

CABIN STRUCTURE
QUALITY CARD

CAB No.: CAB_ 4 2 7

WEIGHT: 1 4 8 5 Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Regulus	19/12/23	5110326 VHE 89171	178247 104825 01	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Regulus	19/01/24	V201257 VFK 70756	176226 103020 01	
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Regulus	19/12/24	V208170 VPL 97579	177332 103232 01	
RCS 355	20 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Regulus	19/12/23	V201051 VAK 9764		
RCS 355	30 mm					

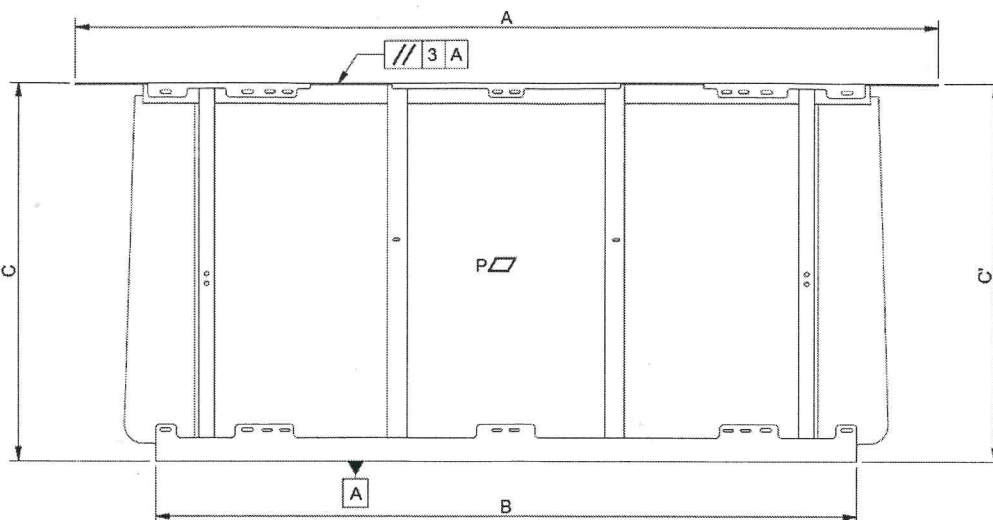
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Regulus	19/12/23	V201903 VH 651923	175252 102206 01	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm				176986 102206 01	
RCS 450	6 mm					
RCS 450	6 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Regulus	19/12/23	V201039 VHS 55762	175569 102206 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	<input type="checkbox"/>
Operator:	① YLAN ① DAVIDS	Assembly Date:	20 <u>24</u> / <u>01</u> / <u>15</u>			
Sign:		Wire Batch No.:	107238261			




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:		Date:	20 <u>24</u> / <u>01</u> / <u>15</u>	

Dimensional Control

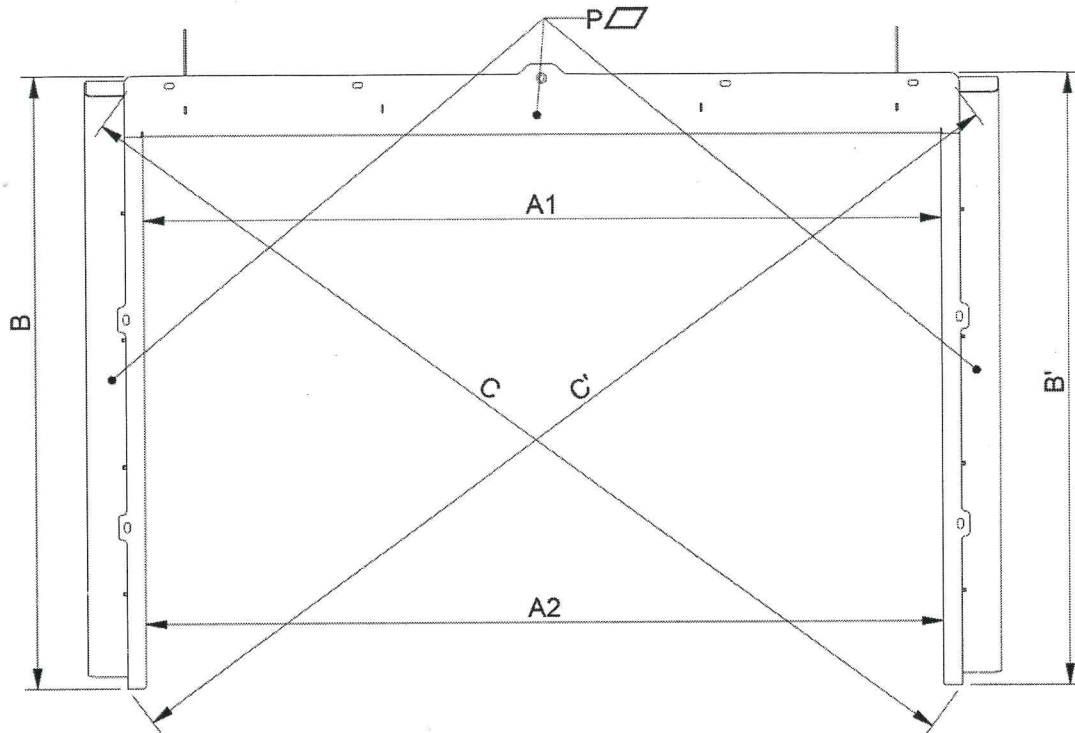
Rep		Toler.	Dimension measured		Measuring Equipment	Observations	
A	2216	+5/-0	2216		Tape Measure	Accepted	
B	1800	± 4	1800			Accepted	
C	976	+2/-3	976	975		Accepted	
QC Inspector:		LEON		Sign:		Date:	20_24/_01/_15

Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations	
Planity P		6 mm	Passes		Ruler	Accepted	
//	3	A	Passes		Set Square	Accepted	
QC Inspector:		Leon	Sign:			Date:	20 <u>24</u> / <u>01</u> / <u>15</u>

Cabin Front Frame Assembly: GN002840


Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Bamuelo G. Guman	Assembly Date:	20 24/01/14			
Sign:		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	
QC Inspector:	Leon	Sign:		Date:	20 24/01/14	

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	1910	± 2	1912		Tape Measure	Acceptable	
A2	1910		1911			Acceptable	
B	1475	± 1	1475	1475		Acceptable	
C	Diagonals C - C' ≤ 3		2478	2475		Acceptable	
QC Inspector:		LEON		Sign:		Date:	20_24/_01/_14

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P : Planity	4 mm	Pass	Ruler	Acceptable
QC Inspector:	Leon	Sign:		Date: 20 24/01/14

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	<input type="checkbox"/>
Operator:	<i>Xander</i>	Assembly Date:	20 <u>24</u> / <u>01</u> / <u>05</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

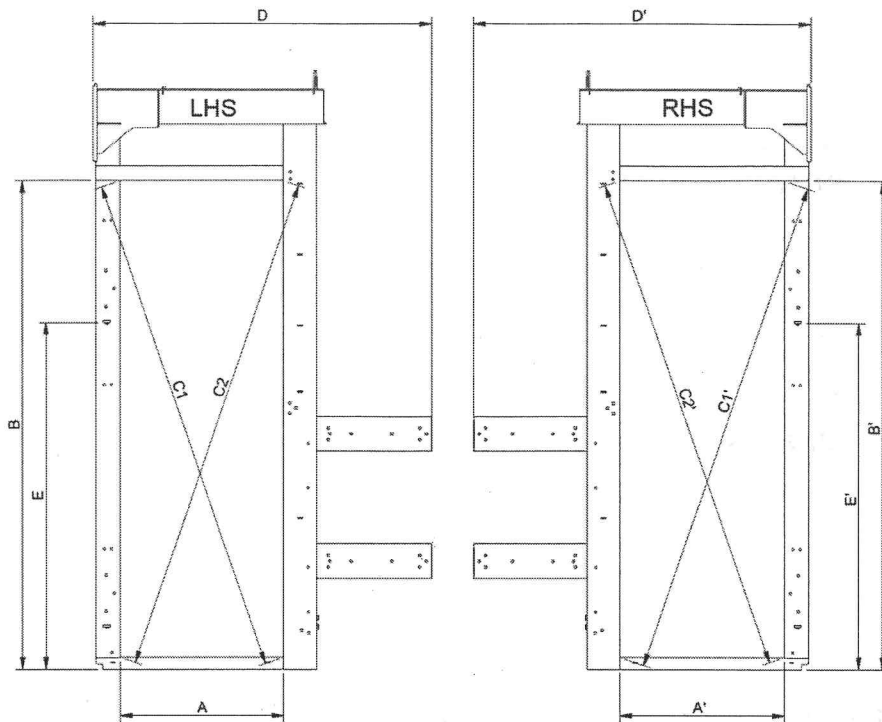
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Glenn</i>	Assembly Date:	20 <u>24</u> / <u>01</u> / <u>05</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Glenn</i>	Assembly Date:	20 <u>24</u> / <u>01</u> / <u>05</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

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:	2023/12/21			
Sign:	<i>Glenn</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 type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Rudley	Sign:	<i>[Signature]</i>	Date:	2023/12/22	

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	697	695	Tape Measure	Acceptable
B	2086	+1/-3	2087	2086		Acceptable
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2153	2156		Acceptable
C1 - C2			2154	2159		Acceptable
D	1438	+2/-3	1440	1440		Acceptable
E			1485	1483		Acceptable

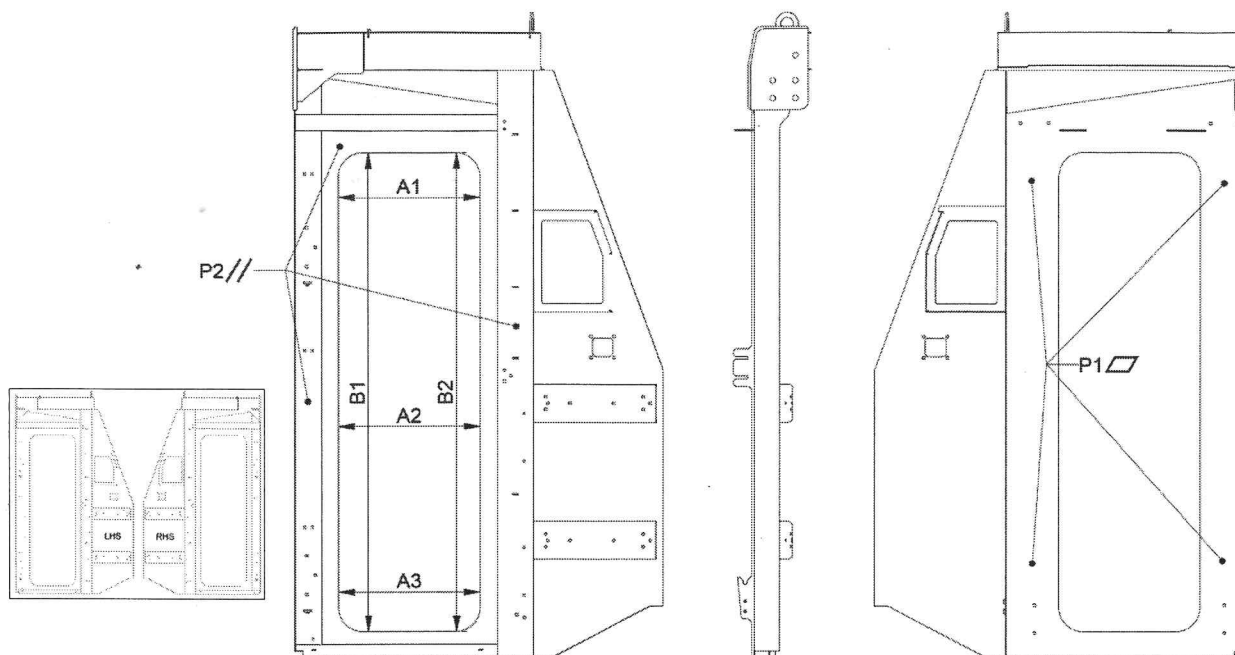
QC Inspector:	Rudley	Sign:	<i>[Signature]</i>	Date:	2023/12/22	
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Geometrical Control

Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P1 : planeity of 2 edges	4 mm	Passed		Ruler	Acceptable	
QC Inspector:	Leon	Sign:			Date:	2023/12/22

Cabin LHS/RHS Side Assembly: GN002838/GN002837


Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Xander</i>	Assembly Date:	20 <u>23</u> / <u>12</u> / <u>21</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	<u>2202152</u>			




Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>21</u> / <u>01</u> / <u>15</u>	

Dimensional Control

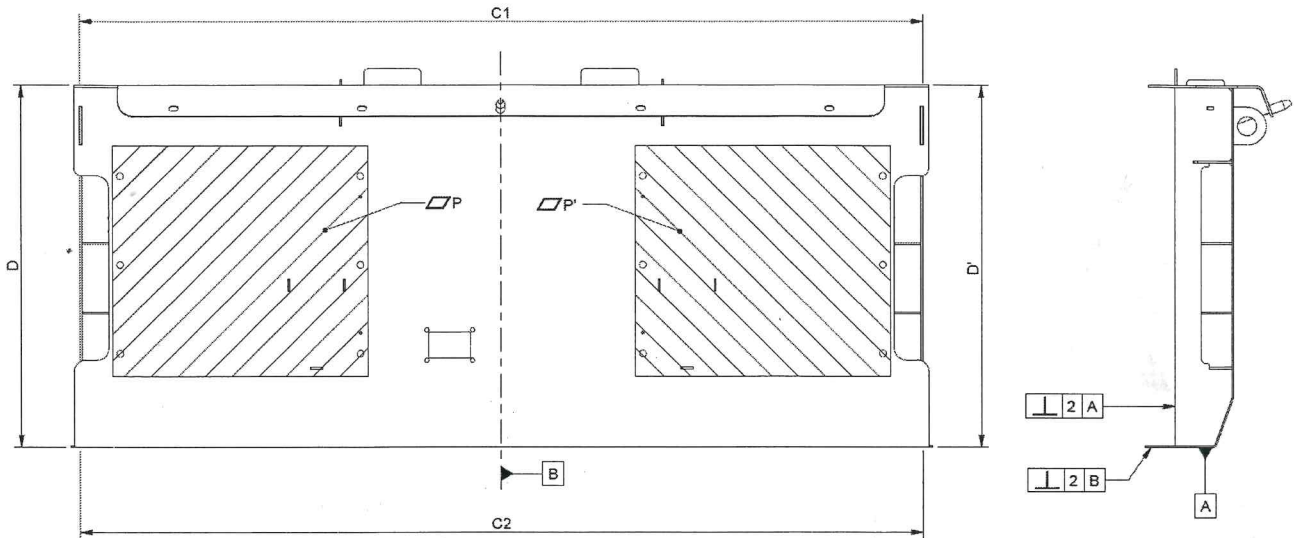
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	558	558	Tape Measure	Acceptable
A2			559	559		Acceptable
A3			560	560		Acceptable
B1	1900	± 2	1898	1898		Acceptable
B2			1898	1898		Acceptable
QC Inspector:		Leon		Sign:		Date: 2024/01/15

Geometrical Control

Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P1 : Planeity	4 mm	Passes		Ruler	Acceptable	
P2 : Planeity	2 mm	Passes		Ruler	Acceptable	
QC Inspector:	Leon	Sign:			Date:	20_24/01/15

Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	BEVAN JAWEN HILL	Assembly Date:	20 24/01/14			
Sign:		Wire Batch No.:	2202152			



Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
QC Inspector:	LEON	Sign:		Date:	2024/01/14	


Dimensional Control

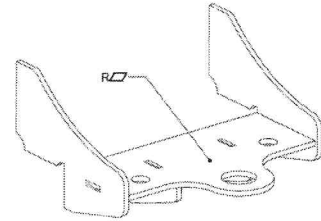
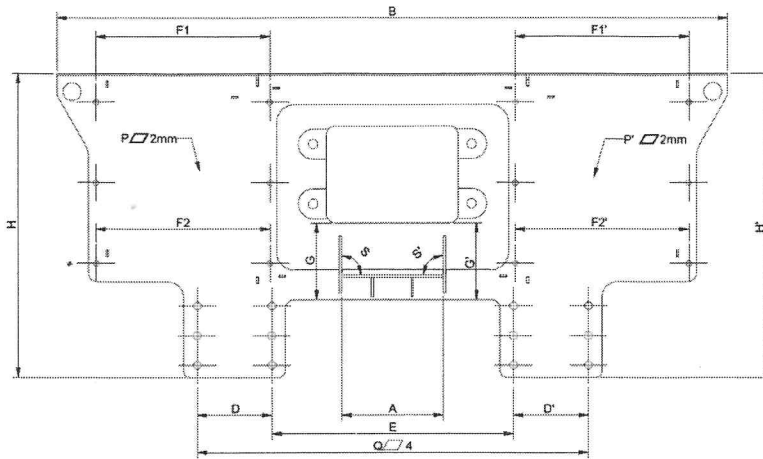
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2214	2214	Tape Measure	Acceptable
D / D'	956	± 2	955	955		Acceptable
QC Inspector:			Sign:		Date:	2024/01/14

Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planarity P / P'		2 mm	Passed		Ruler	Acceptable
Perpendicularity	2	A	Passed		Set Square	Acceptable
	2	B	Passed		Set Square	Acceptable
QC Inspector:	LEON		Sign:		Date:	2024/01/14

Cabin Front Headstock Assembly: GN002841


Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	TK BOOLE	Assembly Date:	2023/01/10			
Sign:		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:		Date:	2024/01/10	

Dimensional Control

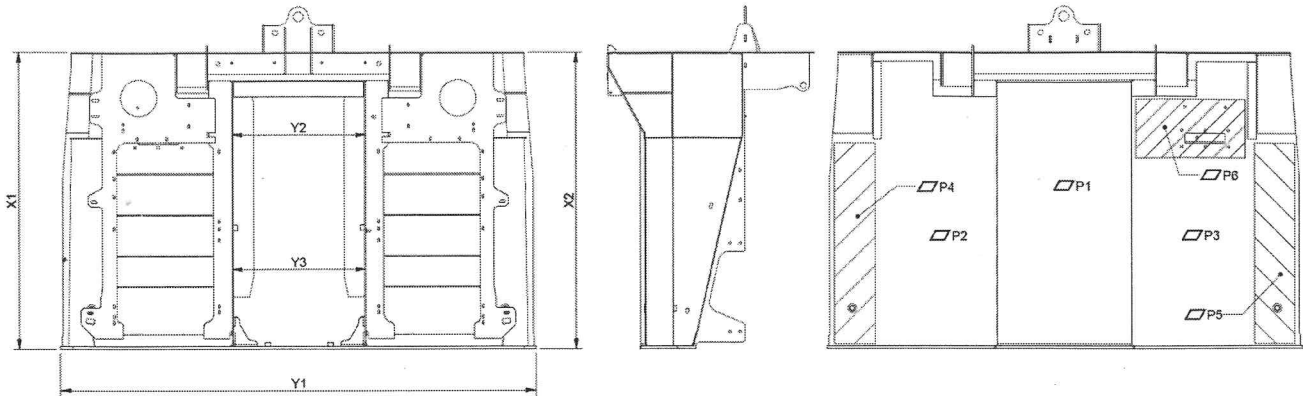
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	340	± 1	340		Tape Measure	Acceptable	
B	2240	± 4	2244			Acceptable	
D / D'	250	± 1	251	251		Acceptable	
E	808	± 2	808			Acceptable	
F1 / F1'	580	± 1	581	581		Acceptable	
F2 / F2'			581	581		Acceptable	
G / G'	258	± 1	258	258		Acceptable	
H / H'	1019	± 2	1020	1020		Acceptable	
QC Inspector:		Lison		Sign:		Date:	2024 / 01 / 10

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:	Leon	Sign:		Date:	20_24_01/_10


Cabin Underframe Assembly: GN002835

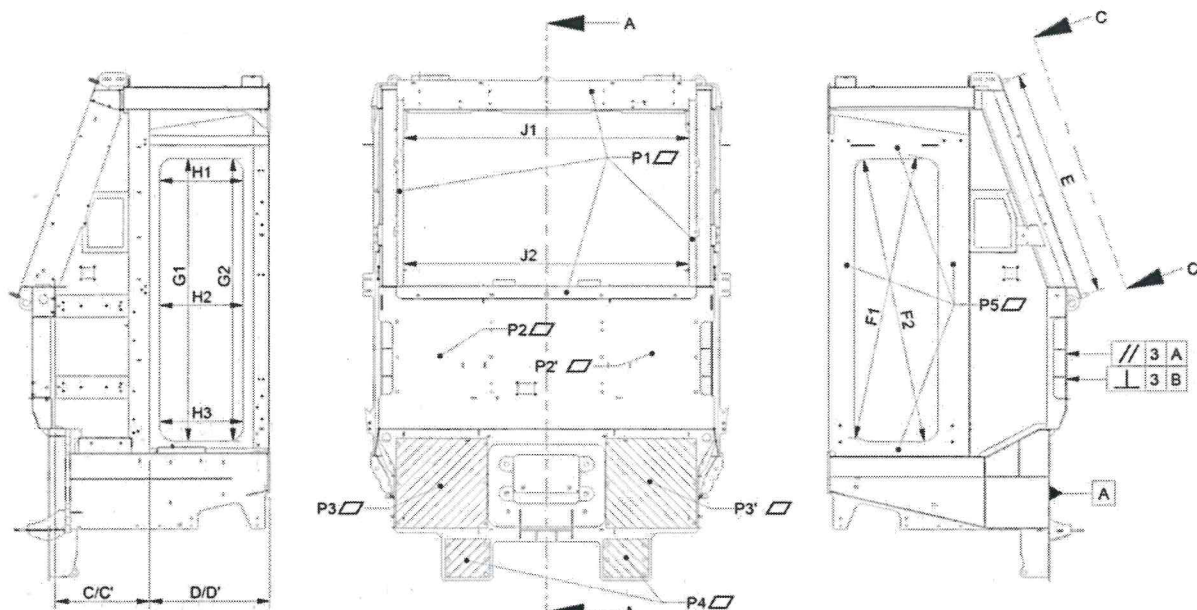
Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Waver</i>	Assembly Date:	2024/01/08	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152	



Welding Control						
Assembly Completed as per WI/SOS MD_0042		Confirmed		Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/01/13	
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1486	1486	Tape Measure	<i>Acceptable</i>
Y 1	2354	± 3	2351			<i>Acceptable</i>
Y2 / Y3	666	± 1	667	667		<i>Acceptable</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/01/13	
Geometrical Control						
Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P1 : Planeity	4 mm	<i>Passed</i>		Ruler	<i>Acceptable</i>	
P2 / P3 : Planeity	4 mm	<i>Passed</i>		Ruler	<i>Acceptable</i>	
P4 / P5 : Planeity	2 mm	<i>Passed</i>		Ruler	<i>Acceptable</i>	
P6 : Planeity	2 mm	<i>Passed</i>		Ruler	<i>Acceptable</i>	
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/01/13	


Cabin Structure Assembly: GN002834

Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLOEM	Assembly Date:	20 24/01/13			
Sign:		Wire Batch No.:	2202152			

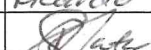


Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed	Yes	<input checked="" type="checkbox"/>	No	
QC Inspector:		Leon		Sign:				Date:	2024/01/18
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	626	626	Acceptable				
D / D'	813	± 2,5	812	812	Acceptable				
E	1531.5	± 3	1531		Acceptable				
G1 / G'1	Height 1900	+1	1897	1897	Acceptable				
G2 / G'2		-3	1894	1899	Acceptable				
H1 / H'1	Width 560	+1	557	557	Acceptable				
H2 / H'2		-3	558	559	Acceptable				
H3 / H'3			559	559	Acceptable				
F1 / F'1	Diagonals 1939		1935	1935	Acceptable				
F2 / F'2			1937	1937	Acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	2	2	Acceptable				
J	Gap of Doors	± 1,5	0		Acceptable				
K1 / K2	1515	± 3	1513,5	1513	Acceptable				
L1 / L2	1996	± 3	1998	1996	Acceptable				
M1 / M'1	2306	± 3	2469	2469	Acceptable				
M2 / M'2			2478	2478	Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2108	2107	Acceptable				
T2 / T'2	2230 Top/Bottom			2228	2238	Acceptable			
Difference	U - U' (3522)	≤ 4mm	3519	3522	Acceptable				
QC Inspector:		Leon		Sign:				Date:	2024/01/18
Geometrical Control									
Nature of checks				Toler.	LHS / Dimension Measured / RHS				
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		Acceptable		
Shield	⊥	3	A	3	Passed		Acceptable		
Door Post	⊥	3	A	Front	Passed		Acceptable		
				Back	Passed		Acceptable		
QC Inspector:		Leon		Sign:				Date:	2024/01/18


Cabin Bracket Assembly: GN002833



Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BROWN	Assembly Date:	20 24/01/14			
Sign:		Wire Batch No.:	2202152			


Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Ricardo	Assembly Date:	2024/02/05			
Sign:		Wire Batch No.:				

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:		TD [Signature]	
Date:	2024/02/05				
Record of Shot Blasting					
Operator:		Date:	2024/02/05		
Start Time:	08 H15	End Time:	16 H30		
Temperature ($\geq 15^\circ$):	21-02°C	Humidity ($\leq 75\%$):	70-09%		
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:		TD [Signature]	
Date:	2024/02/05				
Shot Blasting Cleaning					
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID	Sign:		TD [Signature]	
Date:	2024/02/05				
Shot Blasting Control					
Temperature $\geq 15^\circ$:	22-03°C	Humidity $\leq 75\%$:	71-01%		
Internal Roughness $3.2 \leq Ra \leq 12.5$	9,4 Ra	External Roughness $3.2 \leq Ra \leq 12.5$	10,7 Ra		
QC Inspector:	David Ridley	Sign:		RD	
Date:	6/02/24				

Record of Priming							
Start Time:		17:00		End Time:		19:00	
Temperature $\geq 15^{\circ}$:		25°C		Humidity $\leq 75\%$:		36%	
Paint Batch No.:		7296866		Paint Expiry Date:		06/05/2024	
Hardener Batch No.:		7287752		Hardener Expiry Date:		13/04/2024	
Desolvation Start Time:		19:00		Desolvation End Time:		19:15	
Stoving Start Time:		19:15		Stoving End Time:		20:15	
Stoving Temp:		60°C					
Operator:		CRAIG		Sign:		CRAIG	
Date:		20/02/05					
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 40.9	5: 50.4	1: 44.2	5: 41.9	1: 53.3	5: 72.2	1: 57.7	5: 48.2
2: 52.8	6: 42.3	2: 58.2	6: 40.2	2: 56.6	6: 69.4	2: 42.3	6: 63.0
3: 78.9	7: 40.0	3: 47.6	7: 84.9	3: 82.9	7: 64.0	3: 48.2	7: 59.7
4: 42.8	8: 85.4	4: 46.6	8: 52.9	4: 56.7	8: 56.7	4: 40.4	8: 57.7
Min:	40.0	Min:	40.2	Min:	53.3	Min:	40.4
Max:	85.4	Max:	84.9	Max:	82.9	Max:	63.0
Average:	54.2	Average:	52.1	Average:	65.8	Average:	52.2
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 62.3	5: 67.9	1: 83.9	5: 51.4	1: 101	5: 64.5	1: 81.7	5: 61.6
2: 90.9	6: 75.8	2: 40.8	6: 53.3	2: 58.9	6: 69.6	2: 46.3	6: 60.6
3: 44.2	7: 64.5	3: 41.4	7: 95.9	3: 68.2	7: 40.6	3: 68.6	7: 63.5
4: 58.4	8: 61.6	4: 63.8	8: 64.0	4: 51.4	8: 42.8	4: 58.7	8: 76.9
Min:	44.2	Min:	40.8	Min:	40.6	Min:	46.3
Max:	90.9	Max:	95.9	Max:	101	Max:	88.7
Average:	69.7	Average:	61.8	Average:	71.5	Average:	65.6
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 90.9	5: 84.9	1: 70.4	5: 66.9	1: 104	5: 57.2	1: 87.9	5: 81.9
2: 75.4	6: 87.7	2: 60.6	6: 72.0	2: 90.4	6: 63.0	2: 87.3	6: 63.1
3: 78.6	7: 83.3	3: 62.1	7: 71.9	3: 72.4	7: 65.0	3: 105	7: 61.3
4: 58.7	8: 63.0	4: 70.2	8: 83.4	4: 84.9	8: 68.9	4: 90.2	8: 68.9
Min:	58.7	Min:	60.6	Min:	57.2	Min:	67.3
Max:	98.6	Max:	83.4	Max:	104	Max:	105
Average:	80.3	Average:	69.6	Average:	76.2	Average:	80.7
Primer has been inspected and is free of defects				Confirmed		Yes	No
QC Inspector:		Zothile		Sign:			
Date:		07.02.2024					

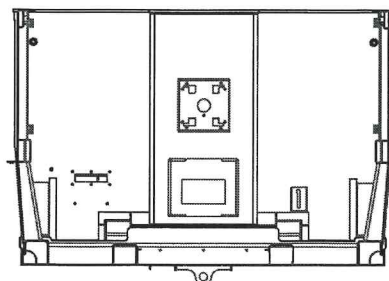
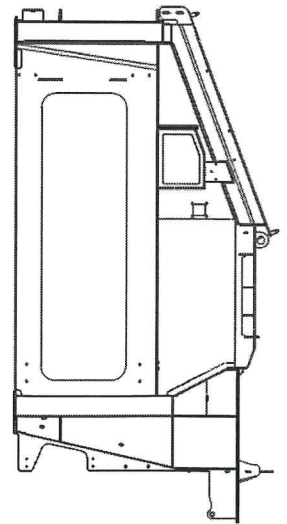
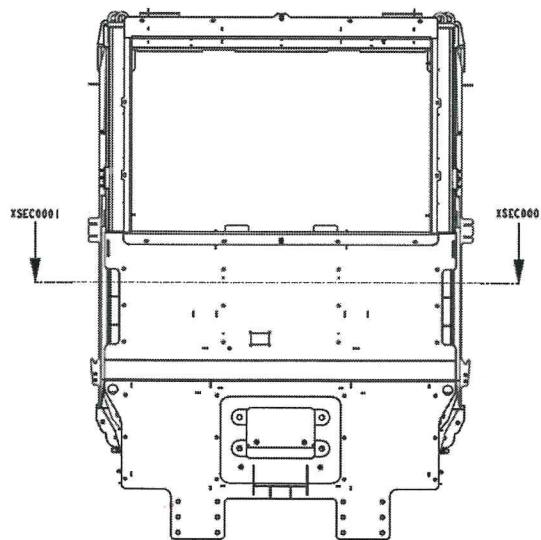
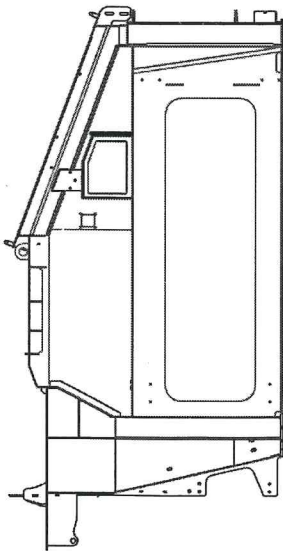
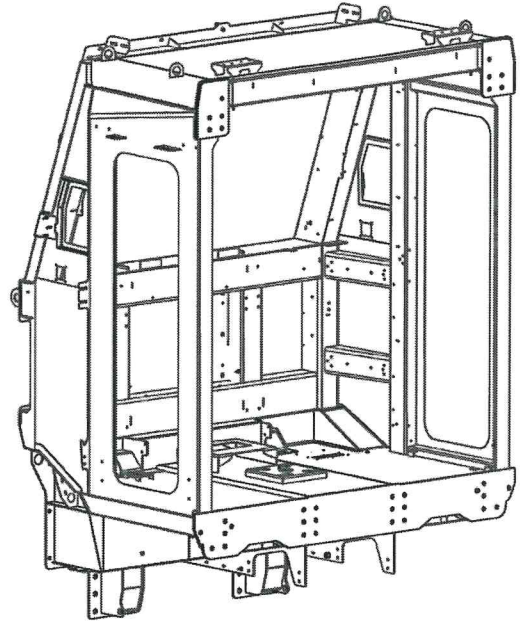
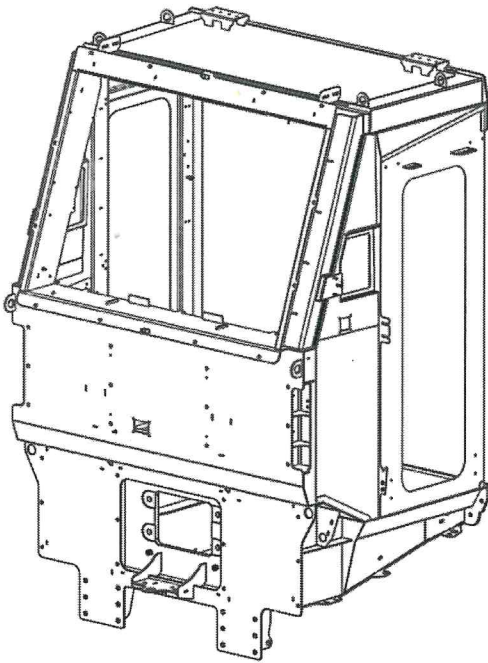
Record of Painting NCSS3010 R90B			
Start Time:	04:00	End Time:	05:00
Temperature $\geq 15^{\circ}$:	25°C	Humidity $\leq 75\%$:	50%
Paint Batch No.:	8136210	Paint Expiry Date:	17/11/2024
Hardener Batch No.:	7250479041	Hardener Expiry Date:	04/24
Desolvation Start Time:	05:00	Desolvation End Time:	05:15
Stoving Start Time:	05:15	Stoving End Time:	06:15
Stoving Temp:	60°C		
Operator:	Ntuthuko	Sign:	
Date:	20 24/02/05		
Painting NCSS3010 R90B Control			
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS	
1: 811	5: 79.6	1: 89.5	5: 78.7
2: 82.2	6: 97.8	2: 81.2	6: 90.9
3: 87.1	7: 114	3: 84.2	7: 83.0
4: 98.3	8: 132	4: 89.1	8: 83.6
Min:	79.6	Min:	90.9
Max:	132	Max:	78.7
Average:	105	Average:	84.8
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	33.7
QC Inspector:	Zothile	Sign:	
Date:	07.02.2024		

Record of Painting Blue NCSS1565 B			
Start Time:	16:00	End Time:	17:00
Temperature $\geq 15^{\circ}$:	25°C	Humidity $\leq 75\%$:	42%
Paint Batch No.:	8032294	Paint Expiry Date:	13/06/2024
Hardener Batch No.:	7250479041	Hardener Expiry Date:	04/24
Desolvation Start Time:	17:00	Desolvation End Time:	17:15
Stoving Start Time:	17:15	Stoving End Time:	18:15
Stoving Temp:	60°C		
Operator:	Phoka	Sign:	Phoka
Date:	20/02/2024		
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: 74.1	5: 85.6	1: 81.7	5: 81.5
2: 91.8	6: 98.1	2: 83.3	6: 84.6
3: 91.0	7: 86.7	3: 80.9	7: 79.4
4: 92.4	8: 82.5	4: 86.9	8: 85.2
Min:	74.1	Min:	79.4
Max:	98.1	Max:	86.9
Average:	86.1	Average:	83.1
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	93.8
QC Inspector:	Zotwile	Sign:	
Date:	07.02.2024		

Record of RAL 7012							
Start Time:		03:00		End Time:		05:00	
Temperature $\geq 15^{\circ}$:		25°C		Humidity $\leq 75\%$:		39%	
Paint Batch No.:		8096599		Paint Expiry Date:		21/09/2024	
Hardener Batch No.:		7230479041		Hardener Expiry Date:		04/24	
Desolvation Start Time:		08:00		Desolvation End Time:		05:15	
Stoving Start Time:		05:15		Stoving End Time:		06:15	
Stoving Temp:		60°C					
Operator:		Ntotohuko		Sign:		Ntotohuko	
Date:		2024/02/06					
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 147	5: 149	1: 111	5: 136	1: 113	5: 106	1: 141	5: 106
2: 131	6: 142	2: 123	6: 152	2: 85.1	6: 147	2: 104	6: 125
3: 146	7: 114	3: 108	7: 127	3: 108	7: 137	3: 89.1	7: 141
4: 157	8: 122	4: 126	8: 159	4: 963	8: 107	4: 80.1	8: 97.6
Min:	114	Min:	108	Min:	85.1	Min:	80.1
Max:	157	Max:	159	Max:	147	Max:	141
Average:	135	Average:	133	Average:	116	Average:	110
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 92.2	5: 104	1: 92.2	5: 103	1: 133	5: 92.7	1: 138	5: 139
2: 116	6: 93.7	2: 95.5	6: 91.7	2: 93.7	6: 87.1	2: 86.1	6: 129
3: 94.2	7: 101	3: 83.1	7: 147	3: 113	7: 101	3: 99.8	7: 120
4: 130	8: 88.6	4: 89.8	8: 93.7	4: 118	8: 115	4: 154	8: 151
Min:	88.6	Min:	83.1	Min:	87.1	Min:	86.1
Max:	130	Max:	147	Max:	133	Max:	154
Average:	107	Average:	115	Average:	106	Average:	120
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 133	5: 117	1: 121	5: 87.6				
2: 145	6: 164	2: 110	6: 84.4				
3: 135	7: 128	3: 82.2	7: 97.6				
4: 159	8: 153	4: 85.6	8: 112				
Min:	117	Min:	82.2				
Max:	164	Max:	121				
Average:	141.5	Average:	101				
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	38.4		
QC Inspector:		Zetule		Sign:		H. G. M.	
Date:		08.02.2024					
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.	DATE:	08/02/24		

REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)

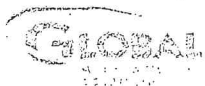


FAULT TRACKING

[illegible]

REMINDERS / COMMENTS	
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[illegible]



CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	0427	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 CLOSEDNO BREAKS IN THE SEALANTCORRECT BEAD	0			
4	RIVET NUTS ARE PROPERLY CRIMPED <ul style="list-style-type: none">RIVETS ARE MARKEDCORRECT 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	10.02.2024