



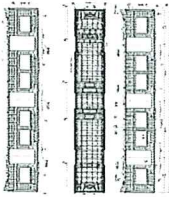


CONFIDENTIAL INFORMATION
This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA and treated as such.

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE				WORK INSTRUCTION	SAFETY 1	
				TCL	M1	M2	M3			
<input type="checkbox"/>	DT002548/2	CARBODYSHELL M4J0J04 ASSEMBLY	CR220		X	<input checked="" type="checkbox"/>	X	PR-CB1220.DT002548 7/2.V21	YES	
<input type="checkbox"/>										
<input type="checkbox"/>										
<input type="checkbox"/>										
<input type="checkbox"/>										
<input type="checkbox"/>										
<input type="checkbox"/>										
REV	DATE	MODIFICATION CONTENT						RESPONSIBLE	NAME	DATE
0	01/02/2018	GIBELA NEW CREATION						APPROVER	Iumeleng Modiba	01/02/2018
								CHECKER	Nosiso Pindela	01/02/2018
								COMPLIER	Thanyani Mathegu	01/02/2018
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PYE Manager to Quality manager						APPROVER	Iumeleng Modiba	18/05/2018
								CHECKER	Nosiso Pindela	18/05/2018
								REVISD BY	Ramokone Motama	18/05/2018
2	2018/07/05	Certain dimensional checks added and others moved to CB1210						APPROVER	Iumeleng Modiba	2018/07/05
								CHECKER	Nosiso Pindela	2018/07/05
3	2018/06/12	Width tolerance as per DT000398600						REVISD BY	Nosiso Pindela	2018/06/12
								APPROVER	Iumeleng Modiba	2018/06/12
								CHECKER	Nosiso Pindela	2018/06/12
5	24/01/2019	As per Baseline 10.2						REVISD BY	Nosiso Pindela	24/01/2019
								CHECKER	Nosiso Pindela	24/01/2019
								REVISD BY	Nosiso Pindela	24/01/2019
								APPROVER	Iumeleng Modiba	13/03/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements						CHECKER	Nosiso Pindela	13/03/2019
								REVISD BY	Nosiso Pindela	13/03/2019
10	22/08/2019	New Baseline 10.2.5						APPROVER	Iumeleng Modiba	22/08/2019
								REVISD BY	Nosiso Pindela	22/08/2019
								APPROVER	Iumeleng Modiba	22/08/2019
								CHECKER	Bongane Masina	06/08/2020
15	06/08/2020	New Baseline 10.2.6						REVISD BY	Bongane Masina	06/08/2020
								APPROVER	Timothy Maimela	19/04/2021
								CHECKER	Bongane Masina	19/04/2021
20	19/04/2021	New Baseline change 10.3						REVISD BY	Bongane Masina	19/04/2021
								APPROVER	Mkhombi Collins	17/08/2021
								CHECKER	Mpho Mulaudzi	17/08/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING						REVISD BY	Mpho Mulaudzi	17/08/2021
								APPROVER	Mkhombi Collins	19/02/2022
								CHECKER	Andani Muthelo	19/02/2022
25	20/02/2022	New Baseline change 10.3.1						REVISD BY	Andani Muthelo	19/02/2022
								APPROVER	Mkhombi Collins	14/06/2022
								CHECKER	Andani Muthelo	14/06/2022
26	14/06/2022	Update minimum temperature requirement for sealant application						REVISD BY	Mkhombi Collins	14/06/2022
								CHECKER	Nitokozo Zwane	17/10/2022
27	17/10/2022	Addition of traceability for sealant application and welding						REVISD BY	Amogelang Mohlamepe	17/10/2022
								APPROVER	Vanessa Ntuli	14/04/2023
								CHECKER	Nitokozo Zwane	14/04/2023
28	14/04/2023	Added sealant batch number & welding consumables traceability						REVISD BY	Amogelang Mohlamepe	14/04/2023
								APPROVER	Nyobeni Tyson	28/10/2023
								CHECKER	Nitokozo Zwane	28/10/2023
29	28/10/2023	Addition of bracket quantity						REVISD BY	Amogelang Mohlamepe	28/10/2023
TRAINSET	CAR	OPERATOR NAMES ALPS NO		DATE		SELF INSPECTION NUMBER		PAGES		
213	M1	Mthophozi 426954		21/02/24		SI.CB1220.250.V29		14		

	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

II.1 - Items to check					
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NON OK
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB1220.DTR30225487/2	<input checked="" type="checkbox"/>	<input type="checkbox"/>
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	<input checked="" type="checkbox"/>	<input type="checkbox"/>
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TTPDEF - ARC - 0000	<input checked="" type="checkbox"/>	<input type="checkbox"/>
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	<input checked="" type="checkbox"/>	<input type="checkbox"/>
05		Functionals 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"/>	<input type="checkbox"/>
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.	<input checked="" type="checkbox"/>	<input type="checkbox"/>
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) 10°C - 35°C Relative humidity Min - Max (H) 25% - 80%	Actuals Expiry Date: <u>15/10/24</u> Temperature: <u>30°C</u> Humidity: <u>50%</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278556	<input checked="" type="checkbox"/>	<input type="checkbox"/>
09		Verification of safety welds	Approved according to DTD0000210658 reference and Self inspection	<input checked="" type="checkbox"/>	<input type="checkbox"/>


2024-02-01
INDUSTRIAL QUALITY MAINLINE



CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR302254872

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

II - Self Inspection - Items to Check

SEALANT APPLICATION

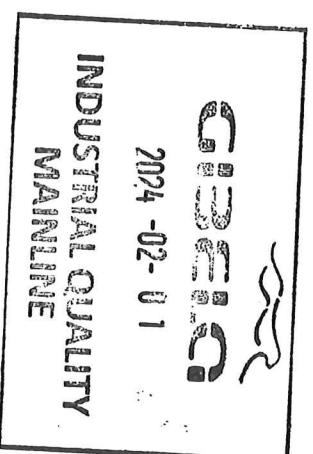
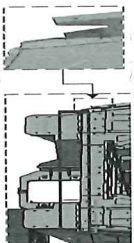
AREA 1 & 2 END 1

Operator (Name & sign):

Piscillon
open

Operator (Name & sign):

Piscillon
open



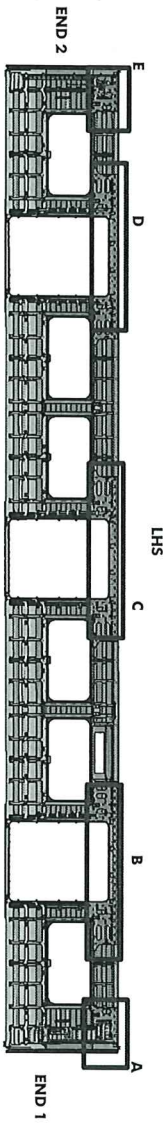
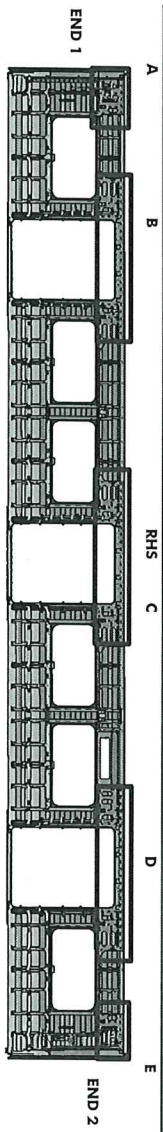


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30224547/2

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): <i>Wakungu Drian</i>	<i>Wakungu Drian</i>
B	Operator (Name&sign): <i>Wakungu Drian</i>	<i>Wakungu Drian</i>
C	Operator (Name&sign): <i>Wakungu Drian</i>	<i>Wakungu Drian</i>
D	Operator (Name&sign): <i>Wakungu Drian</i>	<i>Wakungu Drian</i>
E	Operator (Name&sign): <i>Wakungu Drian</i>	<i>Wakungu Drian</i>

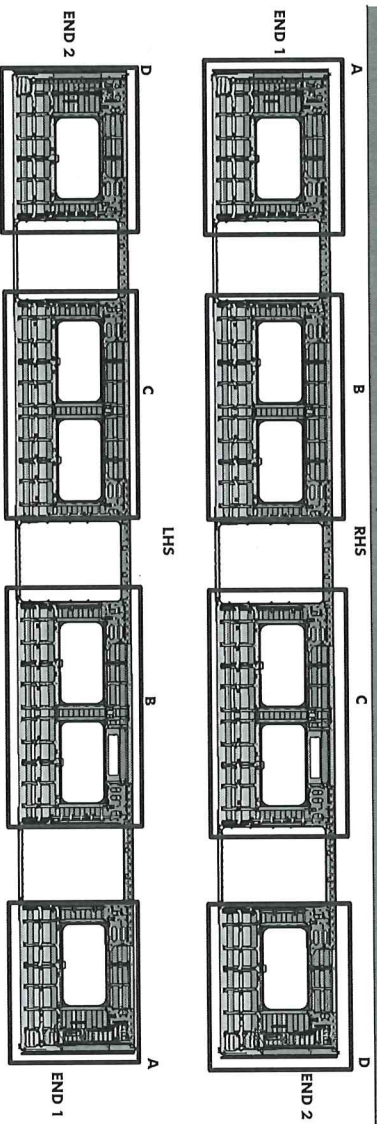
GIBELCO
2024-02-01
INDUSTRIAL QUALITY
MAINLINE



CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR3025487/2

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

II - Self Inspection - Items to Check



BRACKETING

INSTALLATION

C-RAILS:

Operator:

Levi

[Signature]

Operator:

DOOR MECHANISMS:

Operator:

Teledo

[Signature]

Operator:

TAPPING PADS

Operator:

Ant Teledo

[Signature]

Operator:

INSTALLATION & VERIFICATION

SEAT & LUGGAGE BRACKETS:

Operator:

Piscillo

[Signature]

Operator:

SEAT BRACKETS VERIFICATION:

Operator:

Piscillo

[Signature]

Operator:

WELDING

AREA

LHS

RHS

A (Seat brackets)

: Operator (Name&sign): [Signature]

[Signature]

(C-rails, Luggage and earth bushes) : Operator (Name&sign): [Signature]

[Signature]

B (Seat brackets)

: Operator (Name&sign): [Signature]

[Signature]

(C-rails, Luggage and earth bushes) : Operator (Name&sign): [Signature]

[Signature]

C (Seat brackets)

: Operator (Name&sign): [Signature]

[Signature]

(C-rails, Luggage and earth bushes) : Operator (Name&sign): [Signature]

[Signature]

D (Seat brackets)

: Operator (Name&sign): [Signature]

[Signature]

(C-rails, Luggage and earth bushes) : Operator (Name&sign): [Signature]

[Signature]

ENDS

END 1 TAPPING PADS WELDING:

Operator (Name&sign):

[Signature]

[Signature]

END 1 TAPPING PADS WELDING:

Operator (Name&sign):

[Signature]

[Signature]

2024 -02- 01

INDUSTRIAL QUALITY
MAINLINE

M1/M3/M4 BRACKET INSTALLATION



VERIFICATION BY:

VERIFICATION BY:

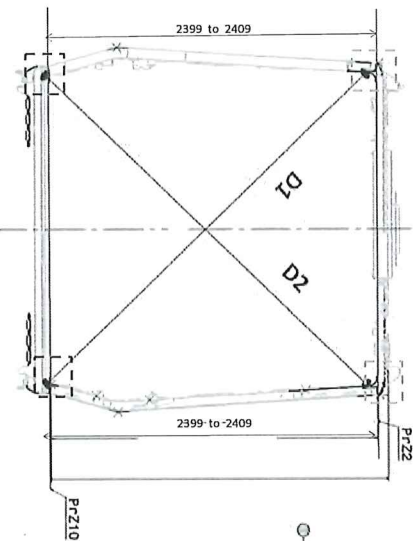
2024-02-01
INDUSTRIAL QUALITY
MAINTENANCE



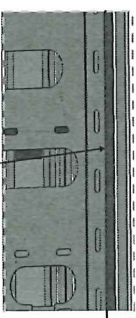
CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR302225487/2

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

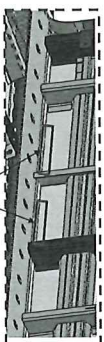
Specifications of Details for GBS measurement



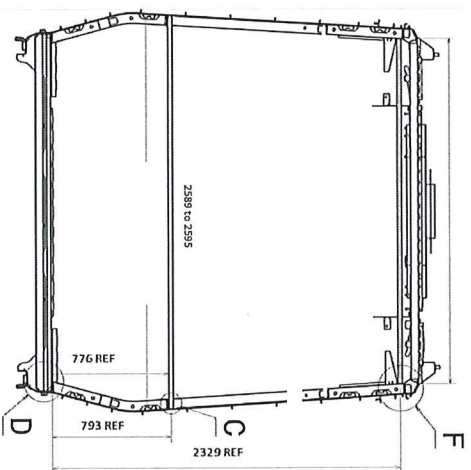
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



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2024-02-U1
INDUSTRIAL QUALITY
MAINLINE

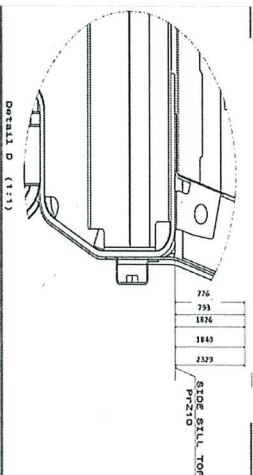
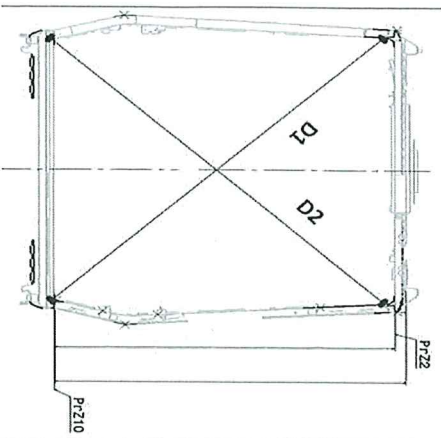
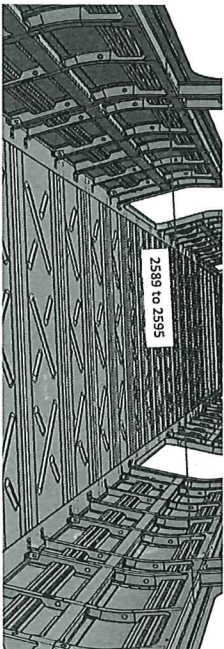
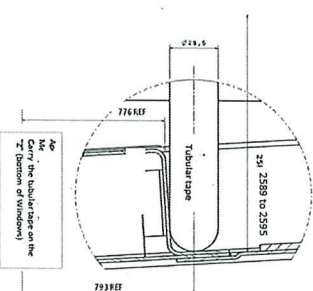
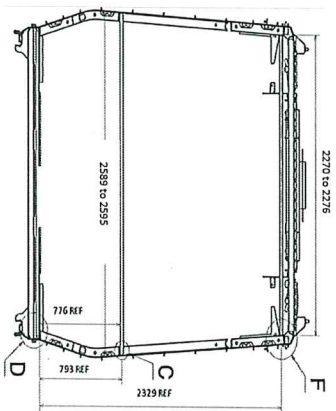


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

Rev.
29
Date
28/10/2023


Project: PRASA
SI.CB1220.250.V29

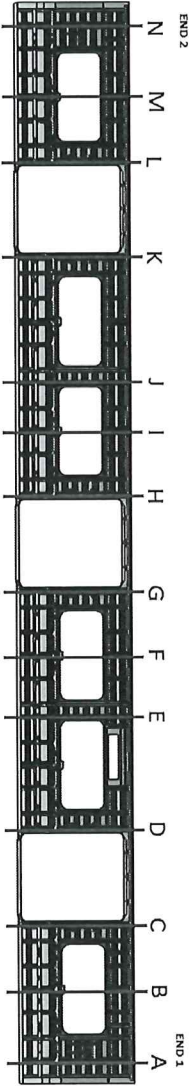
CBS measurement





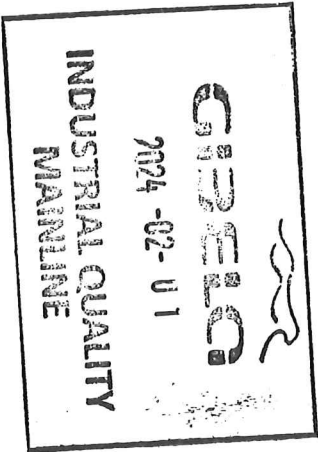
GIBELCO
2024-02-01
INDUSTRIAL QUALITY
MAINLINE

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2		Rev. 29	Project: PRASA
	CBS measurement		Date 26/10/2023	SI.CB1220.250.V29



BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3300	0	-
B	3267	3267	0	-
C	3298	3245	3	-
D	3298	3297	1	-
E	3267	3268	1	-
F	3267	3267	0	-
G	3298	3298	0	-
H	3296	3257	1	-
I	3269	3268	1	-
J	3270	3270	0	-
K	3297	3299	2	-
L	3294	3297	3	-
M	3267	3265	2	-
N	3299	3294	5	-

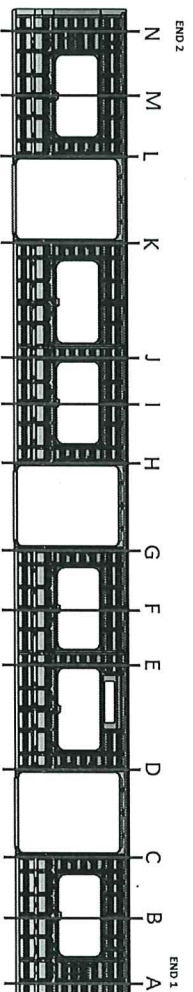




CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

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Date	
28/10/2023	SI.CB1220.250.V29

CBS measurement



AFTER WELDING

Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A 3304	3302	2	2595
B 3268	3268	0	2589
C 3297	3298	1	2589
D 3300	3296	4	2592
E 3268	3262	1	2595
F 3268	3265	3	2595
G 3300	3299	2	2595
H 3295	3295	0	2594
I 3269	3267	2	2594
J 3270	3270	0	2594
K 3299	3299	0	2593
L 3292	3292	0	2589
M 3269	3264	5	2590
N 3299	3294	5	2595

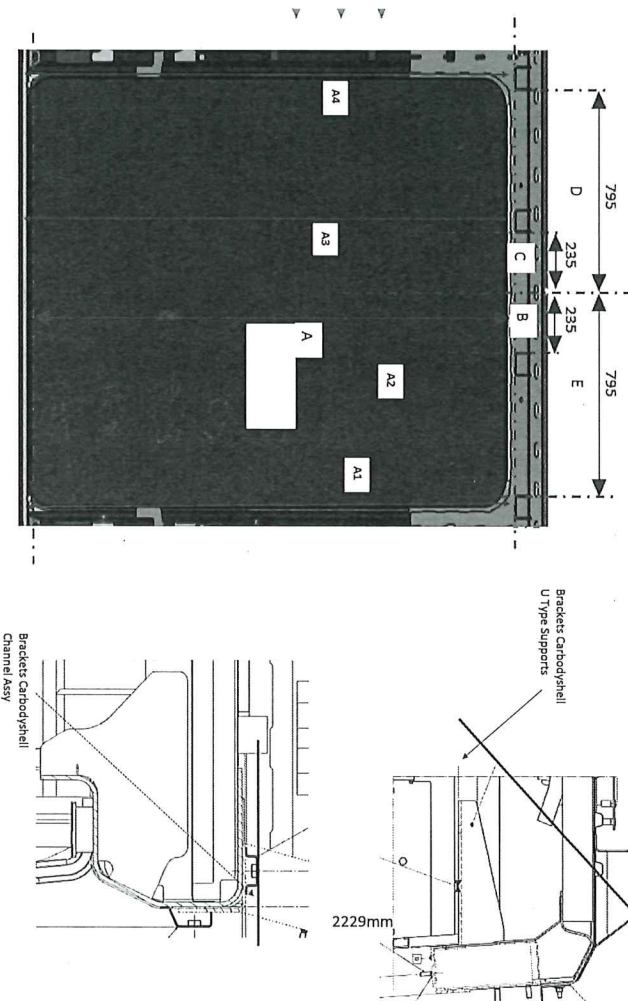

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2024-02-01
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CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

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Date	29
28/10/2023	SI.CB1220.250.V29

Specifications of Details for CBS measurement GB1220



DOOR 1 - LHS

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

DOOR 2 - LHS

VALUE	ACTUAL
A1 2230 to 2232	2234
A2 2230 to 2232	2234
A3 2230 to 2232	2234
A4 2230 to 2232	2234
B 234 to 236	234
C 234 to 236	234
D 794 to 796	794
E 794 to 796	794

DOOR 2 - LHS

VALUE	ACTUAL
A1 2230 to 2232	2233
A2 2230 to 2232	2233
A3 2230 to 2232	2233
A4 2230 to 2232	2233
B 234 to 236	235
C 234 to 236	235
D 794 to 796	794
E 794 to 796	794

DOOR 1 - RHS

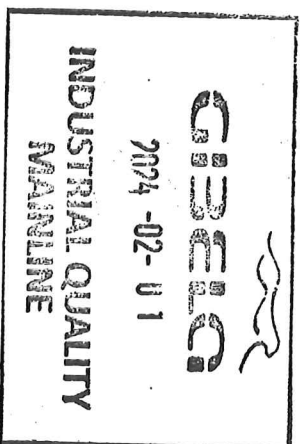
VALUE	ACTUAL
A1 2230 to 2232	2232
A2 2230 to 2232	2232
A3 2230 to 2232	2232
A4 2230 to 2232	2232
B 234 to 236	234
C 234 to 236	234
D 794 to 796	794
E 794 to 796	794

DOOR 2 - RHS

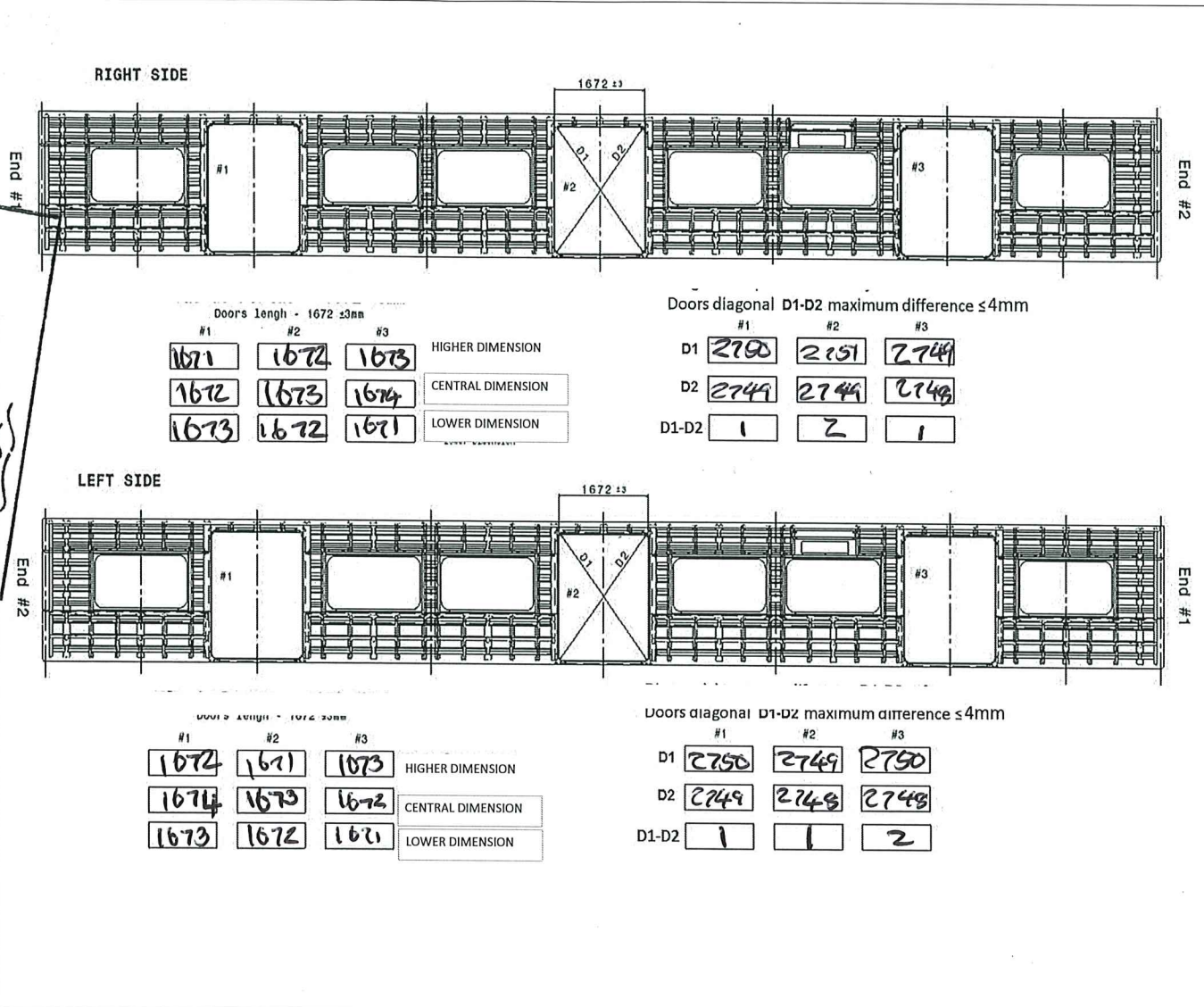
VALUE	ACTUAL
A1 2230 to 2232	2231
A2 2230 to 2232	2231
A3 2230 to 2232	2231
A4 2230 to 2232	2231
B 234 to 236	235
C 234 to 236	235
D 794 to 796	794
E 794 to 796	794

DOOR 3 - RHS

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



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 2024-02-01
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CARBODYSHELL M1,M3,M4 ASSEMBLY
 DTR30225487/2



Rev.	29
Date	28/10/2023

Project: PRASA
 SI.CB1220.250.V29

Specifications of Details for CBS measurement CB1220

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA
		29 Date 28/10/2023	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
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)	Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	21/06/24	Mthelkopsi Operations	
	NO GO	There are activities pending that impact the activities of the next process Obs: (To describe problems below)	There are non-conformities impact the quality of the product and there is no corrective action defined yet)	21/06/24	N to lead 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	

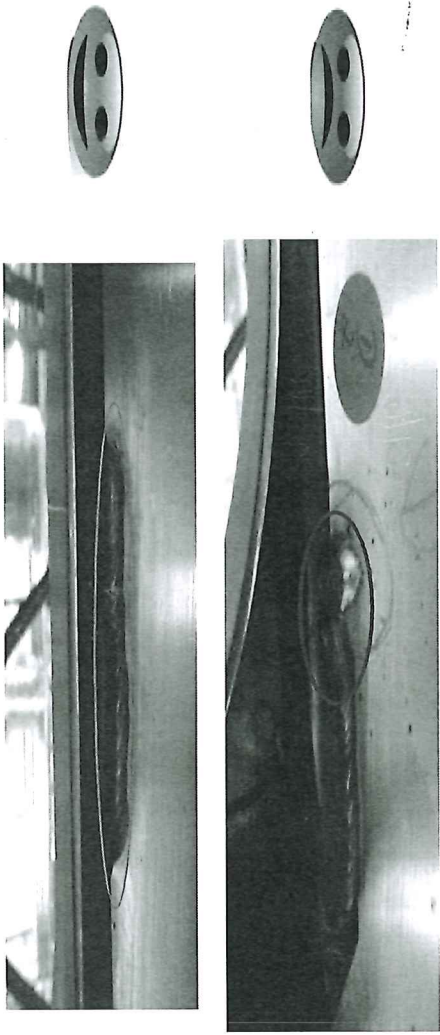
Operations

Quality



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

ANNEXURE A: 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 MSA, and treated as such.

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE					WORK INSTRUCTION	SAFETY ?
				TC1	M4	M1	M2	M3		
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<input type="checkbox"/>										
<input type="checkbox"/>										
REV	DATE	MODIFICATION CONTENT						RESPONSIBLE	NAME	DATE
0	2018/08/02	GIBELA NEW CREATION					APPROVER	Philipe Marques	2018/08/02	
							CHECKER	Nosizo Pindela	2018/08/02	
							COMPILER	Nosizo Pindela	2018/08/02	
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager					APPROVER	Itumeleng Modiba	30/5/2018	
							CHECKER	Nosizo Pindela	30/5/2018	
							REVISED BY	Nosizo Pindela	30/5/2018	
2	2018/05/07	Certain dimensional checks moved to CB1220					APPROVER	Itumeleng Modiba	2018/05/07	
							CHECKER	Nosizo Pindela	2018/05/07	
							REVISED BY	Ramokone Motama	2018/05/07	
5	24/01/2019	As per Baseline 10.2					APPROVER	Itumeleng Modiba	24/01/2019	
							CHECKER	Nosizo Pindela	24/01/2019	
							REVISED BY	Vanessa Ntuli	24/01/2019	
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements					APPROVER	Itumeleng Modiba	13/03/2019	
							CHECKER	Nosizo Pindela	13/03/2019	
							REVISED BY	Nosizo Pindela	13/03/2019	
10	23/08/2019	New Baseline 10.2.5					APPROVER	Itumeleng Modiba	23/08/2019	
							CHECKER	Nosizo Pindela	23/08/2019	
							REVISED BY	Nosizo Pindela	23/08/2019	
15	06/08/2020	New Baseline 10.2.6					APPROVER	Timothy Maimela	06/08/2020	
							CHECKER	Bongane Masina		
							REVISED BY	Bongane Masina		
20	19/04/2021	New Baseline change 10.3					APPROVER	Timothy Maimela		
							CHECKER	Bongane Masina	19/04/2021	
							REVISED BY	Bongane Masina		
25	20/02/2022	New Baseline change 10.3.1					APPROVER	Collins Mkhombhi		
							CHECKER	Ardani Muthelo	20/02/2022	
							REVISED BY	Ardani Muthelo		
26	14/06/2022	Update minimum temperature requirement for sealant application					APPROVER	Collins Mkhombhi		
							CHECKER	Ardani Muthelo	14/06/2022	
							REVISED BY	Ardani Muthelo		
27	19/10/2022	Addition of traceability for sealant application					APPROVER	Collins Mkhombhi		
							CHECKER	Ntokozo Zwane	19/10/2022	
							REVISED BY	Amogelang Mhlappe		
28	14/04/2023	Added sealant batch number & welding consumables traceability					APPROVER	Vanessa Ntuli		
							CHECKER	Ntokozo Zwane	14/04/2023	
							REVISED BY	Amogelang Mhlappe		
29	06/11/2023	Added thresholds traceability for boiler makers and welders					APPROVER	Tyson Ngobeni		
							CHECKER	Ardani Muthelo	06/11/2023	
							REVISED BY	Ntokozo Zwane		
TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE		SELF INSPECTION NUMBER				PAGES	
213	M01	Sinité 426955	22/02/24		SI.CB1230.256.V28				11	

2024 -02- 01

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CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev. 29
Date 06/11/2023
Project: PRASA
SI.CB1230.256.V28

Car:

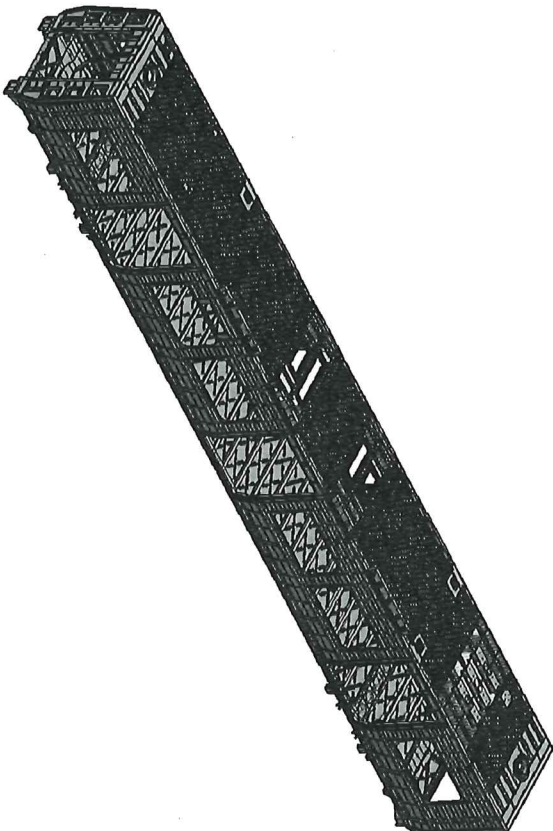
NCR:

Work station:

CB1230



Safety Related



I - Documentation and Instruments Control

1.1 - Documentation Control

Document	Type of car					Revision	Observation	OK	NOK	Removal	Signature/Date (Operations)	Signature/Date (Quality)
	M	N	W	M	GL							
PRA.CB1230.DT00000225487	X					29		OK		N/A	8/22/02/24	29/02/24

1.2 - 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)
T-Jouler	2273-1	29/11/24	OK		8/22/02/24	29/02/24
Measuring Tape	GIBTR0394	05/04/24	OK		8/22/02/24	29/02/24
Combination Square	GIBCS037	06/06/24	OK		8/22/02/24	29/02/24










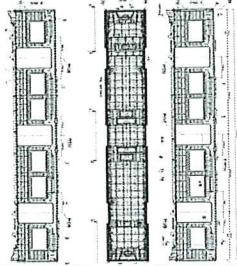









1.3 Consumables

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		8/22/02/24	29/02/24
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II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOK	Rework	Signature/Date (Operations)	Signature/Date (Quality)						
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	OK			22/02/24 	22/02/24 						
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	OK			22/02/24 	22/02/24 						
	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	OK			22/02/24 	22/02/24 						
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	OK			22/02/24 	22/02/24 						
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	OK			22/02/24 	22/02/24 						
		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 is in the mainline DTD0000210658				22/02/24 	22/02/24 						
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: <table><tr><td>Temperature Min - Max (1)</td><td>Min-Max</td><td>10°C - 35°C</td></tr><tr><td>Relative humidity Min - Max (1)</td><td>Min-Max</td><td>25% - 80%</td></tr></table>	Temperature Min - Max (1)	Min-Max	10°C - 35°C	Relative humidity Min - Max (1)	Min-Max	25% - 80%	Sealant Batch No: 15270-30 Exp Date: 05 / 24 Actuals Temperature: 17°C Humidity: 50%	OK			22/02/24 	22/02/24 
Temperature Min - Max (1)	Min-Max	10°C - 35°C												
Relative humidity Min - Max (1)	Min-Max	25% - 80%												
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.	OK			22/02/24 	22/02/24 						

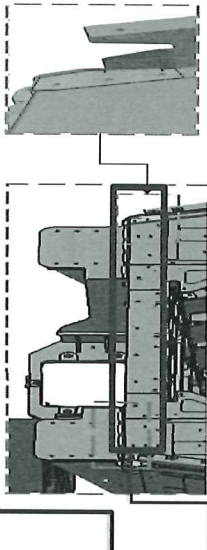


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AREA 1



OPERATOR
(Name & sign):

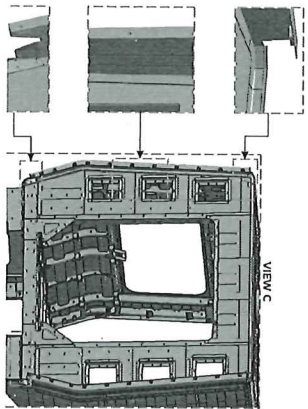
LEEDY

OPERATOR
(Name & sign):

LEEDY

OPERATOR
(Name & sign):

LEEDY



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

RHS
D,E,F, G, H, I

Operator (Name & sign): Iserudo

Iserudo

Operator (Name & sign):

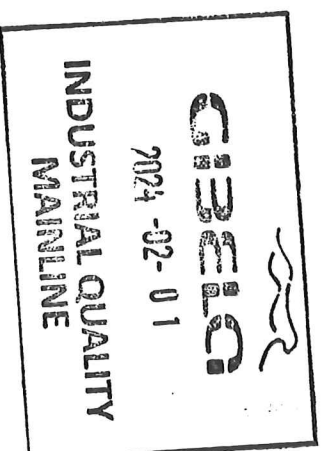
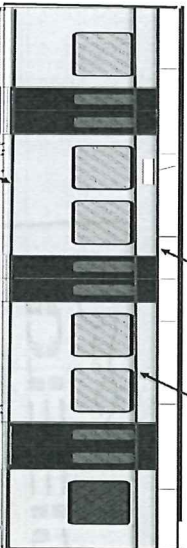
Operator (Name & sign): Smit

Smit

Operator (Name & sign):

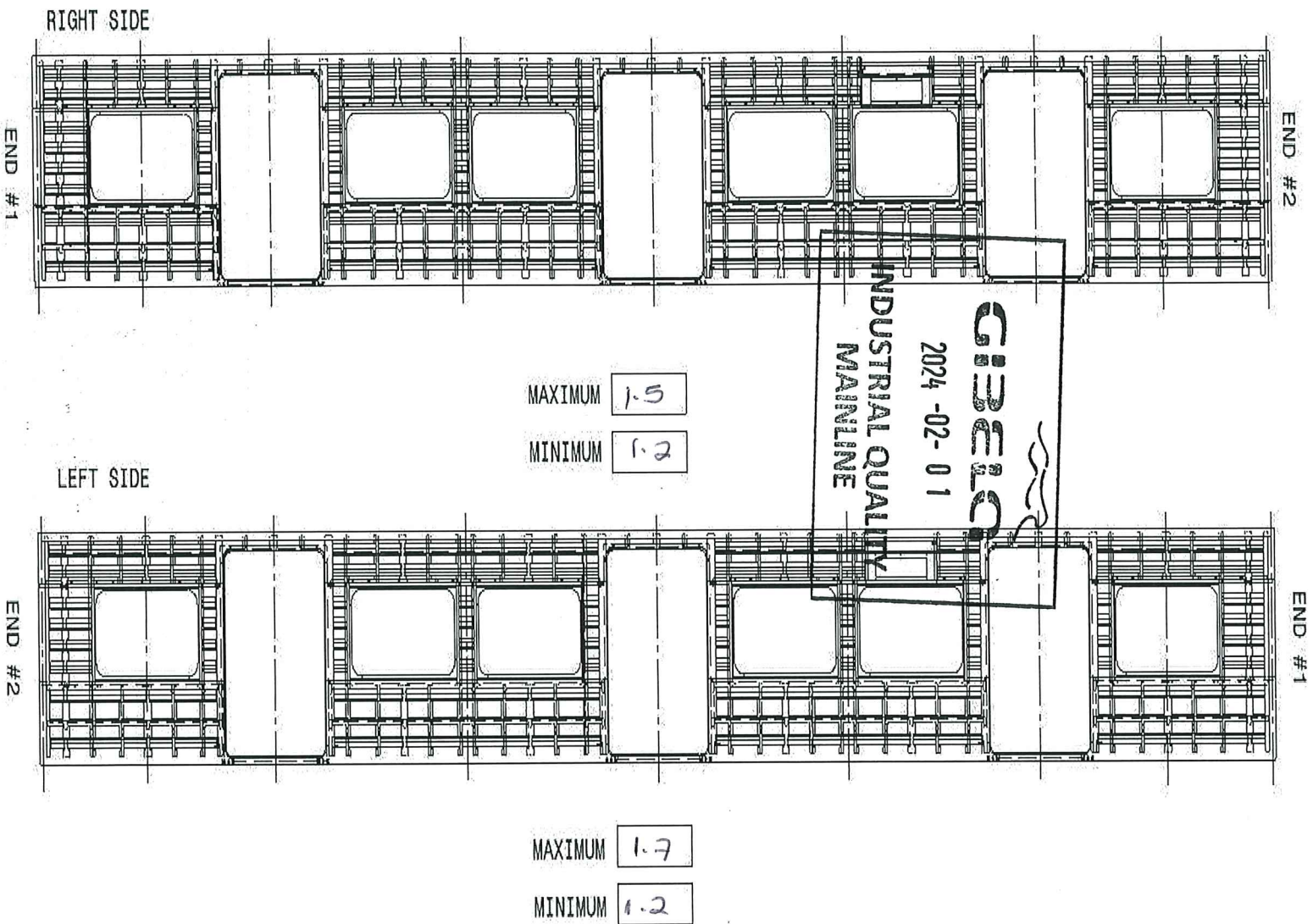
Operator (Name & sign):

H



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.





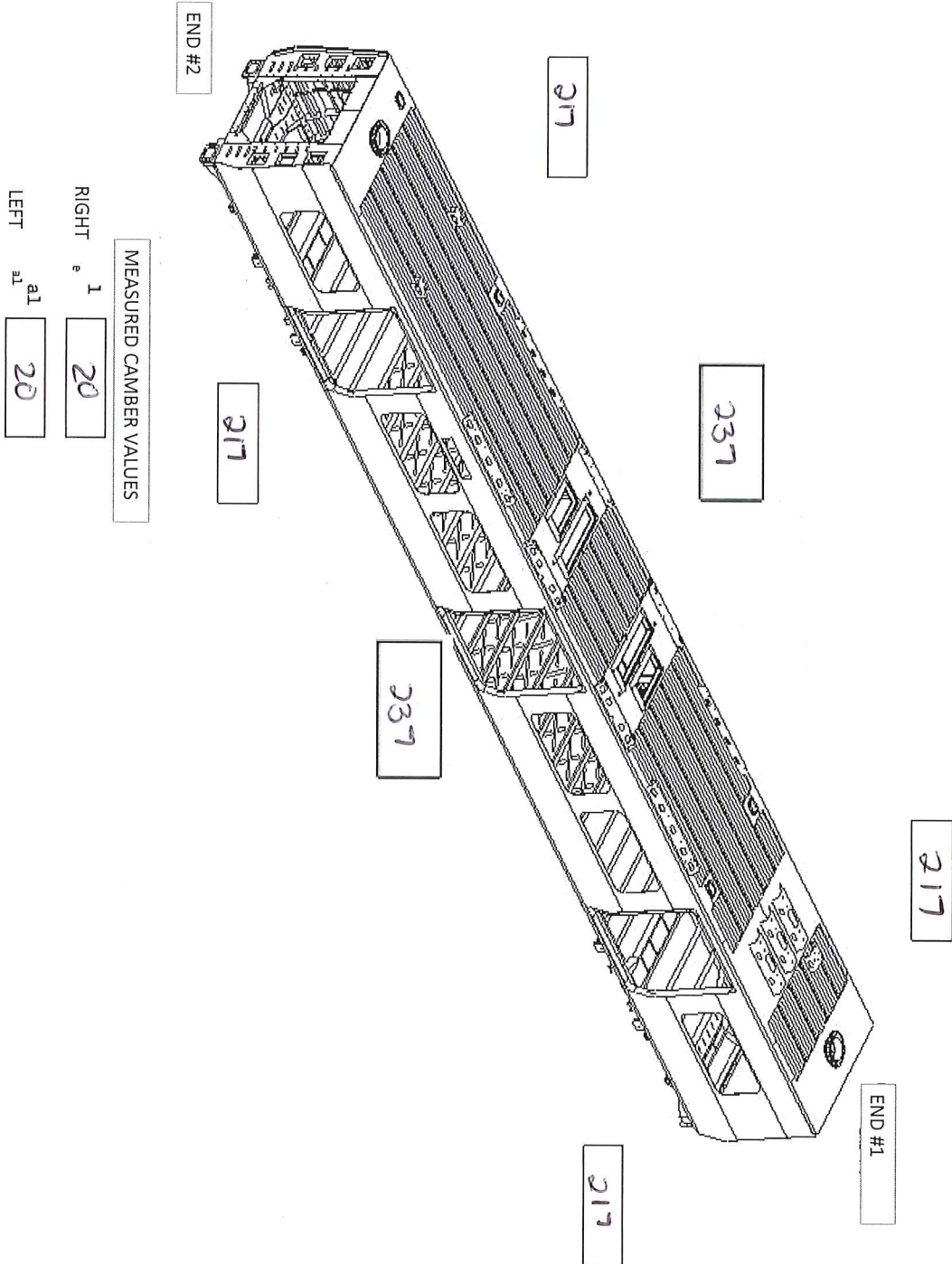
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Specifications of Details for GBS measurement CB1230

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





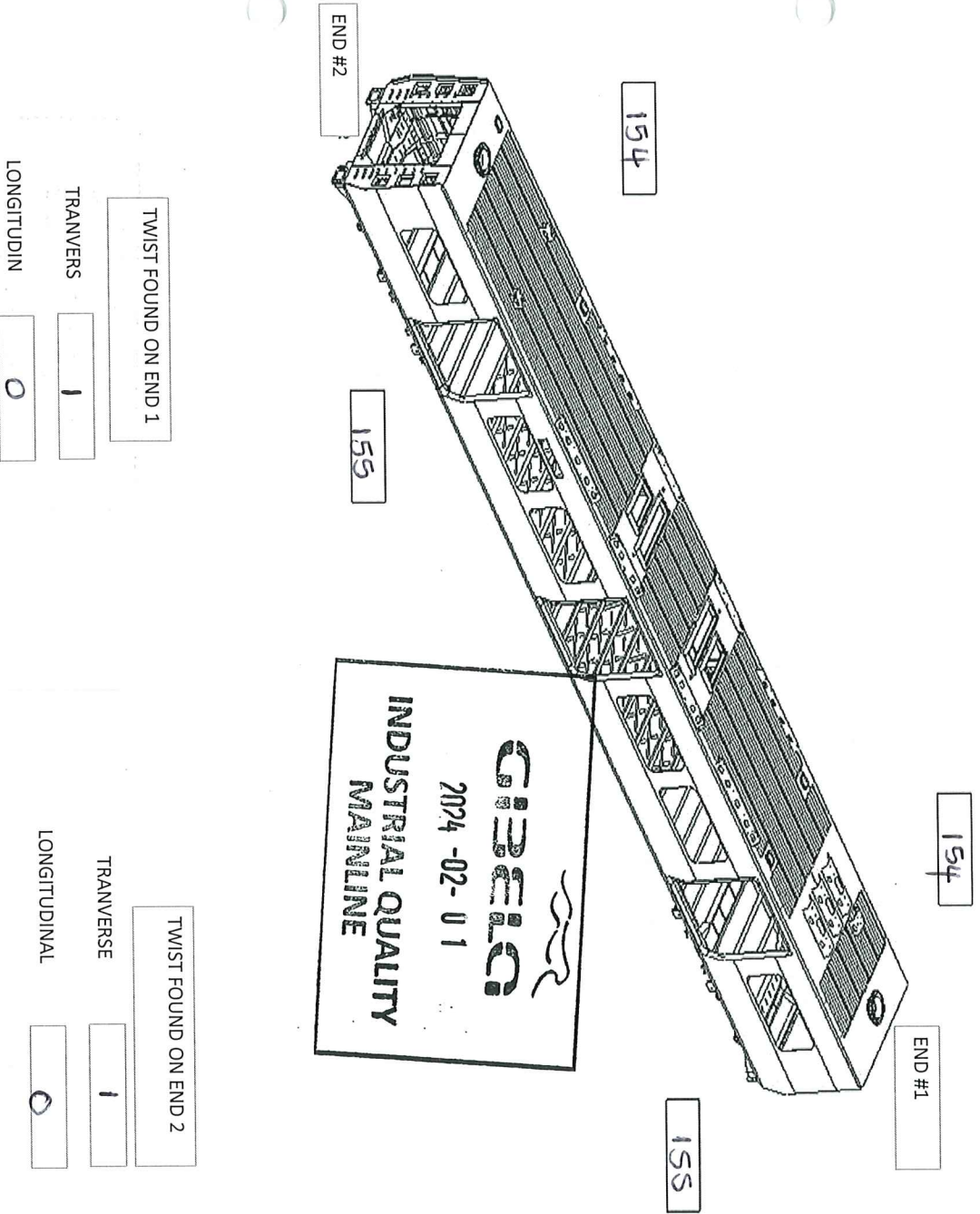
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Rev.	29
Date	06/11/2023

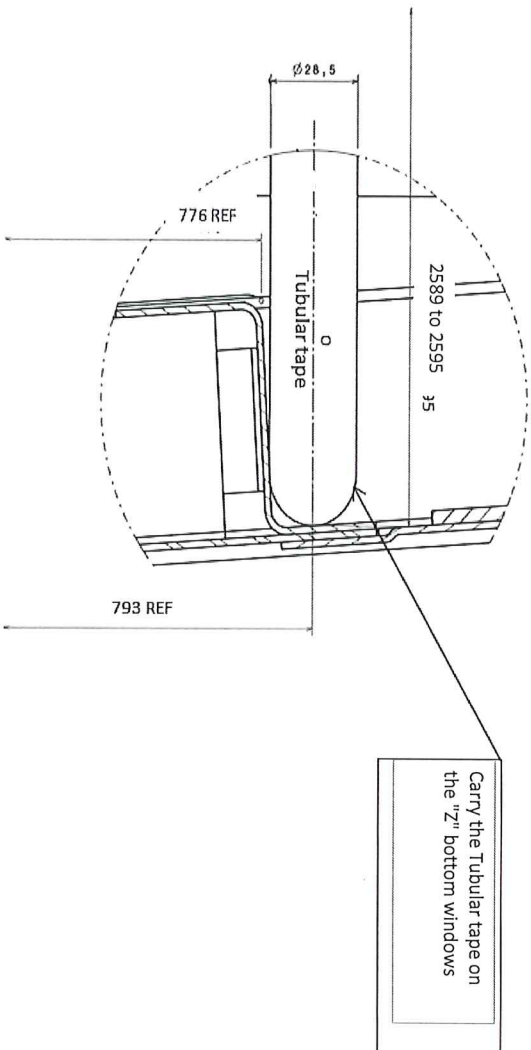
Project: **PRASA**
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Specifications of Details for CBS measurement CB1230

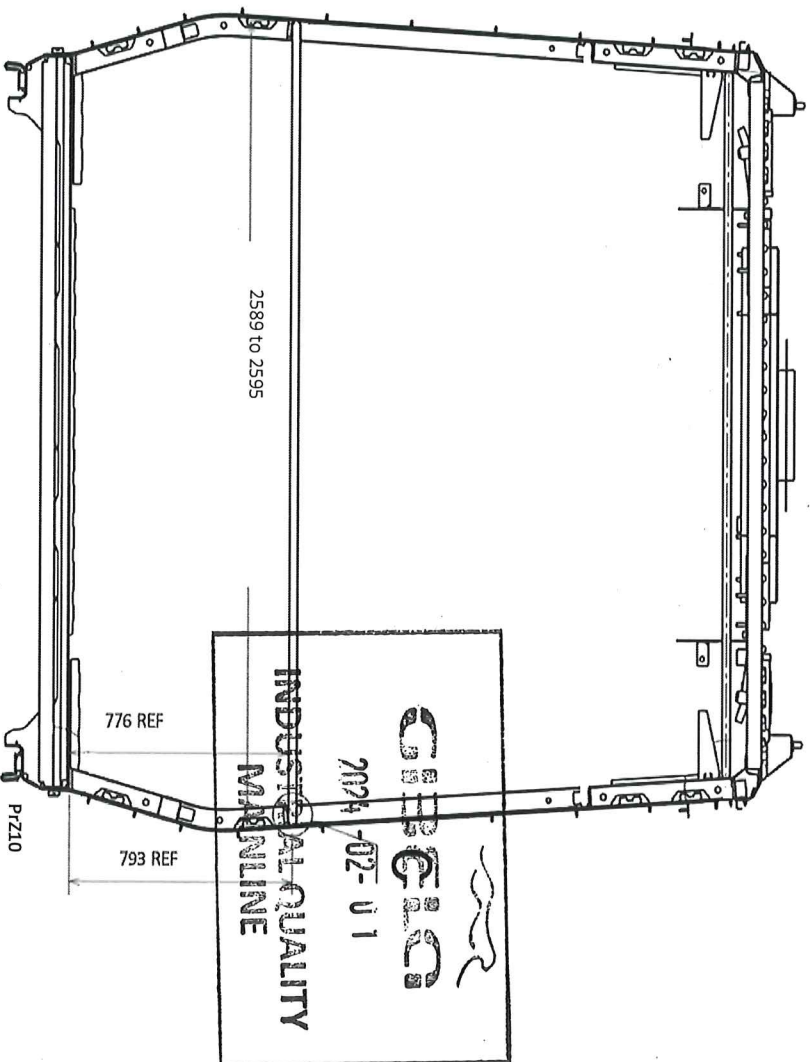
Twist measured in transversal and longitudinal = Maximum 3mm. Measure twist on air spring plates (LHS and RHS), both End 1 and End 2 following twist measurement document.



Specifications of Details for CBS measurement CB1230



Detail C



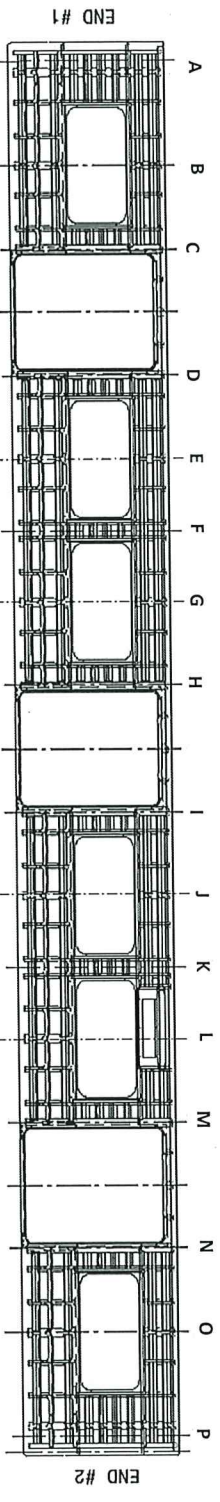


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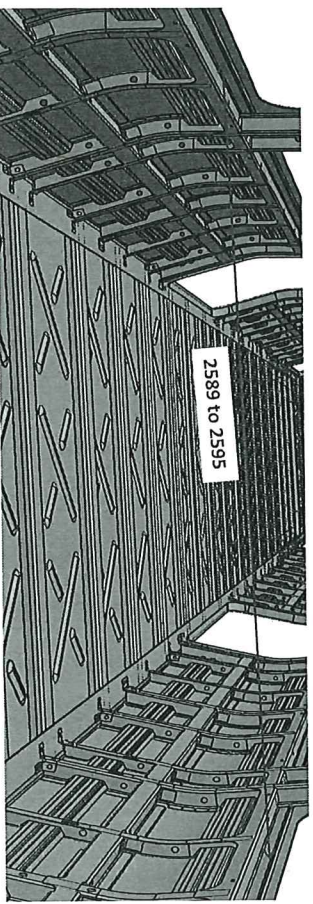
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Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	3590
B	3592
C	3591
D	3589
E	3590
F	3592
G	3593
H	3593
I	3594
J	3595
K	3590
L	3591
M	3591
N	3593
O	3592
P	3590




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Threshold verification

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

BOILER MAKER: Tenorio

WELDER: Zenele

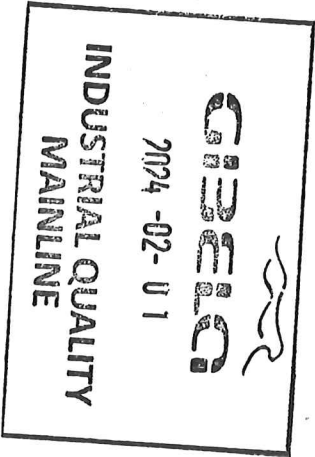
	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev.	Project: PRASA SI.CB1230.256.V28
		29	
		Date	06/11/2023

Dye penetrant test

Dye-penetration test to be performed by quality personnel



Specifications of Details for CBS measurement				
Item	Description of the issue	OK	Signature/Date (Operations)	Signature/Date (Quality)





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Self Inspection - Final Result

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

DATE

NAME

SIGNATURE

GO

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

22/02/24

Sive

Operations

NO GO

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

22/02/24

Two

Industrial Quality

There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)

Operations

Industrial Quality

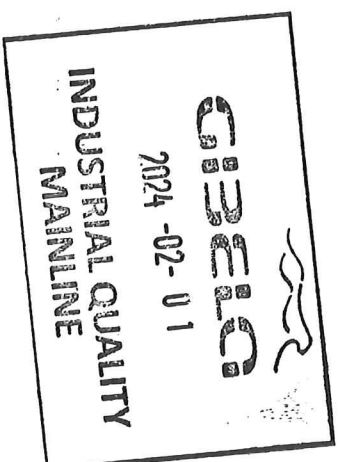
In case of "NO GO", describe blocking problems


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

Item	Description	Responsible	Due date	Status

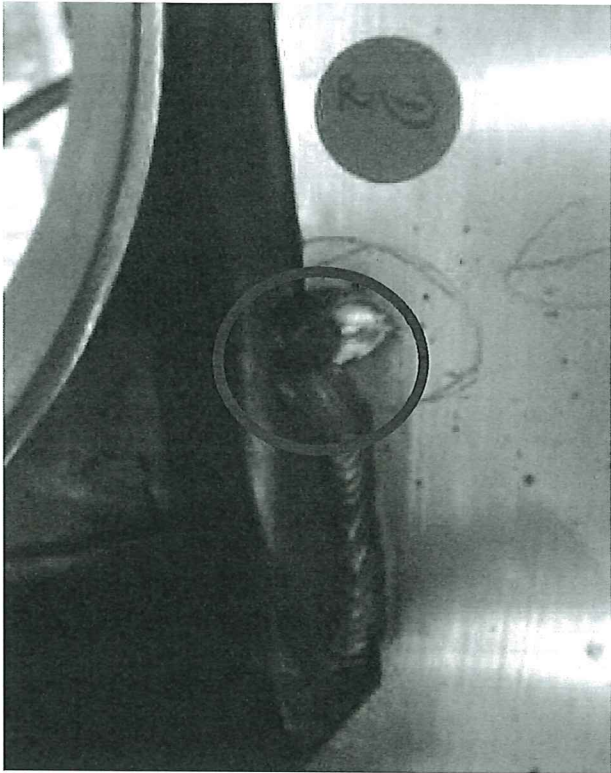
Operations

Quality



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			Date 06/11/2023	

ANNEXURE A: Arc Welding Quality Acceptance Standard





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