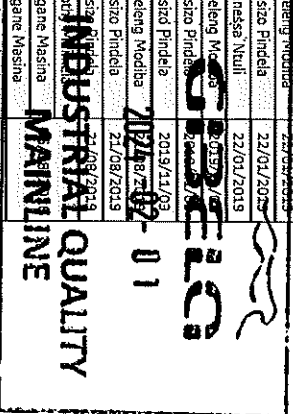
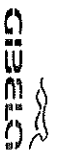


**CONFIDENTIAL INFORMATION**  
This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

| APPLICATION REFERENCE |               |   |             |                        |            |    |    |    |                  |                                   |     |
|-----------------------|---------------|---|-------------|------------------------|------------|----|----|----|------------------|-----------------------------------|-----|
| MOUNTING              | DRAWING       | DESCRIPTION   | STATION     | CAR TYPE               |            |    |    |    | WORK INSTRUCTION | SAFETY ?                          |     |
|                       |               |   |             | TC1                    | M4         | M1 | M2 | M3 |                  |                                   | TC2 |
| 07R30223319/3         | ADD0001244023 | Catchall Assembly TC  | CB2210      | X                      |            |    |    |    |                  | PRA/CB2210.07R3022331<br>9/3. V25 | YES |
| REV                   | DATE          | MODIFICATION CONTENT  | RESPONSIBLE | NAME                   | DATE       |    |    |    |                  |                                   |     |
| 0                     | 09/04/2018    | GIBELA NEW CREATION   | APPROVER    | Iumeleg Modiba         | 09/04/2018 |    |    |    |                  |                                   |     |
|                       |               |   | CHECKER     | Nosizo Pindela         | 09/04/2018 |    |    |    |                  |                                   |     |
|                       |               |   | COMPILER    | Thanyani Mathegu       | 06/04/2018 |    |    |    |                  |                                   |     |
| 1                     | 2018/05/18    | Team leader and Quality Technician to sign Change final signature from PWE Manager to Quality manager | APPROVER    | Iumeleg Modiba         | 2018/05/18 |    |    |    |                  |                                   |     |
|                       |               |   | CHECKER     | Nosizo Pindela         | 2018/05/18 |    |    |    |                  |                                   |     |
|                       |               |   | REVISED BY  | Ramokone Motama        | 2018/05/18 |    |    |    |                  |                                   |     |
| 2                     | 2018/06/18    | MODIFICATION CONTENT  | APPROVER    | Iumeleg Modiba         | 2018/06/18 |    |    |    |                  |                                   |     |
|                       |               |   | CHECKER     | Nosizo Pindela         | 2018/06/18 |    |    |    |                  |                                   |     |
|                       |               |   | REVISED BY  | Ramokone Motama        | 2018/06/18 |    |    |    |                  |                                   |     |
| 3                     | 2018/12/12    | Additional checkpoints  | APPROVER    | Iumeleg Modiba         | 2018/12/12 |    |    |    |                  |                                   |     |
|                       |               |   | CHECKER     | Nosizo Pindela         | 2018/12/12 |    |    |    |                  |                                   |     |
|                       |               |   | REVISED BY  | Ramokone Motama        | 2018/12/12 |    |    |    |                  |                                   |     |
| 5                     | 22/01/2019    | As per Baseline 10.2  | APPROVER    | Iumeleg Modiba         | 22/01/2019 |    |    |    |                  |                                   |     |
|                       |               |   | CHECKER     | Nosizo Pindela         | 22/01/2019 |    |    |    |                  |                                   |     |
|                       |               |   | REVISED BY  | Vanessa Ntuli          | 22/01/2019 |    |    |    |                  |                                   |     |
| 6                     | 2019/11/03    | Record D1 and D2 on Self-Inspection   | APPROVER    | Iumeleg Modiba         | 2019/11/03 |    |    |    |                  |                                   |     |
|                       |               |   | CHECKER     | Nosizo Pindela         | 2019/11/03 |    |    |    |                  |                                   |     |
|                       |               |   | REVISED BY  | Nosizo Pindela         | 2019/11/03 |    |    |    |                  |                                   |     |
| 10                    | 21/08/2019    | New Baseline 10.2.5   | APPROVER    | Iumeleg Modiba         | 21/08/2019 |    |    |    |                  |                                   |     |
|                       |               |   | CHECKER     | Nosizo Pindela         | 21/08/2019 |    |    |    |                  |                                   |     |
|                       |               |   | REVISED BY  | Nosizo Pindela         | 21/08/2019 |    |    |    |                  |                                   |     |
| 15                    | 06/08/2020    | New Baseline 10.2.6   | APPROVER    | Timothy Maimela        | 06/08/2020 |    |    |    |                  |                                   |     |
|                       |               |   | CHECKER     | Bongane Masina         | 06/08/2020 |    |    |    |                  |                                   |     |
|                       |               |   | REVISED BY  | Bongane Masina         | 06/08/2020 |    |    |    |                  |                                   |     |
| 20                    | 19/04/2020    | New Baseline change 10.3  | APPROVER    | Mkhombi Collins        | 19/04/2021 |    |    |    |                  |                                   |     |
|                       |               |   | CHECKER     | Mpho Mulaudzi          | 17/08/2021 |    |    |    |                  |                                   |     |
|                       |               |   | REVISED BY  | Mpho Mulaudzi          | 17/08/2021 |    |    |    |                  |                                   |     |
| 21                    | 17/08/2021    | ADDED DIMENSIONS BEFORE WELDING   | APPROVER    | Mkhombi Collins        | 17/08/2021 |    |    |    |                  |                                   |     |
|                       |               |   | CHECKER     | Andani Muthelo         | 21/02/2022 |    |    |    |                  |                                   |     |
|                       |               |   | REVISED BY  | Andani Muthelo         | 21/02/2022 |    |    |    |                  |                                   |     |
| 25                    | 21/02/2022    | New Baseline change 10.3.1  | APPROVER    | Ntuli Vanessa          | 21/02/2022 |    |    |    |                  |                                   |     |
|                       |               |   | CHECKER     | Mohlame Amogelang      | 14/04/2023 |    |    |    |                  |                                   |     |
|                       |               |   | REVISED BY  | Mohlame Amogelang      | 14/04/2023 |    |    |    |                  |                                   |     |
| 26                    | 14/04/2023    | Addition of welding consumable traceability   | APPROVER    | Ngobeni Tyson          | 27/07/2023 |    |    |    |                  |                                   |     |
|                       |               |   | CHECKER     | Matsipo Keetone        | 27/07/2023 |    |    |    |                  |                                   |     |
|                       |               |   | REVISED BY  | Mohlame Amogelang      | 27/07/2023 |    |    |    |                  |                                   |     |
| 27                    | 27/07/2023    | Added verification of loaded parts  | APPROVER    | Ngobeni Tyson          | 07/11/2023 |    |    |    |                  |                                   |     |
|                       |               |   | CHECKER     | Andani Muthelo         | 07/11/2023 |    |    |    |                  |                                   |     |
|                       |               |   | REVISED BY  | Ntoko Zwane            | 07/11/2023 |    |    |    |                  |                                   |     |
| TRAINSET              | CAR           | OPERATOR NAME & ALPS NUMBER   | DATE        | SELF INSPECTION NUMBER | PAGES      |    |    |    |                  |                                   |     |
| 215                   | 1002          | 100604 1271497  | 21/02/24    | SI.CB2210.322.V28      | 16         |    |    |    |                  |                                   |     |





DTR3022319/3 Carshell Assembly TC

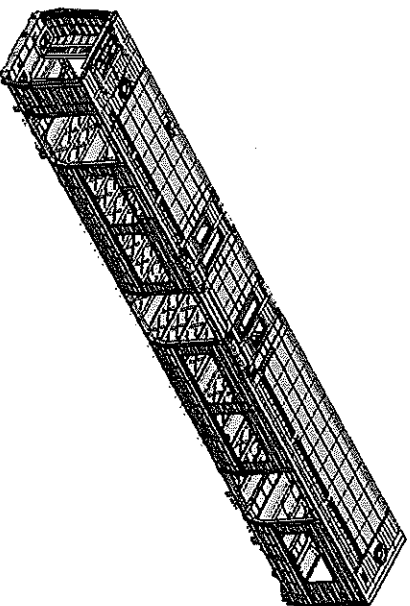
Rev. V28  
Date: 07/11/2023  
Project: PRASA  
SI.CB2210.322.V28

Car: TC1 & TC2

NOTE:

Work station:

CB2270



### I - Documentation and Instruments

#### I.1 - Documentation Control

| Document     | Type of car |    |    |    |     | Revision | Observation | OK | Signature/Date (Manufacturing) | Signature/Date (Quality) |
|--------------|-------------|----|----|----|-----|----------|-------------|----|--------------------------------|--------------------------|
|              | TC1         | 1W | 2W | 3W | CT1 |          |             |    |                                |                          |
| DTR3022319/3 |             |    |    |    | X   | 146      |             | ✓  | N/A                            | <i>[Signature]</i>       |

#### I.2 - Instruments Control

| Monitoring and Measuring Instrument Control - Used for Special Process |            |  |   |  |    |
|--|------------|--|---|--|----|
| Instruments  | Validation |  | Calibration or Verification Validation Date |  | OK |
| TURULIN  | 22715      |  | 04/10/23                                    |  | ✓  |
| 35M TAP  | 6157P 0084 |  | 23/05/31                                    |  | ✓  |
| CASED TAP  | 125425924  |  | 08/01/24                                    |  | ✓  |
|  |            |  |   |  |    |
|  |            |  |   |  |    |

#### 1.3 Consumables

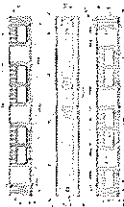

| Welding Consumable Control - Used for Special Process |             |                 |  |    |                                |
|---|-------------|-----------------|--|----|--------------------------------|
| File Material   | Heat Number | Welding Process |  | OK | Signature/Date (Manufacturing) |
| 4UT720 308LSI   | E20980      | MIG             |  | ✓  | <i>[Signature]</i> 21/07/24    |
| ER 309 LSI  | 318392      | MIG             |  |    | <i>[Signature]</i> 21/07/24    |
|   |             |                 |  |    |                                |
|   |             |                 |  |    |                                |
|   |             |                 |  |    |                                |
|   |             |                 |  |    |                                |

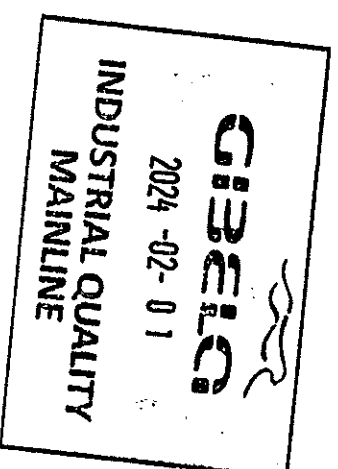


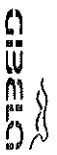
GIBELCO

2024 -02- U 1

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| GIBELCO |   | DTR3022319/3 Carshell Assembly TC   |   | Rev. V28<br>Date- 07/11/2023 |                                | Project: PRASA<br>SI-CB2210.322.V28 |  |
|---------|---|---|---|------------------------------|--------------------------------|-------------------------------------|--|
| Item    | Picture/Drawing   | Description   | Acceptance criteria / Record                                | OK                           | Signature/Date (Manufacturing) | Signature/Date (Quality)            |  |
| 01      | N/A   | Verification of correct parts loaded (Sidewalls, Endframes, Roof and Underframe)  | DTD00000284980  | ✓                            | 21/02/24                       | 21/02/24                            |  |
| 02      | N/A   | Carshell free of significant flaws which compromise the appearance or functionality.  | DTD00000210675  | ✓                            | 21/02/24                       | 21/02/24                            |  |
| 03      |  | Functional dimensions approved according drawing or complementary document approved by Abtom engineering and registered in this document.   | Approved according specified on pages below.                | ✓                            | 21/02/24                       | 21/02/24                            |  |
| 04      | REFER TO ANNEXURE A   | Spot Welding inspected and approved according procedure   | IND-SAL-WMS-016 e<br>DTD00000210675                         | ✓                            | 21/02/24                       | 21/02/24                            |  |
| 05      | REFER TO ANNEXURE B   | Arc Welding inspected and approved according procedure.   | IND-SAL-WMS-016<br>REFER TO GIB - TYPEDEF -<br>ARC - 0000   | ✓                            | 21/02/24                       | 21/02/24                            |  |
| 06      |  | Cleaning of all Stainless Steel Surface   | According TO GIB-WEL -<br>PROC-0002                         | ✓                            | 21/02/24                       | 21/02/24                            |  |
| 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. | As the welding procedure IND-SAL-WMS-018 and DTD00000210658 | ✓                            | 21/02/24                       | 21/02/24                            |  |



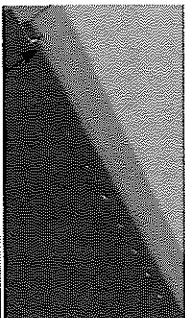


DTR3022319/3 Carshell Assembly TC

Rev. V28  
Project: PRASA  
Date- 07/11/2023  
SI.CB2210.322.V28

### Welder traceability

Roof ring welds

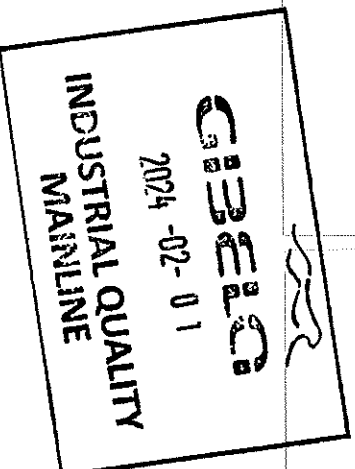



|   |     |   |     |
|---|-----|---|-----|
| Boiler maker (Name & Sign): <u>Wagon #1</u> <u>20/02/24</u> | LHS | Welder (Name & Sign): <u>Wagon #1</u> <u>20/02/24</u> | RHS |
| Boiler maker (Name & Sign): <u>Wagon #1</u> <u>20/02/24</u> | RHS | Welder (Name & Sign): <u>Wagon #1</u> <u>20/02/24</u> | RHS |

|   |     |   |     |
|---|-----|---|-----|
| Boiler maker (Name & Sign): <u>Wagon #1</u> <u>20/02/24</u> | LHS | Welder (Name & Sign): <u>Wagon #1</u> <u>20/02/24</u> | LHS |
| Boiler maker (Name & Sign): <u>Wagon #1</u> <u>20/02/24</u> | RHS | Welder (Name & Sign): <u>Wagon #1</u> <u>20/02/24</u> | RHS |

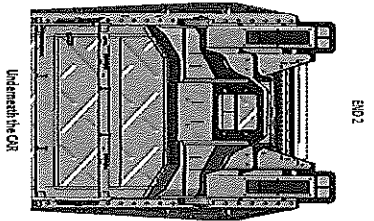
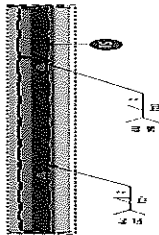


|   |     |   |     |
|---|-----|---|-----|
| Boiler maker (Name & Sign): <u>Wagon #1</u> <u>20/02/24</u> | LHS | Boiler maker (Name & Sign): <u>Wagon #1</u> <u>20/02/24</u> | RHS |
| Welder (Name & Sign): <u>Wagon #1</u> <u>20/02/24</u>       | LHS | Welder (Name & Sign): <u>Wagon #1</u> <u>20/02/24</u>       | RHS |



|  |                                    |                     |                                     |
|--|------------------------------------|---------------------|-------------------------------------|
| <br><b>GIBECO</b> | DTR30223319/3 Carshell Assembly TC | Rev.<br>V28         | Project: PRASA<br>SI.CB2210.322.V28 |
|  |                                    | Date-<br>07/11/2023 |                                     |

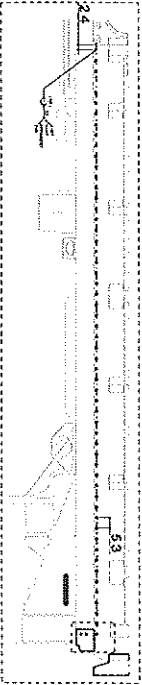
EUF Reinforcement Plates



END 2


Boiler maker (Name & Sign): Laurence Mlqye

Welder (Name & Sign): Mthokozisi



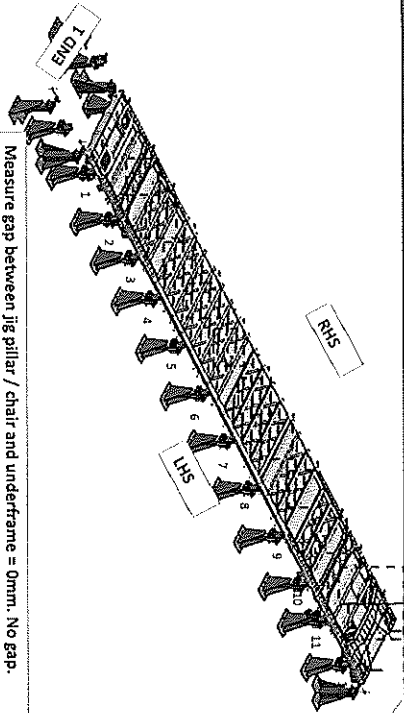
FEDOU

Operator: Laurence Mlqye



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2024-02-01  
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Specifications of Details for CBS measurement



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

Fill in the gap foundon each jig pillars / chair and underframe should be 0mm.

After Loading Underframe and Lamping.

|                 |   |   |   |   |   |   |   |   |   |    |    |    |
|-----------------|---|---|---|---|---|---|---|---|---|----|----|----|
|                 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 |
| Left Hand Side  |   |   |   |   |   |   |   |   |   |    |    |    |
| Right Hand Side |   |   |   |   |   |   |   |   |   |    |    |    |

Signature Operators:  Date: 21/02/24

After Welding.

|                 |   |   |   |   |   |   |   |   |   |    |    |    |
|-----------------|---|---|---|---|---|---|---|---|---|----|----|----|
|                 | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 |
| Left Hand Side  |   |   |   |   |   |   |   |   |   |    |    |    |
| Right Hand Side |   |   |   |   |   |   |   |   |   |    |    |    |

Signature Industrial Quality:  Date:

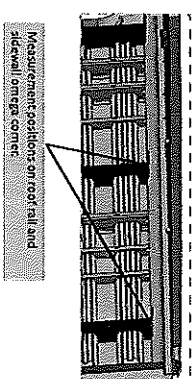
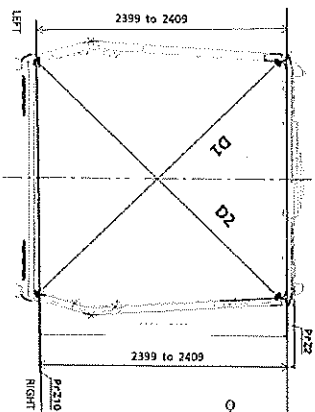
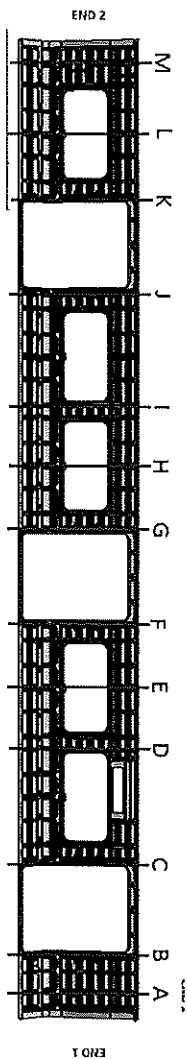


DTR3022331913 Carshell Assembly TC

Rev. V28  
Project: PRA5A

Date- 07/1/2023  
SI.CB2210.322 V28

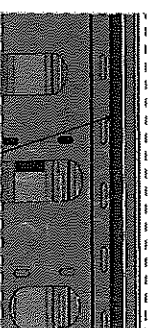
Specifications of Details for CB5 measurement



Measurement points on roof ridge and side wall corner.

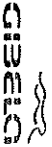


Measurement points on side wall and side wall corner.

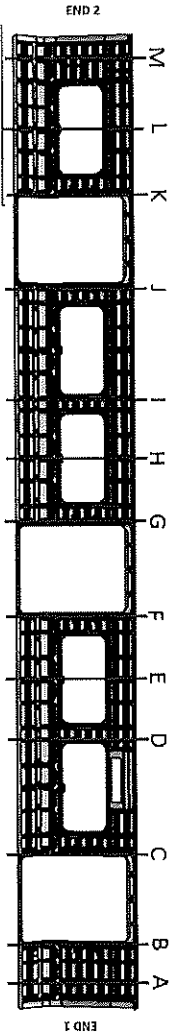


Reinforcement area measurement points on roof reinforcement area.

**CIBEC**  
2024 -02- 01  
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|   |                                   |  |                                     |
|---|-----------------------------------|--|-------------------------------------|
|  | Rev. V28<br>Date: 07/11/2023      |  | Project: PRASA<br>51.CB2210.322.V28 |
|   | DTR3022319/3 Carshell Assembly TC |  |                                     |
| Specifications of Details for CBS measurement                                       |                                   |  |                                     |

BEFORE WELDING



PMI: The difference in Height values measured on the LHS and RHS should be ≤ 2MM on each point.

|   | Record D1 values | Record D2 values | D1-D2 ≤ 5mm | 2399 to 2409 | 2399 to 2409 (RHS) | LHS-RHS ≤ 2 |
|---|------------------|------------------|-------------|--------------|--------------------|-------------|
| A | 3269             | 3264             | 0           | 2405         | 2404               | 1           |
| B | 3269             | 3267             | 2           | 2405         | 2403               | 2           |
| C | 3268             | 3268             | 0           | 2404         | 2405               | 1           |
| D | 3265             | 3265             | 0           | 2406         | 2405               | 1           |
| E | 3266             | 3265             | 1           | 2405         | 2405               | 0           |
| F | 3270             | 3269             | 1           | 2404         | 2406               | 2           |
| G | 3269             | 3271             | 2           | 2405         | 2406               | 1           |
| H | 3264             | 3265             | 1           | 2405         | 2405               | 0           |
| I | 3266             | 3266             | 0           | 2406         | 2406               | 0           |
| J | 3268             | 3268             | 0           | 2405         | 2406               | 1           |
| K | 3269             | 3270             | 1           | 2405         | 2404               | 1           |
| L | 3268             | 3266             | 2           | 2406         | 2409               | 0           |
| M | 3265             | 3267             | 2           | 2408         | 2407               | 1           |

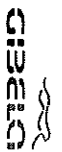


2024-02-01

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21/02/24



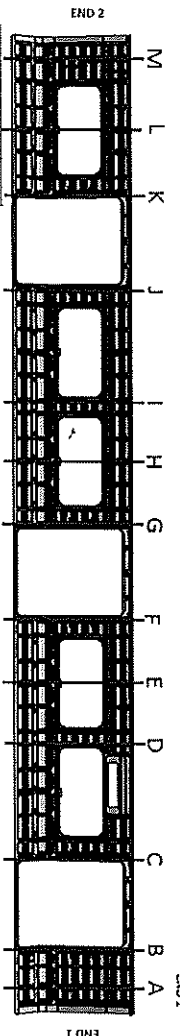


DTR302233193 Carshell Assembly TC

Rev. V28  
Project: PRASA  
Date- 07/11/2023  
SI.CB2210.322.V28

Specifications of Details for CBS measurement

AFTER WELDING



PM/E: The difference in Height values measured on the LHS and RHS should be  $\leq 2\text{MM}$  on each point.

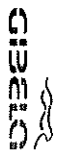
| Record D1 values |      | Record D2 values |      | D1-D2 ≤ 5mm |      | 2399 to 2409 | 2399 to 2409 (RHS) | LHS-RHS ≤ 2 |
|------------------|------|------------------|------|-------------|------|--------------|--------------------|-------------|
| A                | 3270 | 3268             | 2    | 2405        | 2403 | 2            |                    |             |
| B                | 3298 | 3296             | 2    | 2403        | 2405 | 2            |                    |             |
| C                | 3296 | 3296             | 0    | 2405        | 2404 | 1            |                    |             |
| D                | 3265 | 3265             | 0    | 2406        | 2406 | 0            |                    |             |
| E                | 3266 | 3266             | 2    | 2405        | 2404 | 1            |                    |             |
| F                | 3295 | 3296             | 1    | 2406        | 2405 | 1            |                    |             |
| G                | 3296 | 3296             | 0    | 2404        | 2404 | 0            |                    |             |
| H                | 3264 | 3265             | 2403 | 2405        | 2404 | 2            |                    |             |
| I                | 3266 | 3266             | 2405 | 2404        | 2404 | 1            |                    |             |
| J                | 3295 | 3294             | 2404 | 2404        | 2404 | 2            |                    |             |
| K                | 3296 | 3297             | 2405 | 2405        | 2405 | 0            |                    |             |
| L                | 3268 | 3264             | 4    | 2406        | 2407 | 1            |                    |             |
| M                | 3294 | 3296             | 2    | 2406        | 2406 | 2            |                    |             |

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2024-02-01  
INDUSTRIAL QUALITY  
MAINLINE

W/M

21/02/24



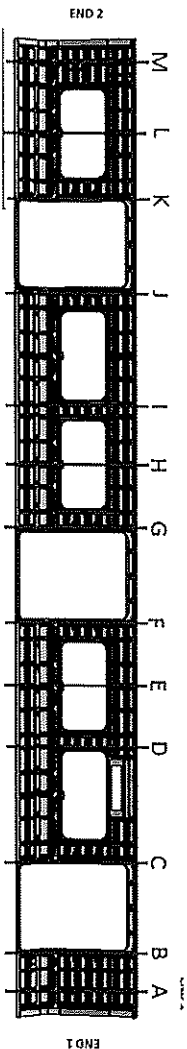


DTR302233193 Carshell Assembly TC

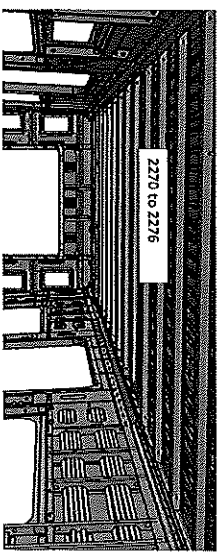
| Rev.       | Project: PRASA    |
|------------|-------------------|
| V28        |                   |
| Date-      | SI.CB2210.322.V28 |
| 07/11/2023 |                   |

Specifications of Details for C85 measurement

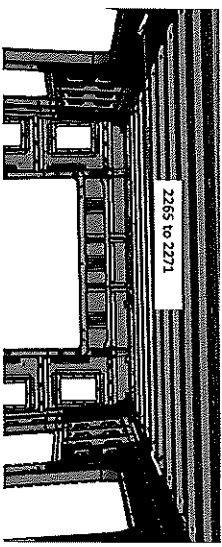
AFTER WELDING



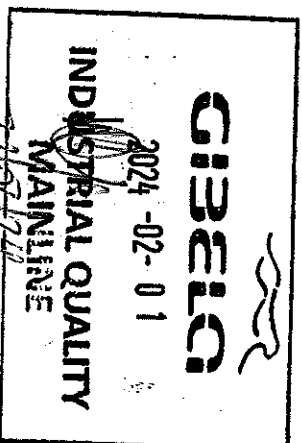
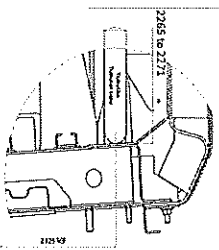
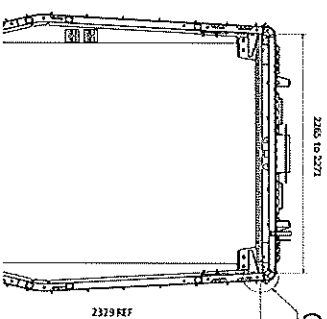
|   | 2265 to 2271 | 2270 to 2276 |
|---|--------------|--------------|
| A | NA           | 2270         |
| B | 2271         | NA           |
| C | 2268         | NA           |
| D | NA           | 2276         |
| E | NA           | 2274         |
| F | 2260         | NA           |
| G | 2269         | NA           |
| H | NA           | 2276         |
| I | NA           | 2276         |
| J | 2269         | NA           |
| K | 2265         | NA           |
| L | NA           | 2273         |
| M | 2265         | NA           |

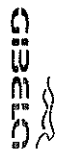


Do not consider reinforcement (Take measurements top area of zee profile)



Take measurement close to radius ( considering reinforcement)





DTR3022319/3 Carshell Assembly TC

Rev.  
V28

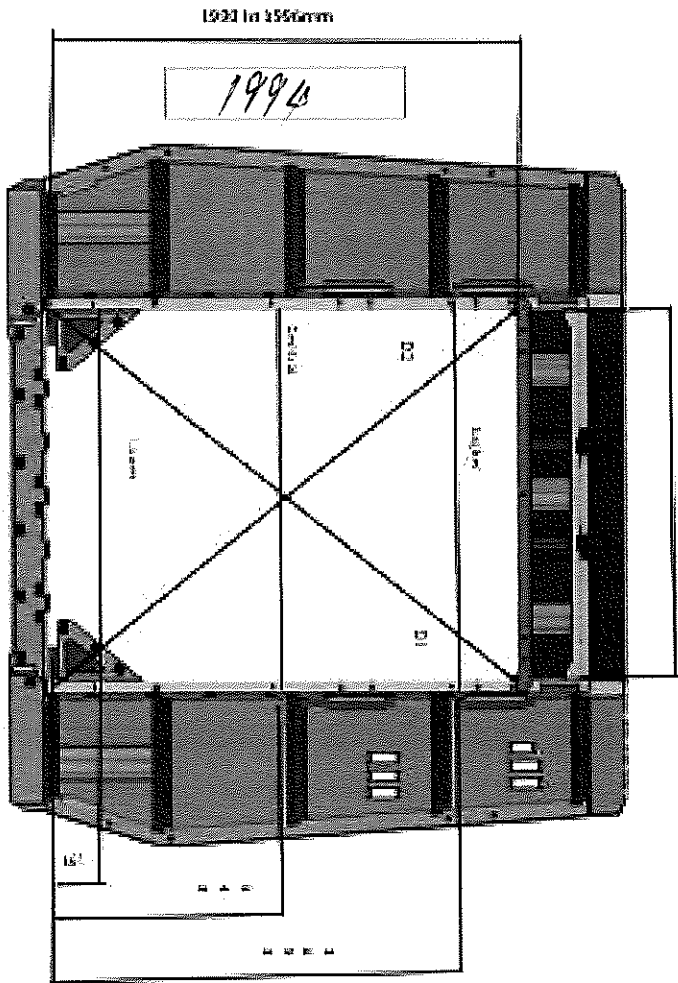
Project: PRASA

Date:  
07/11/2023

S1.CB2210.322.V28

Specifications of Details for CBS measurement

Endframe 2



1185 to 1182 mm

DIAGONAL DIFFERENCE D1-D2 ± 3mm

HIGHER DIMENSION

1381

D1

2413

CENTRAL DIMENSION

1381

D2

2410

LOWER DIMENSION

1380

D1-D2

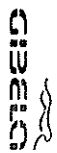
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INDUSTRIAL QUALITY  
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DTR30232319/3 Carshell Assembly TC

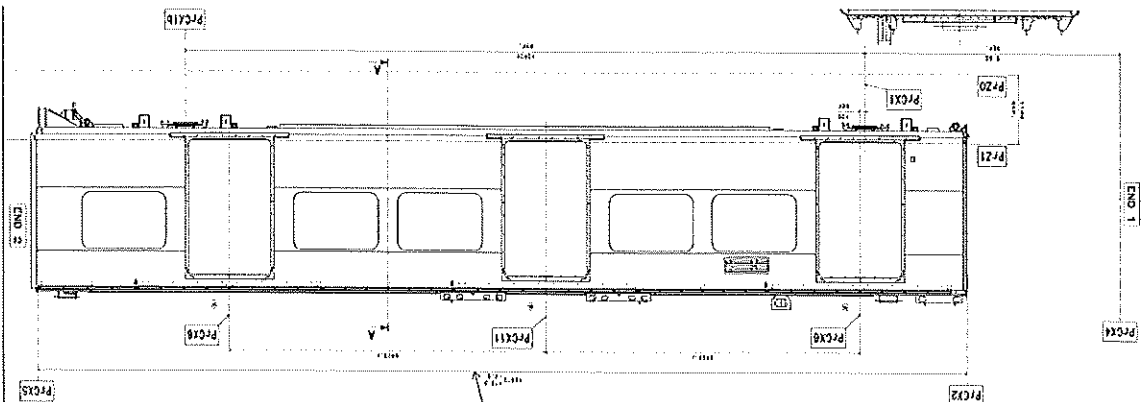
Rev.  
V/28

Project: PRASA

Date- 07/11/2023

SI.CB2210.322.V28

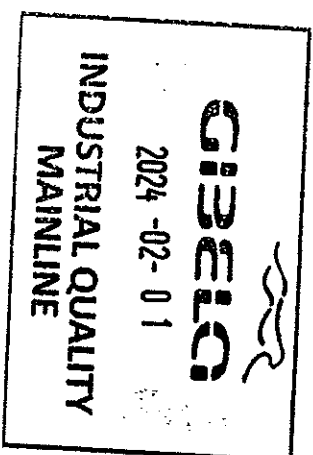
Specifications of Details for CBS measurement



1A

| LEFT SIDE          |                        |             |
|--------------------|------------------------|-------------|
| SPECIFICATION SIZE |                        | ACTUAL SIZE |
| 1A                 | 18870<br>+10.5<br>-4.5 | 18871       |

| RIGHT SIDE         |                        |             |
|--------------------|------------------------|-------------|
| SPECIFICATION SIZE |                        | ACTUAL SIZE |
| 1A                 | 18870<br>+10.5<br>-4.5 | 18871       |

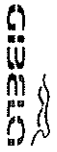


Dye penetrant test

Dye-penetration test to be performed by quality personnel

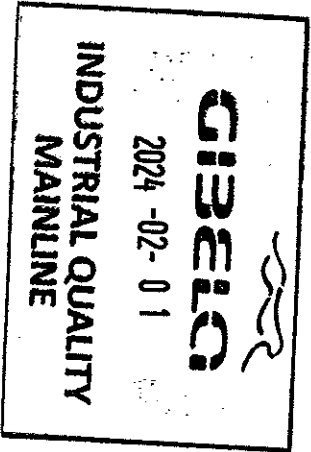





|  |             |                                   |             |                     |                   |           |
|--|-------------|-----------------------------------|-------------|---------------------|-------------------|-----------|
|                             |             | DTR302233193 Carshell Assembly TC |             | Rev.<br>V28         | Project: PRASA    |           |
|  |             |                                   |             | Date-<br>07/11/2023 | SI.CB2210.322.V28 |           |
| Self Inspection - Final Result   |             |                                   |             |                     |                   |           |
| Is the car good to advance to the next workstation/process?<br>(Approval of Operations and Industrial Quality) |             |                                   |             | DATE                | NAME              | SIGNATURE |
| <div>HOLD POINT</div>  |             |                                   |             |                     |                   |           |
|  |             |                                   |             |                     |                   |           |
|  |             |                                   |             |                     |                   |           |
|  |             |                                   |             |                     |                   |           |
| 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 | Action                            | Responsible | Due date            | Status            |           |
|  |             |                                   |             |                     |                   |           |
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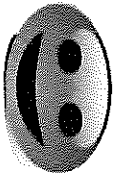
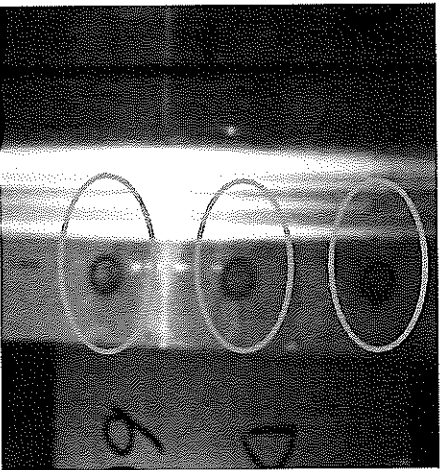
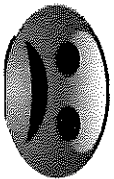
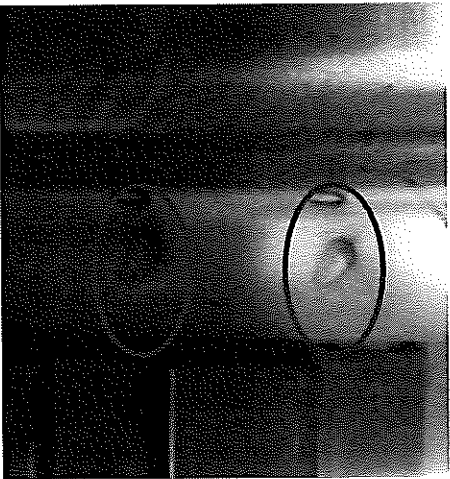
Operations

Quality

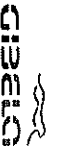


|   |                   |                                   |  |
|---|-------------------|-----------------------------------|--|
|  <b>GIBELL</b> |                   | DTR302233193 Carshell Assembly TC |  |
| Rev.  | Project: PRASA    |                                   |  |
| V28   |                   |                                   |  |
| Date-   | SI CB2210.322.V28 |                                   |  |
| 07/11/2023  |                   |                                   |  |

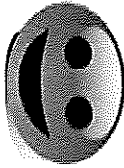
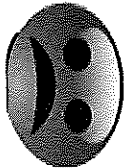
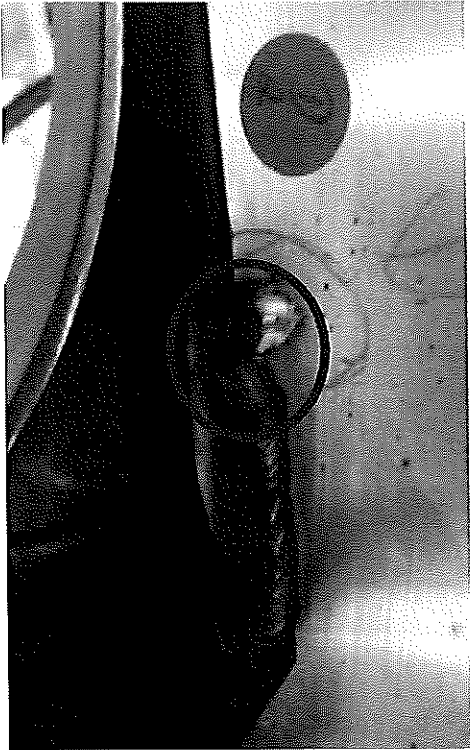
**ANNEXURE A: Spot Welding Quality Acceptance Standard**






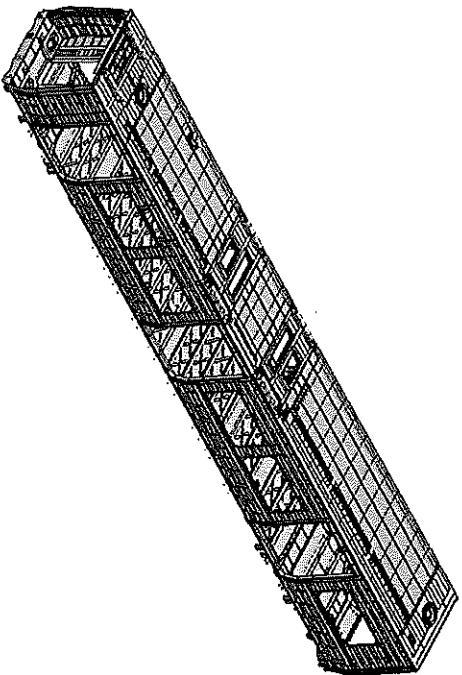
|   |  |                                    |  |                                    |                                     |
|---|--|------------------------------------|--|------------------------------------|-------------------------------------|
|  |  | DTR3022331913 Carshell Assembly TC |  | Rev.<br>V28<br>Date-<br>07/11/2023 | Project: PRASA<br>SI.CB2210.322.V28 |
|---|--|------------------------------------|--|------------------------------------|-------------------------------------|

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





|   |                                   |            |                      |
|---|-----------------------------------|------------|----------------------|
|  | DTR302231912 Carshell Assembly TC | Rev.       | Project: PRASA       |
|   |                                   | 29         |                      |
|   |                                   | Date-      | SLCB2220.323.V29     |
|   |                                   | 28/10/2023 |                      |
| Carro   | TC1, TC2                          | NCR:       | Work station: CB2220 |



I - Documentation and Instruments

I.1 - Documentation Control


| Document     | Type of car |     |     |     |     | Revision | Observation | OK | Signature/Date (Manufacturing) | Signature/Date (Quality)  |
|--------------|-------------|-----|-----|-----|-----|----------|-------------|----|--------------------------------|---|
|              | TC1         | TC2 | TC3 | TC4 | TC5 |          |             |    |                                |   |
| DTR302231912 |             |     |     |     | X   | 29       | 28-10-2023  | X  | N/A                            | 22-02-24  22/02/24 |

I.2 - Instruments Control

| Monitoring and Measuring Instrument Control - Used for Special Process |            |   |    |                                |                          |  |
|--|------------|---|----|--------------------------------|--------------------------|--|
| Instruments  | Validation | Calibration or Verification Validation Date | OK | Signature/Date (Manufacturing) | Signature/Date (Quality) |  |
| Tubulan  | 22713      | 05/08/2024                                  | X  | 22-02-24                       |                          |  |
| measuring tape   | 657A1831   | 2024/03/30                                  | X  | 22-02-24                       |                          |  |
|  |            |   |    |                                |                          |  |

1.3 Consumables

| Welding Consumable Control - Used for Special Process |             |                 |    |                                |                          |
|---|-------------|-----------------|----|--------------------------------|--------------------------|
| Filler Material                                       | Heat Number | Welding Process | OK | Signature/Date (Manufacturing) | Signature/Date (Quality) |
| 308   | 231054      | MIG             | X  | 22-02-24                       | 22/02/24                 |
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DTR30223319/2 Carshell Assembly TC

Rev.  
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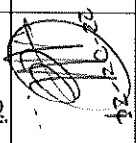
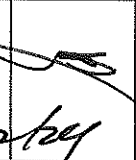
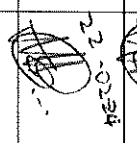

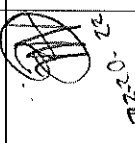

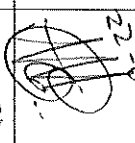
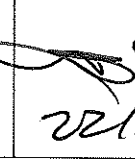
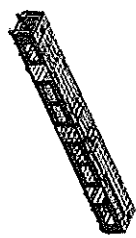
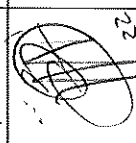

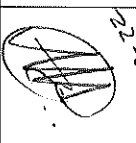

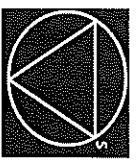
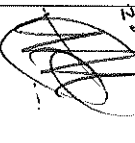

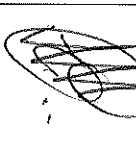
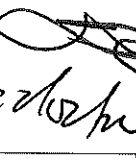
Project: PRASA

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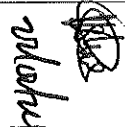

## II - Control Activities of Production

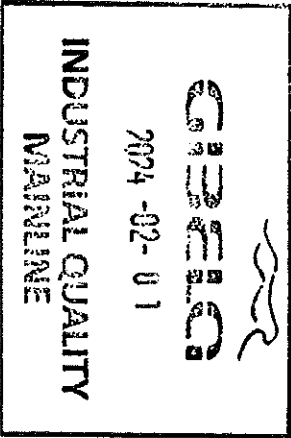
II.1 - Items to check

| Item | Picture/Drawing   | Description   | Acceptance criteria / Record   | OK | Signature/Date (Manufacturing)  | Signature/Date (Quality)  |
|------|---|---|--|----|---|---|
| 01   | N/A   | Assembly according to Instruction Engineering n° PRA.CB2220.DTR3022548/2<br>Verification of fitment for all reinforcement brackets.   | DTR30223319/2  | /  | <br>22-02-24 | <br>22/02/24 |
| 02   | N/A   | Carshell free of significant flows which compromise the appearance or functionality.  | DTD0000210675  | /  | <br>22-02-24 | <br>22/02/24 |
| 03   | REFER TO ANNEXURE A   | Spot Welding inspected and approved according procedure   | IND-SAL-WMS-016 e<br>DTD0000210675   | /  | <br>22-02-24 | <br>22/02/24 |
| 04   | REFER TO ANNEXURE B   | Arc Welding inspected and approved according procedure.   | IND-SAL-WMS-016 REFER<br>TO GIB - TYPDEF - ARC - 0000  | /  | <br>22-02-24 | <br>22/02/24 |
| 05   |  | Cleaning of all Stainless Steel Surface   | According TO GIB-WEL - PROC-0002   | /  | <br>22-02-24  | <br>22/02/24  |
| 06   | N/A   | Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.  | Approved according specified on pages below.   | /  | <br>22-02-24   | <br>22/02/24   |
| 07   |    | 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                                     | /  | <br>22-02-24   | <br>22/02/24   |
| 08   | N/A   | Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values<br>Specified:<br>Temperature Min - Max (°) 10°C - 35°C<br>Relative Humidity Min - Max (%) 25% - 80% | Sealant Batch No: 1SR 7030<br>Exp Date: 05/24<br>Actuals<br>Temperature: 26°C<br>Humidity: 72% | /  | <br>22-02-24   | <br>22/02/24   |

2024-02-01

INDUSTRIAL QUALITY  
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|  |    | Rev.<br>29<br>Date-<br>28/10/2023                                     |   | Project: PRASA<br>SI.CB2220.323.V29 |   |   |  |
|---|----|---|---|-------------------------------------|---|---|--|
|   |    |   |   |                                     |   |   |  |
|   |    | DTR30223319/2 Carshell Assembly TC                                    |   |                                     |   |   |  |
| 09  | NA | Verification of sedant application in certain regions in the drawing. | AAD0001241033   | ✓                                   |  |  |  |
| 10  | NA | Verification of sedant application on the roof and sidewall finishers | Sedant must be:<br>-Applied stroight and even (.5mm)<br>-Free of gaps,cracks,damage and debris (flashes, dirt, dust)<br>Refer to Annexure B | ✓                                   |  |  |  |



|         |                                    |                     |                   |
|---------|------------------------------------|---------------------|-------------------|
| GIBELCO | DTR30223319/2 Carshell Assembly TC | Rev.<br>29          | Project: PRASA    |
|         |                                    | Date-<br>28/10/2023 | SI.CB2220.323.V29 |



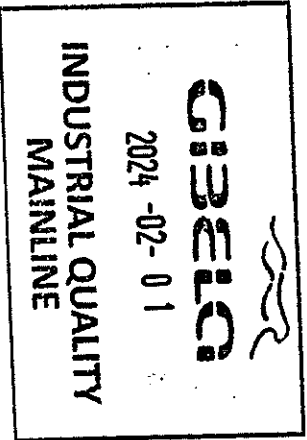
END 1  
SEALANT


OPERATOR  
(Name & sign):

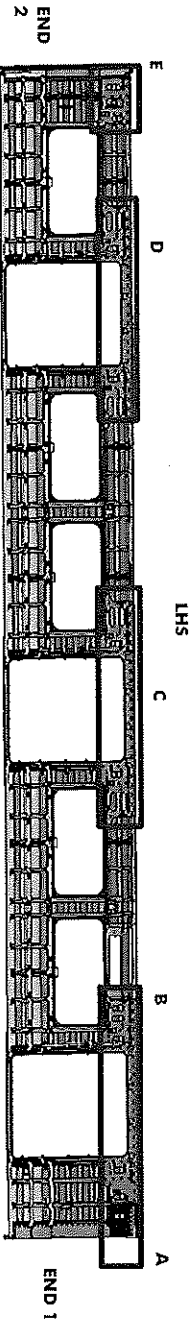
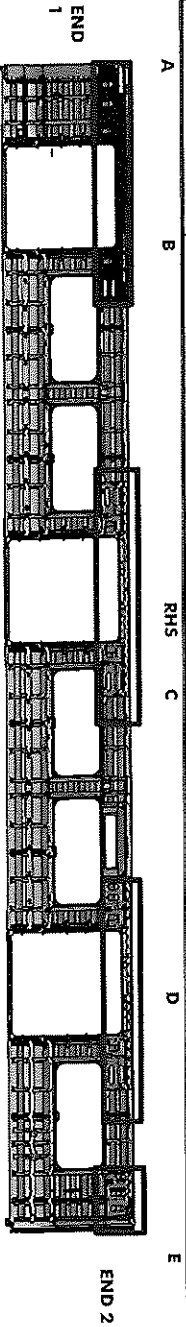
Levy

OPERATOR  
(Name & sign):

Levy




|   |  |                                    |  |                     |                   |
|---|--|------------------------------------|--|---------------------|-------------------|
|  |  | DTR3022331912 Carshell Assembly TC |  | Rev.<br>29          | Project: PRASA    |
|   |  |                                    |  | Date-<br>28/10/2023 | SI,CE2220.323.V29 |



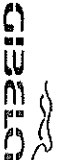
REINFORCEMENT WELDING

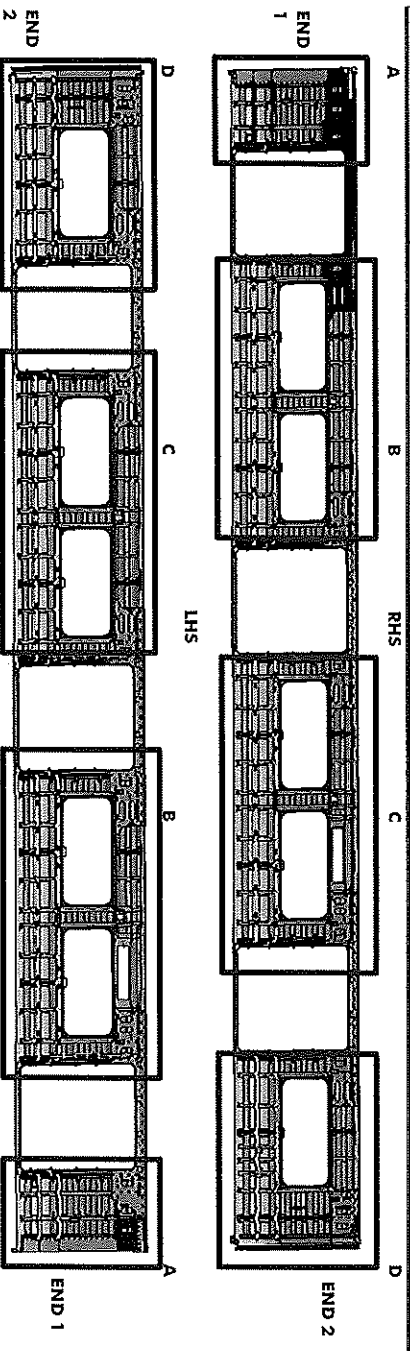
| AREA | LHS                                    | RHS                     |
|------|--|-------------------------|
| A    | Operator (Name&sign): <u>LINDO MD</u>  | <del>LINDO MD</del>     |
| B    | Operator (Name&sign): <u>LINDO MD</u>  | <u>KEITO KND</u>        |
| C    | Operator (Name&sign): <u>deling De</u> | <u>deling De</u>        |
| D    | Operator (Name&sign): <u>deling De</u> | <u>Mmasileto Mhlati</u> |
| E    | Operator (Name&sign): <u>deling De</u> | <u>Mmasileto Mhlati</u> |




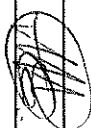



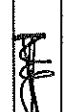
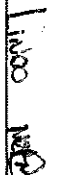




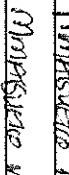


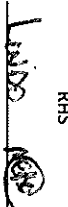






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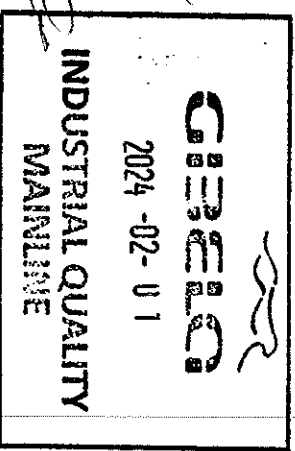
2024-02-01

|   |                                    |            |                   |
|---|------------------------------------|------------|-------------------|
|  | DTR302233191Z Carshell Assembly TC | Rev.       | Project: PRASA    |
|   |                                    | 29         |                   |
|   |                                    | Date-      | SI.CB2220.323.V29 |
|   |                                    | 28/10/2023 |                   |

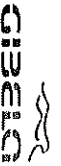


BRACKETING

|                                       |                         |                  |  |
|---------------------------------------|-------------------------|------------------|--|
| C-RAILS:                              | Operator:               | INSTALLATION     |       |
|                                       | Operator:               | ASTHIDA          |       |
| DOOR MECHANISMS:                      | Operator:               | Lindo            | END2  |
| TAPPING PADS                          | Operator:               |                  |  |
|                                       | Operator:               |                  |  |
| SEAT & LUGGAGE BRACKETS:              | Operator:               | Manaswini Meel   |       |
|                                       | Operator:               | Maharaj K. S. S. |        |
| SEAT BRACKETS VERIFICATION:           | Operator:               | Maharaj K. S. S. |         |
|                                       | Operator:               |                  |  |
| AREA                                  |                         | WELDING          |  |
|                                       |                         | LHS              |  |
| A (Seat brackets)                     | : Operator (Name&sign): | Lindo            |         |
| (C-rails, Luggage and earth bushes) : | Operator (Name&sign):   | Lindo            |         |
| B (Seat brackets)                     | : Operator (Name&sign): | Lindo            |         |
| (C-rails, Luggage and earth bushes) : | Operator (Name&sign):   | Lindo            |         |
| C (Seat brackets)                     | : Operator (Name&sign): | Lindo            |         |
| (C-rails, Luggage and earth bushes) : | Operator (Name&sign):   | Lindo            |         |
| D (Seat brackets)                     | : Operator (Name&sign): | Lindo            |         |
| (C-rails, Luggage and earth bushes) : | Operator (Name&sign):   | Lindo            |         |
|                                       |                         | RHS              |  |
|                                       |                         | Lindo            |       |
|                                       |                         | Lindo            |       |
|                                       |                         | Lindo            |       |
|                                       |                         | Lindo            |       |
|                                       |                         | Lindo            |       |
|                                       |                         | Lindo            |       |
|                                       |                         | Lindo            |       |




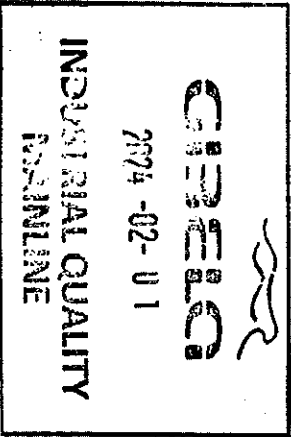


|   |                                    |                     |                   |
|---|------------------------------------|---------------------|-------------------|
|  | DTR3022331912 Carshell Assembly TC | Rev.<br>29          | Project: PRASA    |
|   |                                    | Date-<br>28/10/2023 | SI.CB2220.323.V29 |

ENDS

END 1 TAPPING PADS WELDING: Operator (Name&sign): N/A

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



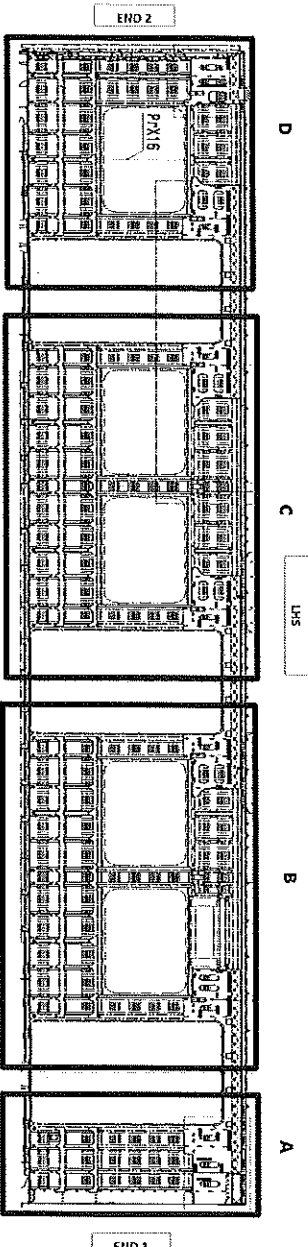
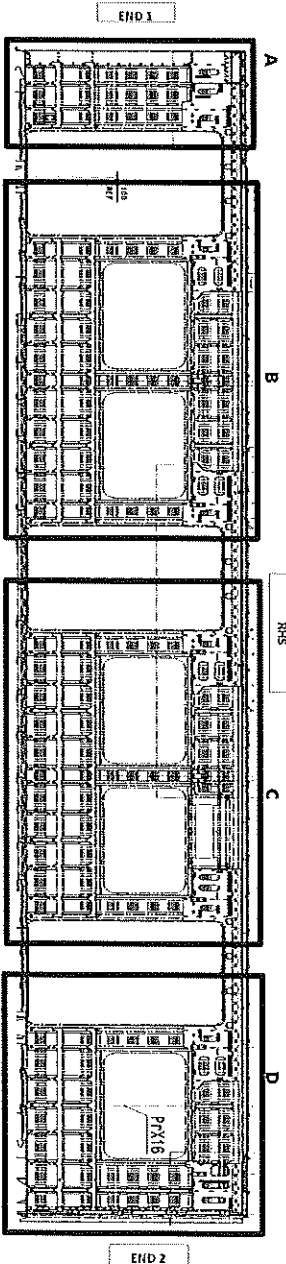


DTR3022331912 Carshell Assembly TC

Rev.  
29  
Date-  
28/10/2023

Project: PRASA  
SI.CB2220.323.V29

TC BRACKET INSTALLATION



QUANTITIES (TC)

RHS

| SECTION       | QUANTITY | OK | NOK |
|---------------|----------|----|-----|
| C-RAILS       | A        | 4  | —   |
|               | B        | 4  | —   |
|               | C        | 8  | —   |
|               | D        | 12 | —   |
| SEAT BRACKETS | A        | 0  | —   |
|               | B        | 21 | —   |
|               | C        | 21 | —   |
|               | D        | 13 | —   |
| EARTH BUSH    | A        | 1  | —   |
|               | B        | 4  | —   |
|               | C        | 5  | —   |
|               | D        | 4  | —   |

ROOF ENDS:

GRAILS 2 OFF END 2  
EARTH BUSH 4 OFF END 2

VERIFICATION BY:

LHS

| SECTION       | QUANTITY | OK | NOK |
|---------------|----------|----|-----|
| C-RAILS       | A        | 4  | —   |
|               | B        | 8  | —   |
|               | C        | 4  | —   |
|               | D        | 6  | —   |
| SEAT BRACKETS | A        | 0  | —   |
|               | B        | 21 | —   |
|               | C        | 21 | —   |
|               | D        | 13 | —   |
| EARTH BUSH    | A        | 1  | —   |
|               | B        | 4  | —   |
|               | C        | 4  | —   |
|               | D        | 2  | —   |

ROOF ENDS:

GRAILS 2 OFF END 2  
EARTH BUSH 4 OFF END 2

VERIFICATION BY:

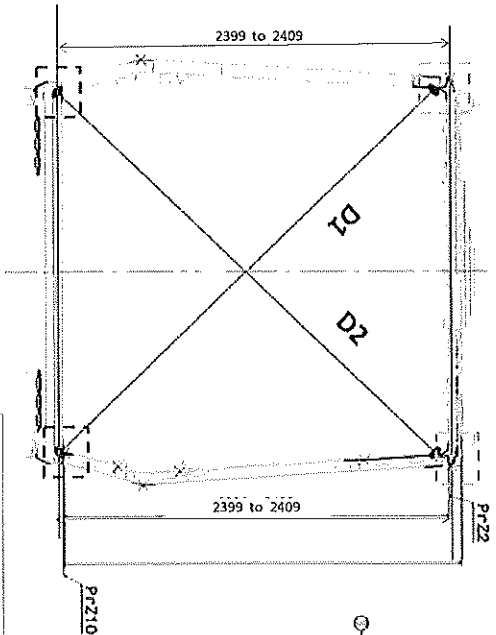
**GIBECO**  
2024 -02- 01  
INDUSTRIAL QUALITY  
MAINLINE



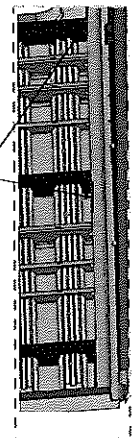
DTR3022319/2 Carshell Assembly TC

| Rev. | Date       |
|------|------------|
| 29   | 28/10/2023 |

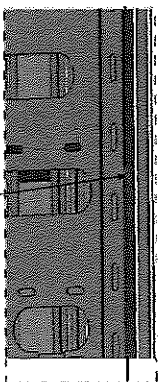
Project: PRASA  
SI.CB2220.323.V29



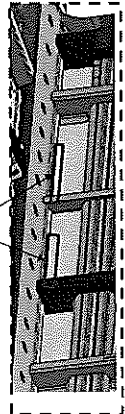
Take measurement close to radius



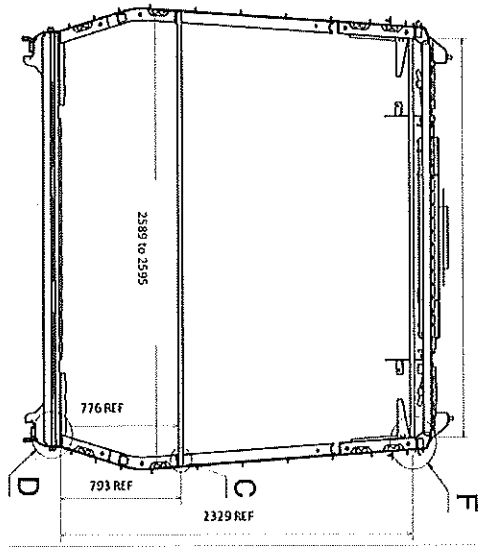
Measurement positions on roof rail and sidewall omega corner



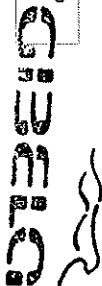
Reinforcement area measurement positions on roof reinforcement area



Measurement positions on sidewall and side sill corner

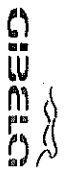


Take measurement close to radius



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DTR302233191Z Carshell Assembly TC

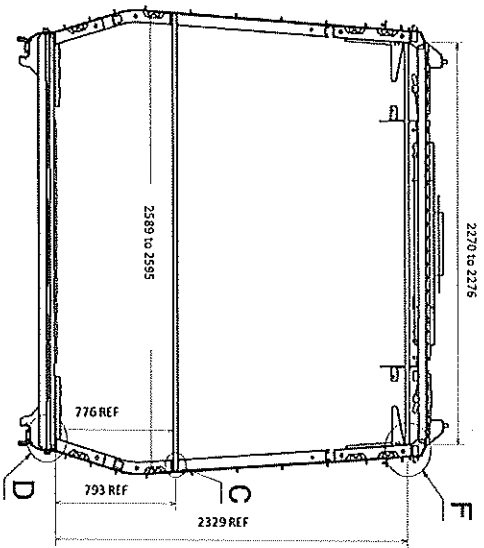
Rev.  
29

Project: PRA5A

Date-

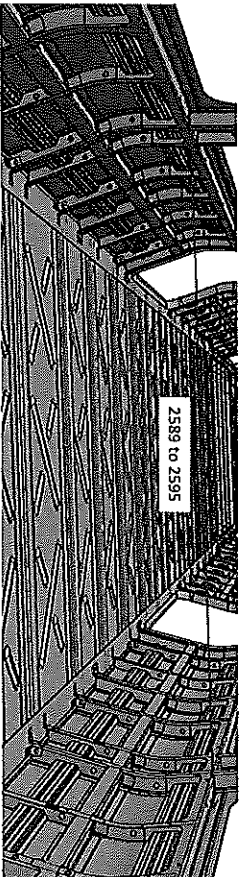
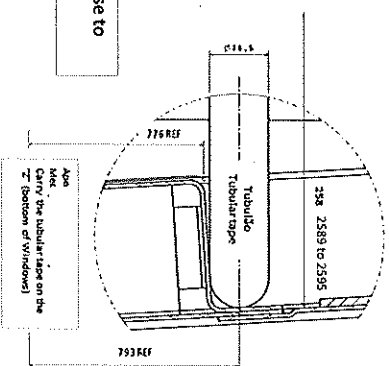
28/10/2023

SI.CB2220.323.V29

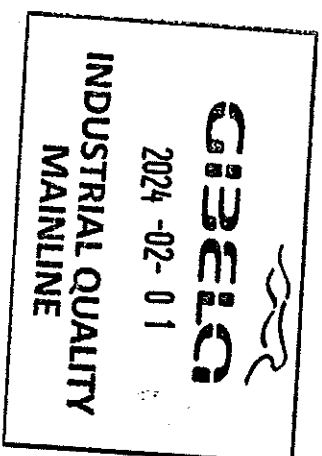
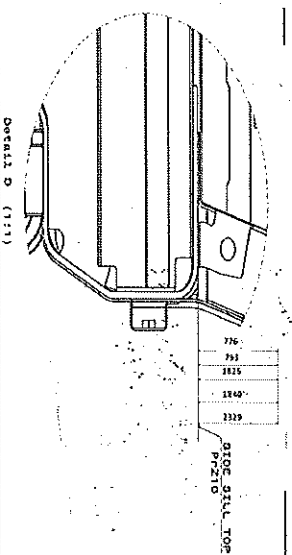
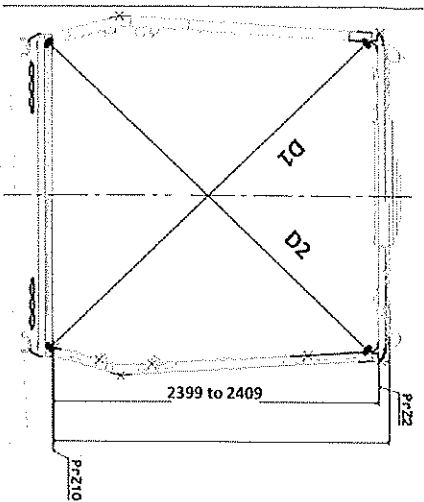


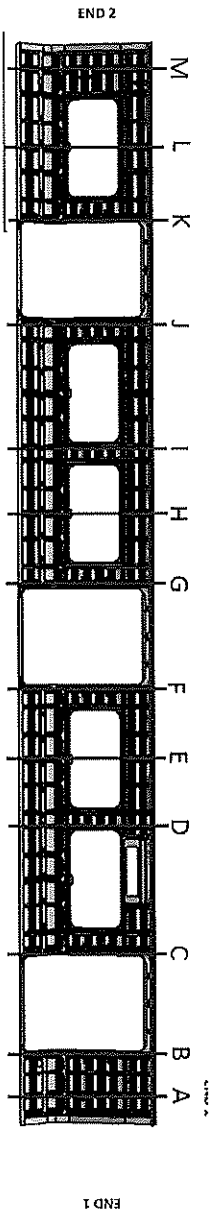
Take measurement close to  
radius

Detail C



2589 to 2595

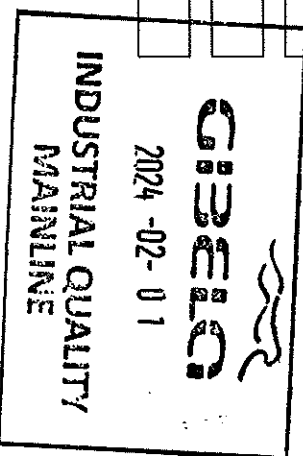




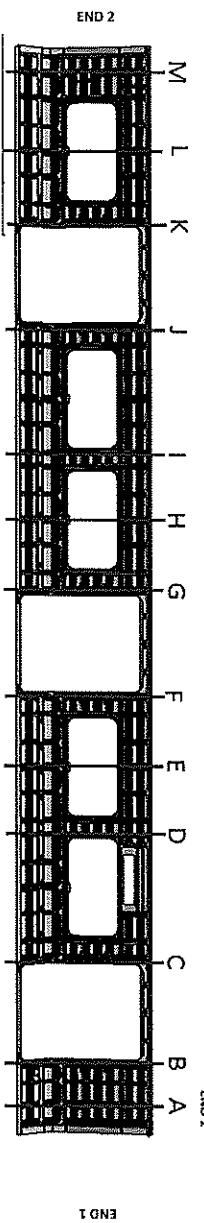
BEFORE WELDING

|   | Record D1 values | Record D2 values | D1-D2 ≤ 5mm | 2589 to 2595 |
|---|------------------|------------------|-------------|--------------|
| A | 3266             | 3268             | 2           |              |
| B | 3294             | 3294             | 0           |              |
| C | 3296             | 3296             | 0           |              |
| D | 3268             | 3269             | 1           |              |
| E | 3264             | 3264             | 0           |              |
| F | 3296             | 3298             | 2           |              |
| G | 3298             | 3295             | 3           |              |
| H | 3267             | 3265             | 2           |              |
| I | 3268             | 3268             | 0           |              |
| J | 3292             | 3293             | 5           |              |
| K | 3295             | 3295             | 0           |              |
| L | 3269             | 3270             | 1           |              |
| M | 3297             | 3297             | 0           |              |

22-02-24




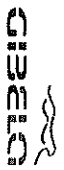
|         |                                   |                     |                   |
|---------|-----------------------------------|---------------------|-------------------|
| GIBELCO | DTR302231912 Carshell Assembly TC | Rev.<br>29          | Project: PRASA    |
|         |                                   | Date-<br>28/10/2023 | SI.CB2220.323.V29 |



AFTER WELDING

|   | Record D1 values | Record D2 values | D1-D2 ≤ 5mm | 2589 to 2595 |
|---|------------------|------------------|-------------|--------------|
| A | 3296             | 3291             | 5           | 2592         |
| B | 3295             | 3290             | 5           | 2589         |
| C | 3296             | 3290             | 6           | 2589         |
| D | 3265             | 3270             | 5           | 2589         |
| E | 3267             | 3262             | 5           | 2589         |
| F | 3295             | 3300             | 5           | 2590         |
| G | 3300             | 3292             | 8           | 2592         |
| H | 3265             | 3270             | 5           | 2589         |
| I | 3270             | 3264             | 6           | 2592         |
| J | 3295             | 3300             | 5           | 2591         |
| K | 3299             | 3295             | 4           | 2593         |
| L | 3270             | 3269             | 1           | 2589         |
| M | 3298             | 3298             | 0           | 2595         |

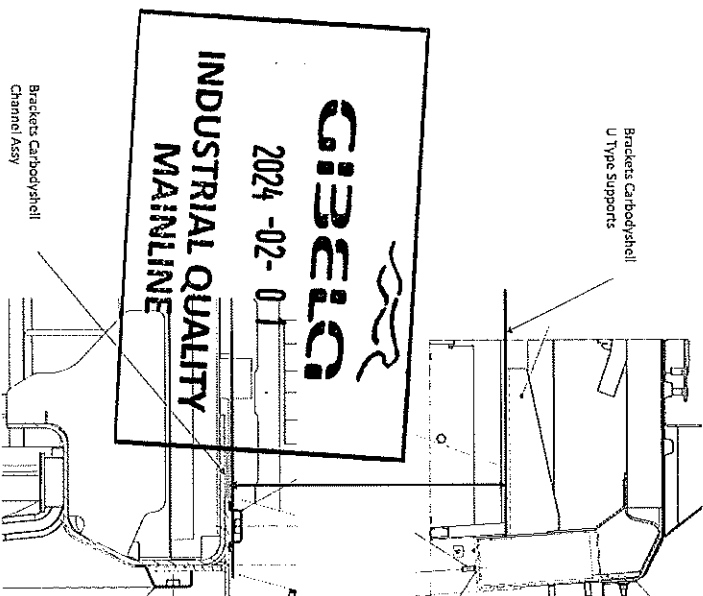
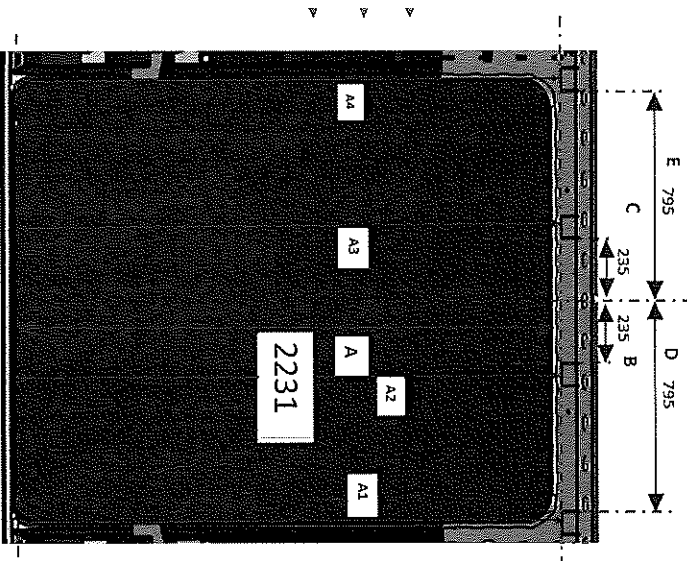
  
22-02-24



DTR3022319/2 Carshell Assembly TC

Rev.  
29  
Project: PRASA  
Date-  
28/10/2023  
SI:CB2220.323.V29

Specifications of Details for CBS measurement



DOOR 1 - LHS

| VALUE              | ACTUAL |
|--------------------|--------|
| A1<br>2230 to 2232 | 2231   |
| A2<br>2230 to 2232 | 2232   |
| A3<br>2230 to 2232 | 2231   |
| A4<br>2230 to 2232 | 2230   |
| B<br>234 to 236    | 235    |
| C<br>234 to 236    | 234    |
| D<br>794 to 796    | 796    |
| E<br>794 to 796    | 794    |

DOOR 2 - LHS

| VALUE              | ACTUAL |
|--------------------|--------|
| A1<br>2230 to 2232 | 2230   |
| A2<br>2230 to 2232 | 2232   |
| A3<br>2230 to 2232 | 2232   |
| A4<br>2230 to 2232 | 2231   |
| B<br>234 to 236    | 234    |
| C<br>234 to 236    | 235    |
| D<br>794 to 796    | 796    |
| E<br>794 to 796    | 794    |

DOOR 3 - LHS

| VALUE              | ACTUAL |
|--------------------|--------|
| A1<br>2230 to 2232 | 2232   |
| A2<br>2230 to 2232 | 2232   |
| A3<br>2230 to 2232 | 2231   |
| A4<br>2230 to 2232 | 2230   |
| B<br>234 to 236    | 234    |
| C<br>234 to 236    | 235    |
| D<br>794 to 796    | 794    |
| E<br>794 to 796    | 796    |

DOOR 1 - RHS

| VALUE              | ACTUAL |
|--------------------|--------|
| A1<br>2230 to 2232 | 2231   |
| A2<br>2230 to 2232 | 2232   |
| A3<br>2230 to 2232 | 2232   |
| A4<br>2230 to 2232 | 2231   |
| B<br>234 to 236    | 234    |
| C<br>234 to 236    | 236    |
| D<br>794 to 796    | 794    |
| E<br>794 to 796    | 795    |

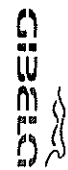
DOOR 2 - RHS

| VALUE              | ACTUAL |
|--------------------|--------|
| A1<br>2230 to 2232 | 2231   |
| A2<br>2230 to 2232 | 2231   |
| A3<br>2230 to 2232 | 2232   |
| A4<br>2230 to 2232 | 2231   |
| B<br>234 to 236    | 235    |
| C<br>234 to 236    | 234    |
| D<br>794 to 796    | 794    |
| E<br>794 to 796    | 796    |

DOOR 3 - RHS

| VALUE              | ACTUAL |
|--------------------|--------|
| A1<br>2230 to 2232 | 2232   |
| A2<br>2230 to 2232 | 2231   |
| A3<br>2230 to 2232 | 2231   |
| A4<br>2230 to 2232 | 2232   |
| B<br>234 to 236    | 234    |
| C<br>234 to 236    | 236    |
| D<br>794 to 796    | 794    |
| E<br>794 to 796    | 794    |

22-02-24



DTR30223319/2 Carshell Assembly TC

Rev.  
29  
Date-  
28/10/2023

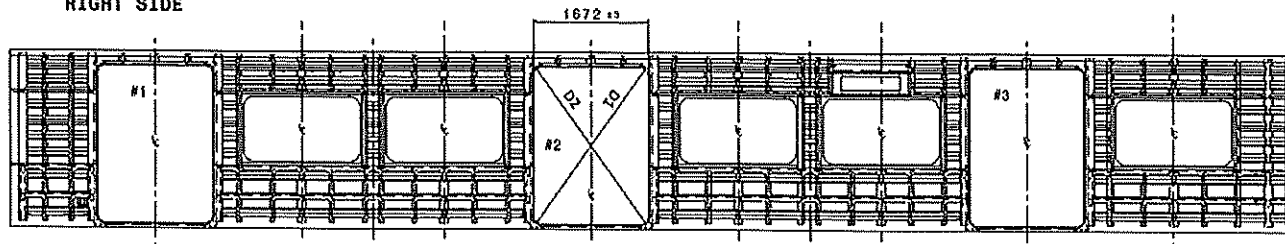
Project: PRASA  
SI.CB2220.323.V29

Specifications of Details for CBS measurement

End #2

RIGHT SIDE

End #1



Doors length - 1672 ±3mm

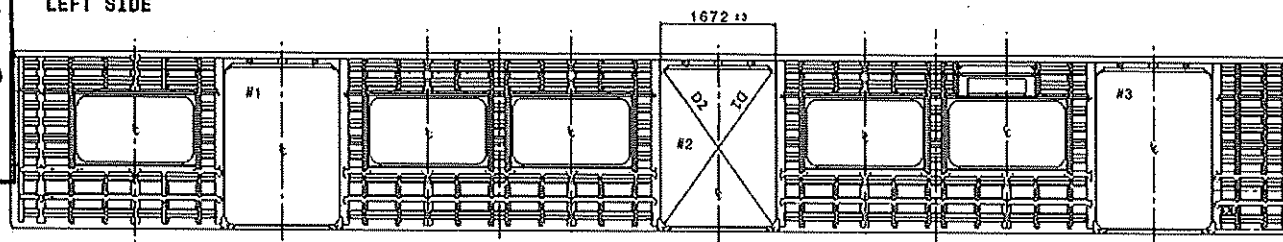
| #1   | #2   | #3   |                   |
|------|------|------|-------------------|
| 1674 | 1673 | 1674 | HIGHER DIMENSION  |
| 1672 | 1672 | 1671 | CENTRAL DIMENSION |
| 1672 | 1671 | 1671 | LOWER DIMENSION   |

Doors diagonal D1-D2 maximum difference ≤ 4 mm

|       | #1   | #2   | #3   |
|-------|------|------|------|
| D1    | 2748 | 2747 | 2744 |
| D2    | 2747 | 2746 | 2747 |
| D1-D2 | 1    | 1    | 3    |

LEFT SIDE

End #2



Vão de Portas - 1672 ±3mm  
Doors length - 1672 ±3mm

| #1   | #2   | #3   |                                       |
|------|------|------|---------------------------------------|
| 1673 | 1674 | 1674 | DIMENSÃO SUPERIOR<br>HIGHER DIMENSION |
| 1672 | 1672 | 1672 | CENTRAL DIMENSION                     |
| 1671 | 1671 | 1672 | LOWER DIMENSION                       |


Diagonal de portas - diferença D1-D2 < 4 mm

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

**GIBELCO**  
2024-02-01  
INDUSTRIAL QUALITY  
MAINLINE

22-02-24

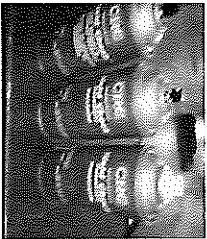


|   |                                    |                     |                   |
|---|------------------------------------|---------------------|-------------------|
|  | DTR3022331912 Carshell Assembly TC | Rev.<br>29          | Project: PRASA    |
|   |                                    | Date-<br>28/10/2023 | SI CB2220.323.V29 |

Specifications of Details for CBS measurement

Dye penetrant test

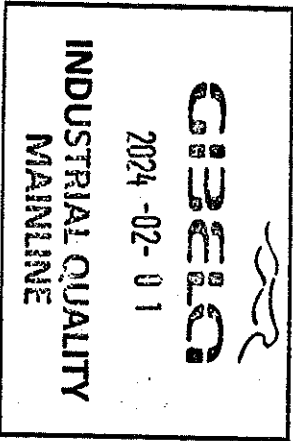
Dye-penetration test to be performed by quality personnel

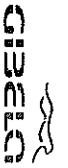


| Item | Description of the issue | OK | Signature/Date (Manufacturing) | Signature/Date (Quality) |
|------|--------------------------|----|--------------------------------|--------------------------|
|      |                          |    |                                |                          |
|      |                          |    |                                |                          |
|      |                          |    |                                |                          |
|      |                          |    |                                |                          |
|      |                          |    |                                |                          |
|      |                          |    |                                |                          |
|      |                          |    |                                |                          |
|      |                          |    |                                |                          |
|      |                          |    |                                |                          |

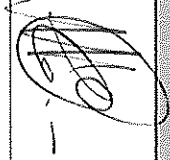

11.2 - Check List REX

| Check List Items |                 |                 |  |    |                                |
|------------------|-----------------|-----------------|--|----|--------------------------------|
| Item             | Picture/Drawing | Description     | Criteria /Record                                   | OK | Signature/Date (Manufacturing) |
| 01               | N/A             | To complete REX | Refer to REX. New defects must be added on the REX |    |                                |



|   |                                   |                     |                |
|---|-----------------------------------|---------------------|----------------|
|  | DTR302233192 Carshell Assembly TC | Rev.<br>29          | Project: PRASA |
|   |                                   | Date-<br>28/10/2023 |                |

Self Inspection - Final Result

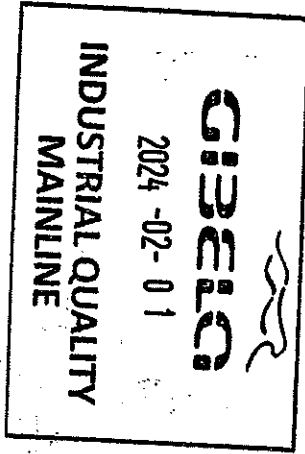
| Is is the car good to advance to the next workstation/process?<br>(Approval of Operations and Industrial Quality) |    | DATE     | NAME               | SIGNATURE   |
|---|----|----------|--------------------|---|
| HOLD POINT  | GO | 22-02-24 | ASTH DIT           |  |
|   |    | 27/02/24 | Industrial Quality |  |
|   |    |          | 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 | Action | Responsible | Due date |
|  |             |        |             |          |
|  |             |        |             |          |
|  |             |        |             |          |

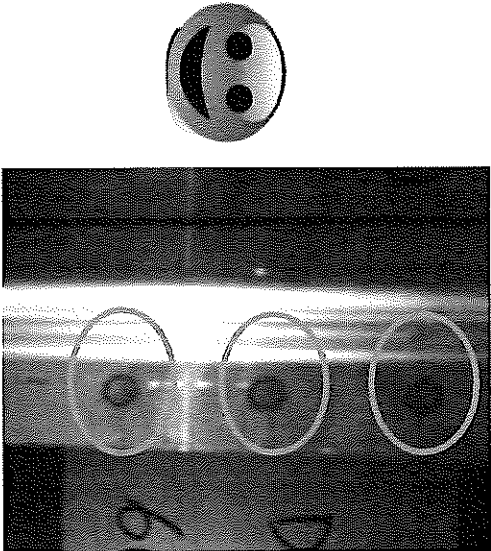
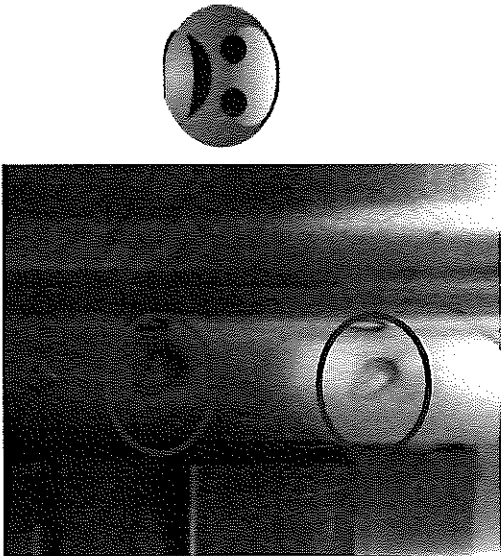
Operations


Quality



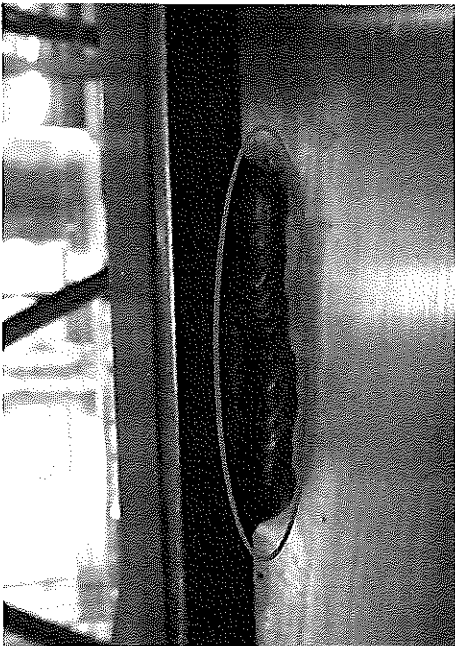
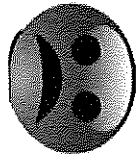
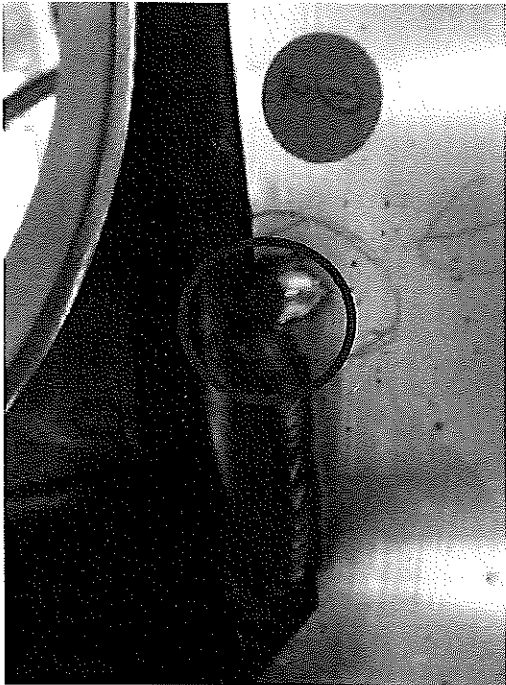
|   |                                    |  |            |                   |
|---|------------------------------------|--|------------|-------------------|
| <br><b>GIBELCO</b> | DTR3022331912 Carshell Assembly TC |  | Rev.       | Project: PRASA    |
|   |                                    |  |            |                   |
|   |                                    |  | Date-      |                   |
|   |                                    |  | 28/10/2023 | SI.CB2220.323.V29 |

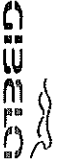
ANNEXURE A: Spot Welding Quality Acceptance Standard



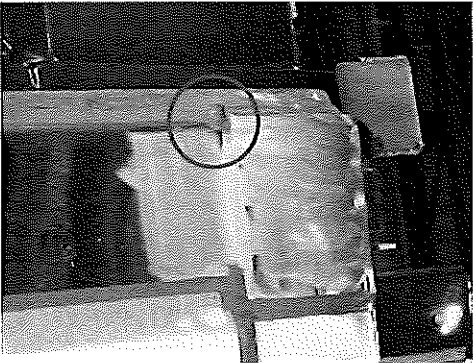
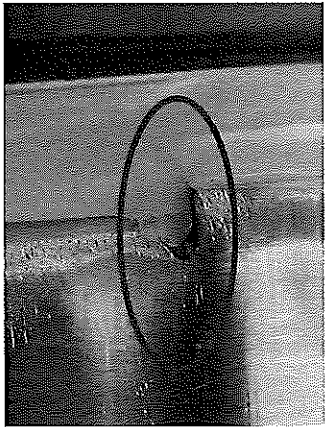
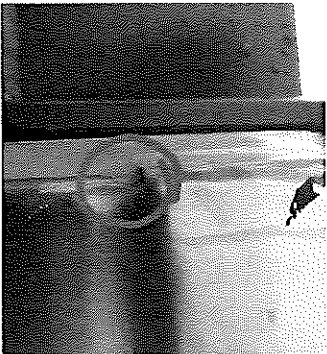
|   |                                    |  |                     |                                     |
|---|------------------------------------|--|---------------------|-------------------------------------|
|  | DTR3022331912 Carshell Assembly TC |  | Rev.<br>29          | Project: PRASA<br>SI.CB2220.323.V29 |
|   |                                    |  | Date-<br>28/10/2023 |                                     |

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



|   |                                   |  |                     |                                     |
|---|-----------------------------------|--|---------------------|-------------------------------------|
|  | DTR3023319/2 Carshell Assembly TC |  | Rev.<br>29          | Project: PRASA<br>SI.CB2220.323.V29 |
|   |                                   |  | Date-<br>28/10/2023 |                                     |

ANNEXURE B: Sealant





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                  | SHEET 1 |
|                          |             |  | CI      | PI | MI | MO          | IC                     | MS         |  |                                   |         |
| <input type="checkbox"/> | 01000022313 | A0000022300<br>IC  | CB2230  | X  |    |             |                        |            |  | PRA.CB2230.DT0000012<br>23313.V20 | YES     |
| <input type="checkbox"/> |             |  |         |    |    |             |                        |            |  |                                   |         |
| REV                      | DATE        | MODIFICATION CONTENT   |         |    |    | RESPONSIBLE | NAME                   | DATE       |  |                                   |         |
| 0                        | 06/04/2018  | GIBELA NEW CREATION  |         |    |    | APPROVER    | Ismaeleng Mediba       | 09/04/2018 |  |                                   |         |
|                          |             |  |         |    |    | CHECKER     | Nesozo Pindela         | 09/04/2018 |  |                                   |         |
|                          |             |  |         |    |    | COMPLIER    | Thangeni Mangu         | 09/04/2018 |  |                                   |         |
| 1                        | 30/5/2018   | Team leader and Quality Technician to sign<br>Change final signature from PVE Manager to Quality Manager |         |    |    | APPROVER    | Ismaeleng Mediba       | 30/5/2018  |  |                                   |         |
|                          |             |  |         |    |    | CHECKER     | Nesozo Pindela         | 30/5/2018  |  |                                   |         |
|                          |             |  |         |    |    | REVISED BY  | Nesozo Pindela         | 30/5/2018  |  |                                   |         |
| 2                        | 05/07/2018  | Certain dimensional checks moved to CB1220   |         |    |    | APPROVER    | Ismaeleng Mediba       | 05/07/2018 |  |                                   |         |
|                          |             |  |         |    |    | CHECKER     | Nesozo Pindela         | 05/07/2018 |  |                                   |         |
|                          |             |  |         |    |    | COMPLIER    | Ramokone Mafama        | 05/07/2018 |  |                                   |         |
|                          |             |  |         |    |    | APPROVER    | Ismaeleng Mediba       | 24/01/2019 |  |                                   |         |
| 5                        | 24/01/2019  | As per Baseline 10.2   |         |    |    | CHECKER     | Nesozo Pindela         | 24/01/2019 |  |                                   |         |
|                          |             |  |         |    |    | REVISED BY  | Vanessa Ntuli          | 24/01/2019 |  |                                   |         |
|                          |             |  |         |    |    | APPROVER    | Ismaeleng Mediba       | 13/03/2019 |  |                                   |         |
|                          |             |  |         |    |    | CHECKER     | Nesozo Pindela         | 13/03/2019 |  |                                   |         |
| 6                        | 13/03/2019  | Added Twist and Door Bracket Measurements<br>Remove Door Measurements                                    |         |    |    | COMPLIER    | Nesozo Pindela         | 13/03/2019 |  |                                   |         |
|                          |             |  |         |    |    | APPROVER    | Ismaeleng Mediba       | 17/09/2019 |  |                                   |         |
|                          |             |  |         |    |    | CHECKER     | Nesozo Pindela         | 17/09/2019 |  |                                   |         |
| 7                        | 17/09/2019  | Added Cab Fire Barrier<br>Fitness Measurements   |         |    |    | COMPLIER    | Nesozo Pindela         | 17/09/2019 |  |                                   |         |
|                          |             |  |         |    |    | APPROVER    | Ismaeleng Mediba       | 20/09/2019 |  |                                   |         |
| 10                       | 20/09/2019  | New Baseline 10.2.5  |         |    |    | CHECKER     | Nesozo Pindela         | 20/09/2019 |  |                                   |         |
|                          |             |  |         |    |    | COMPLIER    | Nesozo Pindela         | 20/09/2019 |  |                                   |         |
|                          |             |  |         |    |    | APPROVER    | Timothy Maimela        | 28/01/2021 |  |                                   |         |
| 15                       | 28/01/2021  | New Baseline 10.2.6  |         |    |    | CHECKER     | Bongane Masina         | 28/01/2021 |  |                                   |         |
|                          |             |  |         |    |    | COMPLIER    | Bongane Masina         | 28/01/2021 |  |                                   |         |
|                          |             |  |         |    |    | APPROVER    | Timothy Maimela        | 19/04/2021 |  |                                   |         |
| 20                       | 19/04/2021  | New Baseline change 10.3   |         |    |    | CHECKER     | Bongane Masina         | 19/04/2021 |  |                                   |         |
|                          |             |  |         |    |    | COMPLIER    | Bongane Masina         | 19/04/2021 |  |                                   |         |
|                          |             |  |         |    |    | APPROVER    | Collins Mkhombhi       | 20/02/2022 |  |                                   |         |
| 25                       | 20/04/2022  | New Baseline change 10.3.1   |         |    |    | CHECKER     | Andani Muthelo         | 20/02/2022 |  |                                   |         |
|                          |             |  |         |    |    | COMPLIER    | Andani Muthelo         | 20/02/2022 |  |                                   |         |
|                          |             |  |         |    |    | APPROVER    | Collins Mkhombhi       | 14/06/2022 |  |                                   |         |
| 26                       | 14/06/2022  | Update minimum temperature requirement for sealant application   |         |    |    | CHECKER     | Andani Muthelo         | 14/06/2022 |  |                                   |         |
|                          |             |  |         |    |    | COMPLIER    | Andani Muthelo         | 14/06/2022 |  |                                   |         |
|                          |             |  |         |    |    | APPROVER    | Collins Mkhombhi       | 26/07/2022 |  |                                   |         |
| 27                       | 27/07/2022  | Threshold measurements addition  |         |    |    | CHECKER     | Andani Muthelo         | 26/07/2022 |  |                                   |         |
|                          |             |  |         |    |    | COMPLIER    | Andani Muthelo         | 26/07/2022 |  |                                   |         |
|                          |             |  |         |    |    | APPROVER    | Collins Mkhombhi       | 19/10/2022 |  |                                   |         |
| 28                       | 19/10/2022  | Addition of traceability for sealant application   |         |    |    | CHECKER     | Nesozo Zwane           | 19/10/2022 |  |                                   |         |
|                          |             |  |         |    |    | COMPLIER    | Amogelang Mchampe      | 19/10/2022 |  |                                   |         |
|                          |             |  |         |    |    | APPROVER    | Vanessa Ntuli          | 14/04/2023 |  |                                   |         |
| 29                       | 14/04/2023  | Added sealant batch number & welding consumables traceability  |         |    |    | CHECKER     | Amogelang Mchampe      | 14/04/2023 |  |                                   |         |
|                          |             |  |         |    |    | COMPLIER    | Amogelang Mchampe      | 14/04/2023 |  |                                   |         |
|                          |             |  |         |    |    | APPROVER    | Tyson Ngweni           | 06/11/2023 |  |                                   |         |
| 30                       | 06/11/2023  | Added threshold traceability for boiler makers and welders   |         |    |    | CHECKER     | Andani Muthelo         | 06/11/2023 |  |                                   |         |
|                          |             |  |         |    |    | COMPLIER    | Nesozo Zwane           | 06/11/2023 |  |                                   |         |
| TRAINSET                 | CAR         | OPERATOR NAME AND ALPS NUMBER  |         |    |    | DATE        | SELF INSPECTION NUMBER |            |  |                                   | PAGES   |
| 213                      | KE2         | K90500 69522 010100  |         |    |    | 12/01/2024  | SI.CB2230.324.V29      |            |  |                                   | 12      |

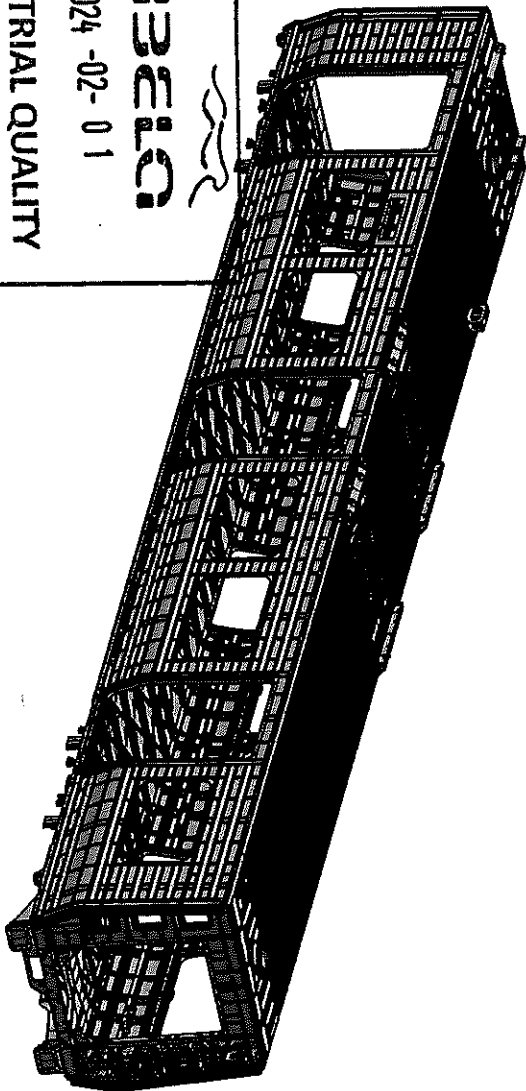
|       |      |
|-------|------|
| Carro | NCR: |
| Car:  |      |

**Work station:**

CB2230



## Safety Related



**2024-02-01**

**INDUSTRIAL QUALITY**

**MAINLINE**



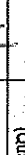
## I - Documentation and Instruments

### 1.1 - Documentation Control

| Document     | Type of car |    |    |    |    | Revision | Observation | OK | Signature/Date<br>(Signature) | Signature/Date<br>(Quality) |
|--------------|-------------|----|----|----|----|----------|-------------|----|-------------------------------|-----------------------------|
|              | TC1         | M1 | M2 | M3 | M4 |          |             |    |                               |                             |
| DT0000023319 |             |    |    |    | 2  | 30       |             | 2  | NA                            |                             |

## 1.2 - Instruments Control

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

| Instruments       | Validation | Calibration or Verification<br>Validation Date | OK | Signature/Date<br>(Quality)   |
|-------------------|------------|--|----|---|
| Pressure Gauge    | 40070076   | 2024/04/05                                     | X  |  14/2/22 |
| Conductance probe | 61555083   | 2024/03/18                                     | ✓  |  14/2/22 |
| Indicator         | 22913      |  | ✓  |  14/2/22 |

### 1.3 Consumables

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

[illegible]

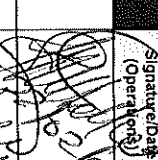
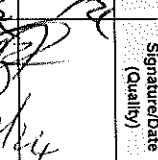

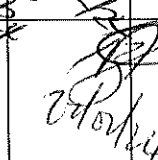

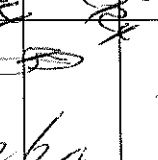

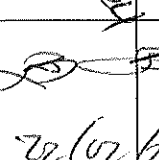

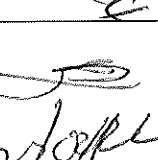



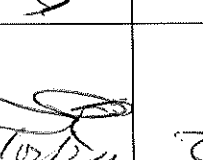


DT00000223319 Carshell Assembly TC

Rev.  
30  
Date-  
06/11/2023Project: PRASA  
SI.CB2230.324.V29

## II - Control Activities of Production

## II.1 - Items to check

| Item | Picture/Drawing     | Description  | Acceptance criteria / Record  | OK | Signature/Date<br>(Operators)   | Signature/Date<br>(Quality)   |
|------|---------------------|--|---|----|---|---|
| 01   | N/A                 | Assembly according to Instruction Engineering n° DT00000223319   | DT00000223319   | ✓  | <br>22/02/24 | <br>22/02/24 |
| 02   | N/A                 | Carshell free of significant flaws which compromise the appearance or functionality.   | DTD0000210675   | ✓  | <br>22/02/24 | <br>22/02/24 |
| 03   | REFER TO ANNEXURE A | Arc Welding inspected and approved according procedure.  | IND-SAL-WMS-016<br>DTD0000210675  | ✓  | <br>22/02/24 | <br>22/02/24 |
| 04   | N/A                 | Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.   | Approved according specified on pages below.  | ✓  | <br>22/02/24 | <br>22/02/24 |
| 05   | N/A                 | Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.  | As the welding procedure IND-SAL-WMS-018 and DTD0000210658  | ✓  | <br>22/02/24 | <br>22/02/24 |
| 06   | 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:<br>Temperature Min - Max (°) Min-Max 10°C - 35°C<br>Relative humidity Min - Max (%) Min-Max 25% - 80% | Sealant Batch<br>No: FA233257323<br>Exp Date: 02/02/24<br>Actuals<br>Temperature: 21°C<br>Humidity: 78%   | OK | <br>22/02/24   | <br>22/02/24   |
| 07   | N/A                 | Verification of sealant application in regions of roof and sidiframe finishers.  | Sealant must be:<br>-Applied straight and even (1.5mm)<br>-Free of gaps, cracks, damage and debris (flashes, dirt, dust)<br>Refer to Annexure B | ✓  | <br>22/02/24   | <br>22/02/24   |



2024-02-01

INDUSTRIAL QUALITY  
MAINLINE





DT00000223319 Carshell Assembly TC

| Rev.       |
|------------|
| 30         |
| Date-      |
| 06/11/2023 |

Project: PRASA  
SI.CB2230.324.V29

VIEW A



**END 1  
SEALANT**

OPERATOR  
(Name & sign):

Leato *(Signature)*

OPERATOR  
(Name & sign):

Boiky

**END 2 SEALANT  
(VIEW C)**

OPERATOR  
(Name & sign):

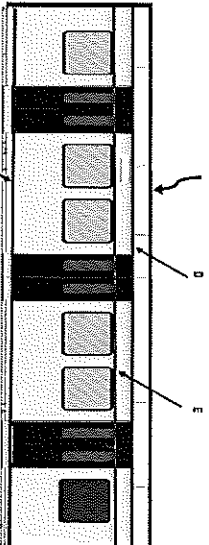
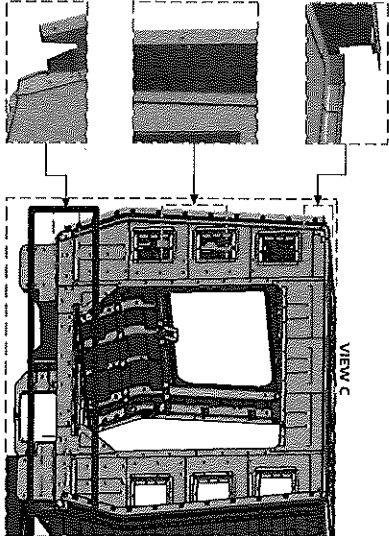
Leato *(Signature)*

OPERATOR  
(Name & sign):

Boiky

OPERATOR  
(Name & sign):

Leato *(Signature)*  
Boiky



**GIBBELQ**  
2024 -02- 01  
INDUSTRIAL QUALITY  
MAINLINE

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

Operator(Name & sign) :

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

Operator (Name & sign) :

Leato *(Signature)* Leato *(Signature)* Boiky

Operator (Name & sign) :

Boiky

Operator (Name & sign) :

Boiky

Operator (Name & sign) :

Boiky

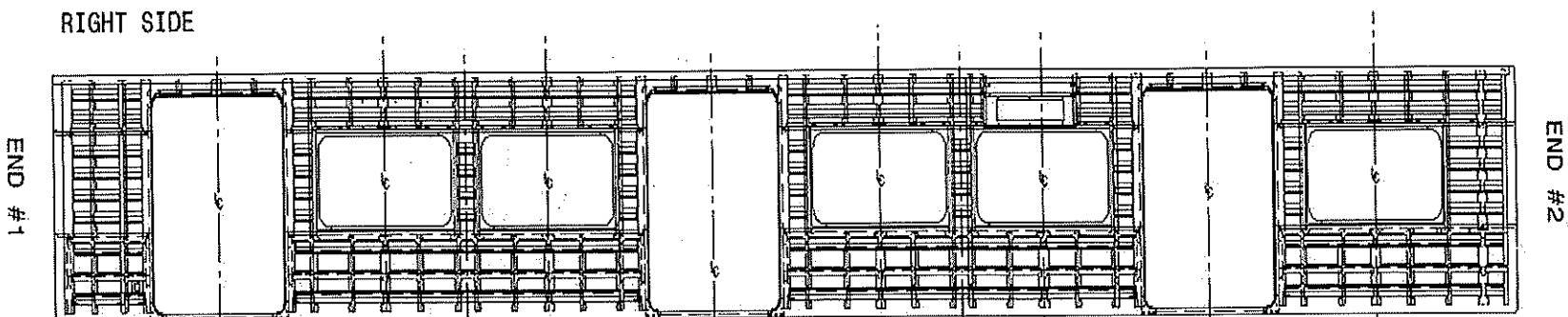
Operator (Name & sign) :

Boiky

Specifications of Details for CBS measurement CB2230

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.

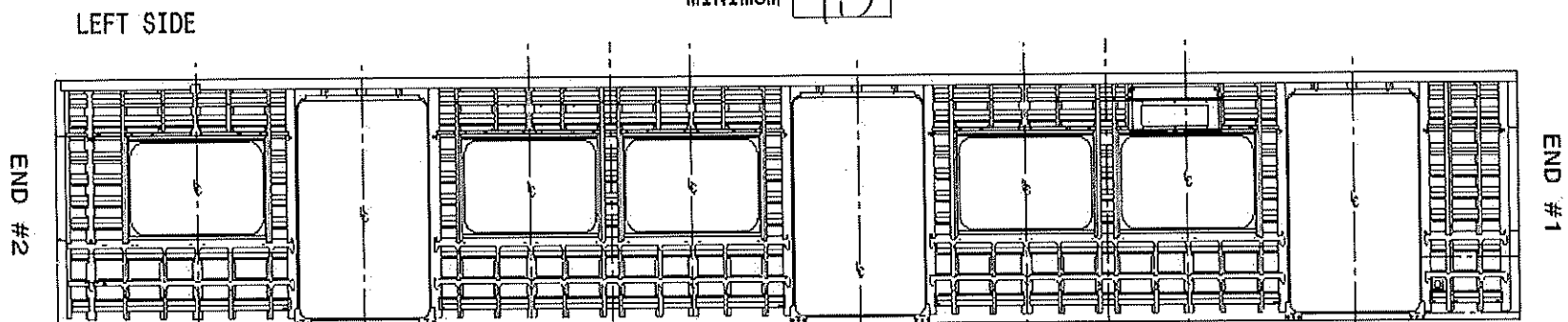
RIGHT SIDE



MAXIMUM 1.9

MINIMUM 1.3

LEFT SIDE



MAXIMUM 1.7

MINIMUM 1.2

**GIBELD**

2024 -02- 0 1

INDUSTRIAL QUAL  
MAINLINE





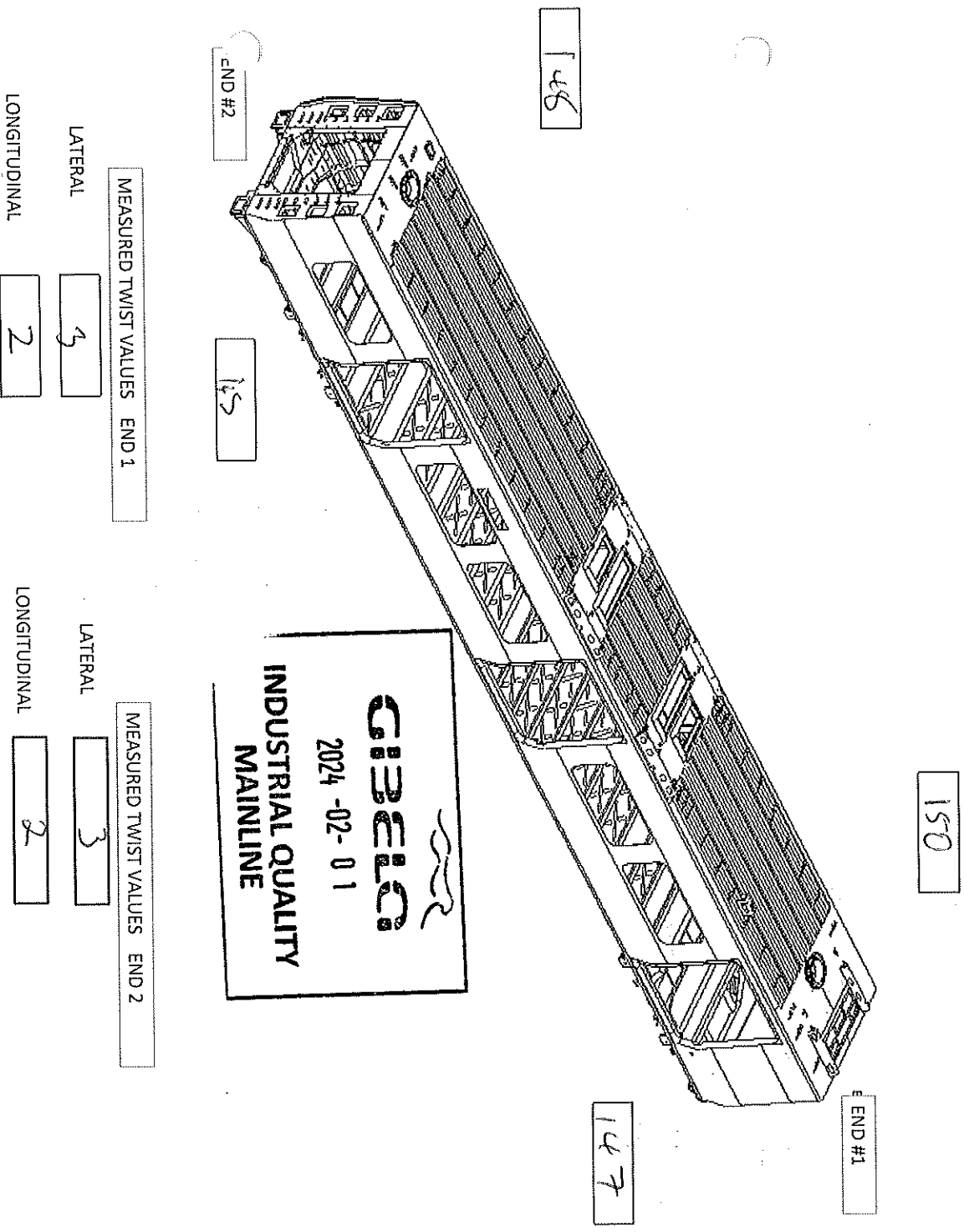
DT00000223319 Carshell Assembly TC

| Rev.       |
|------------|
| 30         |
| Date-      |
| 06/11/2023 |

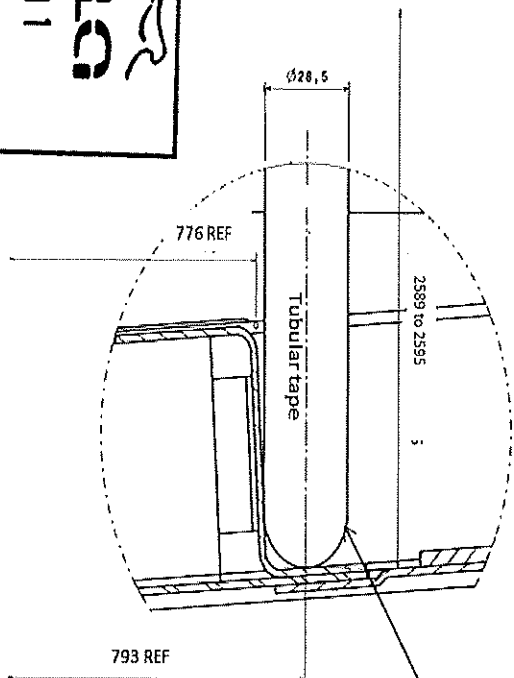
Project: PRASA  
SI.CB2230.324.V29

Specifications of Details for CBS measurement    **CB2230**

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.



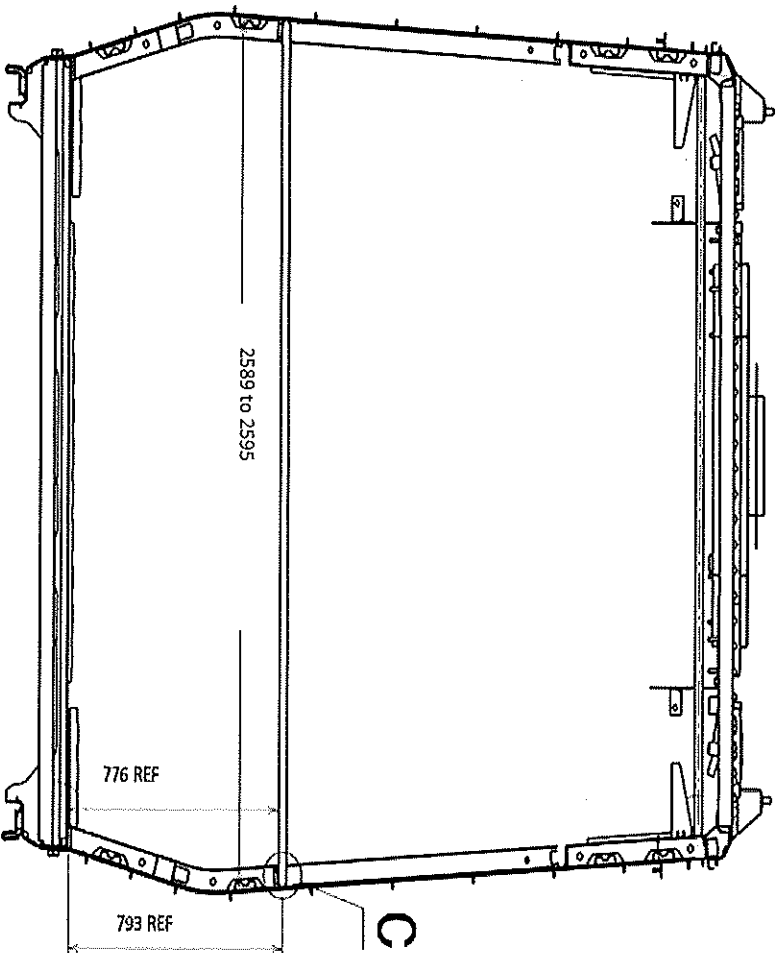
Details for measuring on the CB1230 stage, after completion of activities

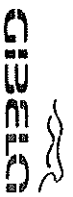


Carry the tubular tape on the "Z" bottom of Windows

**GIBELQ**  
2024 -02- 01  
INDUSTRIAL QUALITY  
MAINLINE

Detail C



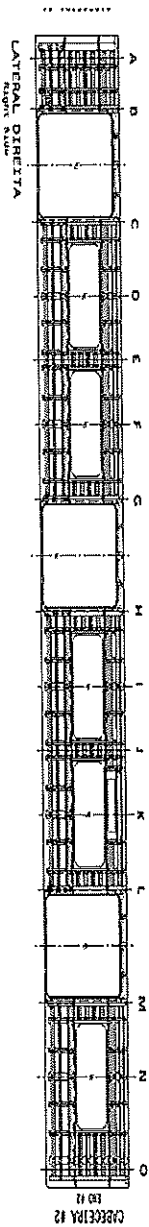


DT00000223319 Carshell Assembly TC

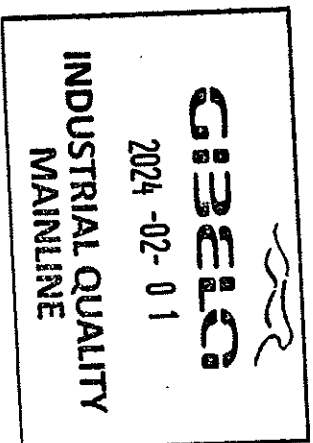
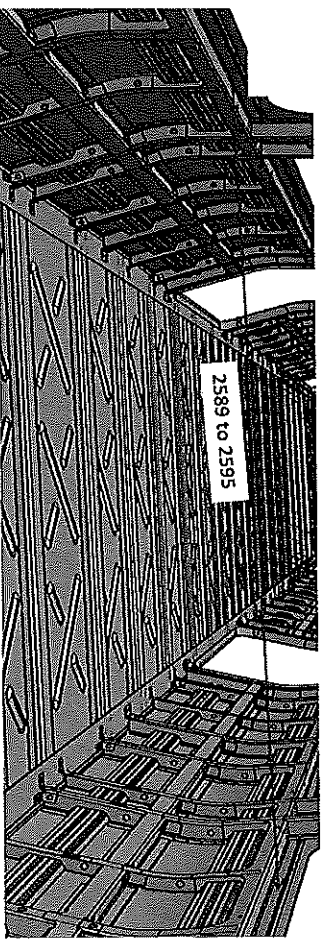
| Rev.       |
|------------|
| 30         |
| Date-      |
| 06/11/2023 |

Project: PRASA  
SI.CB2230.324.V29

### Specifications of Details for CBS measurement



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



### Threshold verification

| Door 1 |    | Door 2 |    | Door 3 |    |
|--------|----|--------|----|--------|----|
| L      | R  | L      | R  | L      | R  |
| 38     | 28 | 39     | 38 | 37     | 37 |
| Door 4 |    | Door 5 |    | Door 6 |    |
| L      | R  | L      | R  | L      | R  |
| 38     | 38 | 38     | 38 | 39     | 38 |

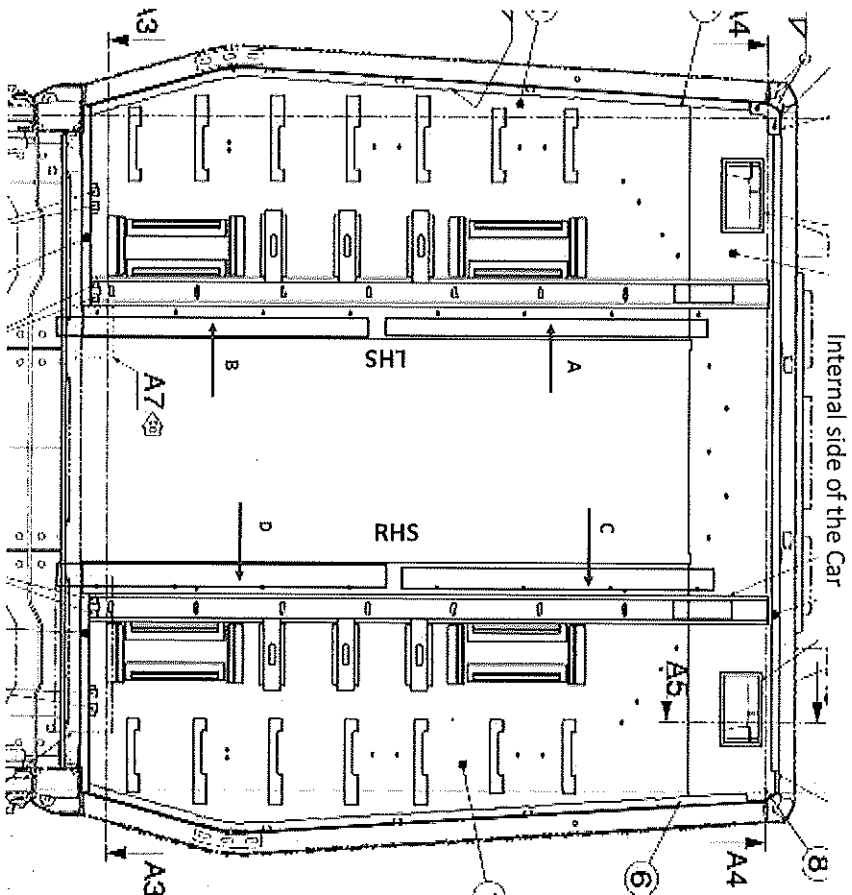
BOILER MAKER: Murthyapelo WASDA

WELDER: Murthyapelo WASDA

### Specifications of Details for CBS measurement

Measure the flatness on the Cab Fire Barrier after installation and welding. Measure positions A, B, C and D using 1000mm flatness ruler and taper gauge.

Specified Maximum Flatness deviation on Cab Fire Barrier = 2mm





DT00000223319 Carshell Assembly TC

Rev.  
30

**Project: PRASA**

SI.CB2230.324.V29

## Dye penetrant test

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

[illegible]





DT00000223319 Carshell Assembly TC

Rev.  
30

Project: PRASA

SI.CB2230.324.V29

Date-  
06/11/2023

Self Inspection - Final Result

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

|            |       | DATE   | NAME                                | SIGNATURE          |
|------------|-------|--|-------------------------------------|--------------------|
| HOLD POINT | GO    | <i>apb/bt</i>  | <i>Legido</i><br>Operations         | <i>[Signature]</i> |
|            |       | <i>26/02/23</i>  | <i>Wolend</i><br>Industrial Quality | <i>[Signature]</i> |
|            | NO GO | Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)  |                                     |                    |
|            |       | There are activities pendings that impadstop the activities of the next process Obs: (To describe problems below)<br><br>There are non-conformities impact the quality of the product and there is no corrective action defined yet) | Operations<br>Industrial Quality    |                    |

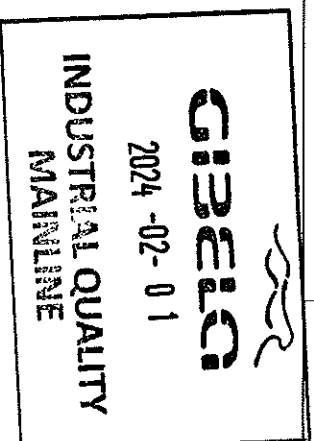
In case of "NO GO", describe blocking problems


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

| Item | Description | Action | Responsible | Due date | Status |
|------|-------------|--------|-------------|----------|--------|
|      |             |        |             |          |        |
|      |             |        |             |          |        |
|      |             |        |             |          |        |

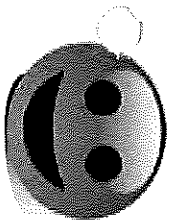
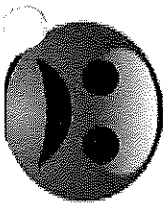
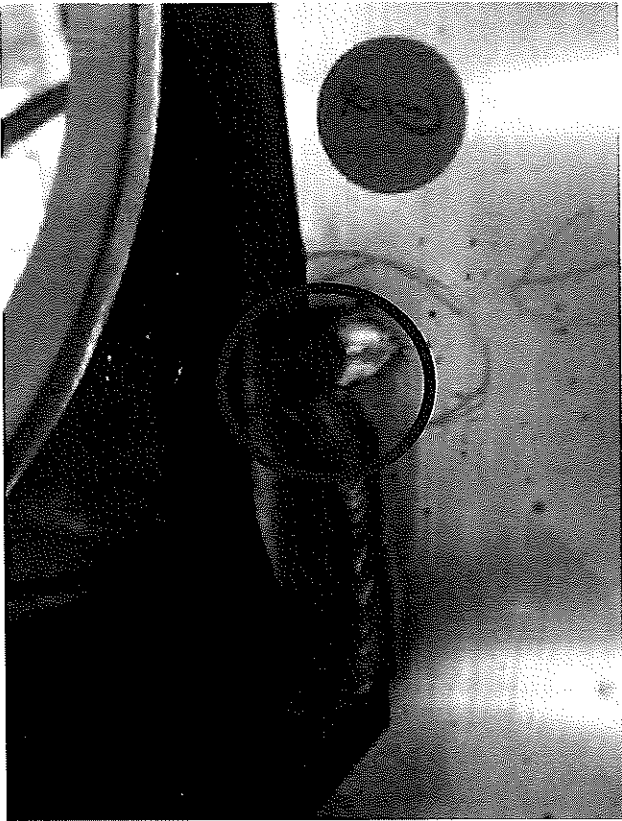
Operations


Quality



|   |                                    |  |            |                   |
|---|------------------------------------|--|------------|-------------------|
|  <b>GIBELD</b> | DT00000223319 Carshell Assembly TC |  | Rev.<br>30 | Project: PRASA    |
|   | 06/11/2023                         |  | Date-      | SI.CB2230.324.V29 |

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



|  |  |                                    |  |                     |                   |
|--|--|------------------------------------|--|---------------------|-------------------|
|  |  | DT00000223319 Carshell Assembly TC |  | Rev.<br>30          | Project: PRASA    |
|  |  |                                    |  | Date-<br>06/11/2023 | SI.CB2230.324.V29 |

**ANNEXURE B: Sealant**

