


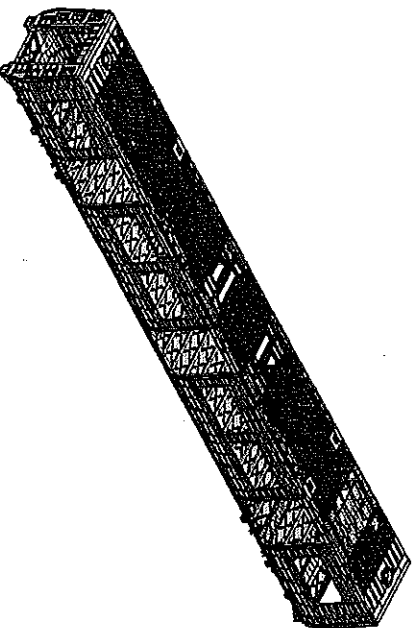
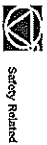


**CONFIDENTIAL INFORMATION**  
This document and the information contemplated therein have to be considered as Confidential information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

APPLICATION REFERENCE										
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE				WORK INSTRUCTION	SAFETY ?	
				TC1	M4	M2	M3			TC2
<input type="checkbox"/>	DTF30225487/3	CARBODYSTELL M4 ASSEMBLY	CB1210		<input checked="" type="checkbox"/>				PR4.CB1210.DTF30225 487/3.V25	YES
<input type="checkbox"/>										
REV	DATE	MODIFICATION CONTENT			RESPONSIBLE	NAME	DATE			
0	10/01/2018	GIBELA NEW CREATION			APPROVER	tumeleng Modiba	10/01/2018			
					CHECKER	Nosizo Pindela	10/01/2018			
					COMPLER	Thanyani Mathhegu	10/01/2018			
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PHE Manager to Quality manager			APPROVER	tumeleng Modiba	2018/05/18			
					REVISIED BY	Ramokone Motama	2018/05/18			
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230			APPROVER	tumeleng Modiba	2018/07/04			
					REVISIED BY	Nosizo Pindela	2018/07/04			
3	2018/12/12	Added dimensional check points to CB1210			APPROVER	tumeleng Modiba	2018/12/12			
					CHECKER	Nosizo Pindela	2018/12/12			
					REVISIED BY	Ramokone Motama	2018/12/12			
5	22/01/2019	As per Baseline 10.2			APPROVER	tumeleng Modiba	22/01/2019			
					CHECKER	Nosizo Pindela	22/01/2019			
					REVISIED BY	Vanessa Ntuli	22/01/2019			
6	13/03/2019	Added D1 and D2 on Self - Inspection			APPROVER	tumeleng Modiba	13/03/2019			
					CHECKER	Nosizo Pindela	13/03/2019			
					REVISIED BY	Nosizo Pindela	13/03/2019			
10	21/08/2019	New Baseline 10.2.5			APPROVER	tumeleng Modiba	21/08/2019			
					CHECKER	Nosizo Pindela	21/08/2019			
					REVISIED BY	Nosizo Pindela	21/08/2019			
15	06/08/2020	New Baseline 10.2.6			APPROVER	Timothy Maimela	06/08/2020			
					CHECKER	Bongane Masina	06/08/2020			
					REVISIED 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			
					REVISIED 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			
					REVISIED BY	Mpho Mulaudzi	17/08/2021			
25	19/02/2022	New Baseline change 10.3.1			APPROVER	Mbhombi collins	19/02/2022			
					CHECKER	Andani Muthelo	19/02/2022			
					REVISIED BY	Andani Muthelo	19/02/2022			
26	14/04/2023	Addition of welding consumable traceability			APPROVER	Ntuli Vanessa	14/04/2023			
					CHECKER	Mohlame Amogelang	14/04/2023			
					REVISIED BY	Mohlame Amogelang	14/04/2023			
27	27/07/2023	Added verification of leaded parts			APPROVER	Ngobeni Tyson	27/07/2023			
					CHECKER	Zwane Ntokoza	27/07/2023			
					REVISIED BY	Mohlame Amogelang	27/07/2023			
28	07/11/2023	Addition of welding traceability			APPROVER	Ngobeni Tyson	07/11/2023			
					CHECKER	Andani Muthelo	07/11/2023			
					REVISIED BY	Ntokoza Zwane	07/11/2023			
TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES					
75311	M1	P:Matlali	13/10/2024	SLCB1210.254.V28	17					



409944

		CARBODYSHELL M1 ASSEMBLY DTR302254873		Rev. 28	Project: PR05A SI.CB1210.254.V28
Cert: M1	NCR:	Date 07/11/2023	Work station:	CB1210	





I - Documentation and Instruments Control



I.1 - Documentation Control

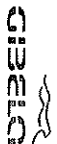
Document	Type of air					Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	TC1	M1	M2	M3	M4	TC2				
DTR302254873		X						✓	 12/03/24	 12/03/24

I.2 - Instruments Control


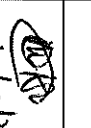

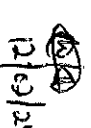

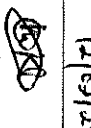

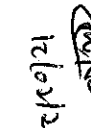


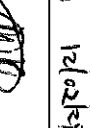
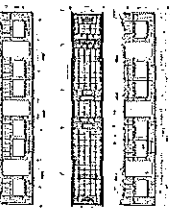

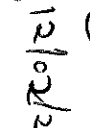

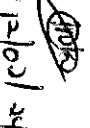
Monitoring and Measuring Instrument Control - Used for Special Process			Monitoring and Measuring Instrument Control - Used for Special Process		
Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
BAUMER LASER MAPPE 30M MAPPE	02516 135436931 G167P0084	07/03/23 01/03/23 03/03/23	✓ ✓ ✓	 12/03/24	 12/03/24

1.3 Consumables

Welding Consumable Control - Used for Special Process					
Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSi	31401834097	MIG	✓	 12/03/24	 12/03/24
ER 308 L	2996537088	TIG	✓		

	CARBODYSHELL M1 ASSEMBLY DTR302254873		Rev. 28	Project: PRASA
			Date 07/11/2023	SI.CB1210.254.V28

### II - Self Inspection - Items to Check

II.1 - Items to check						
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Side walls, End frames, Roof and Underframe)	DTD00000311225	<input checked="" type="checkbox"/>	 12/02/24	 12/02/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD00000210675	<input checked="" type="checkbox"/>	 12/02/24	 12/02/24
03	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD00000210675	<input checked="" type="checkbox"/>	 12/02/24	 12/02/24
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TTPDEF - ARC - 0000	<input checked="" type="checkbox"/>	 12/02/24	 12/02/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-MEL - PROC-0002	<input checked="" type="checkbox"/>	 12/02/24	 12/02/24
06		Functional's dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	<input checked="" type="checkbox"/>	 12/02/24	 12/02/24
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 filler sampling as described in DTD00000210658.	As the welding procedure IND-SAL-WMS-018 and DTD00000210658.	<input checked="" type="checkbox"/>	 12/02/24	 12/02/24



CARBODYSHELL M1 ASSEMBLY DTR302254873

REV.  
28

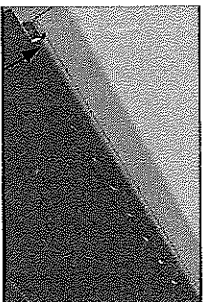
Project: PRASA  
SI.CB1210.254.V28

Date

07/11/2023

### Welder Traceability

Roof ring welds



LHS

Boiler maker (Name & Sign): Laurence Mga Welder (Name & Sign): MITHOKOZISI

RHS

Boiler maker (Name & Sign): Pontso Mga Welder (Name & Sign): MITHOKOZISI

END 1

LHS

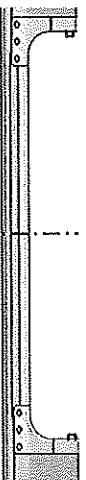
Boiler maker (Name & Sign): Laurence Mga Welder (Name & Sign): MITHOKOZISI

END 2

RHS

Boiler maker (Name & Sign): Pontso Mga Welder (Name & Sign): MITHOKOZISI

Door ring welds



LHS

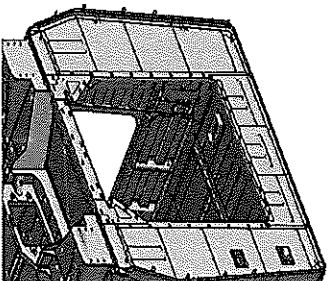
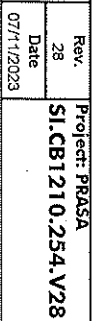
Boiler maker (Name & Sign): Laurence Mga

Welder (Name & Sign): GIFT

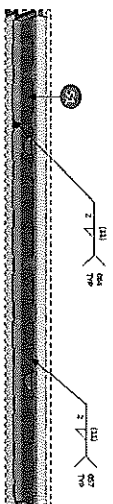
RHS

Boiler maker (Name & Sign): Laurence Mga

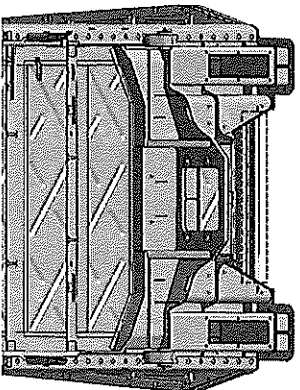
Welder (Name & Sign): GIFT

Boiler maker (Name & Sign) Jeffrey M. W. W. W.

Welder (Name & Sign): Sprick




**END 2**

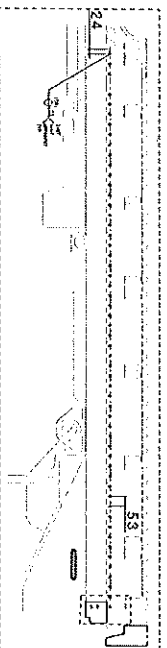


## Underneath the CAR

**END 2**

Boiler maker (Name & Sign): IND 

Welder (Name & Sign): 1.9.2015

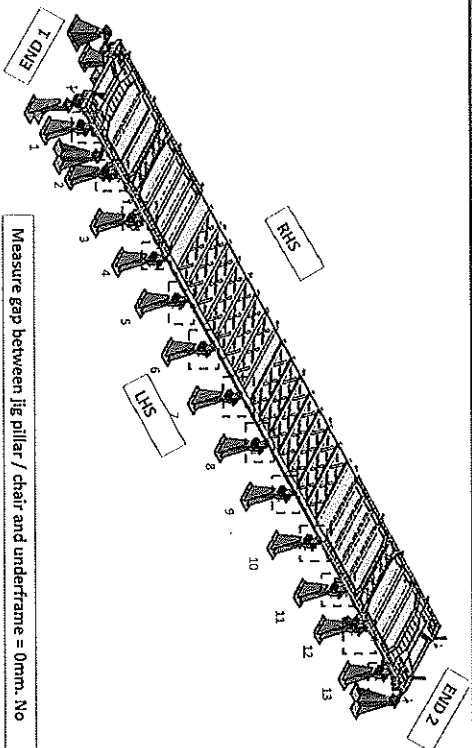


FEDOLI

**OPERATOR:**

Spiders

Specifications of Details for CBS measurement



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

After loading and clamping

Fill in the gap foundon 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					NA								
Right Hand side													

Signature Operator:

*[Signature]* Date: 12/02/24

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					NA								
Right Hand side													

Signature Industrial Quality:

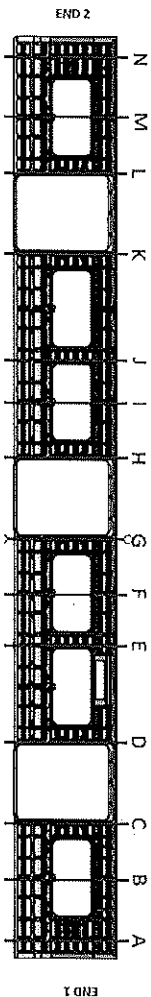
*[Signature]* Date: 12/02/24



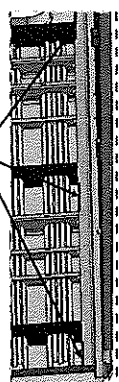
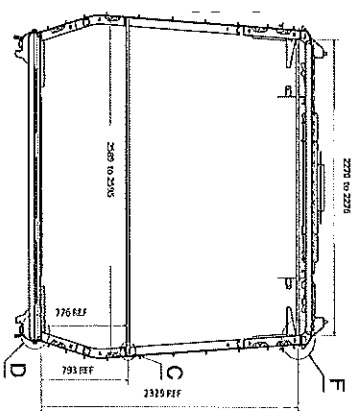
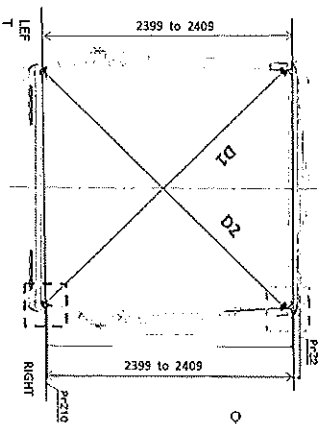
CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev.	28	Project: PRASA SI.CB1210.254.V28
Date	07/11/2023	

Specifications of Details for CBS measurement



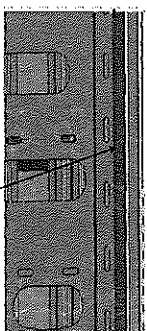
9



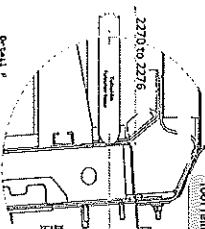
Measurement positions on roof rail and sidewall corner.



Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.



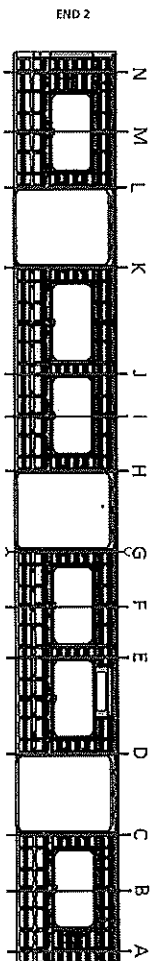
Detail 9  
Roof reinforcement area measurement positions on roof reinforcement area.

**GIBELCO**

CARBODY/SHELL M1 ASSEMBLY DTR30225487/3

Rev. 28  
Date 07/11/2023  
Project: PRASA  
SI.CB1210.254.V28

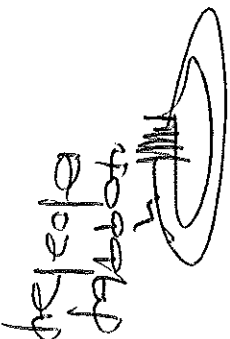
Specifications of Details for CBS measurement



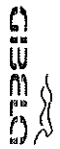
PME Column LHS - RHS should be  $\leq 2\text{MM}$  on each point.

BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS $\leq 2$
A	3069	3068	1	2404	2404	0
B	3069	3069	0	2404	2405	1
C	3071	3069	2	2406	2404	2
D	3069	3072	3	2405	2404	1
E	3068	3066	2	2404	2403	1
F	3068	3068	0	2406	2404	2
G	3070	3071	1	2404	2405	1
H	3069	3069	2	2404	2404	0
I	3069	3069	0	2406	2405	1
J	3068	3066	2	2404	2404	0
K	3070	3069	1	2406	2404	2
L	3068	3069	1	2404	2406	2
M	3068	3068	0	2404	2405	1
N	3066	3065	1	2404	2404	0



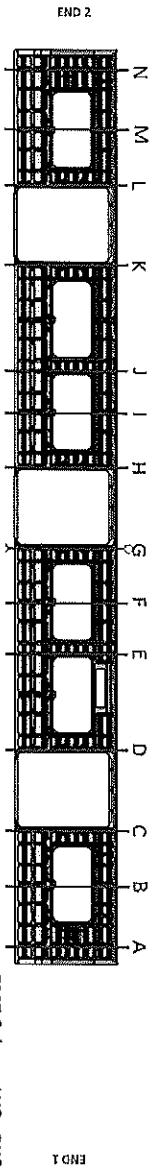




CARBODYSHELL M1 ASSEMBLY DTR302264873

Rev. 28  
Date 07/11/2023  
Project: PRASA  
SI.CB1210.254.V28

Specifications of Details for CBS measurement




PME Column LHS - RHS should be  
≤ 2MM on each point.

AFTER WELDING

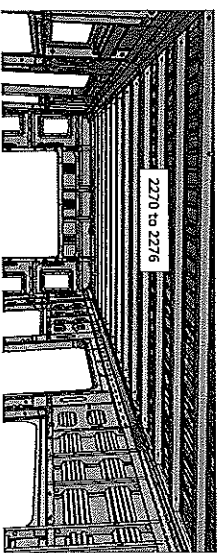
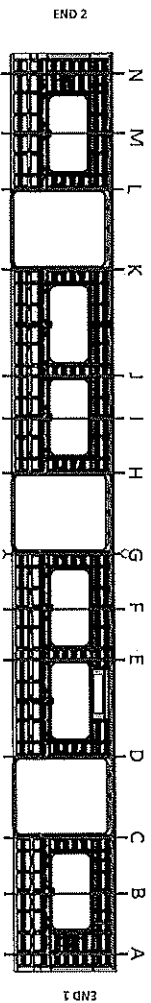
Record D1 values		Record D2 values		D1-D2 ≤ 5mm		2399 to 2409		2399 to 2409 (RHS)		LHS-RHS ≤ 2
A	3096	3095	1	2404	2405	1				
B	3069	3064	0	2404	2404	2				
C	3098	3094	2	2404	2405	1				
D	3099	3097	2	2404	2406	2				
E	3069	3064	0	2406	2404	2				
F	3071	3070	1	2404	2404	0				
G	3096	3096	0	2405	2404	1				
H	3099	3097	2	2404	2403	1				
I	3069	3068	1	2404	2405	1				
J	3068	3068	0	2406	2404	2				
K	3099	3098	1	2404	2405	1				
L	3098	3096	0	2404	2404	0				
M	3069	3068	1	2406	2405	1				
N	3096	3096	0	2404	2404	0				

409964  
12/02/24

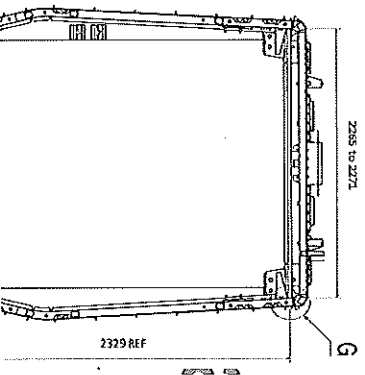
	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28 Date 07/11/2023	Project: PR5A SI.CB1210.254.V28
---	--	----------------------------------	------------------------------------

GBS measurement

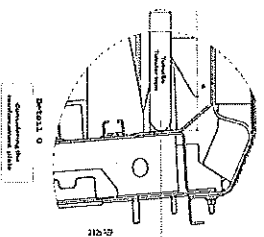
BEFORE WELDING



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



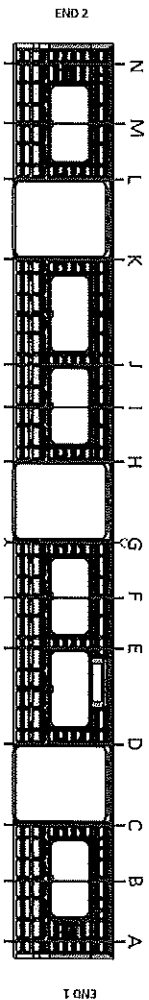
2270 to 2276	A	2274
1990 to	B	2276
	C	2271
	D	2276
	E	2274
	F	2275
	G	2273
	H	2272
	I	2276
	J	2274
	K	2276
	L	2273
	M	2274
	N	2275



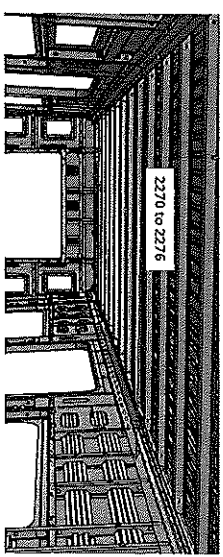
2270 to 2276  
2274 to 2276  
2275 to 2276  
2276 to 2276

CBS measurement

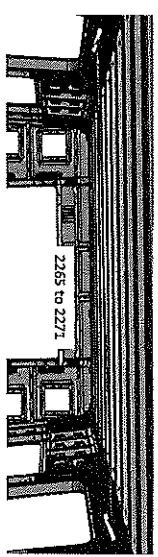
AFTER WELDING



	2265 to 2271	2270 to 2276
A	Ø269	N14
B	N14	Ø275
C	Ø265	N14
D	Ø269	N14
E	N14	Ø274
F	N14	Ø276
G	Ø268	N14
H	Ø269	N14
I	N14	Ø275
J	N14	Ø274
K	Ø269	N14
L	Ø268	N14
M	N14	Ø275
N	Ø265	N14

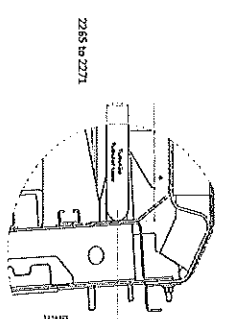
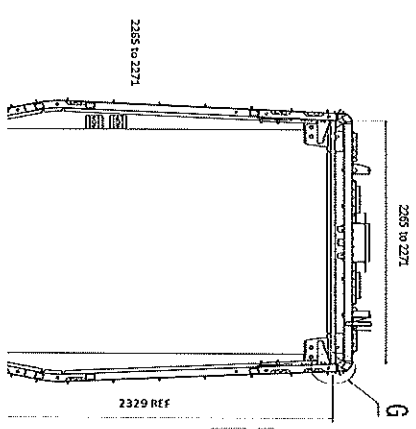


Do not consider reinforcement (Take measurements top area of zee profile)



Take measurement close to radius ( considering reinforcement)

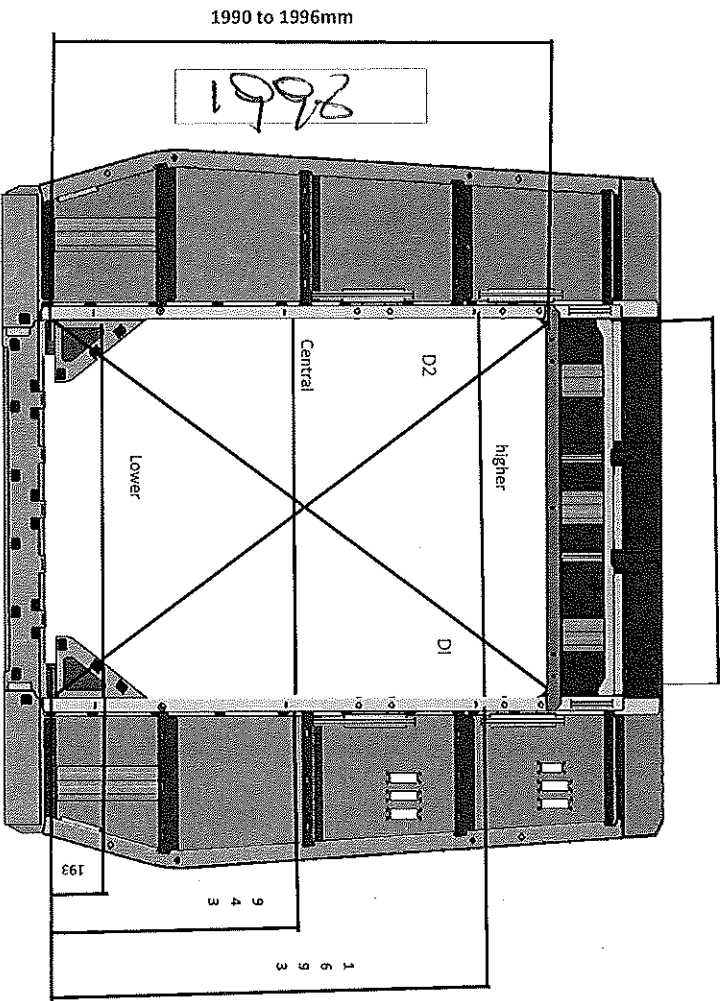
	2265 to 2271	2270 to 2276
A	Ø269	N14
B	N14	Ø275
C	Ø265	N14
D	Ø269	N14
E	N14	Ø274
F	N14	Ø276
G	Ø268	N14
H	Ø269	N14
I	N14	Ø275
J	N14	Ø274
K	Ø269	N14
L	Ø268	N14
M	N14	Ø275
N	Ø265	N14



Handwritten signature and notes.

Specifications of Details for CBS measurement

End frame 1



DIAGONAL DIFFERENCE  $D1-D2 \leq 3mm$

Higher Dimension

1386

D1

2415

Central Dimension

1381

D2

2416

Lower Dimension

1381

D1-D2

1

*Handwritten signature and date: 20/02/24*



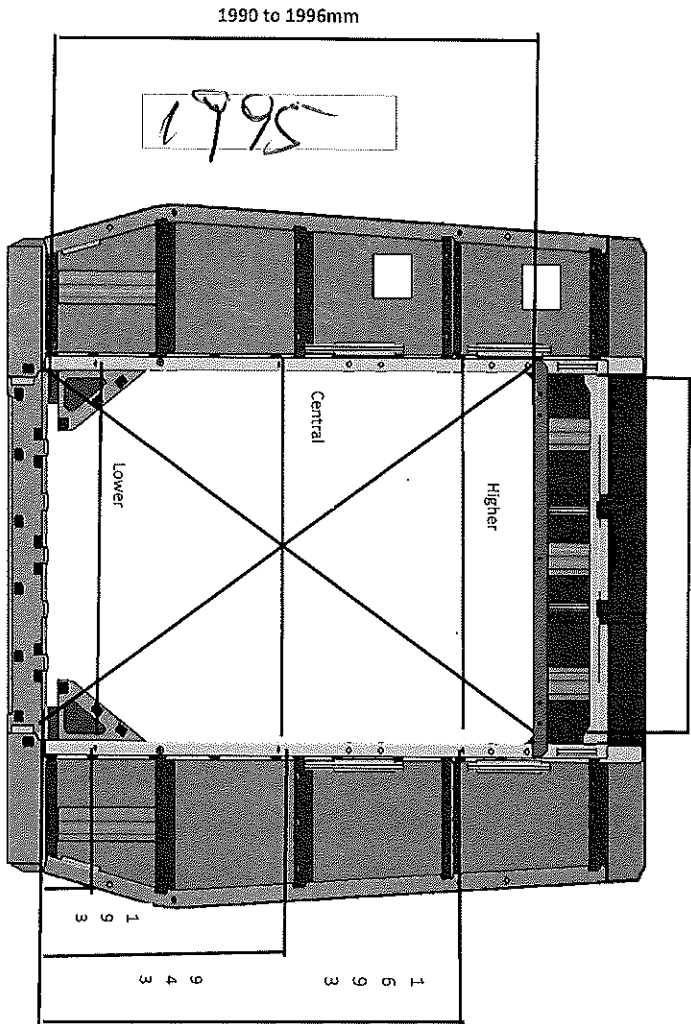
CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev.	28	Project: PRASA SI.CB1210.254.V28
Date	07/1/2023	

Specifications of Details for GBS measurement

Endframe 2

1380 to 1382 mm



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1386

D1

2415

Central Dimension

1388

D2

2414

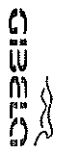
Lower Dimension

1381

D1-D2

1

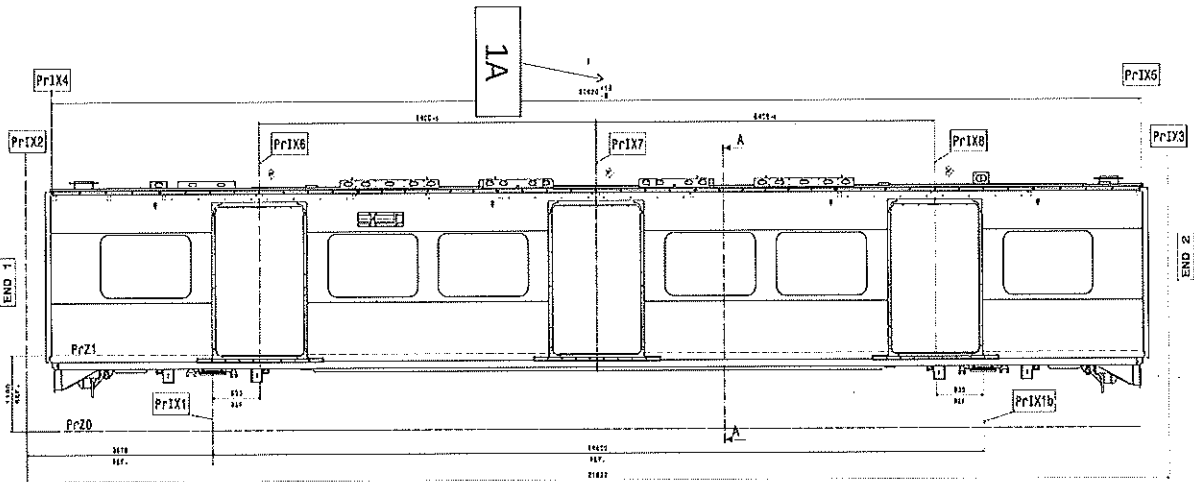
409964  
1010044



CARBOYSHELL M ASSEMBLY DTR302254873

Rev.	Project: PRASA
28	SI.CB1210.254.V28
Date	
07/11/2023	

Specifications of Details for CBS measurement



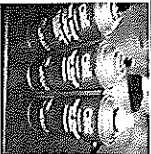
LEFT SIDE	
SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614
	20616

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


Handwritten signature and date: 24/09/24, 10/03/24

Dye penetrant test



Dye-penetration test to be performed by quality personnel



GIBELCO		CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 26 Date 07/11/2023	Project: PRASA  SI.CB1210.254.V28	
Item	Description of the issue	OK	Signature Date (Manufacturing)	Signature Date (Quality)	
01	N/A To comply REX				

	CARBODYSHELL M1 ASSEMBLY DTR302254873	Rev. 28	Project: PR5A
		Date 07/11/2023	SI.CB1210.254.V28

Self Inspection - Final Result

		DATE	NAME	SIGNATURE
HOLD POINT	GO	12/02/24	Richmond	
	NO GO		Operations	
			Industrie 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

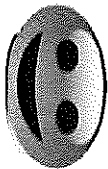
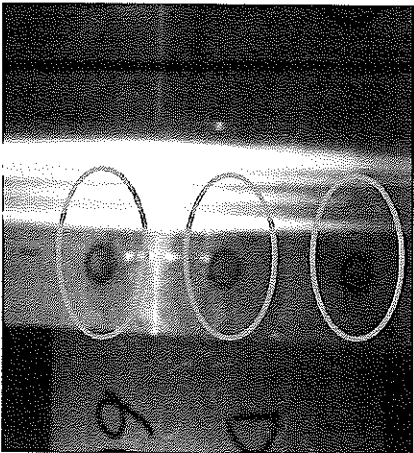
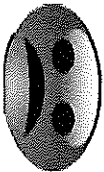
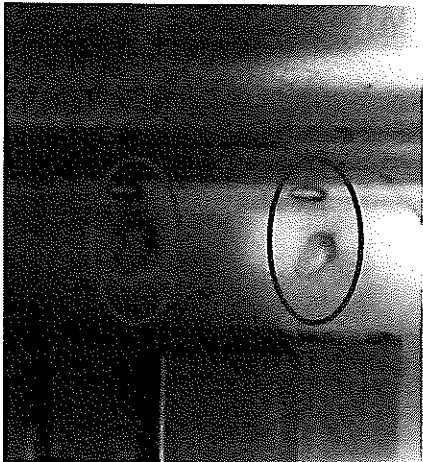
Operations


Quality



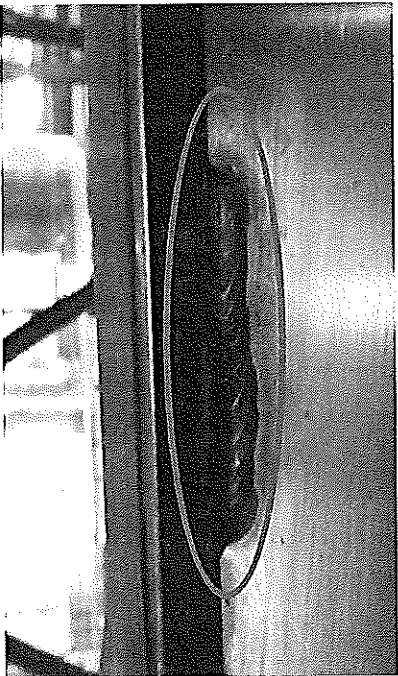
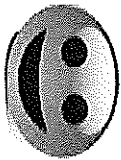
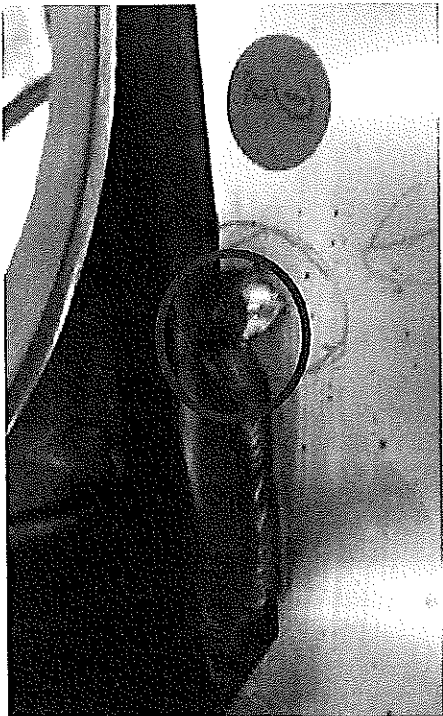
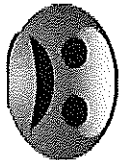
 GIBELCO	CARBODYSHELL M1 ASSEMBLY DTR30225487/3		Rev. 28	Project: PRA5A SI.CB1210.254.V28
			Date 07/11/2023	



ANNEXURE A: Spot Welding Quality Acceptance Standard



	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28 Date 07/11/2023	Project: PRASA SI.CB1210.254.V28

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



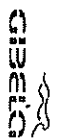



APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

## 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 NSA, and treated as such.

DRAWING	DESCRIPTION	STATION	CARTER				WORK INSTRUCTION	SAFETY
			TC	MC	MC	MC		
<input type="checkbox"/>	07B022548/7	A40000278646	CABRODSHEL	ORCA20	X	<input checked="" type="checkbox"/>	X	YES
REV	DATE	MODIFICATION CONTENT				RESPONSIBLE		DATE
0	01/02/2018	GIBELA NEW CREATION				APPROVER	Ismaeleng Madiha	02/02/2018
						CHECKER	Niccozo Pindela	01/02/2018
						COMPLER	Thangari Muthu	01/02/2018
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PVE Manager to Quality Manager				APPROVER	Ismaeleng Madiha	18/05/2018
						CHECKER	Niccozo Pindela	18/05/2018
						REVISED BY	Ramokone Mokane	18/05/2018
2	2018/07/05	Certain dimensional checks added and others moved to CB210				APPROVER	Ismaeleng Madiha	2018/07/05
						CHECKER	Niccozo Pindela	2018/07/05
						REVISED BY	Ramokone Mokane	2018/07/05
3	2018/06/12	Width tolerance as per 070000336400				APPROVER	Ismaeleng Madiha	2018/06/12
						CHECKER	Niccozo Pindela	2018/06/12
						REVISED BY	Niccozo Pindela	2018/06/12
5	24/01/2019	As per Baseline 10.2				APPROVER	Ismaeleng Madiha	24/01/2019
						CHECKER	Niccozo Pindela	24/01/2019
						REVISED BY	Vanessa Ndili	24/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements				APPROVER	Ismaeleng Madiha	13/03/2019
						CHECKER	Niccozo Pindela	13/03/2019
						REVISED BY	Niccozo Pindela	13/03/2019
10	22/08/2019	New Baseline 10.2.5				APPROVER	Ismaeleng Madiha	22/08/2019
						CHECKER	Niccozo Pindela	22/08/2019
						REVISED BY	Niccozo Pindela	22/08/2019
15	06/08/2020	New Baseline 10.2.6				APPROVER	Ismaeleng Madiha	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	Ismaeleng Madiha	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	Ismaeleng Madiha	17/08/2021
						CHECKER	Mpho Malsandi	17/08/2021
						REVISED BY	Mpho Malsandi	17/08/2021
25	20/02/2022	New Baseline change 10.3.1				APPROVER	Ismaeleng Madiha	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	Ismaeleng Madiha	14/06/2022
						CHECKER	Andani Muthelo	14/06/2022
						REVISED BY	Andani Muthelo	14/06/2022
27	17/10/2022	Addition of traceability for sealant application and welding				APPROVER	Ismaeleng Madiha	17/10/2022
						CHECKER	Niccozo Zwane	17/10/2022
						REVISED BY	Niccozo Zwane	17/10/2022
28	14/04/2023	Added sealant batch number & welding consumables traceability				APPROVER	Ismaeleng Madiha	14/04/2023
						CHECKER	Niccozo Zwane	14/04/2023
						REVISED BY	Niccozo Zwane	14/04/2023
29	28/10/2023	Addition of bracket quantity				APPROVER	Nipphet Tsion	28/10/2023
						CHECKER	Niccozo Zwane	28/10/2023
						REVISED BY	Amogelang Mochame	28/10/2023
TRAINSET	CAR	OPERATOR NAME/APS NO	DATE	SELF INSPECTION NUMBER				PAGES
211	M1	416788 THOLANI	14/02/24	SI.CB1220.250.V29				14



CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2

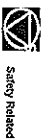
Rev. 29  
Date 28/10/2023  
Project: PRASA  
SI.CB1220.250.V29

Car: M1,M3,M4

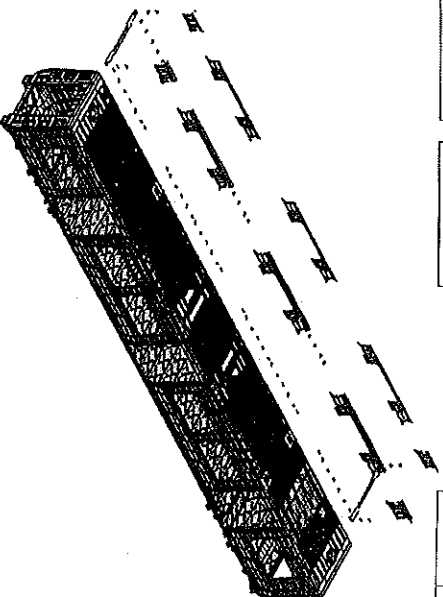
NCR:

Work station:

CB1220



Safety Related



### L - Documentation and Instruments Control

#### L1 - Documentation Control

Documents	Type of car					Rev./aon	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	M1	M2	M3	M4	M2					
DTR30225487/2						29	28/01/2023	L	N/A	14/02/24

14/02/24

#### L2 - Instruments Control

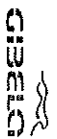
##### Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULOR	22713	03/03/2023	L	14/02/24	14/02/24
THPE-MEASURC	GAB7A0341	05/04/2023	L	14/02/24	14/02/24

#### 1.3 Consumables

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

Elect Material	Mat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308 1mm	330498	MIG	L	14/02/24	14/02/24

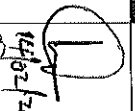
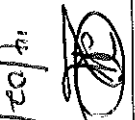
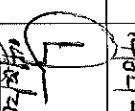
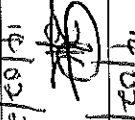
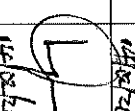
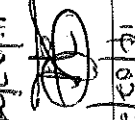

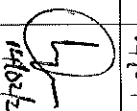
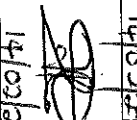
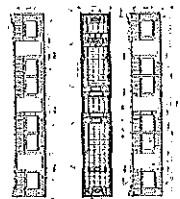
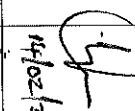
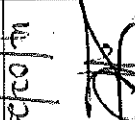
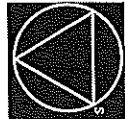
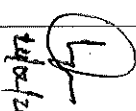
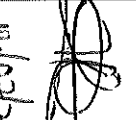
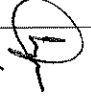




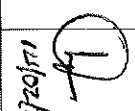
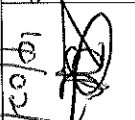


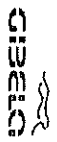
CARBOYSHELL M1,M3,M4 ASSEMBLY  
DTR302254872

Rev.  
29  
Date  
28/07/2023  
Project: PRASA  
SI,CB1220.250.V29

II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Records	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Inspection Engineering n° PRA-CB1220.DTR302254872 Verification of format for all reinforcement brackets.	PRA-CB1220.DTR302254872	<input checked="" type="checkbox"/>	 14/02/24	 14/02/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210475	<input checked="" type="checkbox"/>	 14/02/24	 14/02/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - ITPDET - ARC - 0000	<input checked="" type="checkbox"/>	 14/02/24	 14/02/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	<input checked="" type="checkbox"/>	 14/02/24	 14/02/24
05		Function's dimensions approved according drawing or complementary document approved by Adam engineering and registered in this document.	Approved according specified on pages below.	<input checked="" type="checkbox"/>	 14/02/24	 14/02/24
06		Perform visual inspection of welds in 100% of the project. Run by percent testing in electro arc welding (weld ring) as IND-SAL-WMS-018. Run by percent testing welds (weld ring) and fillet sampling as described in DTD0000210558.	As the welding procedure IND-SAL-WMS-018 and DTD0000210558.	<input checked="" type="checkbox"/>	 14/02/24	 14/02/24
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 (T) Min-Max 10°C - 35°C Relative humidity Min - Max-Max 25% - 80%	Spotlont Batch No: <u>210203</u> Exp Date: <u>10/02/23</u> Actuals Temperature: <u>30</u> Humidity: <u>66</u>	<input checked="" type="checkbox"/>	 14/02/24	 14/02/24
08	NA	Verification of sealant application in certain regions in the drawing.	AA0000217856	<input checked="" type="checkbox"/>	 14/02/24	 14/02/24
09		Verification of safety welds	Approved according to DTD0000210658 reference and Self inspection	<input checked="" type="checkbox"/>	 14/02/24	 14/02/24



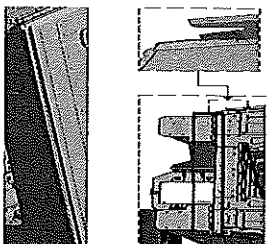
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2



Rev.	Project: PRASA
29	
Date	
28/10/2023	SI.CB1220.250.V29

II - Self Inspection - Items to Check

SEALANT APPLICATION

AREA 1 & 2 END 1



Operator (Name & sign):  
Mthokozisi   
Operator (Name & sign):  
Mthokozisi 

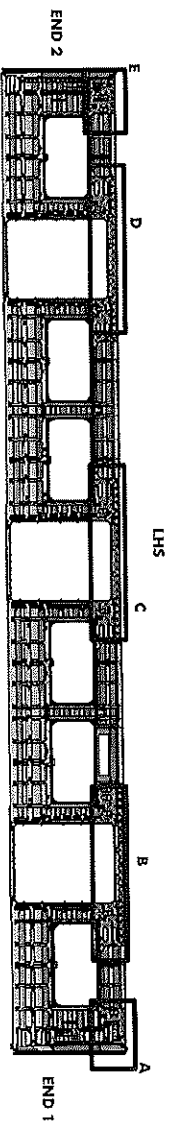
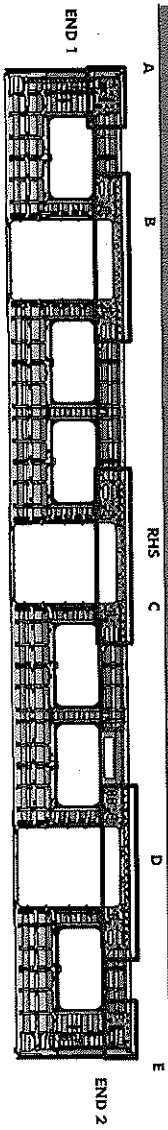


CARBOOVSHELL M1.M3.M4 ASSEMBLY  
DTR30225487/2

Rev.  
29  
Date  
28/10/2023

Project: PRASA  
SI.CB1220.250.V29

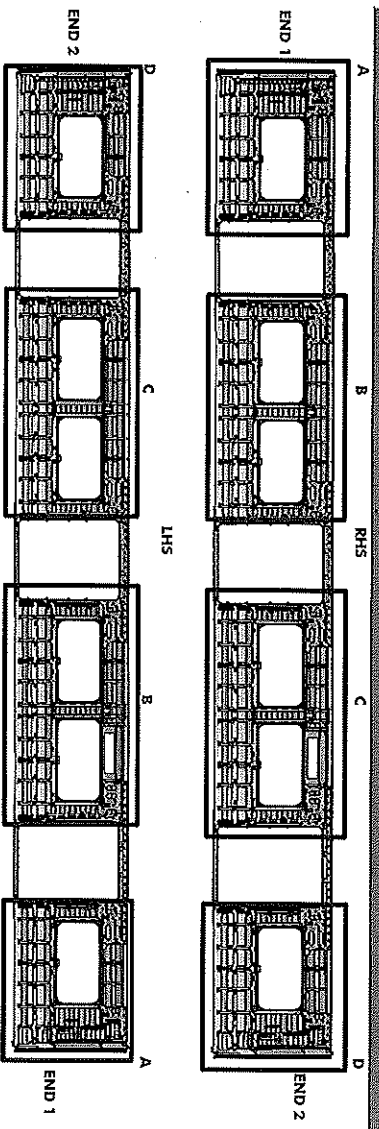
II - Self Inspection - Items to Check



REINFORCEMENT WELDING

AREA	LHS	RHS
A	Operator (Name&sign): <u>[Signature]</u>	<u>Neuven Agra</u>
B	Operator (Name&sign): <u>[Signature]</u>	<u>Neuven Agra</u>
C	Operator (Name&sign): <u>[Signature]</u>	<u>S. M. Agra</u>
D	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>
E	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>

**II - Self Inspection - Items to Check**



**BRACKETING**

C-RAILS: Operator: Installa Installa

DOOR MECHANISMS: Operator: Tebeo Tebeo

TAPPING PADS: Operator: NORALUNGA Welding only NORALUNGA Welding only

SEAT & LUGGAGE BRACKETS: Operator: Installa Installa

SEAT BRACKETS VERIFICATION: Operator: Installa Installa

**WELDING**

AREA LHS  
A (Seat brackets) : Operator (Name&sign): Installa Installa

(C-rails, Luggage and earth bushes) : Operator (Name&sign): Installa Installa

B (Seat brackets) : Operator (Name&sign): Installa Installa

(C-rails, Luggage and earth bushes) : Operator (Name&sign): Installa Installa

C (Seat brackets) : Operator (Name&sign): Installa Installa

(C-rails, Luggage and earth bushes) : Operator (Name&sign): Installa Installa

D (Seat brackets) Operator (Name&sign): Installa Installa

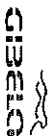
(C-rails, Luggage and earth bushes) : Operator (Name&sign): Installa Installa

ENDS

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

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





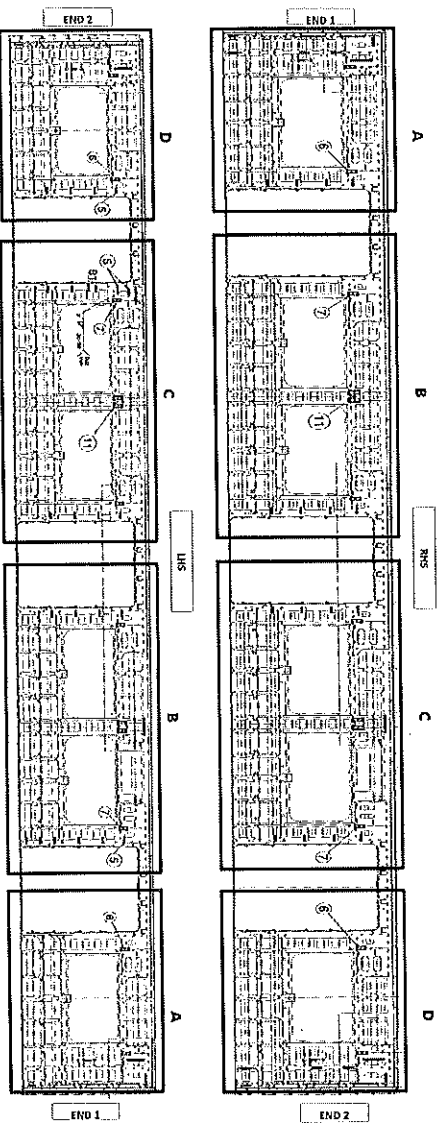
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2

Rev. 29  
Date 28/10/2023  
Project: PRASA

SI.CB1220.250.V29

## II - Self Inspection - Items to Check

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

RHS

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

ROOF ENDS:

CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: N/A

LHS

SECTION	QUANTITY	OK	NOK
C-ROLLS	2		
A	8		
B	11		
C	13		
D	13		
SEAT BRACKETS	21		
A	21		
B	21		
C	13		
D	13		
EARTH BUSH	2		
A	2		
B	2		
C	2		
D	2		

ROOF ENDS:

CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: N/A

QUANTITIES (M1)

RHS

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

ROOF ENDS:

CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: Theodor D

LHS

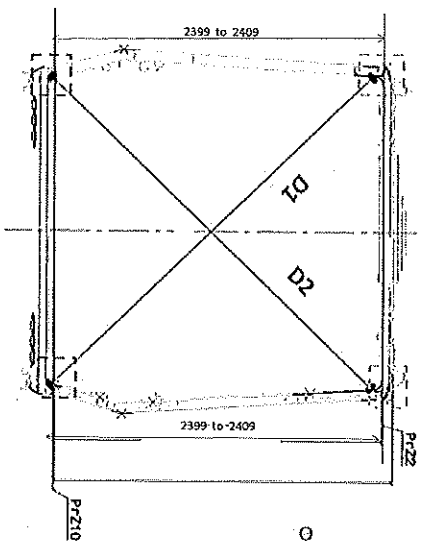
SECTION	QUANTITY	OK	NOK
C-ROLLS	2		
A	8		
B	11		
C	13		
D	13		
SEAT BRACKETS	21		
A	21		
B	21		
C	13		
D	13		
EARTH BUSH	2		
A	2		
B	2		
C	2		
D	2		

ROOF ENDS:

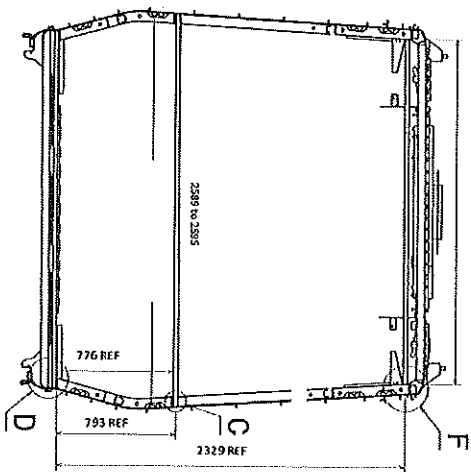
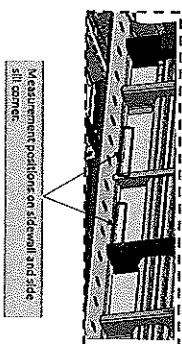
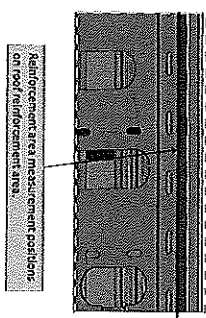
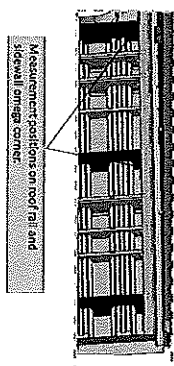
CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: Theodor D

Specifications of Details for CBS measurement



Q

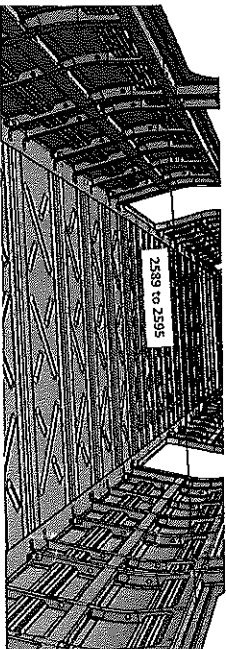
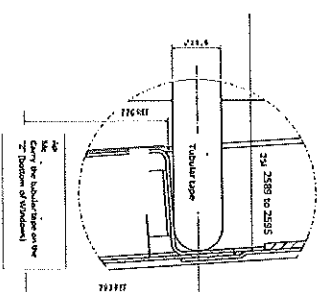
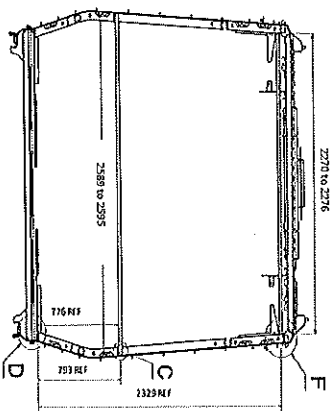




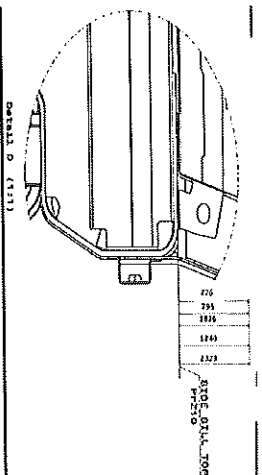
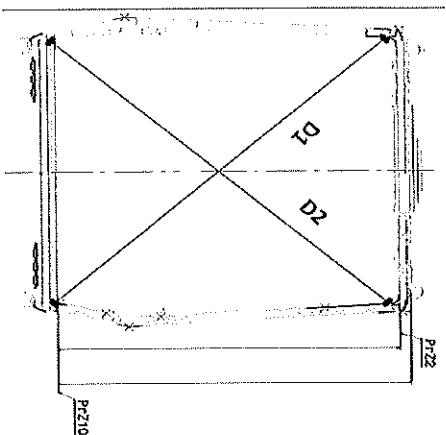
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR302254872


Rev.	Project: PRA5A
29	
Date	
28/10/2023	
	SI.CB1220.250.V29

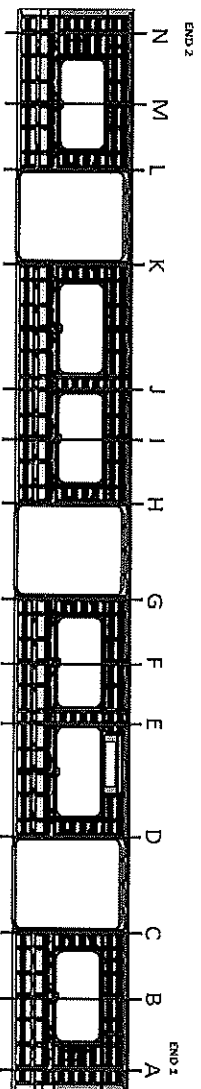
GBS measurement



Take measurement close to radius



	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2		Rev. 29	Project: PRASA
			Date 28/10/2023	SI.CB1220.250.V29
GBS measurement				



BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3299	1	
B	3269	3269	0	
C	3296	3299	3	
D	3296	3299	1	
E	3270	3267	3	
F	3269	3267	2	
G	3306	3299	1	
H	3306	3292	3	
I	3269	3267	2	
J	3293	3267	6	
K	3305	3297	3	
L	3299	3299	4	
M	3269	3270	3	
N	3295	3297	2	

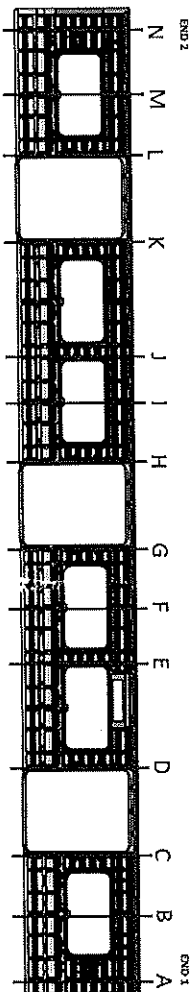
**GIBELCO**

CARBODYSHELL M1 M3 M4 ASSEMBLY  
DTR3022648712

Rev. 29  
Date 28/10/2023

Project: PRASA  
SI.CB1220.250.V29

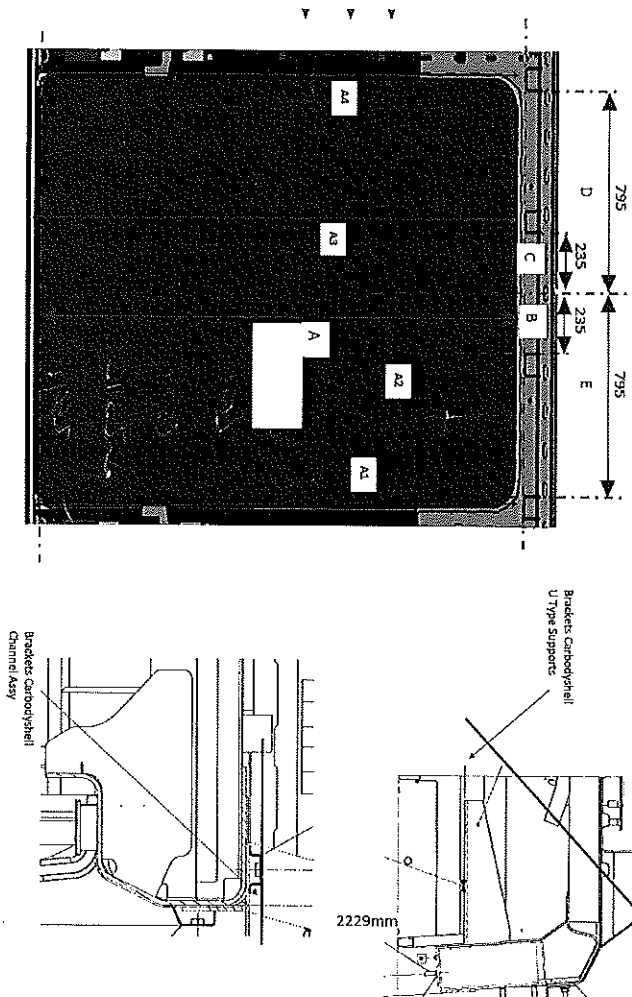
**CBS measurement**



**AFTER WELDING**

Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A 3300	3308	0	2605
B 3269	3265	1	2591
C 3300	3300	0	2589
D 3299	3300	1	2594
E 3272	3271	1	2592
F 3272	3270	2	2594
G 3300	3300	0	2599
H 3300	3300	0	2595
I 3270	3271	1	2595
J 3273	3270	3	2596
K 3290	3300	10	2596
L 3300	3300	0	2570
M 3269	3275	5	2590
N 3295	3296	3	2596

## Specifications of Details for CBS measurement CB1220



DOOR 1 - LHS

VALUE	ACTUAL
A1 2230 to 2232	7232
A2 2230 to 2232	7232
A3 2230 to 2232	7230
A4 2230 to 2232	7232
B 234 to 236	234
C 234 to 236	234
D 794 to 796	796
E 794 to 796	796

DOOR 2 - LHS

VALUE	ACTUAL
A1 2230 to 2232	7230
A2 2230 to 2232	7230
A3 2230 to 2232	7250
A4 2230 to 2232	7230
B 234 to 236	234
C 234 to 236	236
D 794 to 796	794
E 794 to 796	794

DOOR 2 - RHS

VALUE	ACTUAL
A1 2230 to 2232	7230
A2 2230 to 2232	7232
A3 2230 to 2232	7232
A4 2230 to 2232	7232
B 234 to 236	234
C 234 to 236	234
D 794 to 796	794
E 794 to 796	796

DOOR 1 - RHS

VALUE	ACTUAL
A1 2230 to 2232	7230
A2 2230 to 2232	7230
A3 2230 to 2232	7232
A4 2230 to 2232	7232
B 234 to 236	234
C 234 to 236	236
D 794 to 796	794
E 794 to 796	794

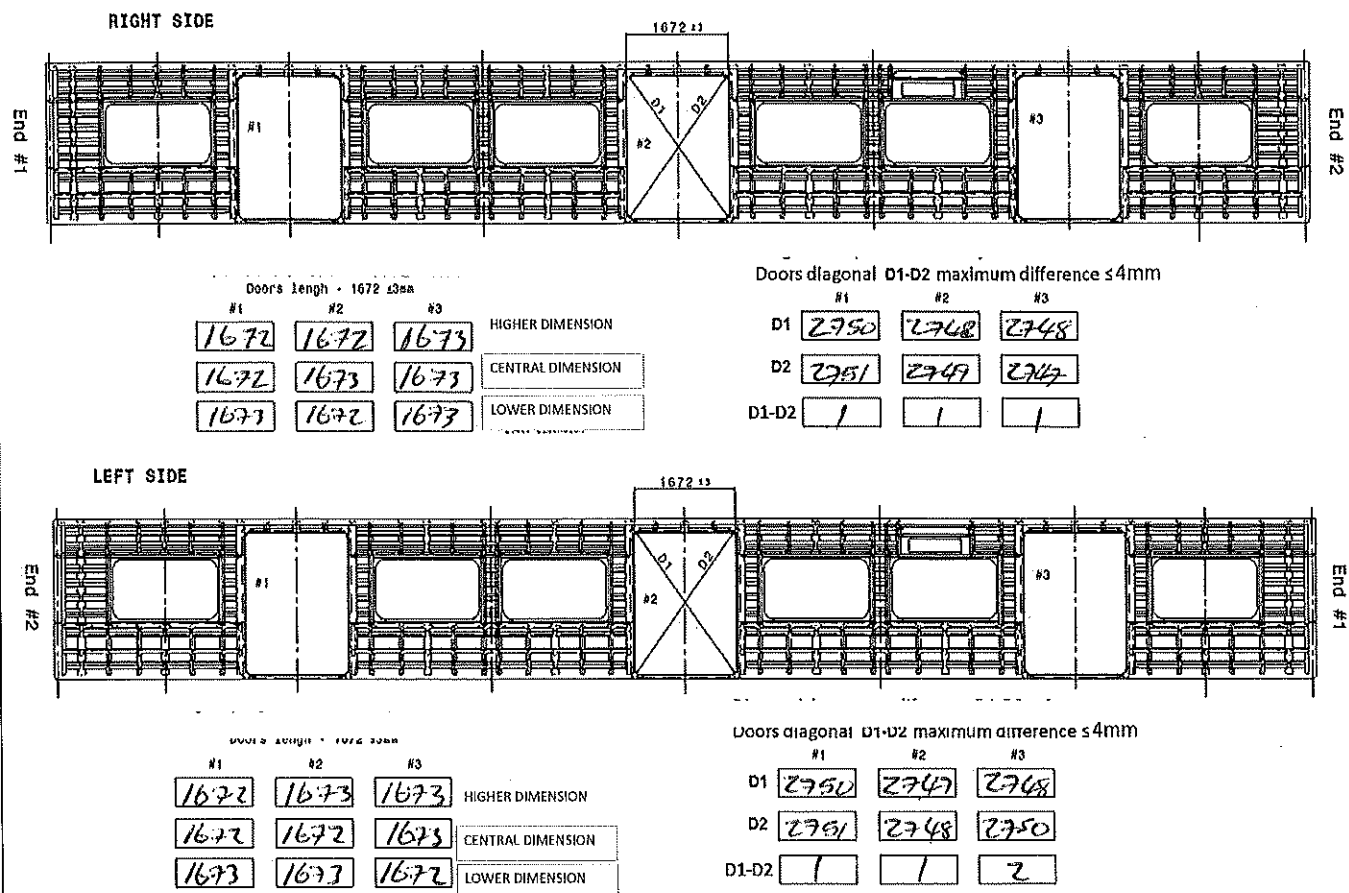
DOOR 2 - RHS

VALUE	ACTUAL
A1 2230 to 2232	7230
A2 2230 to 2232	7230
A3 2230 to 2232	7230
A4 2230 to 2232	7232
B 234 to 236	234
C 234 to 236	236
D 794 to 796	796
E 794 to 796	796

DOOR 3 - RHS

VALUE	ACTUAL
A1 2230 to 2232	7230
A2 2230 to 2232	7230
A3 2230 to 2232	7230
A4 2230 to 2232	7232
B 234 to 236	234
C 234 to 236	236
D 794 to 796	794
E 794 to 796	796

Specifications of Details for CBS measurement CB1220



**CBS measurement (Manufacturing)**

## Dye penetrant test

**Dye-penetration test to be performed by quality personnel**

[illegible]





CARBODYSHELL M1.M3.M4 ASSEMBLY  
DTR3022548712

Rev. 29  
Date 28/10/2023  
Project: PRASA  
SI.CB1220.250.V29

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

If activities are not complete, the missing activities must not impact the next stage!

14/02/24

TRUCAN

Operations

GO

Every year, Inspectors performed conforms to specification or in case of discrepancy the same is approved by the competent party.)

14/02/24

Amogdang

Industrial Quality

There are activities pending that impact 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

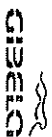
In case of "NO GO", describe blocking problems

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

Item	Description	Responsible	Due date	Status

Operations

Quality

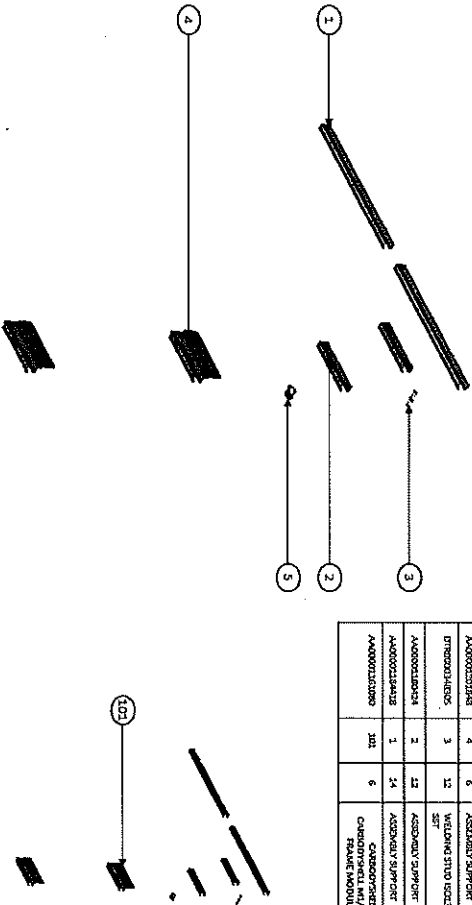
	CARBODYSHELL M1,M3,M4 ASSEMBLY		Rev.	Project: PRASA
	DTR30225487/2		29	
			Date	
			29/10/2023	
SI, CB1 220, 250, V29				

ANNEXURE A: Arc Welding Quality Acceptance Standard



Station: CB1220-004- U108 & U107

PART NO.	ITEM NO.	QTY	DESCRIPTION	MASS (KG)
DTR30225487/2	5	6	EARTH STUD 6	0.206
AA00000301948	4	6	ASSEMBLY SUPPORT	0.271
DTR30225487/2	3	12	WELDING STUD (22.12V16 PT - NAR20 - 50T)	0.107
AA0000018924	2	12	ASSEMBLY SUPPORT	0.193
AA00000189412	1	14	ASSEMBLY SUPPORT	0.132
AA0000018980	101	6	CARBODYSHELL IMPACTS CARBODYSHELL M1/M3/M4 CARBODYSHELL MODULE (RD - 089)	12.112



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.

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE					WORK INSTRUCTION	SAFETY ?	
				TC1	M1	M2	M3	TC2			
<input type="checkbox"/>	DT0000235487	CARBODYSHELL ML,M3,M4 ASSEMBLY	CB2230		X				X	PRA-CB2230, DT0000002 25487.V20	YES
<input type="checkbox"/>											
<input type="checkbox"/>											
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	Ramelokone 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	13/09/2019	Added Twist and Door Bracket Measurements Remove Door Measurements					APPROVER	Itumeleng Modiba	13/09/2019		
							CHECKER	Nosizo Pindela	13/09/2019		
							REVISED BY	Nosizo Pindela	13/09/2019		
10	23/09/2019	New Baseline 10.2.5					APPROVER	Timothy Maimela	23/09/2019		
							CHECKER	Nosizo Pindela	23/09/2019		
							REVISED BY	Timothy Maimela	23/09/2019		
15	06/08/2020	New Baseline 10.2.6					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		
25	20/02/2022	New Baseline change 10.3.1					APPROVER	Collins Mkhombhi	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	Collins Mkhombhi	14/06/2022		
							CHECKER	Andani Muthelo	14/06/2022		
							REVISED BY	Andani Muthelo	14/06/2022		
27	26/07/2022	Threshold measurements addition					APPROVER	Collins Mkhombhi	26/07/2022		
							CHECKER	Andani Muthelo	26/07/2022		
							REVISED BY	Andani Muthelo	26/07/2022		
28	17/10/2022	Added traceability of sealant application					APPROVER	Collins Mkhombhi	17/10/2022		
							CHECKER	Nosikozo Zwane	17/10/2022		
							REVISED BY	Amogelang Mohlamepe	17/10/2022		
29	14/04/2023	Added sealant batch number & welding consumables traceability					APPROVER	Vanessa Ntuli	14/04/2023		
							CHECKER	Nosikozo Zwane	14/04/2023		
							REVISED BY	Amogelang Mohlamepe	14/04/2023		
30	06/11/2023	Added threshold traceability for boiler makers and welders					APPROVER	Ngobeni Tyson	06/11/2023		
							CHECKER	Andani Muthelo	06/11/2023		
							REVISED BY	Nosikozo Zwane	06/11/2023		
TRAINSET	CAR	OPERATOR NAME	ALPS NO	DATE	SELF INSPECTION NUMBER					PAGES	
211	M01	Simle	4286955	15/02/24	SI-CB2230.256.V29					12	



CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

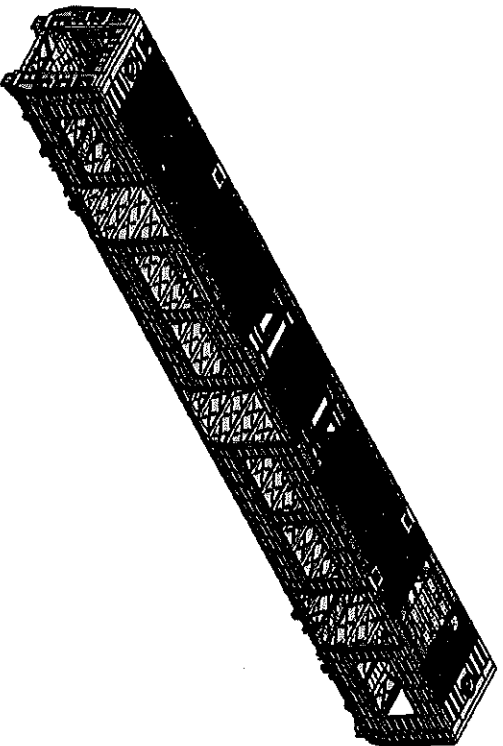
Rev. 30  
Date 06/1/2023  
Project: PRASA  
SI.CB2230.256.V29

Car: NCR: CB2230

Work station:



Safety Related



### I - Documentation and Instruments Control

#### I.1 - Documentation Control


Document	Type of car				Revision	Observation	OK	NOK	Remark	Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4							
PRA CB2230.DT00000225487					30		OK		N/A	15/02/24	15/02/24

#### I.2 - Instruments Control

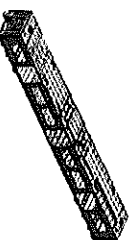
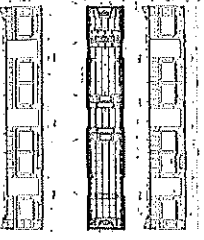
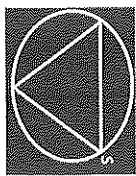
Monitoring and Measuring Instrument Control - Used for Special Process						
Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
Combination Square	6056072	05/06/24	OK		15/02/24	15/02/24
Universal	2273-1	29/11/24	OK		15/02/24	15/02/24
Measuring Tape	615 TA0594	2024/04/05	OK		15/02/24	15/02/24

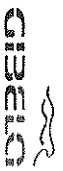
#### 1.3 Consumables

Welding Consumable Control - Used for Special Process						
Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 L	310180	Mig welding	OK		15/03/24	15/02/24

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

### II - Self Inspection - Items to Check

II.1 - Items to check					
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NO
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	N	
02	N/A	Corshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	OK	
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	OK	
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.	✓	
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:	Sealant Batch No: <u>ISA.30-C3</u> Exp Date: <u>05/24</u> Actuals Temperature: <u>19°C</u> Humidity: <u>47%</u>	OK	
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) <b>Refer to Annexure B</b>	OK	
09	N/A	Verification of sealant application in certain regions in the drawing.	AAD0001278566	OK	



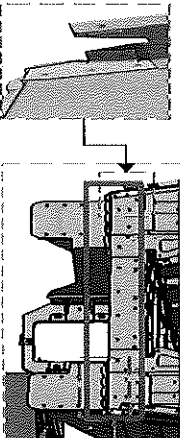
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.  
30  
Date  
06/11/2023

Project: PRASA  
SI.CB2230.256.V29

## II - Self Inspection - Items to Check

### AREA 1



OPERATOR  
(Name & sign):

LERDY

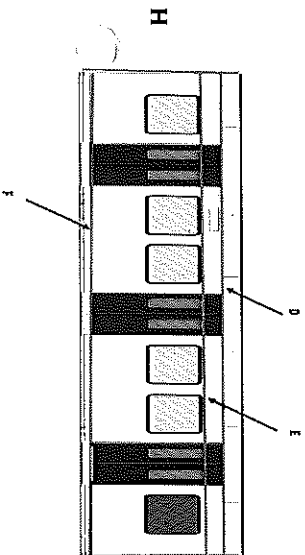
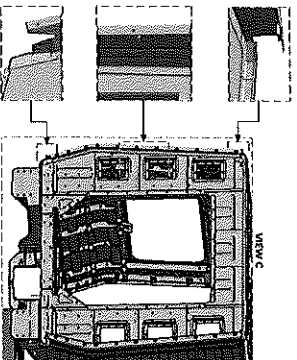
OPERATOR  
(Name & sign):

LERDY

OPERATOR  
(Name & sign):

LERDY

### AREA 2 (VIEW G)



### END 2 SEALANT

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

LHS

Operator (Name & sign): D.E.F.G.H.I

RHS

Operator (Name & sign): D.E.F.G.H.I

Operator (Name & sign):

Ishendo

Ishendo

Operator (Name & sign):

Knosy

Knosy

Operator (Name & sign):

Knosy

Knosy

Operator (Name & sign):

Knosy

Knosy

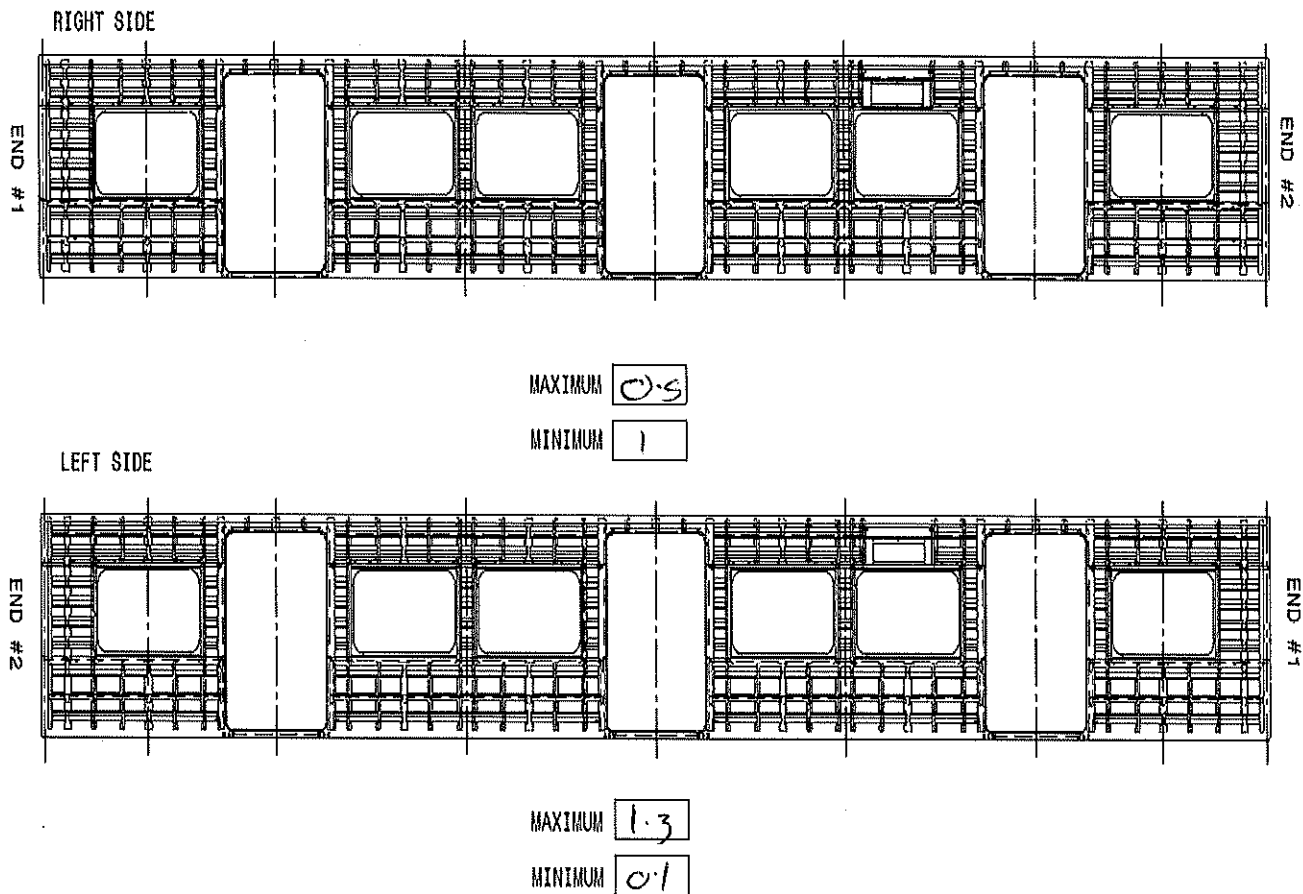
Operator (Name & sign):

Sinleg

Sinle

Specifications of Details for CBS measurement CB1230

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





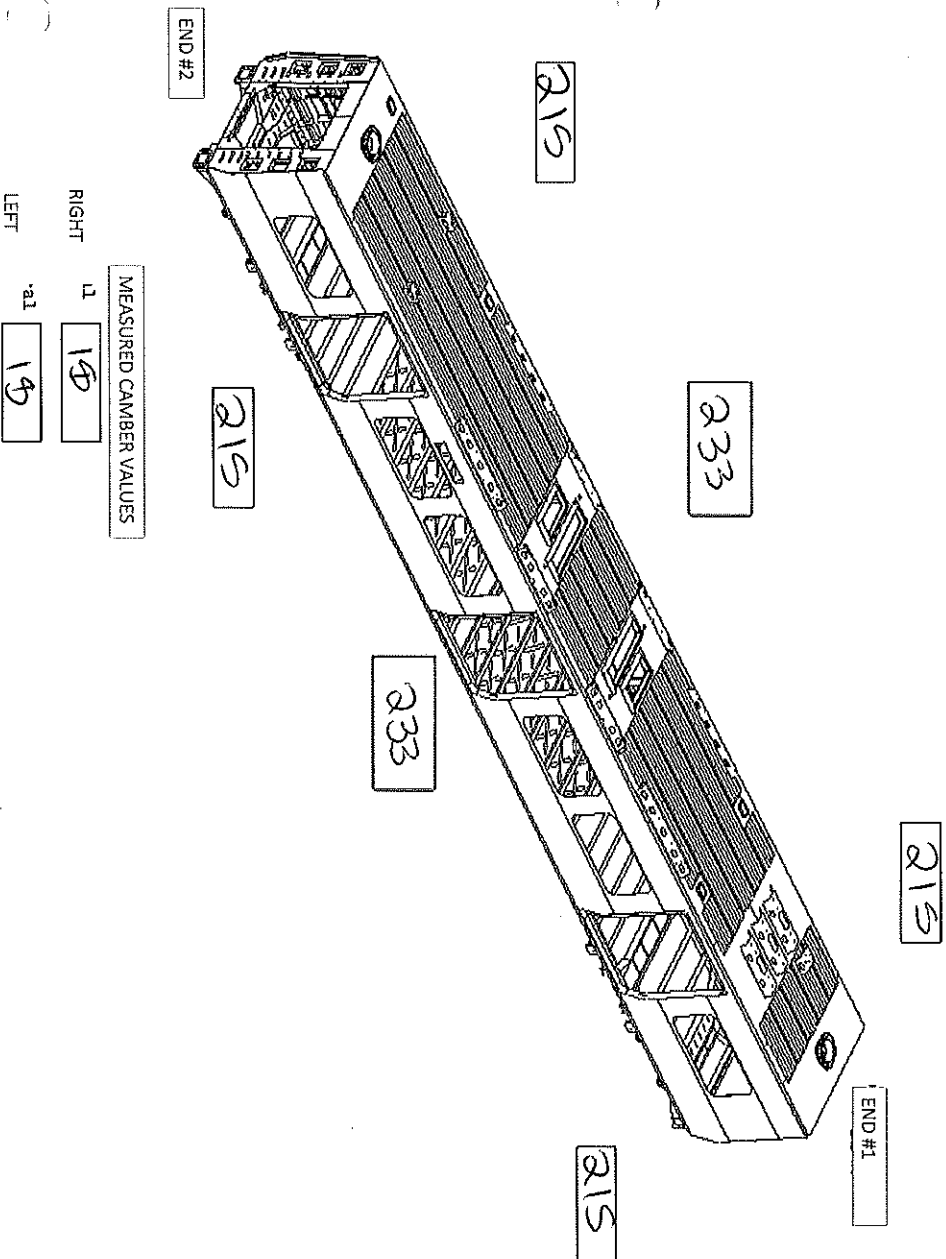
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.	30
Date	06/11/2023

Project: PRASA  
SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230

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







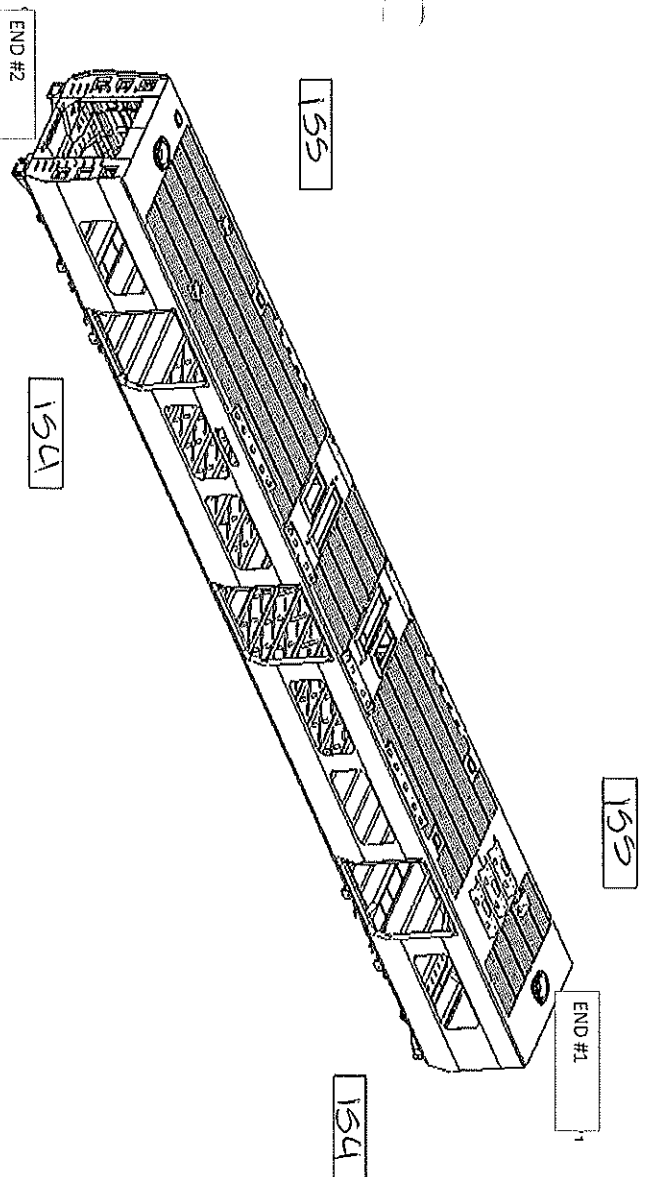
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

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	1
LONGITUDINAL	0

TWIST FOUND ON END 2	
TRANVERSE	1
LONGITUDINAL	0

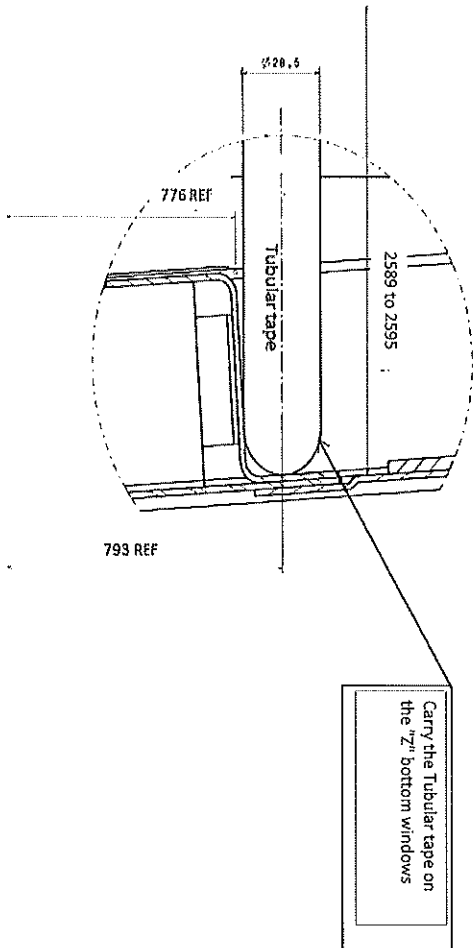


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

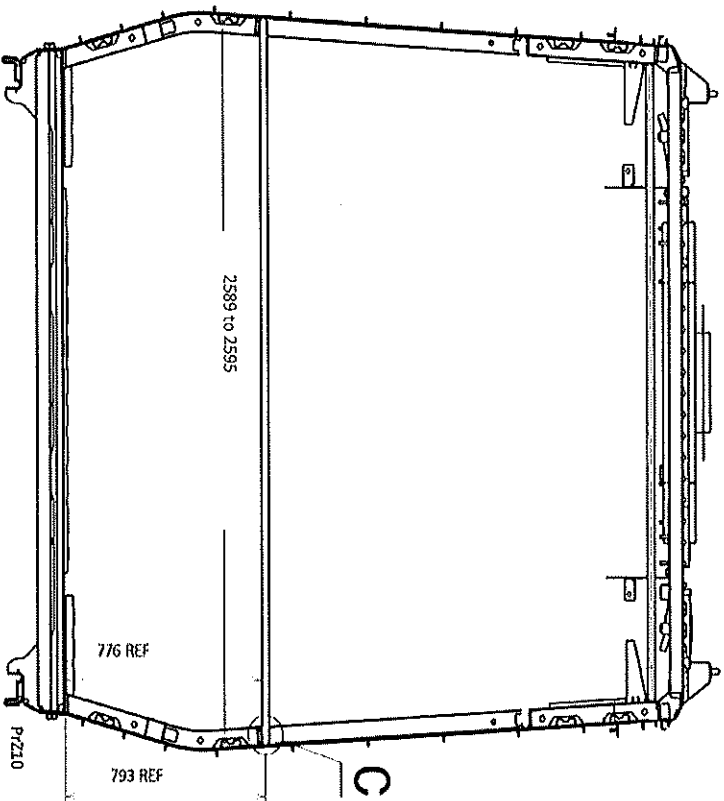
Rev.	30
Date	06/11/2023

Project: PRASA  
SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230



Detail C



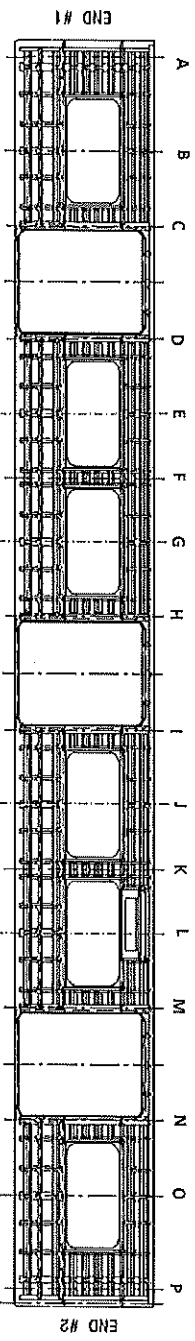


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

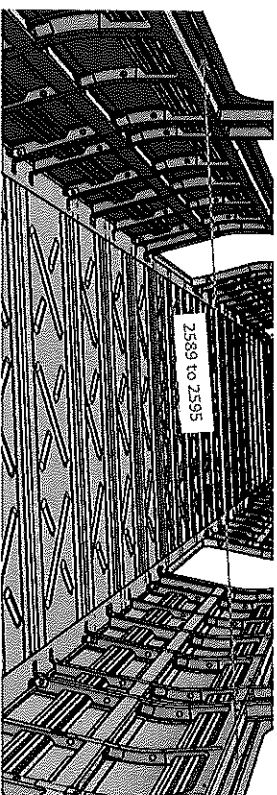
Rev.  
30  
Date  
06/11/2023

Project: PRASA  
SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230



A	2589 to 2595mm
B	2590
C	2591
D	2593
E	2594
F	2594
G	2594
H	2592
I	2591
J	2590
K	2593
L	2594
M	2595
N	2594
O	2590
P	2590



Threshold verification

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

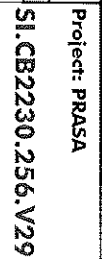
BOILER MAKER: kgotso

WELDER: Ntshonhle

Dye-penetration test to be performed by quality personnel

Dye penetrant test





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

[illegible]

### Check List Items

Item	Picture/Drawing	Description	Criteria Record	OK	N/A	Not OK	Signature/Date (Operators)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to RDX. New devices must be added on the RDX					



CARBODYSHELL M1,M3,M4 ASSEMBLY  
D100000225487

Rev.  
30  
Date  
06/11/2023

Project: PRASA  
SI.CB2230.256.V29

Self Inspection - Final Result

Is the car good to advance to the next workstation/process?  
(Approval of Operations and Industrial Quality)

DATE

NAME

SIGNATURE

(If activities are not complete, the missing activities must not impact the next stage)

15/02/24

Sinle

Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)

16/02/24

anpau  
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

HOLD POINT


In case of "NO GO", describe blocking problems

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

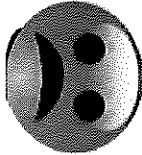
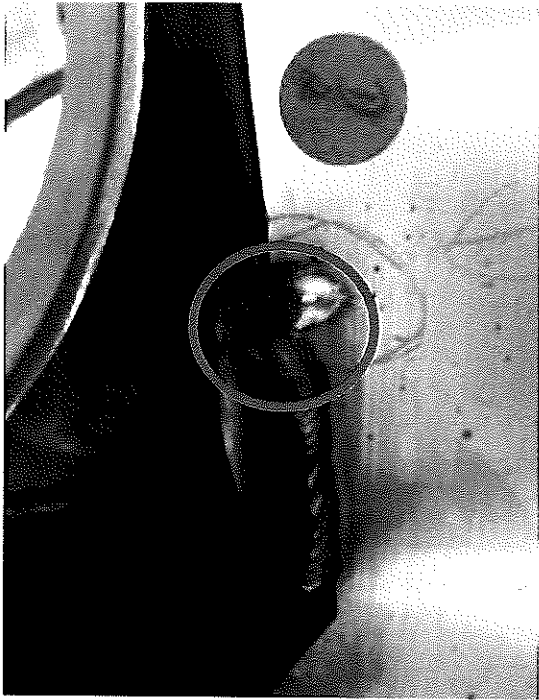
Item	Description	Responsible	Due date	Status


Operations

Quality

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

ANNEXURE A: Arc Welding Quality Acceptance Standard



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

ANNEXURE B: Sealant

