

CABIN STRUCTURE QUALITY CARD

CAB No.: CAB_387
WEIGHT: 1489 Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	11/04/23	F207028 VHE T3366	16306596002 01	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	04/05/23	F208325 VHE T3713	16426997017 01	
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegasus	22/05/23	P300091 VPK9T566	16515097017 01	
RCS 355	20 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegasus	14/03/23	F207905 VAS 28402	95206	
RCS 355	30 mm					

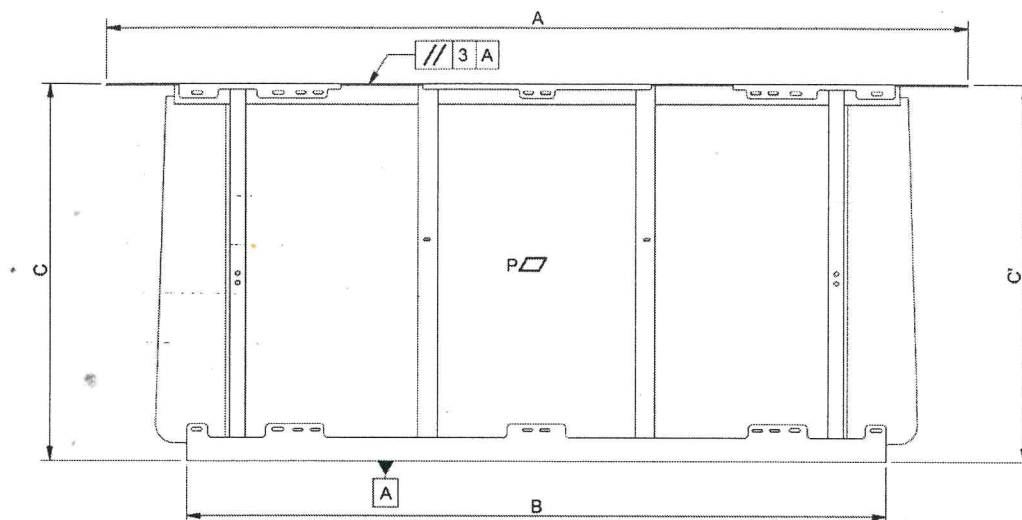
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	04/05/23	F207961 VHC T403	16427097170 01	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	22/05/23	F207905 VHI 28400	16513497170 01	
RCS 450	6 mm					
RCS 450	6 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	22/05/23	F207905 VHS 88283	16514197170 01	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

Cabin Roof Assembly: GN002839

Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	① YLAN ① DAVIDS	Assembly Date:	20 23 / 12 / 18			
Sign:		Wire Batch No.:	101238201			




Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
QC Inspector:	Leon	Sign:		Date:	20 23 / 12 / 18	

Dimensional Control

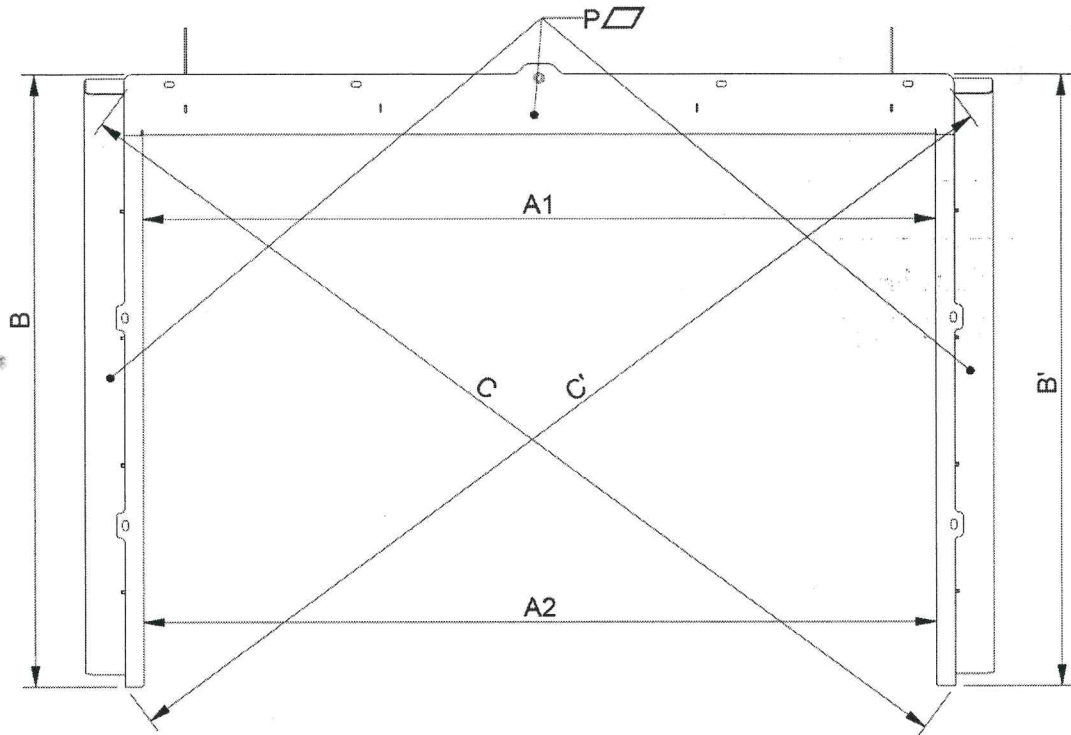
Rep		Toler.	Dimension measured		Measuring Equipment	Observations	
A	2216	+5/-0	2216		Tape Measure	Acceptable	
B	1800	± 4	1801			Acceptable	
C	976	+2/-3	976	977		Acceptable	
QC Inspector:		Leon		Sign:	A	Date:	20_23_/_12_/_18

Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations	
Planeity P		6 mm	Passado		Ruler	Acceptable	
//	3	A	Passado		Set Square	Acceptable	
QC Inspector:		Leon	Sign:			Date:	20_23_ / _12_ / _18_

Cabin Front Frame Assembly: GN002840


Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Bambelo G. C. U. g. n.	Assembly Date:	20_23/12/21			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Leon	Sign:	<i>[Signature]</i>	Date:	20_23/12/21	


Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	1910	± 2	1912		Tape Measure	Accepted
A2	1910		1910			Accepted
B	1475	± 1	1474	1474		Accepted
C	Diagonals C - C' ≤ 3		2478	2476		Accepted
QC Inspector:		Leon		Sign:		Date: 20_23/12/21


Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P : Planeity	4 mm	Passed	Ruler	Accepted
QC Inspector:	Leon		Sign:	<i>[Signature]</i>
			Date:	20_23/12/21


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

Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	TK Booth	Assembly Date:	20__/12/18			
Sign:		Wire Batch No.:	2202152			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

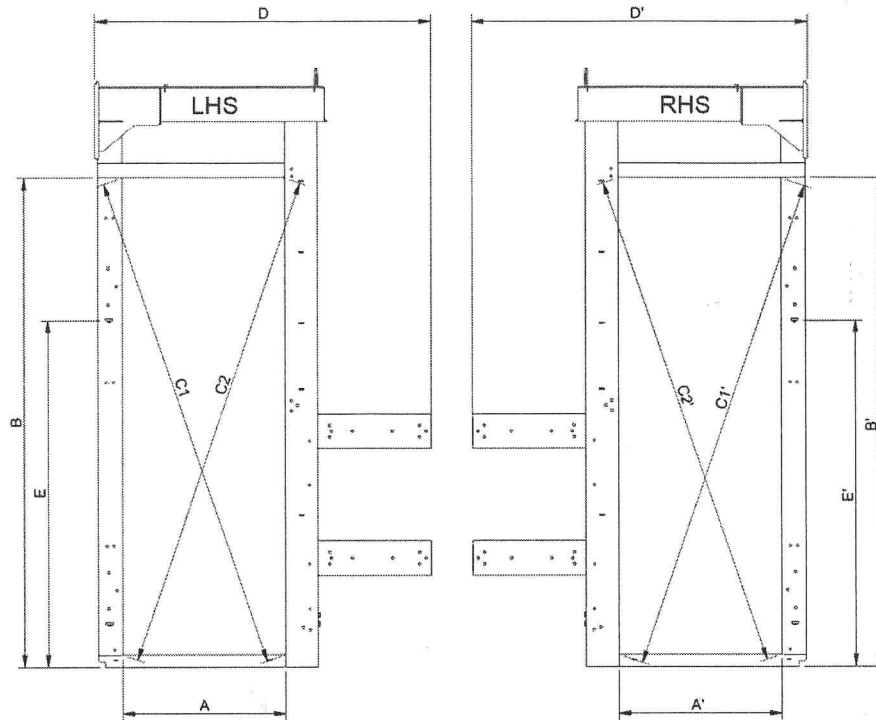
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	2023/12/10			
Sign:		Wire Batch No.:	2202222			

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	2023/12/10			
Sign:		Wire Batch No.:	2202222			

Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Glenn	Assembly Date:	20_23/12/20			
Sign:	<i>Glenn</i>	Wire Batch No.:	2202222			



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Leon	Sign:	<i>Leon</i>	Date:	20_23/12/21	

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	695	695	Tape Measure	Acceptable
B	2086	+1/-3	2086	2086		Acceptable
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2154	2153		Acceptable
C1 - C2			2154	2151		Acceptable
D	1438	+2/-3	1437	1440		Acceptable
E			1482	1484		Acceptable

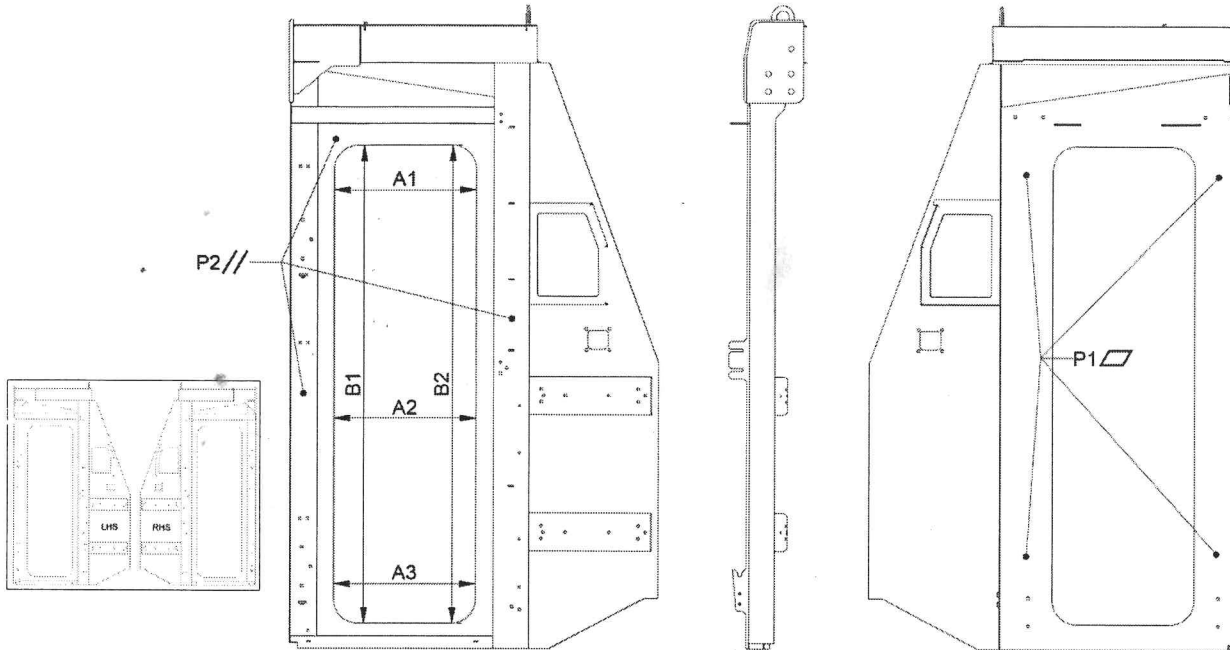
QC Inspector:	Leon	Sign:	<i>Leon</i>	Date:	20_23/12/21	
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Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	Passed	Ruler	Acceptable
QC Inspector:	Leon	Sign:	<i>Leon</i>	Date: 20_23/12/21

Cabin LHS/RHS Side Assembly: GN002838/GN002837

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	TK Boon	Assembly Date:	2023/12/18		
Sign:		Wire Batch No.:	2252152		



Welding Control


Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	Leon	Sign:		Date:	2023/12/18

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	558	560	Tape Measure	Acceptable
A2			560	560		Acceptable
A3			560	560		Acceptable
B1	1900	± 2	1898	1898		Acceptable
B2			1898	1898		Acceptable

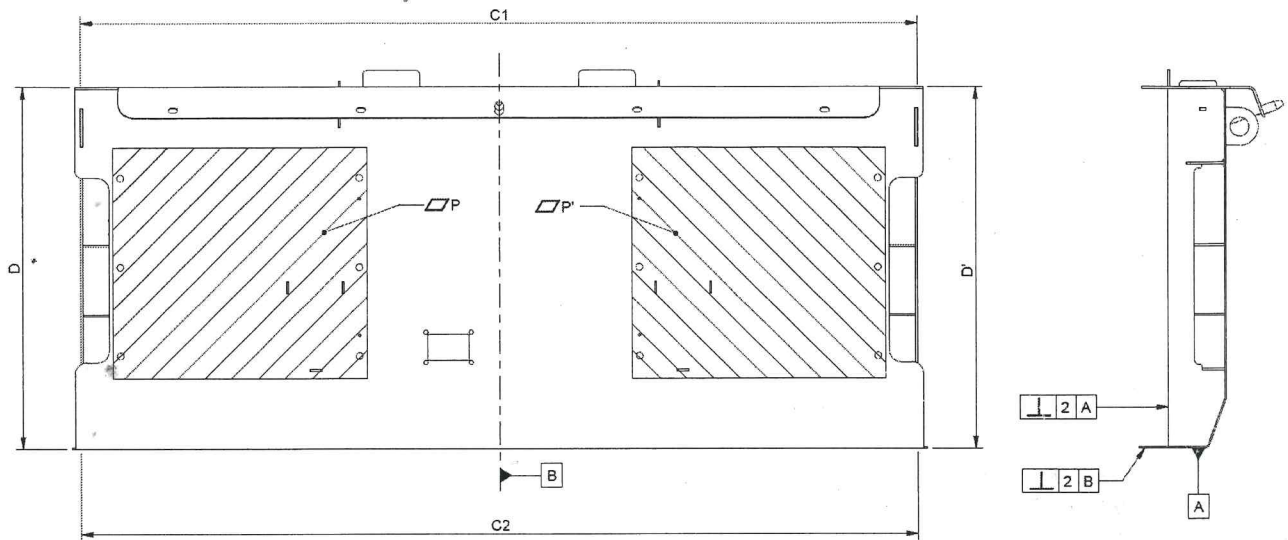
QC Inspector:	Leon	Sign:		Date:	2023/12/18
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Geometrical Control

Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P1 : Planeity	4 mm	PASSED 1.550		Ruler	Acceptable	
P2 : Planeity	2 mm			Ruler	Acceptable	
QC Inspector:	LEON		Sign:		Date:	20 <u>23</u> / <u>12</u> / <u>18</u>

Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>BEYAN / LADENHILL</i>	Assembly Date:	20 <u>23</u> / <u>12</u> / <u>21</u>			
Sign:		Wire Batch No.:	2202167			



Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>23</u> / <u>12</u> / <u>21</u>	

Dimensional Control

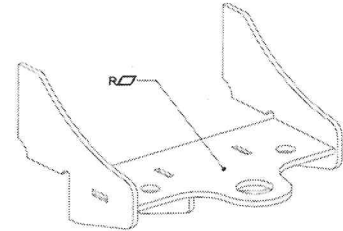
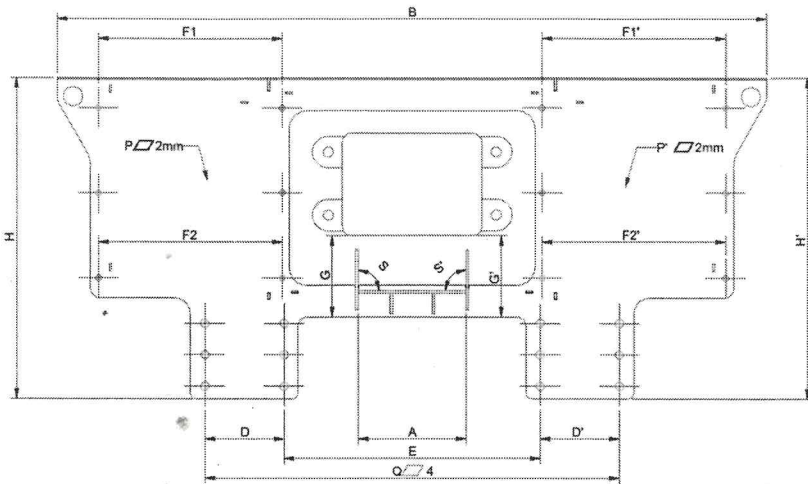
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	<i>2214</i>	<i>2213</i>	Tape Measure	<i>Acceptable</i>
D / D'	956	± 2	<i>956</i>	<i>956</i>		<i>Acceptable</i>
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>23</u> / <u>12</u> / <u>21</u>	

Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planarity P / P'		2 mm	<i>Passed</i>		Ruler	<i>Acceptable</i>
Perpendicularity		2	<i>Passed</i>		Set Square	<i>Acceptable</i>
		2	<i>Passed</i>		Set Square	<i>Acceptable</i>
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>23</u> / <u>12</u> / <u>21</u>	

Cabin Front Headstock Assembly: GN002841

Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	<i>TK Booth</i>	Assembly Date:	2023/08/31		
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202167		



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>Falvin</i>	Sign:	<i>[Signature]</i>	Date:	2023/08/31

Dimensional Control

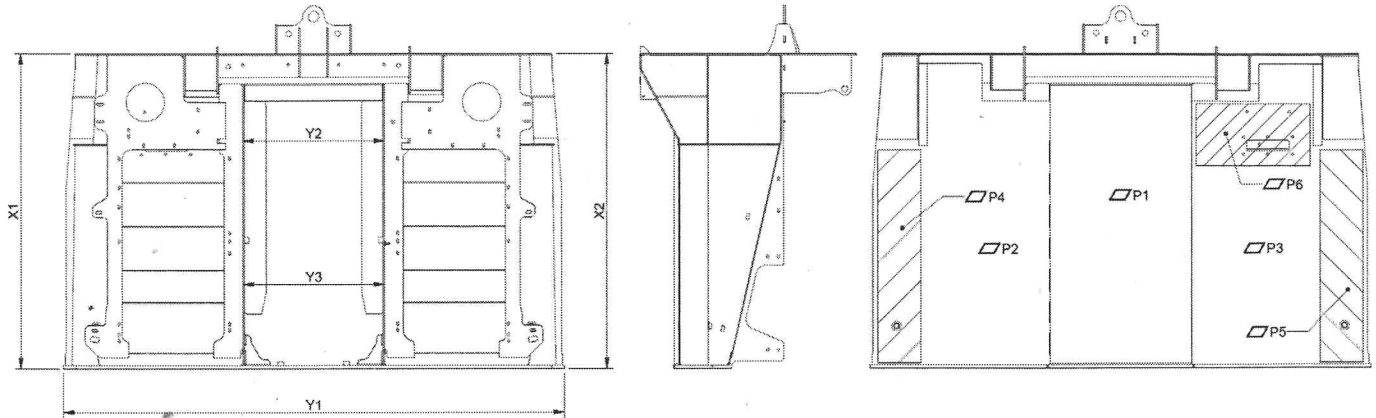
Rep	Theorical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	340	± 1	339		Tape Measure	Acceptable	
B	2240	± 4	2244			Acceptable	
D / D'	250	± 1	251	251		Acceptable	
E	808	± 2	808			Acceptable	
F1 / F1'	580	± 1	580	580		Acceptable	
F2 / F2'			580	580		Acceptable	
G / G'	258	± 1	258	258		Acceptable	
H / H'	1019	± 2	1020	1020		Acceptable	
QC Inspector:		Fahim		Sign:	Ross	Date:	2023/08/31

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
O: Planeity of global assembly	4 mm	Passed	Ruler	Acceptable
P / P': Planeity	2 mm	Passed	Ruler	Acceptable
Q: Planeity Surface of Supports	4 mm	Passed	Ruler	Acceptable
R: Planeity Coupler Support	2 mm	Passed	Ruler	Acceptable
S: Perpendicularity coupler	1mm	Passed	Square	Acceptable
QC Inspector:	<i>Falvin</i>	Sign:	<i>[Signature]</i>	Date: 2023/08/31

Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	20 <u>23</u> / <u>09</u> / <u>04</u>	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202167	




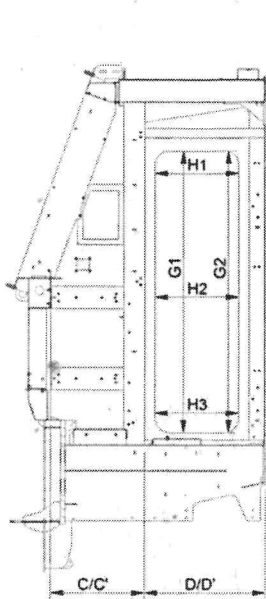
Welding Control					
Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>Falica</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>23</u> / <u>09</u> / <u>04</u>

Dimensional Control					
Rep	Theoretical Dim	Toler.	Dimension Measured		Observations
X1 / X2	1485	+5 / -2	1486	1486	Acceptable Acceptable Acceptable
Y 1	2354	± 3	2351		
Y2 / Y3	666	± 1	668	668	
QC Inspector:	<i>Falica</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>23</u> / <u>09</u> / <u>04</u>

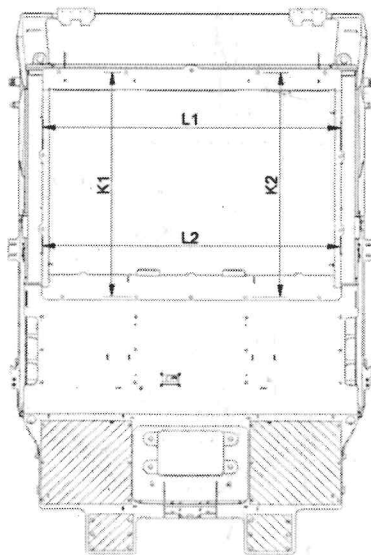
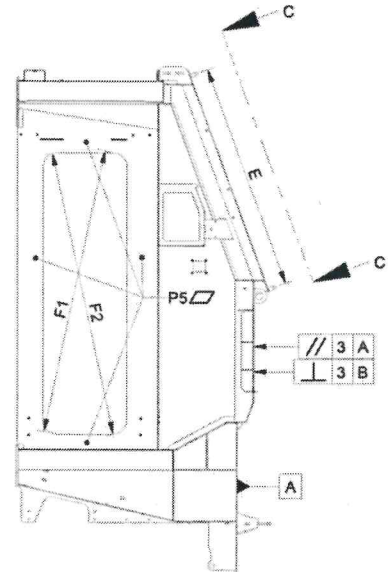
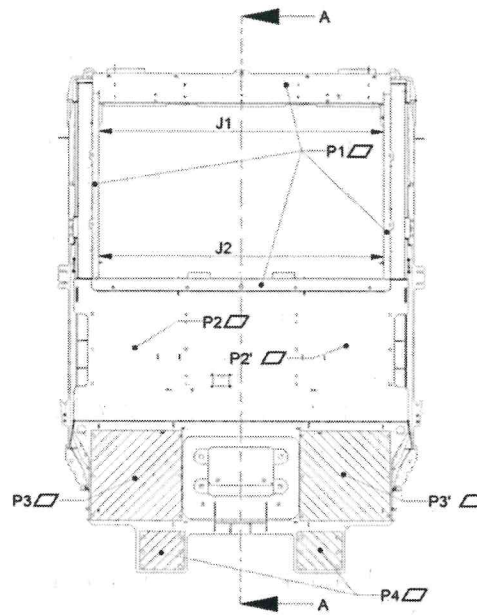
Geometrical Control				
Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Passed	Ruler	Acceptable
P2 / P3 : Planeity	4 mm	Passed	Ruler	Acceptable
P4 / P5 : Planeity	2 mm	Passed	Ruler	Acceptable
P6 : Planeity	2 mm	Passed	Ruler	Acceptable
QC Inspector:	<i>Falica</i>	Sign:	<i>[Signature]</i>	Date: 20 <u>23</u> / <u>09</u> / <u>04</u>

Cabin Structure Assembly: GN002834

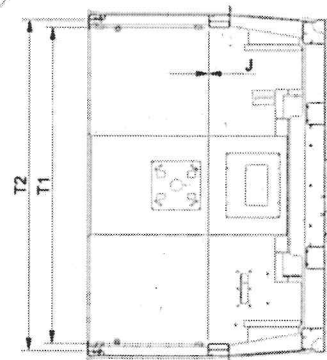
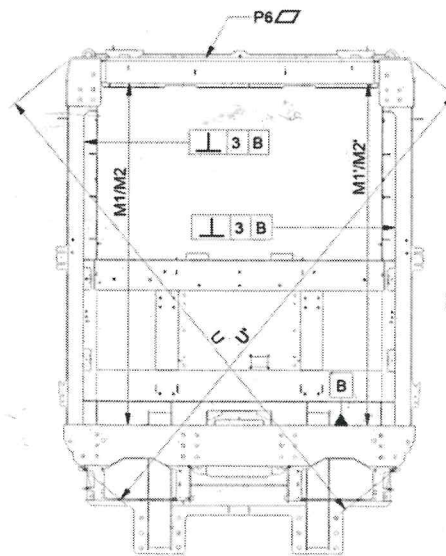
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:	CHARL BLOEM	Assembly Date:	20 24/01/12		
Sign:		Wire Batch No.:	2202152		



SECTION A-A




AUX VIEW: C



SECTION B-B

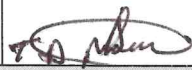



Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042				Confirmed		Yes		No	
QC Inspector:		Leon		Sign:		A		Date: 20_24_/01/12	
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	626	626	Acceptable				
D / D'	813	± 2,5	812	812	Acceptable				
E	1531.5	± 3	1532		Acceptable				
G1 / G'1	Height 1900	+1	1897	1897	Acceptable				
G2 / G'2		-3	1897	1897	Acceptable				
H1 / H'1	Width 560	+1	557	557	Acceptable				
H2 / H'2		-3	559	559	Acceptable				
H3 / H'3			559	559	Acceptable				
F1 / F'1	Diagonals 1939		1935	1935	Acceptable				
F2 / F'2			1935	1935	Acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	0	0	Acceptable				
J	Gap of Doors	± 1,5	0		Acceptable				
K1 / K2	1515	± 3	1513	1512	Acceptable				
L1 / L2	1996	± 3	1999	1997	Acceptable				
M1 / M'1	2306	± 3	2468	2468	Acceptable				
M2 / M'2			2477	2477	Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2127	2127	Acceptable				
T2 / T'2	2230 Top/Bottom		2229	2231	Acceptable				
Difference	U - U' (3522)	≤ 4mm	3520	3521	Acceptable				
QC Inspector:		Leon		Sign:		A		Date: 20_24_/01/12	
Geometrical Control									
Nature of checks		Toler.	LHS / Dimension Measured / RHS		Observations				
P1 / P'1	Planeity	2 mm	Passed		Acceptable				
P2 / P'2	Planeity	2 mm	Passed		Acceptable				
P3 / P'3	Planeity	4 mm	Passed		Acceptable				
P4 / P'4	Planeity	4 mm	Passed		Acceptable				
P5 / P'5	Planeity	4 mm	Passed		Acceptable				
P6 Roof	Planeity	6 With 2m Ruler	Passed		Acceptable				
Shield	//	3 A	3		Passed				
Shield	⊥	3 A	3		Passed				
Door Post	⊥	3 A	Front		Passed				
			Back		Acceptable				
QC Inspector:		Leon		Sign:		A		Date: 20_24_/01/12	

Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLOEN	Assembly Date:	2024/01/12			
Sign:		Wire Batch No.:	2202152			

Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	RICARDO	Assembly Date:	2024/01/22			
Sign:	RSlater.	Wire Batch No.:	N/A			

Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Fasteners positioned in all Rivnuts and Bosses		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Masked as per GMS-SOS-GIBELA-CABIN-001		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator: DAVID		Sign:			
Date: 2024/01/23					
Record of Shot Blasting					
Operator:		Date:		2024/01/23	
Start Time: 07:15		End Time:		17:15	
Temperature ($\geq 15^\circ$): 19 + 08°C		Humidity ($\leq 75\%$):		72 - 03%	
Shot Blasting Self Inspection					
Interior of Cabin: Sa 1 - Light Stripping		Confirmed	Yes	<input checked="" type="checkbox"/>	No
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping		Confirmed	Yes	<input checked="" type="checkbox"/>	No
		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator: DAVID		Sign:			
Date: 2024/01/23					
Shot Blasting Cleaning					
Cabin free of all sand		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator: DAVID		Sign:			
Date: 2024/01/23					
Shot Blasting Control					
Temperature $\geq 15^\circ$: 20 - 04°C		Humidity $\leq 75\%$:		73 - 01%	
Internal Roughness 3.2 \leq Ra \leq 12.5 as per example		External Roughness 3.2 \leq Ra \leq 12.5		as per example	
QC Inspector: Leon		Sign:			
Date: 23/01/24					

Record of Priming							
Start Time:		1:00		End Time:		3:00	
Temperature $\geq 15^{\circ}$:		25.8		Humidity $\leq 75\%$:		57%	
Paint Batch No.:		7296866		Paint Expiry Date:		06/05/2024	
Hardener Batch No.:		7287752		Hardener Expiry Date:		15/04/2024	
Desolvation Start Time:		3:00		Desolvation End Time:		3:15	
Stoving Start Time:		3:15		Stoving End Time:		4:15	
Stoving Temp:		600					
Operator:		Graig 2333		Sign:		Graig	
Date:		2024/01/23					
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 43	5: 58	1: 45	5: 55	1: 41	5: 52	1: 77	5: 61
2: 49	6: 48	2: 41	6: 70	2: 48	6: 44	2: 64	6: 62
3: 78	7: 63	3: 82	7: 49	3: 53	7: 47	3: 54	7: 83
4: 69	8: 83	4: 55	8: 68	4: 77	8: 64	4: 46	8: 59
Min:	43	Min:	45	Min:	41	Min:	46
Max:	83	Max:	82	Max:	77	Max:	83
Average:	61.3	Average:	58.8	Average:	53.2	Average:	63.2
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 79	5: 43	1: 86	5: 81	1: 46	5: 42	1: 52	5: 43
2: 49	6: 80	2: 60	6: 71	2: 63	6: 47	2: 85	6: 54
3: 72	7: 40	3: 65	7: 57	3: 56	7: 67	3: 48	7: 40
4: 68	8: 53	4: 46	8: 51	4: 79	8: 58	4: 76	8: 65
Min:	40	Min:	46	Min:	42	Min:	40
Max:	79	Max:	86	Max:	79	Max:	85
Average:	56.7	Average:	64.6	Average:	57.2	Average:	57.8
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 74	5: 44	1: 62	5: 80	1: 88	5: 45	1: 57	5: 85
2: 50	6: 56	2: 66	6: 60	2: 49	6: 59	2: 74	6: 41
3: 72	7: 61	3: 55	7: 73	3: 47	7: 57	3: 63	7: 51
4: 41	8: 50	4: 61	8: 52	4: 84	8: 42	4: 75	8: 66
Min:	41	Min:	52	Min:	42	Min:	41
Max:	74	Max:	80	Max:	88	Max:	85
Average:	56	Average:	63.6	Average:	58.8	Average:	64
Primer has been inspected and is free of defects				Confirmed		Yes	No
QC Inspector:		Zuthile		Sign:		Graig	
Date:		24.01.2024					

Record of Painting NCSS3010 R90B			
Start Time:	8:00	End Time:	9:00
Temperature $\geq 15^{\circ}$:	25°C	Humidity $\leq 75\%$:	50%
Paint Batch No.:	2136210	Paint Expiry Date:	17/11/2024
Hardener Batch No.:	7250479041	Hardener Expiry Date:	04/24
Desolvation Start Time:	9:00	Desolvation End Time:	9:15
Stoving Start Time:	9:15	Stoving End Time:	10:15
Stoving Temp:	60°C		
Operator:	G. Lin	Sign:	G. Lin
Date:	20/01/24		
Painting NCSS3010 R90B Control			
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS	
GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)			
1: 91.6	5: 112.4	1: 133.6	5: 98.8
2: 80.2	6: 99.8	2: 120.8	6: 126.9
3: 76.8	7: 120.6	3: 104.6	7: 114.8
4: 60.9	8: 118.3	4: 98.6	8: 113.4
Min:	60.9	Min:	98.6
Max:	120.6	Max:	136
Average:	95.2	Average:	115
Painting NCSS3010 R90B has been inspected and is free of defects		Confirmed	Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	40.6
QC Inspector:	Reece	Sign:	Reece
Date:	27/01/24		

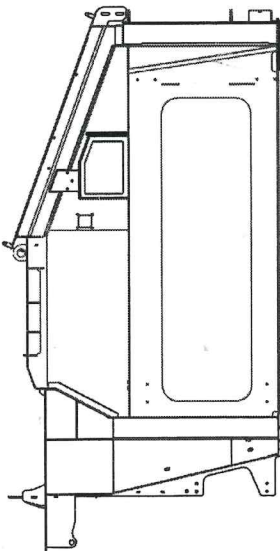
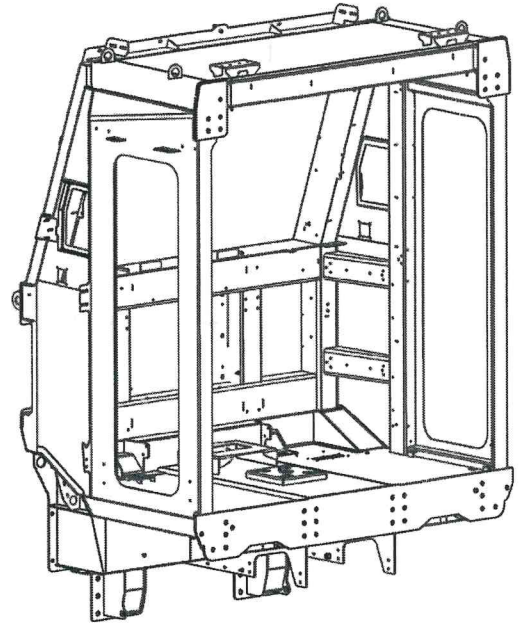
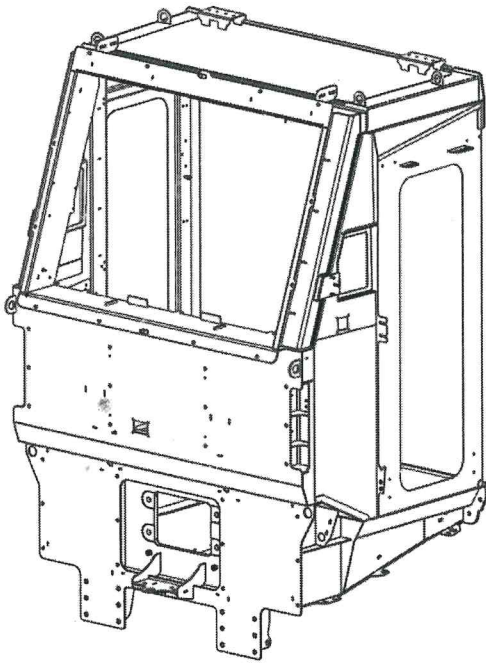
Record of Painting Blue NCSS1565 B					
Start Time:		3:00		End Time:	
Temperature $\geq 15^{\circ}$:		28 $^{\circ}$		Humidity $\leq 75\%$:	
Paint Batch No.:		8032294		Paint Expiry Date:	
Hardener Batch No.:		7250479041		Hardener Expiry Date:	
Desolvation Start Time:		4:00		Desolvation End Time:	
Stoving Start Time:		4:15		Stoving End Time:	
Stoving Temp:		60 $^{\circ}$ C			
Operator:		Colin		Sign: Colin	
Date:		2024/01/24			
Painting Blue NCSS1565 B Control					
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)	
1: 136.9	5: 80.6	1: 160.9	5: 155.5		
2: 140.1	6: 99.8	2: 151.3	6: 136.4		
3: 127.6	7: 113.6	3: 149.7	7: 113.4		
4: 144.8	8: 109.8	4: 113.8	8: 98.6		
Min:	80.6	Min:	98.6		
Max:	141	Max:	160		
Average:	118	Average:	120		
Painting NCSS3010 R90B has been inspected and is free of defects					
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	91.8
QC Inspector:		Reece		Sign: RB	
Date:		27/01/24			

Record of RAL 7012							
Start Time:		7:00		End Time:		9:00	
Temperature $\geq 15^{\circ}$:		25.2		Humidity $\leq 75\%$:		37%	
Paint Batch No.:		8095599		Paint Expiry Date:		21/09/2024	
Hardener Batch No.:		7250479041		Hardener Expiry Date:		04/24	
Desolvation Start Time:		9:00		Desolvation End Time:		9:15	
Stoving Start Time:		9:15		Stoving End Time:		10:15	
Stoving Temp:							
Operator:		NTU THUKOISS		Sign:		N. THUKOISS	
Date:		20/01/25					
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 113.6	5: 116.8	1: 90.9	5: 104.8	1: 79.8	5: 107.6	1: 161.8	5: 118.6
2: 140.8	6: 118.2	2: 170.8	6: 93.2	2: 88.6	6: 93.3	2: 113.8	6: 106.2
3: 120.6	7: 104.8	3: 111.7	7: 121.8	3: 90.4	7: 100.8	3: 120.6	7: 104.3
4: 73.6	8: 130.8	4: 98.9	8: 130.6	4: 100.6	8: 111.6	4: 120.9	8: 140.8
Min:	73.6	Min:	90.9	Min:	79.8	Min:	106
Max:	140	Max:	170.8	Max:	107.6	Max:	161
Average:	114.9	Average:	115	Average:	96	Average:	132
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 160.8	5: 76.9	1: 127.8	5: 104.6	1: 95.6	5: 98.1	1: 77.8	5: 116.7
2: 111.8	6: 98.2	2: 92.2	6: 156.8	2: 141	6: 103.7	2: 89.8	6: 80.6
3: 102.6	7: 110.8	3: 118.2	7: 181.8	3: 150.6	7: 118.8	3: 82.6	7: 109.4
4: 131.8	8: 118.2	4: 76.8	8: 104.3	4: 161.8	8: 120.6	4: 93.4	8: 120.6
Min:	76.9	Min:	76.8	Min:	95.6	Min:	77.8
Max:	160	Max:	156	Max:	161	Max:	120.6
Average:	113	Average:	114	Average:	123	Average:	96
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 93.7	5: 118.1	1: 113.4	5: 115.6				
2: 116.8	6: 137.2	2: 96.2	6: 117.8				
3: 93.2	7: 146.9	3: 90.8	7: 98.6				
4: 141.8	8: 156.7	4: 93.1	8: 104.2				
Min:	93.2	Min:	90.8				
Max:	156	Max:	117				
Average:	125	Average:	103				
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	48.9		
QC Inspector:		Reece		Sign:		Reece	
Date:		27/01/24					
SEALING OF CABIN							
All areas where there is no welding has been sealed with SIKA				Confirmed	YES	<input checked="" type="checkbox"/>	NO
All sealants have been neatly applied along joints				Confirmed	YES	<input checked="" type="checkbox"/>	NO
SIGN OFF							
CLOCK No:	2400	OPERATOR SIGN:	A. M. M. M. M.	DATE:	27/01/24		

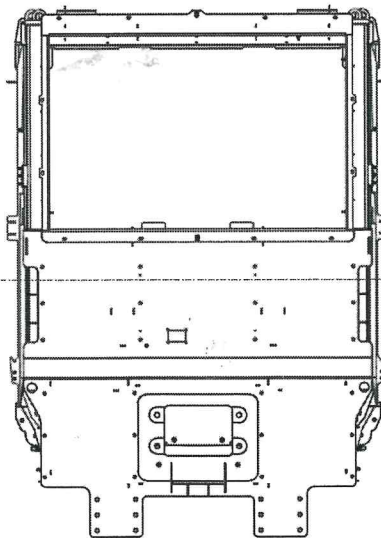
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REWORK IDENTIFICATION

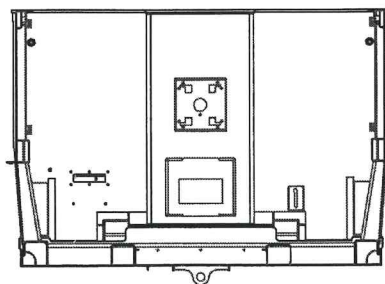
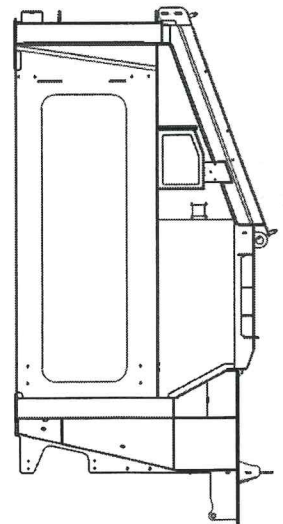
(MARK SECTIONS EFFECTED NUMERICALLY)



XSEC0001



XSEC0001



FAULT TRACKING

DESCRIPTION	LOCATION ON CAB	REWORKED BY (COMPANY NUMBER)	QC VALIDATED

REMINDERS / COMMENTS

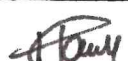
DEPARTMENT	DETAILS OR COMMENT

CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	387	Checks Updated:	2021/07/07

Disposition Key:	0	Pass
	X	Fail (Concession required)
	Δ	Rework required

No.	Description of inspection	Disposition	Validation after rework		Sign
			Repairer	Disposition	
1	WELDS ARE CLOSED	0			
2	NO PIN HOLES ON CAB STRUCTURE	0			
3	SEALANT IS APPLIED CORRECTLY <ul style="list-style-type: none"> JOINTS ARE CLOSED NO BREAKS IN THE SEALANT CORRECT BEAD 	0			
4	RIVET NUTS ARE PROPERLY CRIMPED <ul style="list-style-type: none"> RIVETS ARE MARKED CORRECT GRIP RANGE USED 	0			
5	NO MISS WELDS PRESENT AFTER SANDBLASTING	0			
6	NO VISUAL MISS WELDS (INSPECTION AFTER SEALING)	0			
7					
8					
9					
10					
11					
12					
13					
14					

Quality approval for release Signature	CO. NO:	DATE
	2285	27.01.2024