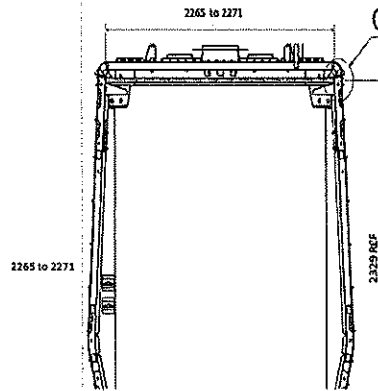
	2265 to 2271	2270 to 2276
A	2266	
B		2273
C	2269	
D	2265	
E		2275
F		2275
G	2269	
H	2268	
I		2275
J		2276
K	2269	
L	2266	
M		2274
N	2268	



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



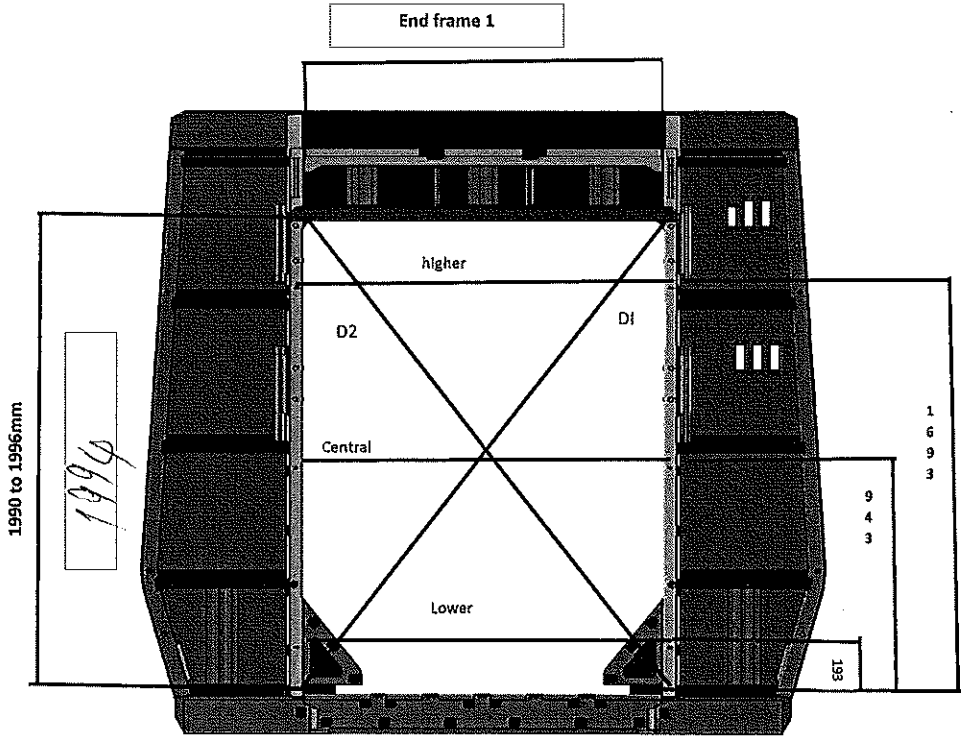
Take measurement close to radius (considering reinforcement)



Detail B
Considering the reinforcement plate

Handwritten signature and date: 05/07/24

Specifications of Details for CBS measurement



1380 to 1382 mm

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

Higher Dimension

Central Dimension

Lower Dimension

D1

D2

D1-D2

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05/01/24

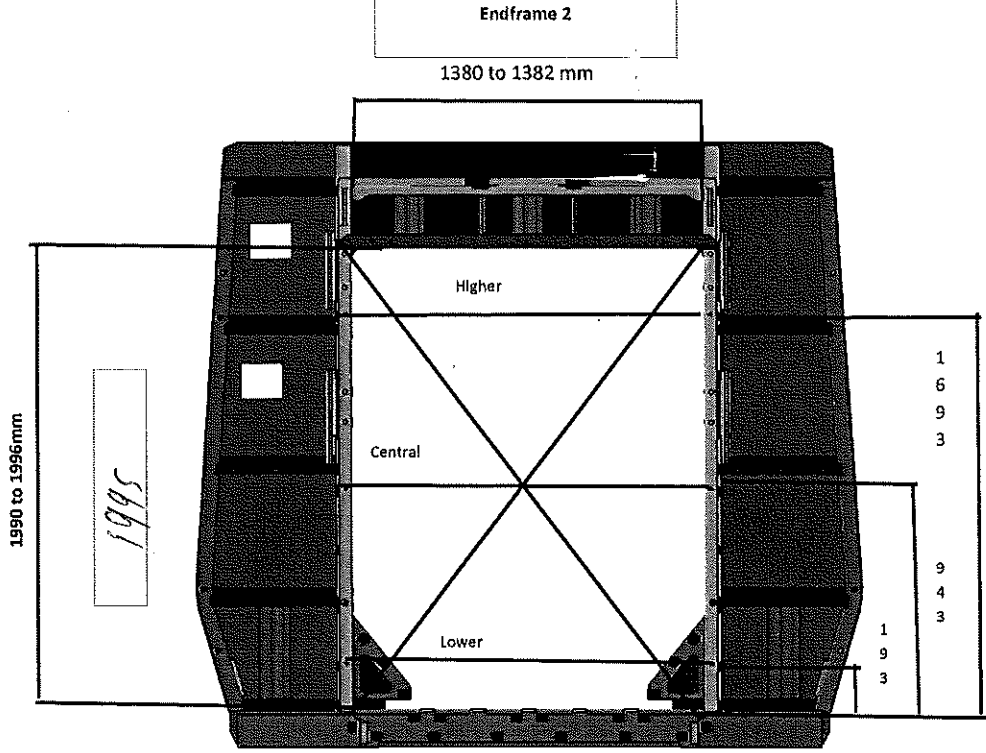


CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

Rev. 31
Date 07/11/2023

Project PRASA
SI.CB2210.254.V30

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3mm$

Higher Dimension

Central Dimension

Lower Dimension

D1

D2

D1-D2

[Handwritten signature]
05/07/24

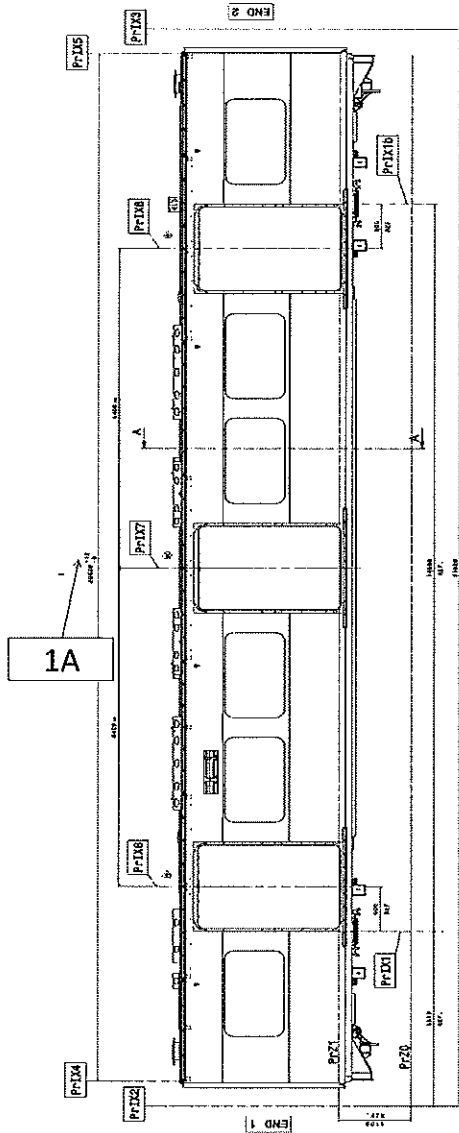


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07/11/2023

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Specifications of Details for CBS measurement



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20615

RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20615

Dye penetrant test

Dye-penetration test to be performed by quality personnel



Self Inspection - Final Result

			DATE	NAME	SIGNATURE	
HOLD POINT	(C)	(If activities are not complete, the missing activities must not impact the next stage)	05/07/24	L. N. G. P.	Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy (the same is approved by the competent party)	05/07/24	A. D. O. R. O.	Industrial Quality	
		There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			Operations	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)			Industrial Quality	

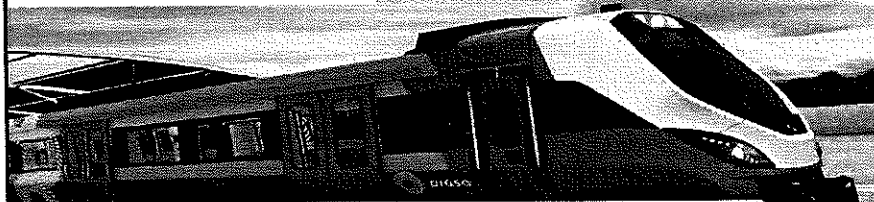
In case of "NO GO", describe blocking problems

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

Item	Description	Responsible	Due date	Status

Operations

Quality



APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

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APPLICATION REFERENCE

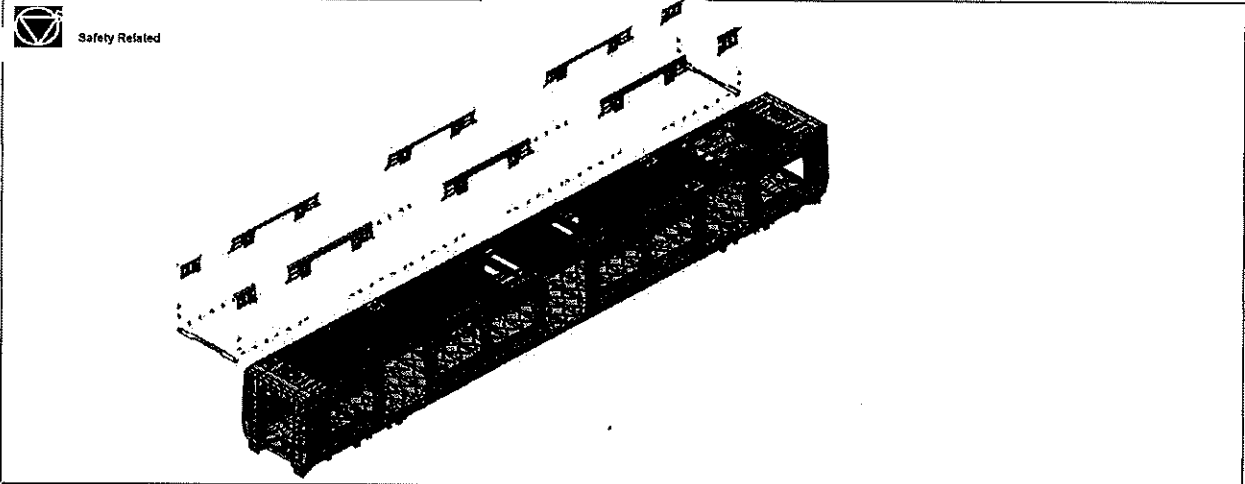
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY	
				TC	MA	ME	MI	TE	TR			
<input type="checkbox"/>	DTR3000152648	AAD0001278566	CARBODY SHELL M1, M3, M4 ASSEMBLY	CB1220			X				PRA.CB2220.DTR3022548 7/2.V21	YES
<input type="checkbox"/>	DTR3000152649	AAD0001278566	CARBODY SHELL M1, M3, M4 ASSEMBLY	CB1220		X	X	X			PRA.CB2220.DTR3022548 7/2.V21	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												

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			REVISED BY	Vanessa Ntuli	24/01/2019
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			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	22/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	22/08/2019
			CHECKER	Nosizo Pindela	22/08/2019
			REVISED BY	Nosizo Pindela	22/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			REVISED BY	Bongane Masina	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISED BY	Mpho Mulaudzi	17/08/2021
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	19/02/2022
			CHECKER	Andani Muthelo	19/02/2022
			REVISED BY	Andani Muthelo	19/02/2022
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbhombhi	14/06/2022
			CHECKER	Andani Muthelo	14/06/2022
			REVISED BY	Andani Muthelo	14/06/2022
27	19/10/2022	Addition of traceability for sealant application & welding	APPROVER	Collins Mbhombhi	19/10/2022
			CHECKER	Ntokozo Zwane	19/10/2022
			REVISED BY	Amogelang Mohlampe	19/10/2022
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	14/04/2023
			REVISED BY	Amogelang Mohlampe	14/04/2023
29	28/10/2023	Addition of bracket quantity	APPROVER	Ngobeni Tyson	28/10/2023
			CHECKER	Ntokozo Zwane	28/10/2023
			REVISED BY	Amogelang Mohlampe	28/10/2023

TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
Ts237	M03	Ashley - 909977	01-07-24	SI.CB2220.250.V29	13

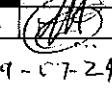
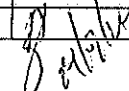
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB2220.250.V29
		29	
		Date	

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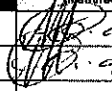
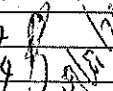
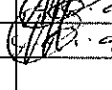
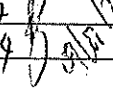
I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car					Revision	Observation	Y/N	Y/N	Signature/Date (Manufacturing)	Signature/Date (Quality)
	C	M	S	M	D						
DTR30225487/2			X			29	28-10-2023	X		N/A	 9-07-24 

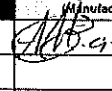

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instrument	Serial number	Calibration or Verification Validation Date	Y/N	Y/N	Signature/Date (Manufacturing)	Signature/Date (Quality)
Tubular	3723	15/03/2025	X		 9-07-24	
measuring tape	GSDIA (A31)	17/07/2025	X		 9-07-24	

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filer Material	Heat Number	Welding Process	Y/N	Y/N	Signature/Date (Manufacturing)	Signature/Date (Quality)
308	375779	MIG	X		 9-07-24	



CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

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II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	QC	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB2220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB2220.DTR30225487/2	/	09-07-24	09/07/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	/	09-07-24	09/07/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	/	09-07-24	09/07/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	/	09-07-24	09/07/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	/	09-07-24	09/07/24
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.	/	09-07-24	09/07/24
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 Specified: Temperature Min - Max (I) Min-Max 10°C - 35°C Relative humidity Min - Max (I) Min-Max 25% - 80%	Sealant Batch No: <u>ISR 70-03</u> Exp Date: <u>1/02/25</u> Actuals Temperature: <u>19/16°C</u> Humidity: <u>42%</u>	/	09/07/24	09/07/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278566	/	09-07-24	09/07/24
09		Verification of safety welds	Approved according to DTD000210658 reference and Self inspection	/	09-07-24	09/07/24



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II - Self Inspection - Items to Check

SEALANT APPLICATION

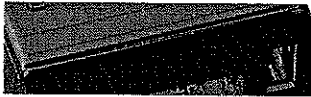
AREA 1 & 2 END 1

Operator (Name & sign):

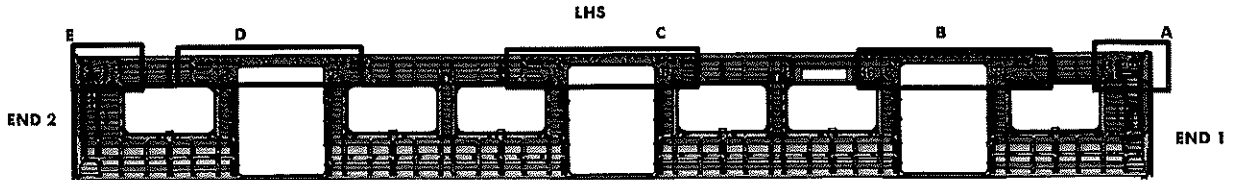
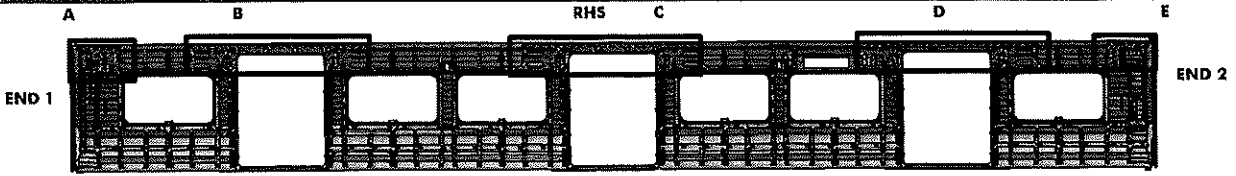
LERAY
[Signature]

Operator (Name & sign):

LERAY
[Signature]



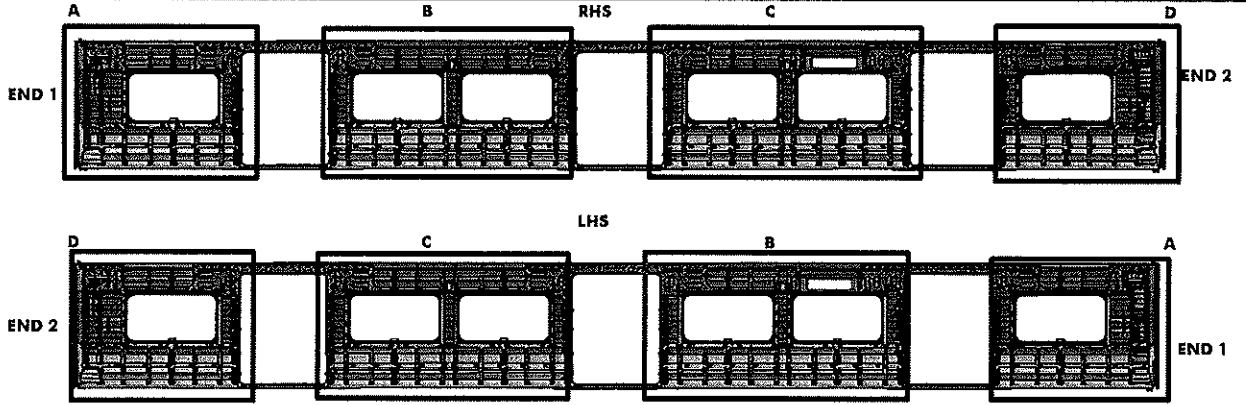
II - Self Inspection - Items to Check



REINFORCEMENT WELDING

AREA	LHS	RHS
A	Operator (Name&sign): <u>S. M. Aguiar</u>	<u>S. M. Aguiar</u>
B	Operator (Name&sign): <u>S. M. Aguiar</u>	<u>S. M. Aguiar</u>
C	Operator (Name&sign): <u>TH. C. A. M. D.</u>	<u>TH. C. A. M. D.</u>
D	Operator (Name&sign): <u>Sibiyá</u>	<u>Sibiyá</u>
E	Operator (Name&sign): <u>Sibiyá</u>	<u>Sibiyá</u>

II - Self Inspection - Items to Check



BRACKETING

INSTALLATION

C-RAILS: Operator: Piscilla Casimiro
Operator: _____

DOOR MECHANISMS: Operator: Teledo JAV
Operator: _____

TAPPING PADS Operator: Piscilla Casimiro
Operator: Casimiro

INSTALLATION & VERIFICATION

SEAT & LUGGAGE BRACKETS: Operator: Teledo JAV
Operator: _____

SEAT BRACKETS VERIFICATION: Operator: Teledo JAV
Operator: _____

WELDING

AREA	LHS	RHS
A (Seat brackets)	Operator (Name&sign): <u>Jilly D</u>	<u>LINDO</u> <u>(L)</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>Jilly D</u>	<u>LINDO</u> <u>(L)</u>
B (Seat brackets)	Operator (Name&sign): <u>Jilly D</u>	<u>LINDO</u> <u>(L)</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>Jilly D</u>	<u>LINDO</u> <u>(L)</u>
C (Seat brackets)	Operator (Name&sign): <u>Alvaro</u>	<u>MARTINELO ALVARO</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>Alvaro</u>	<u>MARTINELO ALVARO</u>
D (Seat brackets)	Operator (Name&sign): <u>Alvaro</u>	<u>MARTINELO ALVARO</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>Alvaro</u>	<u>MARTINELO ALVARO</u>

ENDS

END 1 TAPPING PADS WELDING: Operator (Name&sign): Jilly D

END 2 TAPPING PADS WELDING: Operator (Name&sign): Alvaro



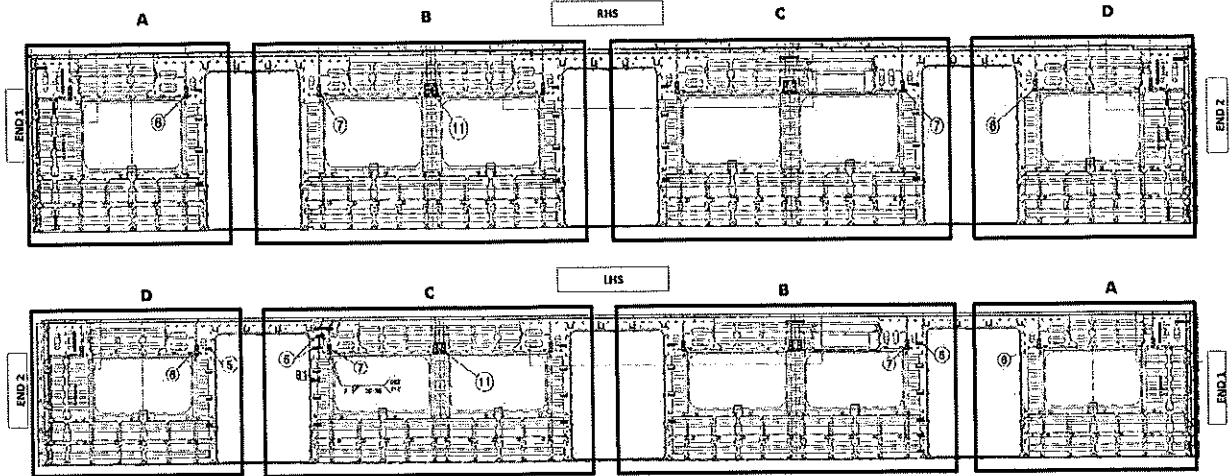
CARBODYSHELL M1,M3,M4 ASSEMBLY
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28/10/2023

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II - Self Inspection - Items to Check

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

RHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7	/	
	B	4	/	
	C	8	/	
	D	6	/	
SEAT BRACKETS	A	13	/	
	B	21	/	
	C	21	/	
	D	13	/	
EARTH BUSH	A	3	/	
	B	5	/	
	C	4	/	
	D	3	/	

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

VERIFICATION BY: *ASA-100* *[Signature]*

LHS

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

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

VERIFICATION BY: *ASA-100* *[Signature]*

QUANTITIES (M1)

RHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7		
	B	6		
	C	8		
	D	8		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	2		
	B	4		
	C	5		
	D	3		

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

VERIFICATION BY: _____

LHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	10		
	C	11		
	D	9		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	7		
	C	6		
	D	2		

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

VERIFICATION BY: _____

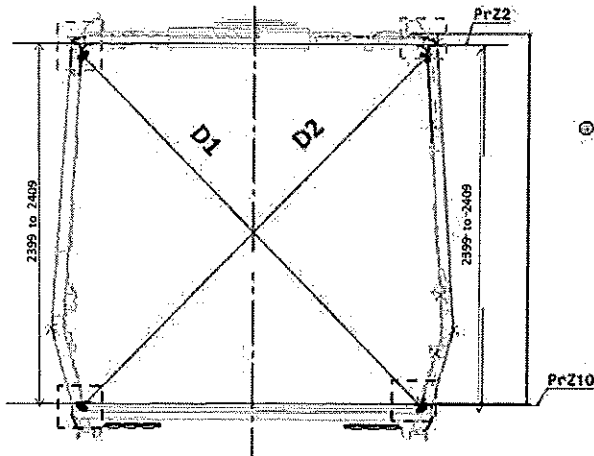


CARBODYSHELL M1,M3,M4 ASSEMBLY
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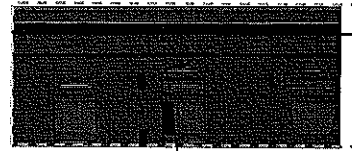
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Specifications of Details for CBS measurement



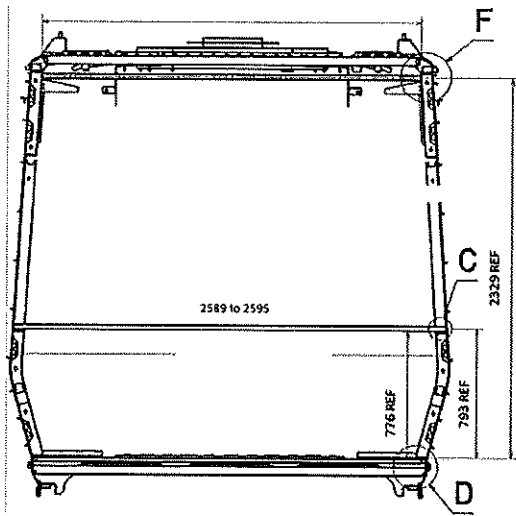
Measurement positions on roof rail and sidewall omega corner.

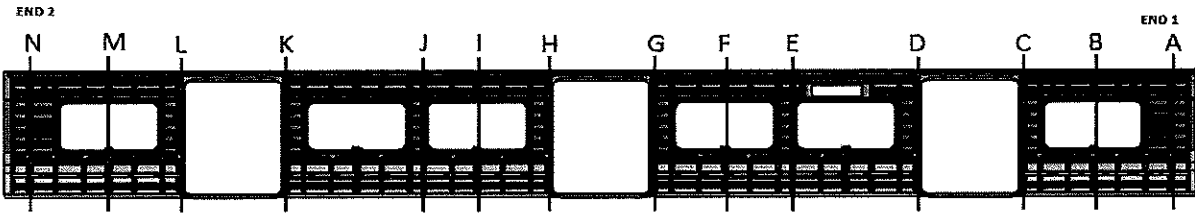


Reinforcement area measurement positions on roof reinforcement bars.




Measurement positions on sidewall and side all corner.





BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3291	9	
B	3260	3270	10	
C	3290	3294	4	
D	3290	3297	7	
E	3265	3270	5	
F	3263	3269	1	
G	3294	3294	0	
H	3294	3296	2	
I	3265	3263	2	
J	3268	3268	0	
K	3298	3295	3	
L	3291	3295	4	
M	3263	3264	1	
N	3295	3294	1	


27-29
27-29

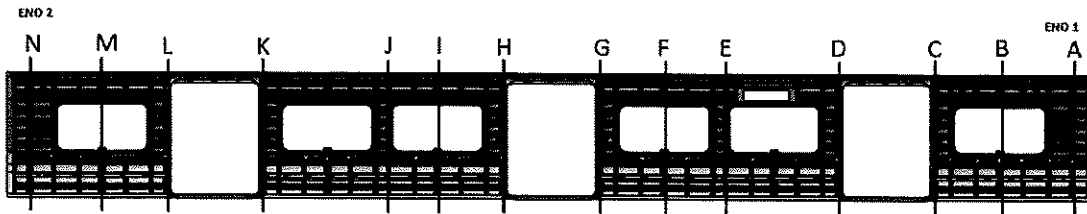


CARBODYSHELL M1,M3,M4 ASSEMBLY
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CBS measurement

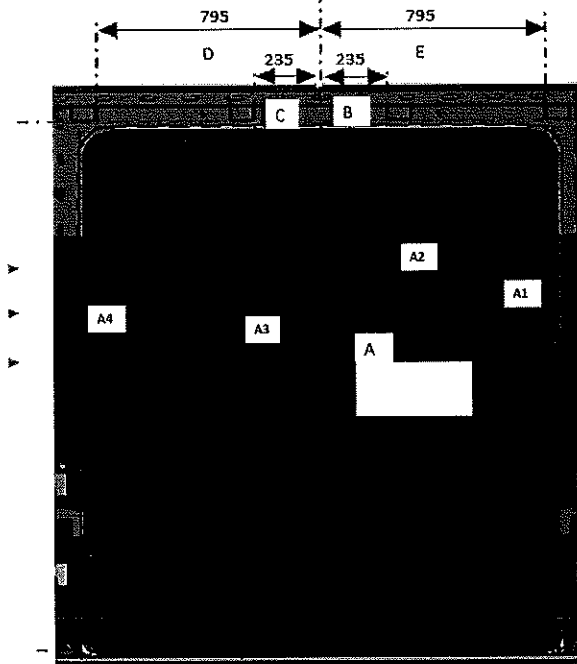


AFTER WELDING

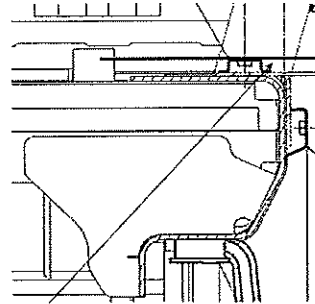
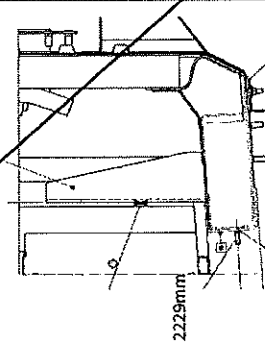
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3295	3302	7	2595
B	3269	3262	7	2589
C	3287	3295	7	2589
D	3297	3291	6	2589
E	3264	3268	4	2592
F	3264	3263	1	2595
G	3294	3294	0	2595
H	3292	3296	4	2589
I	3263	3265	2	2592
J	3265	3267	2	2595
K	3295	3295	0	2592
L	3297	3294	3	2589
M	3265	3263	3	2589
N	3292	3299	7	2595

(Handwritten signature)
07-07-29

Specifications of Details for CBS measurement CB1220



Brackets Carbodysshell
U Type Supports



Brackets Carbodysshell
Channel Assy

DOOR 1 - LHS

	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

DOOR 2 - 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	235
C	234 to 236	235
D	794 to 796	796
E	794 to 796	795

DOOR 2 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2232
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	794

DOOR 1 - 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	794
E	794 to 796	794

DOOR 2 - RHS

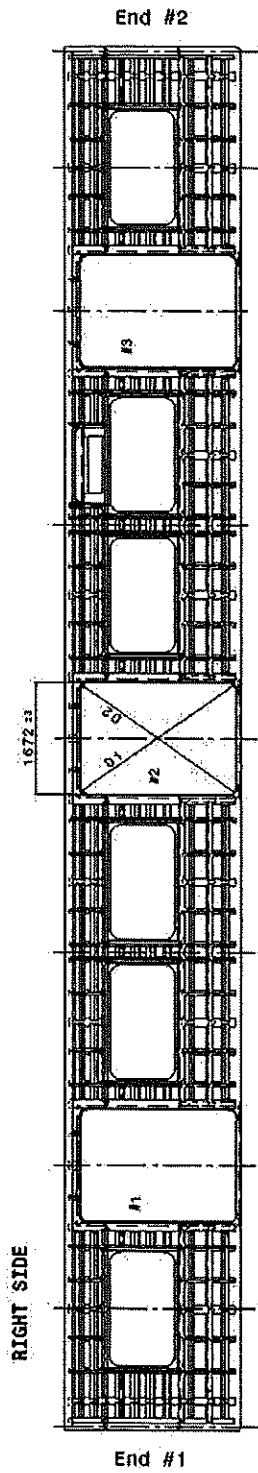
	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2232
A3	2230 to 2232	2232
A4	2230 to 2232	2231
B	234 to 236	235
C	234 to 236	235
D	794 to 796	795
E	794 to 796	795

DOOR 3 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2232
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

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09-04-26

Specifications of Details for CBS measurement CB1220



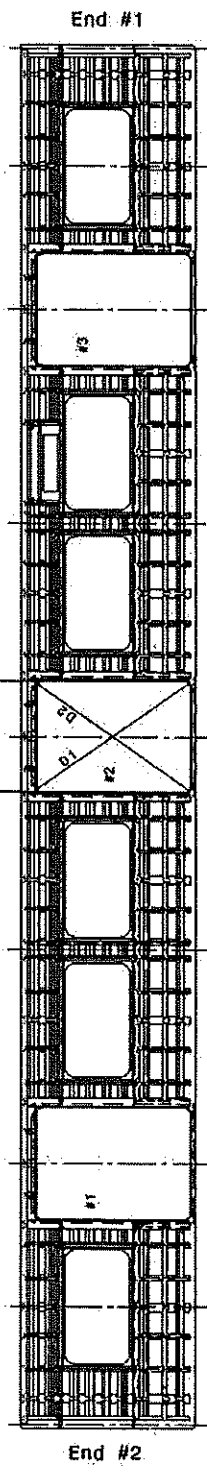
Doors diagonal D1-D2 maximum difference ≤ 4mm

	#1	#2	#3
D1	2748	2747	2747
D2	2746	2745	2746
D1-D2	2	2	1

Door's length = 1672.53mm

	#1	#2	#3
HIGHER DIMENSION	1674	1673	1672
CENTRAL DIMENSION	1672	1672	1672
LOWER DIMENSION	1671	1671	1671

LEFT SIDE




Doors diagonal D1-D2 maximum difference ≤ 4mm

	#1	#2	#3
D1	2746	2746	2744
D2	2745	2746	2747
D1-D2	1	1	3

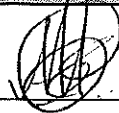

Door's length = 1672.53mm

	#1	#2	#3
HIGHER DIMENSION	1673	1673	1674
CENTRAL DIMENSION	1673	1672	1673
LOWER DIMENSION	1671	1671	1671

Handwritten signature and reference: *112-747-6*

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	

Self Inspection - Final Result

Is the car good to advance to the next workstation/process? (Approval of Operations Manager and Industrial Quality)		DATE	NAME	SIGNATURE	
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)	09-07-24	A. S. ... Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	09/07/24	K. ... Industrial Quality	
		There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)			


In case of "NO GO", describe blocking problems

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

Item	Description	Responsible	Due date	Status

Operations

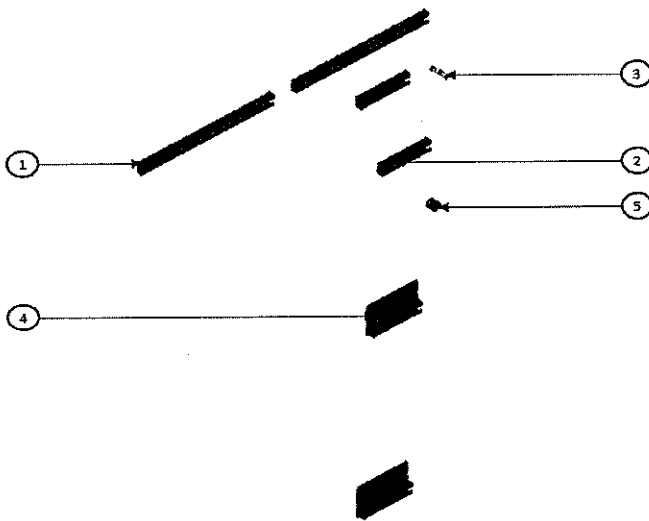
Quality

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	

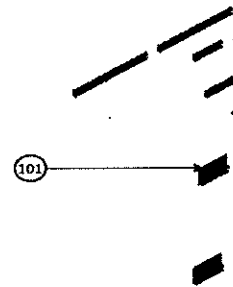
ANNEXURE A: Arc Welding Quality Acceptance Standard



Station: CB1220-004- U108 & U107

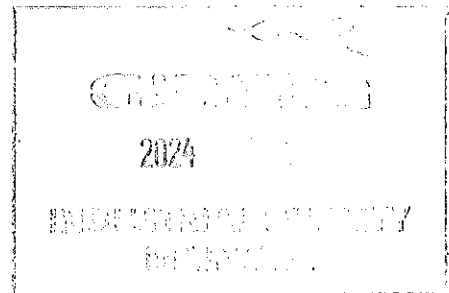
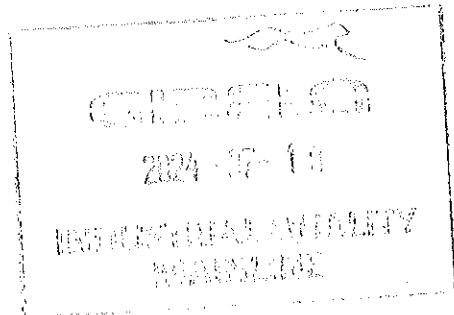



PART NO.	ITEM NO.	CITY	DESCRIPTION	MASS [KG]
DTR0020074088	5	6	EARTH STUD 6	0.036
AA0001201848	4	6	ASSEMBLY SUPPORT	0.271
DTR000348305	3	12	WELDING STUD ISO13818 FT - M8X20 - SST	0.007
AA0001180424	2	12	ASSEMBLY SUPPORT	0.193
AA0001184418	1	14	ASSEMBLY SUPPORT	0.522
AA0001161080	101	6	CARBODYSHELL BRACKETS CARBODYSHELL M1/M3/M4 CAP(SIDE FRAME MODULE END - OPP)	12.131



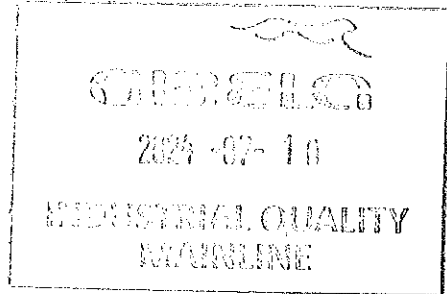
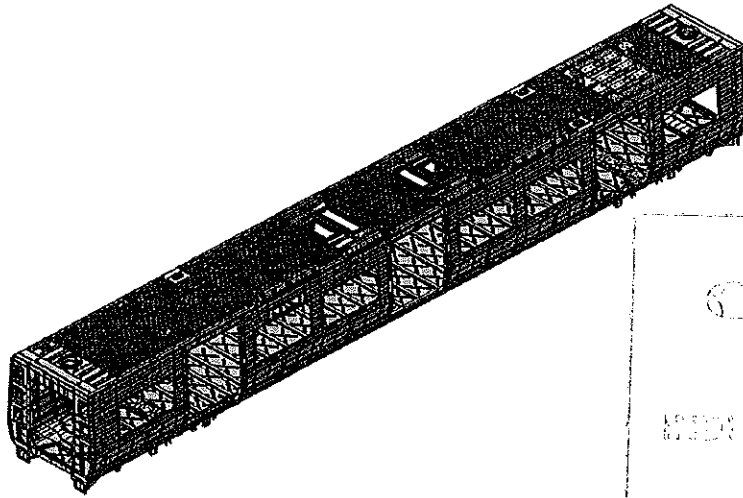


MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?	
				TC1	M6	M1	M2	M3	TC2			
<input type="checkbox"/>	DT00000225487	AAD0001278566	CB2230		X	X			X		PRA.CB2230.DT00000225487.V20	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE							
	2018/08/02	GIBELA NEW CREATION	APPROVER	Philippe Marques	2018/08/02							
			CHECKER	Nosizo Pindela	2018/08/02							
			COMPILER	Nosizo Pindela	2018/08/02							
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	30/5/2018							
			CHECKER	Nosizo Pindela	30/5/2018							
			REVISED BY	Nosizo Pindela	30/5/2018							
2	2018/05/07	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	2018/05/07							
			CHECKER	Nosizo Pindela	2018/05/07							
			REVISED BY	Ramokone Motama	2018/05/07							
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019							
			CHECKER	Nosizo Pindela	24/01/2019							
			REVISED BY	Vanessa Ntuli	24/01/2019							
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements	APPROVER	Itumeleng Modiba	13/03/2019							
			CHECKER	Nosizo Pindela	13/03/2019							
			REVISED BY	Nosizo Pindela	13/03/2019							
10	23/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	23/08/2019							
			CHECKER	Nosizo Pindela	23/08/2019							
			REVISED BY	Nosizo Pindela	23/08/2019							
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020							
			CHECKER	Bongane Masina								
			REVISED BY	Bongane Masina								
	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021							
			CHECKER	Bongane Masina								
			REVISED BY	Bongane Masina								
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	20/02/2022							
			CHECKER	Andani Muthelo								
			REVISED BY	Andani Muthelo								
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbhombhi	14/06/2022							
			CHECKER	Andani Muthelo								
			REVISED BY	Andani Muthelo								
27	26/07/2022	Threshold measurements addition	APPROVER	Collins Mbhombhi	26/07/2022							
			CHECKER	Andani Muthelo								
			REVISED BY	Andani Muthelo								
28	17/10/2022	Added traceability of sealant application	APPROVER	Collins Mbhombhi	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 threshold traceability 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							
237	M03	Norvannie 427423	10/07/24	SI.CB2230.256.V29	12							



	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30	Project: PRASA SI.CB2230.256.V29
		Date 06/11/2023	

Car:	NCR:	Work station:	CB2230
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I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car					Revision	Obsevation	OK	N/A	Remark	Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4	TCE							
PRA.CB2230.DT00000225487			✓			30		✓		N/A	<i>[Signature]</i> 10/07/24	<i>[Signature]</i>

I.2 - Instruments Control


Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	N/A	Signature/Date (Operations)	Signature/Date (Quality)
Tubular	22615	11/09/2024	✓		<i>[Signature]</i> 10/07/24	<i>[Signature]</i>
Measuring Tape	5181P0306	20/08/2024	✓			<i>[Signature]</i>
Combination Square	61850082	16/08/2024	✓			<i>[Signature]</i>

1.3 Consumables



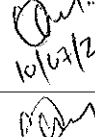
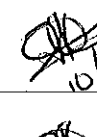
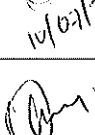
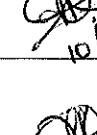
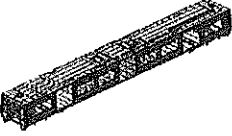

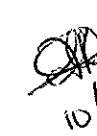
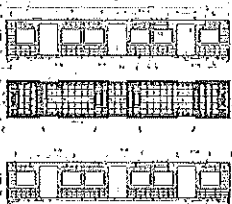


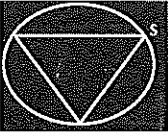






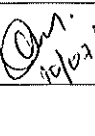
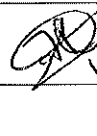
Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)
308 LSI	E231064	MIG	✓		<i>[Signature]</i> 10/07/24	<i>[Signature]</i>


	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30	Project: PRASA SI.CB2230.256.V29
		Date 06/11/2023	

II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NON	Reopen	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.DT00000225487 Verification of filament for all brackets.	PRA.CB1230.DT00000225487	✓			 10/07/24	 10/07/24
02	N/A	Carshell free of significant flows which compromise the appearance or functionality	DTD0000210675	✓			 10/07/24	 10/07/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓			 10/07/24	 10/07/24
		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓			 10/07/24	 10/07/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			 10/07/24	 10/07/24
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.	✓			 10/07/24	 10/07/24
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 Specified: Temperature Min - Max (1) Min-Max Relative humidity Min - Max (1)	Sealant Batch No: <u>76E 70-03</u> Exp Date: <u> </u> / <u>02</u> / <u>25</u> Actuals Temperature: <u>13°C</u> Humidity: <u>41%</u>	✓			 10/07/24	 10/07/2024
08	N/A	Verification of sealant application on the roof and sidewall finishers.	Sealant must be: -Applied straight and even -Free of gaps,cracks,damage and debris (flashes, dirt, dust) Refer to Annexure B	✓			 10/07/24	 10/07/2024
09	N/A	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓			 10/07/24	 10/07/2024

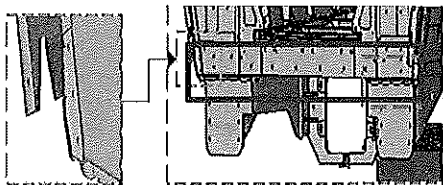
2025-07-10
QUALITY
ENGINE

	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30	Project: PRASA SI.CB2230.256.V29
		Date 06/11/2023	

II - Self Inspection - Items to Check

END 2 SEALANT

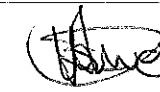
AREA 1



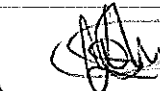
OPERATOR
(Name & sign):

LERoy 

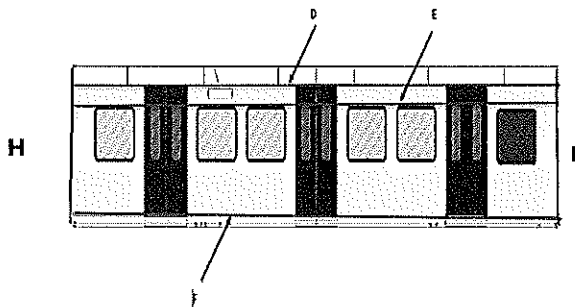
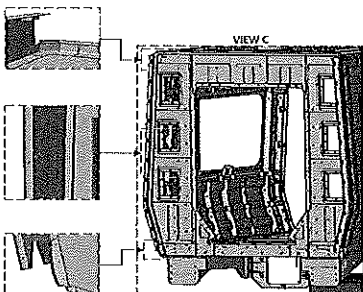
OPERATOR
(Name & sign):

LERoy 

OPERATOR
(Name & sign):

LERoy 

AREA 2 (VIEW C)



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

	LHS	RHS
Operator (Name & sign):	F, I, H (Bottom)	F, I, H (Bottom)

Operator (Name & sign): Bokumelo

Bokumelo

Operator (Name & sign): ~~STARTSE~~

~~STARTSE~~

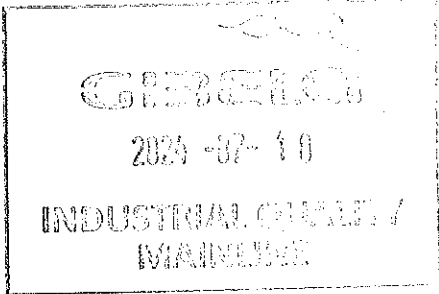
Operator (Name & sign): D, E, G (HI TOP)

(DEG (HI TOP))

Operator (Name & sign): LERoy (LM)

LERoy (LM)

Operator (Name & sign): Nonhlanhla @ Nonhlanhla @





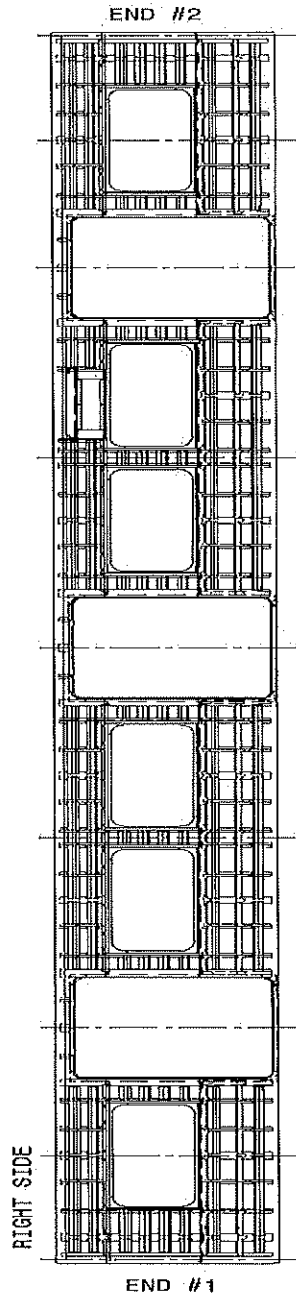
CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

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30
Date
06/11/2023

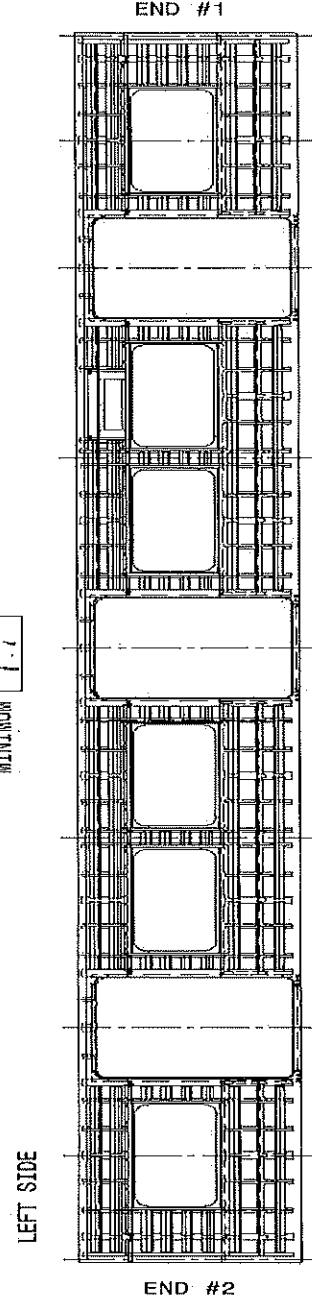
Project: PRASA
SI.CB2230.256.V29

Specifications of Details for CBS measurement GB1230

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



MAXIMUM	1.9
MINIMUM	1.1



MAXIMUM	1.7
MINIMUM	1.2

2023-08-10

PRASA

SI.CB2230.256.V29



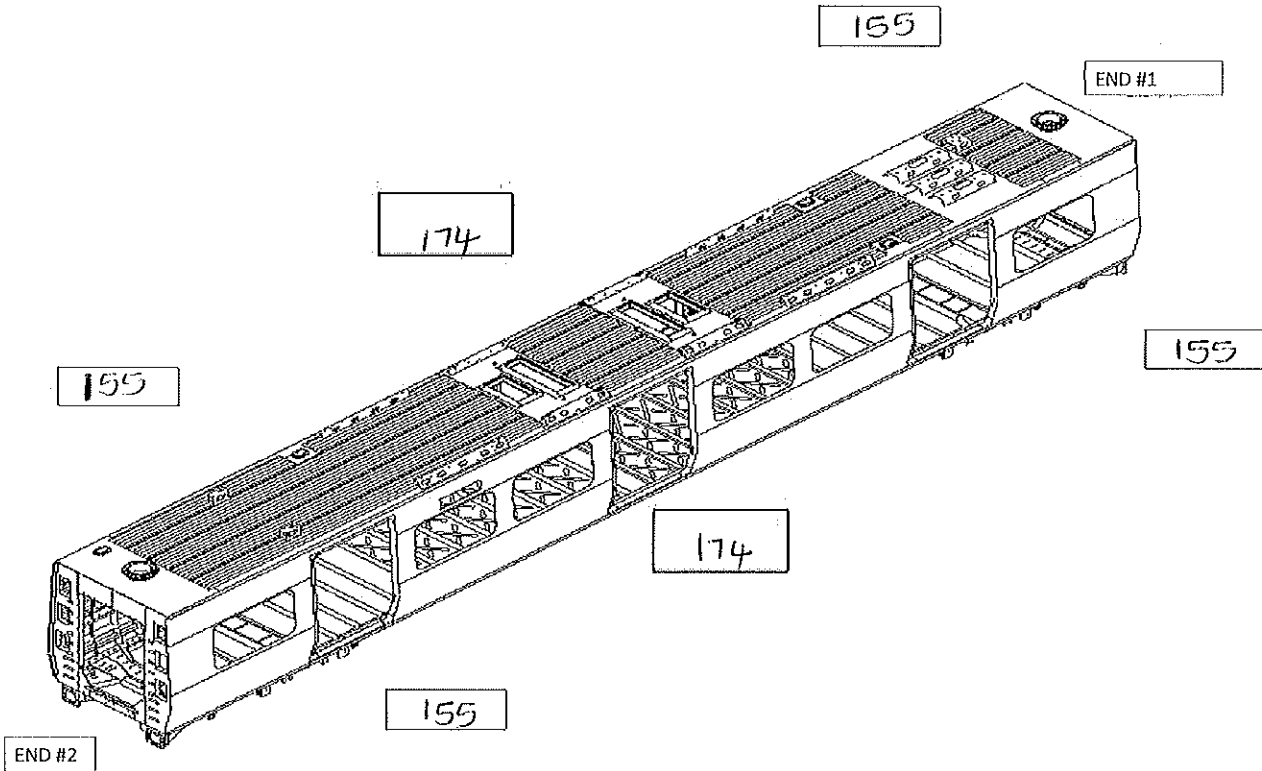
CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
30
Date
06/11/2023

Project: PRASA
SI.CB2230.256.V29

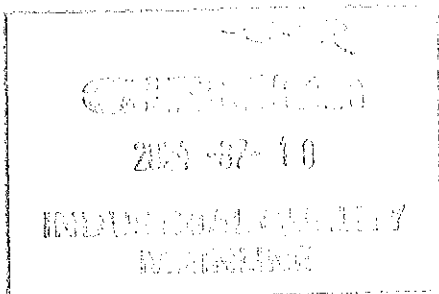
Specifications of Details for GBS measurement GB1230

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



MEASURED CAMBER VALUES

RIGHT	'1	19
LEFT	'a1	19





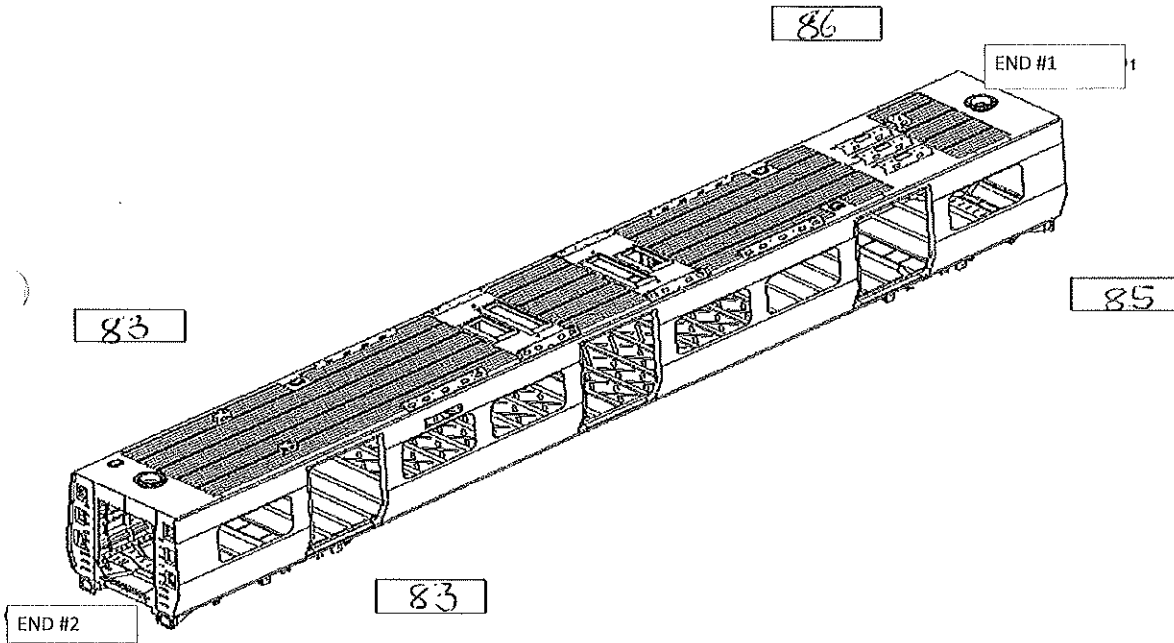
CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
30
Date
06/11/2023

Project: PRASA
SI.CB2230.256.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	<input type="text" value="1"/>
LONGITUDINAL	<input type="text" value="2"/>

TWIST FOUND ON END 2

TRANVERSE	<input type="text" value="0"/>
LONGITUDINAL	<input type="text" value="3"/>

123-07-10
PROPERTY

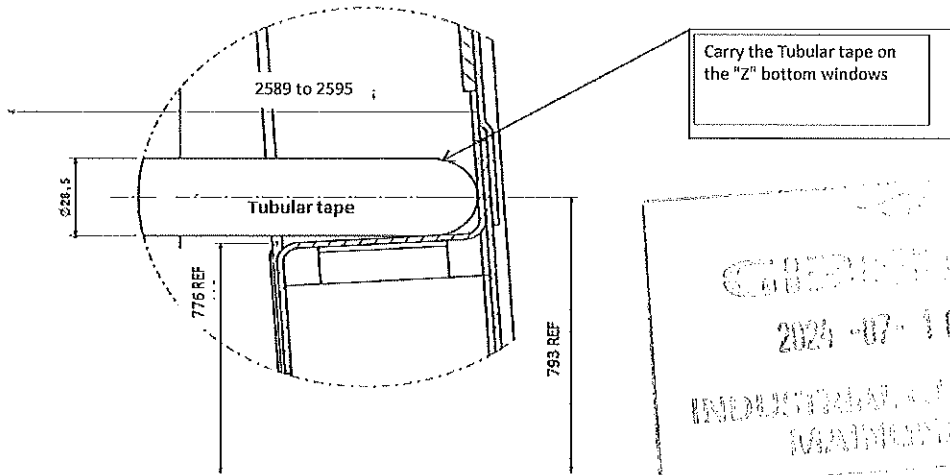


CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

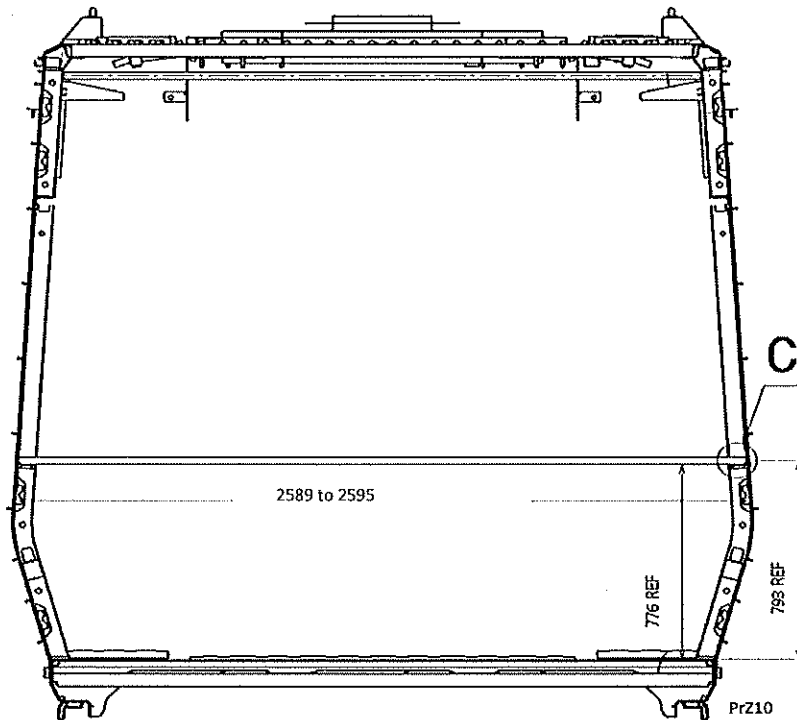
Rev.
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Date
06/11/2023

Project: PRASA
SI.CB2230.256.V29

Specifications of Details for CBS measurement GB1230



Detail C



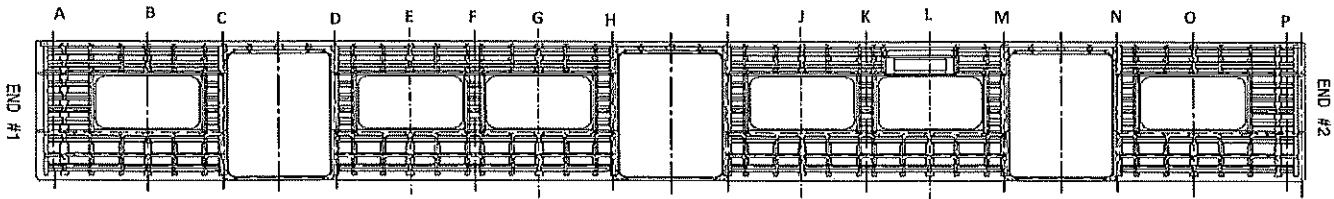


CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev. 30
Date 06/11/2023

Project: PRASA
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Specifications of Details for CBS measurement GB1230



2589 to 2595mm

A	2595
B	2592
C	2585
D	2589
E	2589
F	2594
G	2595
H	2591
I	2589
J	2591
K	2595
L	2595
M	2593
N	2589
O	2591
P	2594



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

BOILER MAKER: Asand et

WELDER: Emmanuel (Bottom) Nantlanha (Top)

Dye penetrant test


Dye-penetration test to be performed by quality personnel



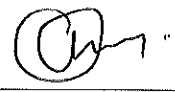

2024-07-10

INSPECTED BY: [Signature]

DATE: 2024-07-10

	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30	Project: PRASA SI.CB2230.256.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)	10/07/24	Nunlanhka <small>Operations</small>		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	10/07/24	Amogelang <small>Industrial Quality</small>		
	NO GO	There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			<small>Operations</small>	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)			<small>Industrial Quality</small>	

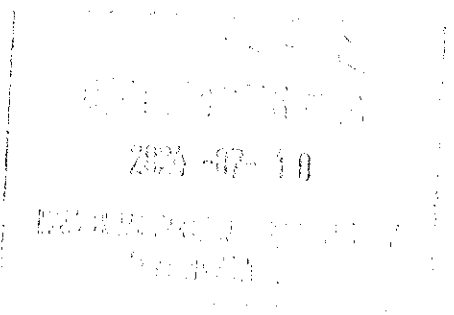
In case of "NO GO", describe blocking problems


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

Item	Description	Responsible	Due date	Status


Operations

Quality


 2023-07-10

	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30	Project: PRASA SI.CB2230.256.V29
		Date 06/11/2023	

ANNEXURE A: Arc Welding Quality Acceptance Standard

