

CABIN STRUCTURE QUALITY CARD

CAB No.: CAB446 _

WEIGHT: 1491 Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	01/02/24	178247 104825 01	LP49402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	14/02/24	178220 104640 01	F205212	
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegasus	28/02/24	178488 104640 01	P200091	
RCS 355	20 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegasus	12/02/24			
RCS 355	30 mm					

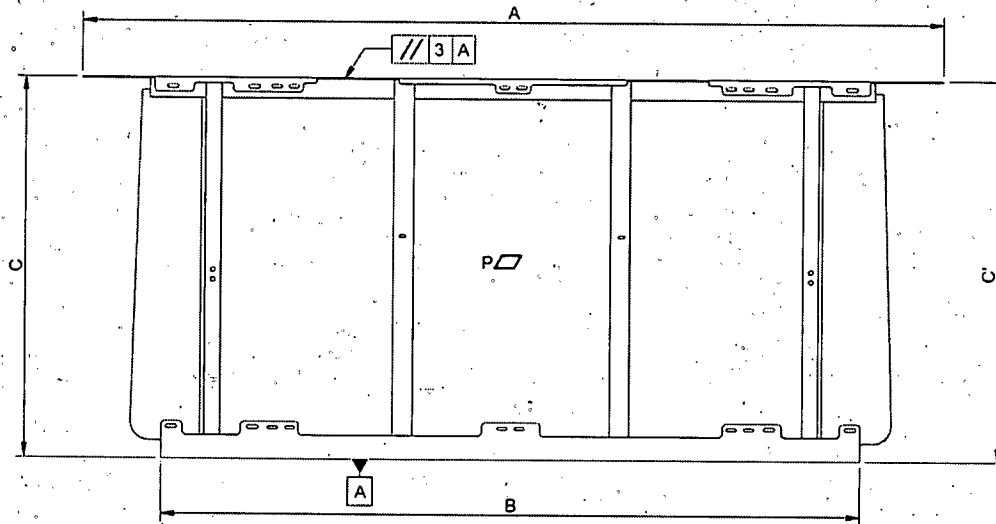
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	08/02/24	178489 104640 01	VHL 35578	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	F207905	TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	14/02/24	178815 104640 01	VHL 28402	
RCS 450	6 mm					
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	FV07906	TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	22/11/23	175919 10200 01	VHSS432	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

Cabin Roof Assembly: GN002839

Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<u>DYLAN DAVIDS</u>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>23</u>			
Sign:	<u>[Signature]</u>	Wire Batch No.:	107238201			



Welding Control

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

Dimensional Control

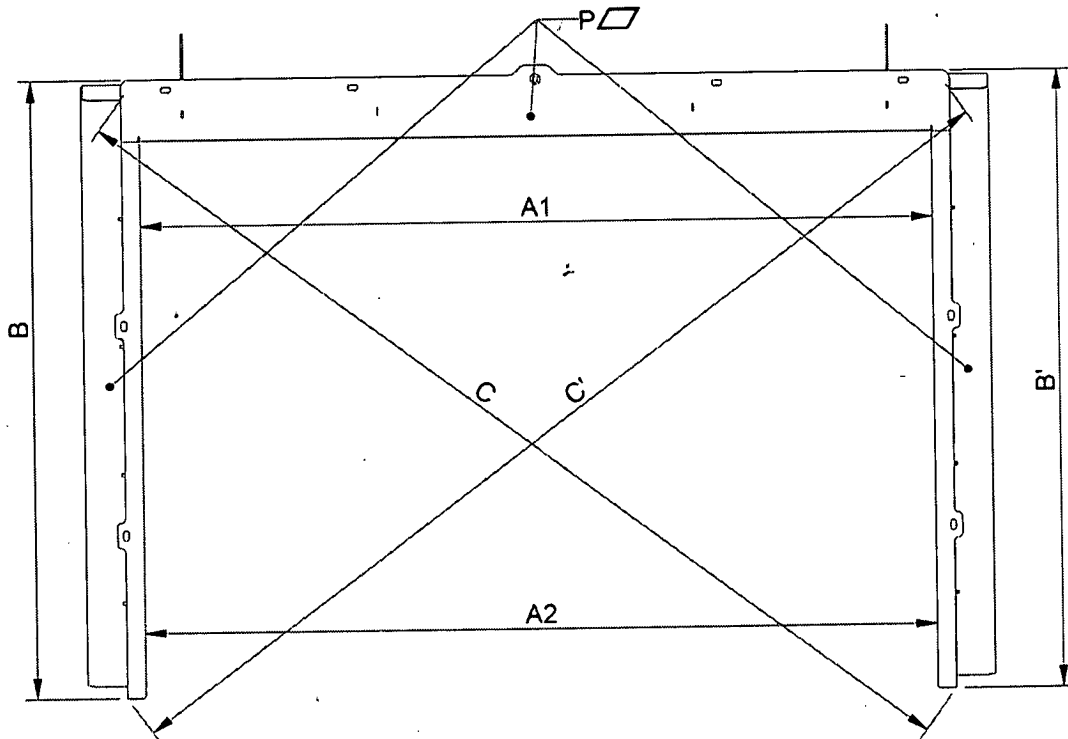
Rep.	Toler.	Dimension measured	Measuring Equipment	Observations		
A	2216	<u>+5/-0</u> <u>2216</u>	Tape Measure	<u>[Signature]</u>		
B	1800	<u>± 4</u> <u>1800</u>		<u>[Signature]</u>		
C	976	<u>+2/-3</u> <u>978</u> <u>977</u>		<u>[Signature]</u>		
QC Inspector:	<u>Leon</u>	Sign:	<u>[Signature]</u>	Date:	20 <u>24</u> / <u>02</u> / <u>23</u>	

Geometrical Control

Nature of Checks	Dimension Measured	Measuring Equipment	Observations		
Planarity P	<u>6 mm</u>	<u>Ruler</u>	<u>[Signature]</u>		
// 3	<u>A</u>	<u>Set Square</u>	<u>[Signature]</u>		
QC Inspector:	<u>Leon</u>	Sign:	<u>[Signature]</u>		
			Date:	20 <u>24</u> / <u>02</u> / <u>23</u>	

Cabin Front Frame Assembly: GN002840


Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<u>Ramello G. Ganan</u>	Assembly Date:	20 <u>24/02/23</u>	
Sign:	<u>[Signature]</u>	Wire Batch No.:	<u>2202-1.92</u>	



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	<u>Leon</u>	Sign:	<u>[Signature]</u>	Date: <u>2024/02/23</u>

Dimensional Control

Rep	Theoretical Dim\}	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	1910	± 2	1911		Tape Measure	Accepted	
A2	1910		1910			Accepted	
B	1475	± 1	1474	1474		Accepted	
C	Diagonals C - C' ≤ 3		2474	2476		Accepted	
QC Inspector:		Leon		Sign:		Date:	2024/02/23

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P : Planeity	4 mm	<u>Pass</u>	Ruler	<u>Accepted</u>
QC Inspector:	<u>Leon</u>		Sign:	<u>[Signature]</u>
				Date: <u>2024/02/23</u>

Cabin LHS/RHS Wing Mirror Plate Assembly: GN002846/GN002844				
Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>Xander</i>	Assembly Date:	2024/02/14	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152	

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907				
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>Glenn</i>	Assembly Date:	2024/02/14	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152	

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897				
Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>Glenn</i>	Assembly Date:	2024/02/14	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152	

Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078

Confirmed

Yes

No

Operator:

Glenn

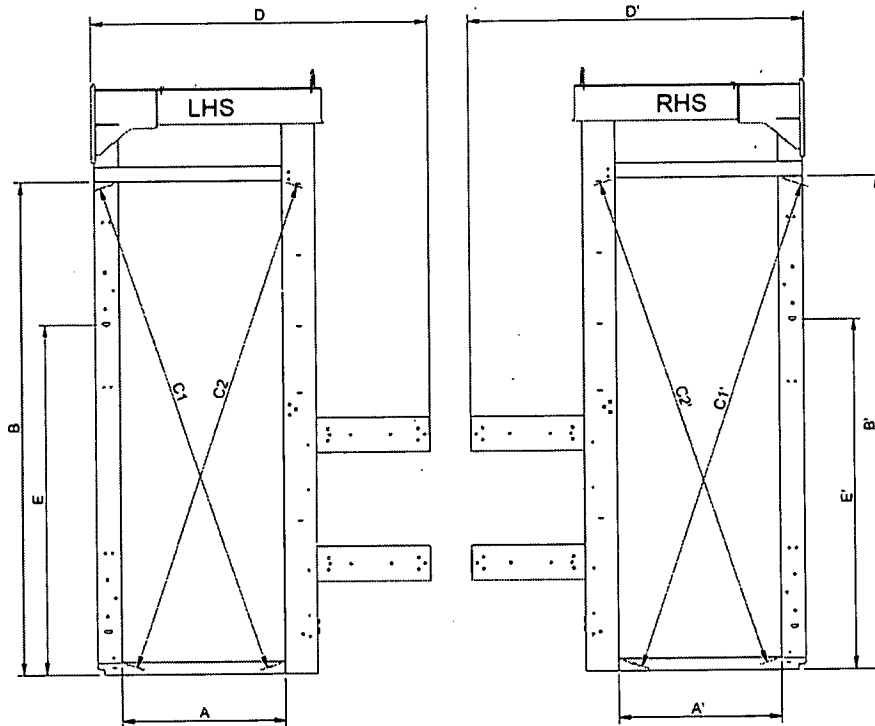
Assembly Date:

20 24/02/19

Sign:

Wire Batch No.:

2202152



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042

Confirmed

Yes

☒

No

QC Inspector:

LEON

Sign:

(Signature)

Date:

20 24/02/19

Dimensional Control

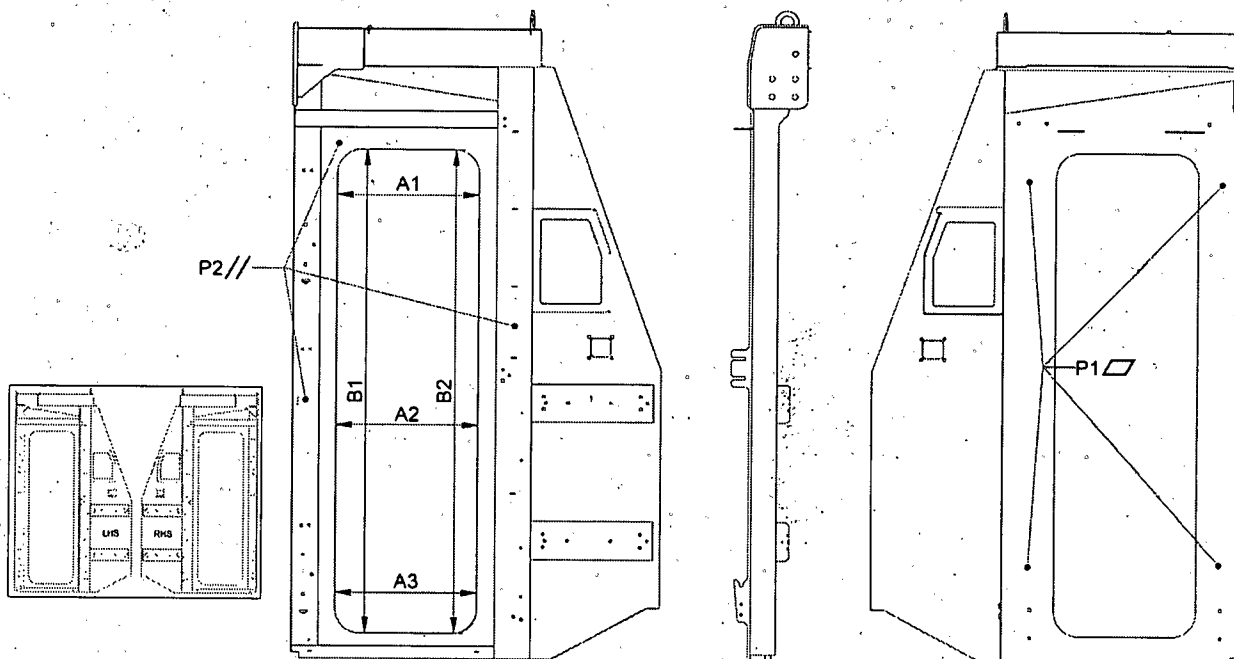
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	696	Tape Measure	Acceptable
B	2086	+1/-3	2087	2087		Acceptable
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2155	2154		Acceptable
C1 - C2			2155	2152		Acceptable
D	1438	+2/-3	1436	1436		Acceptable
E						
QC Inspector:		LEON	Sign:		(Signature)	Date: 20 <u>24</u> / <u>02</u> / <u>19</u>

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations	
P1 : planeity of 2 edges	4 mm	Pass	Ruler	Acceptable	
QC Inspector:	Leon	Sign:	A	Date:	20_24/_02/_19

Cabin LHS/RHS Side Assembly: GN002838/GN002837

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>Xander</i>	Assembly Date:	2024/02/19			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			




Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
QC Inspector:	<i>Leav</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/23	

Dimensional Control

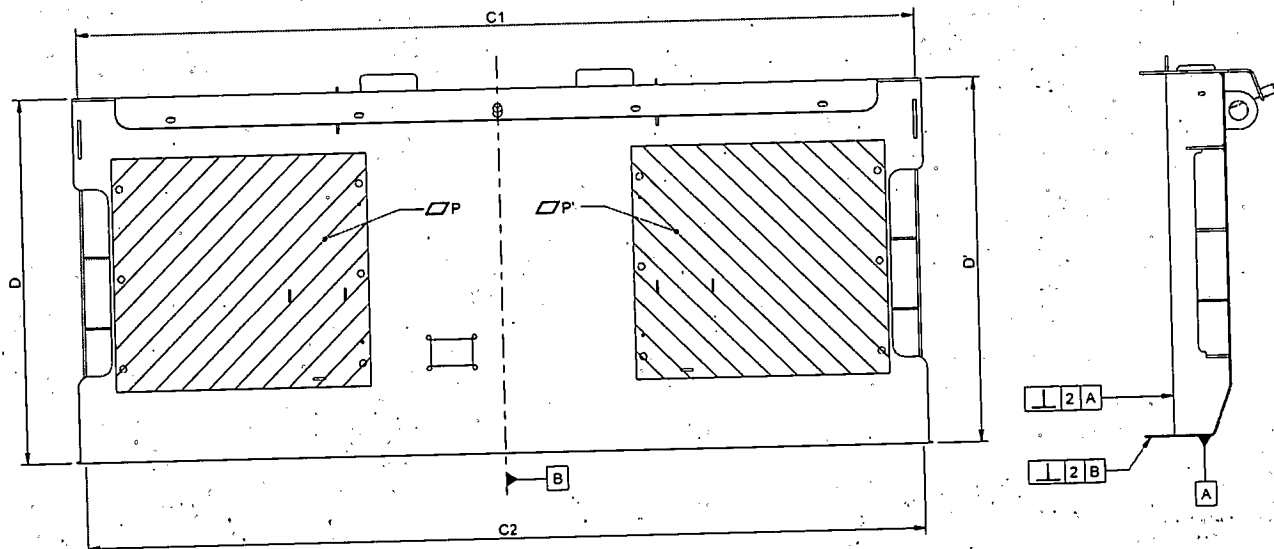
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	560	± 2	558	557	Tape Measure	Accept	
A2			559	558		Accept	
A3			560	559		Accept	
B1	1900	± 2	1898	1898		Accept	
B2			1897	1898		Accept	
QC Inspector:			Sign:			Date:	2024/02/23

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations	
P1 : Planeity	4 mm	<i>P0.550</i>	Ruler	<i>Accept</i>	
P2 : Planeity	2 mm	<i>P0.550</i>	Ruler	<i>Accept</i>	
QC Inspector:	<i>LGU</i>	Sign:		Date:	2024/02/23

Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Raimundo G. C. Lima</i>	Assembly Date:	2024/02/23			
Sign:	<i>[Signature]</i>	Wire Batch No.:	9202152			



Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/23	

Dimensional Control

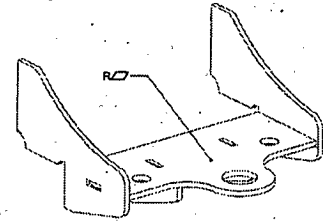
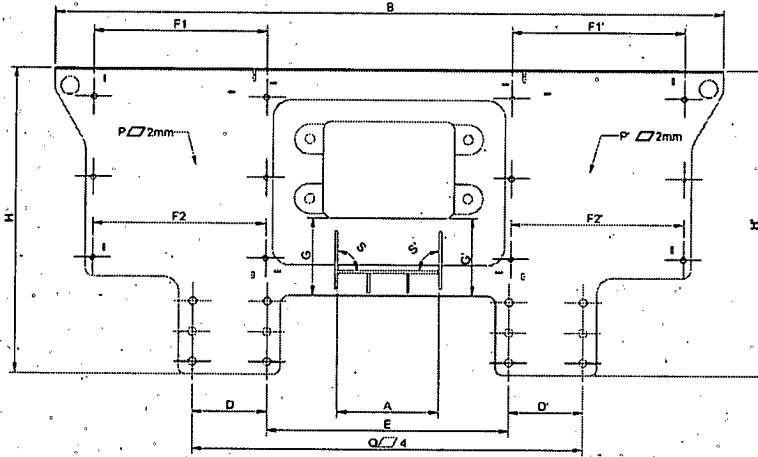
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	<i>2214</i>	<i>2213</i>	Tape Measure	<i>Accepted</i>
D / D'	956	± 2	<i>955</i>	<i>956</i>		<i>Accepted</i>
QC Inspector:	<i>Leon</i>		Sign:	<i>[Signature]</i>	Date:	2024/02/23

Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planeity P / P'		2 mm	<i>Pass</i>		Ruler	<i>Accepted</i>
Perpendicularity	2	A	<i>Pass</i>		Set Square	<i>Accepted</i>
	2	B	<i>Pass</i>		Set Square	<i>Accepted</i>
QC Inspector:	<i>Leon</i>		Sign:	<i>[Signature]</i>	Date:	2024/02/23

Cabin Front Headstock Assembly: GN002841


Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>T. K. Booth</i>	Assembly Date:	2024/02/23			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202/SZ			




Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/20	

Dimensional Control

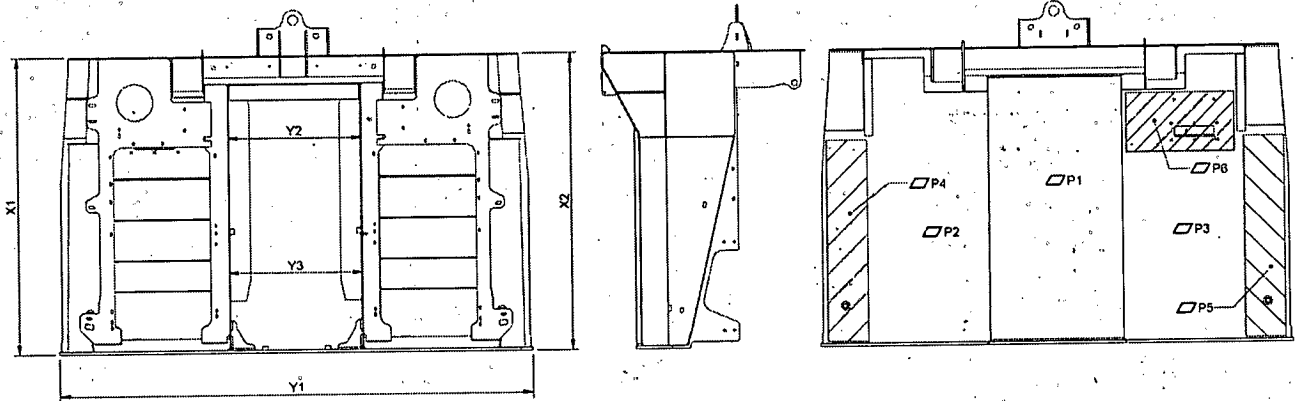
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	340	± 1	339		Tape Measure	Acceptable	
B	2240	± 4	2244			Acceptable	
D / D'	250	± 1	250.5	250.5		Acceptable	
E	808	± 2	807			Acceptable	
F1 / F1'	580	± 1	581	581		Acceptable	
F2 / F2'			581	581		Acceptable	
G / G'	258	± 1	258	258		Acceptable	
H / H'	1019	± 2	1020	1020		Acceptable	
QC Inspector:		Leon		Sign:		Date:	2024/02/20

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
O: Planeity of global assembly	4 mm	PASSED	Ruler	Acceptable
P / P': Planeity	2 mm	PASSED	Ruler	Acceptable
Q: Planeity Surface of Supports	4 mm	PASSED	Ruler	Acceptable
R: Planeity Coupler Support	2 mm	PASSED	Ruler	Acceptable
S: Perpendicularity coupler	1mm	PASSED	Square	Acceptable
QC Inspector:	LGow	Sign:		Date: 2024/02/20

Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>21</u>	
Sign:	<i>[Signature]</i>	Wire Batch No.:	22 02152	



Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date: 20 <u>24</u> / <u>02</u> / <u>21</u>

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1488	1486	Tape Measure	<i>Accepted</i>
Y1	2354	± 3	2353			<i>Accepted</i>
Y2 / Y3	666	± 1	667	667		<i>Accepted</i>
QC Inspector:		<i>LEON</i>	Sign:		<i>[Signature]</i>	Date: 20 <u>24</u> / <u>02</u> / <u>21</u>

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : Planéité	4 mm	<i>Passé</i>	Ruler	<i>Accepted</i>
P2 / P3 : Planéité	4 mm	<i>Passé</i>	Ruler	<i>Accepted</i>
P4 / P5 : Planéité	2 mm	<i>Passé</i>	Ruler	<i>Accepted</i>
P6 : Planéité	2 mm	<i>Passé</i>	Ruler	<i>Accepted</i>
QC Inspector:		<i>LEON</i>	Sign: <i>[Signature]</i> Date: 20 <u>24</u> / <u>02</u> / <u>21</u>	

Cabin Structure Assembly: GN002834

Assembly Completed as per WI/SOS MD_0039

Confirmed

Yes

☒

No

Operator:

Dumir

Assembly Date:

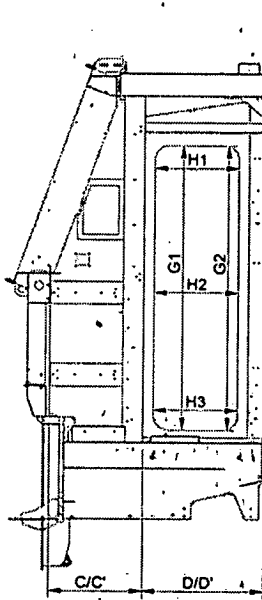
20 *24/02/25*

Sign:

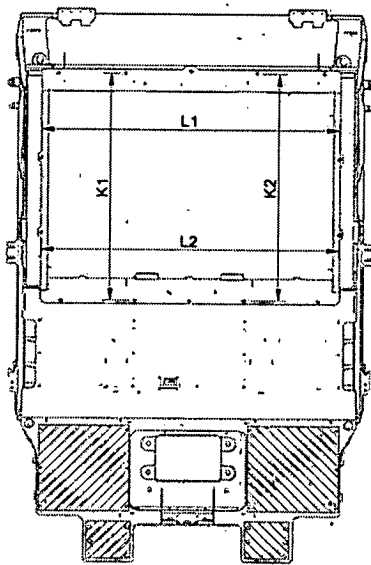
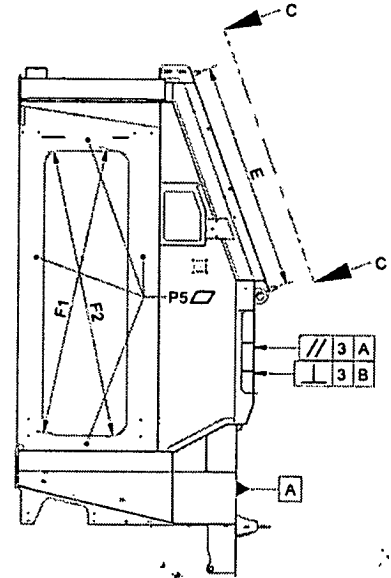
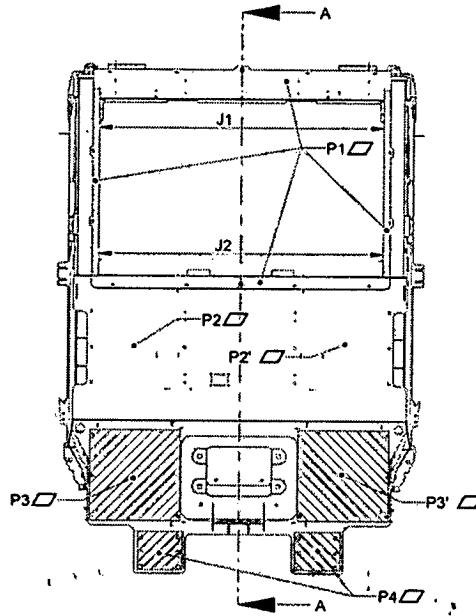
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Wire Batch No.:

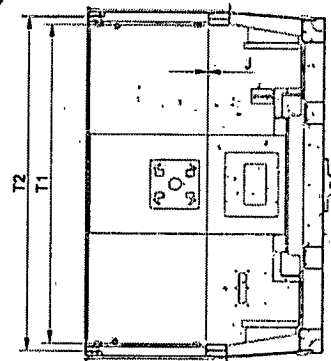
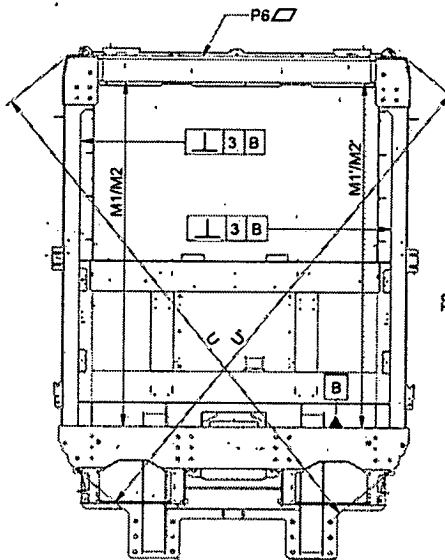
2202152



SECTION A-A



AUX VIEW: C



SECTION B-B

Welding Control										
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed		Yes		No	
QC Inspector:		Leon			Sign:				Date: 2024/02/28	
Dimensional Control										
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations					
C / C'	625	± 2	626	625	Acceptable					
D / D'	813	± 2,5	811	812	Acceptable					
E	1531.5	± 3	1530		Acceptable					
G1 / G'1	Height	+1	1898	1897	Acceptable					
G2 / G'2	1900	-3	1899	1898	Acceptable					
H1 / H'1	Width 560	+1	557	558	Acceptable					
H2 / H'2		-3	558	558	Acceptable					
H3 / H'3		558	559	Acceptable						
F1 / F'1	Diagonals 1939		1936	1937	Acceptable					
F2 / F'2			1937	1935	Acceptable					
Difference	F1-F2 / F'1-F'2	≤ 4	1	2	Acceptable					
J	Gap of Doors	± 1,5	1		Acceptable					
K1 / K2	1515	± 3	1515	1513	Acceptable					
L1 / L2	1996	± 3	1998	1996	Acceptable					
M1 / M'1	2306	± 3	2468	2468	Acceptable					
M2 / M'2			2478	2478	Acceptable					
T1 / T'1	2130 Top/Bottom	± 3	2127	2127	Acceptable					
T2 / T'2	2230 Top/Bottom		2230	2230	Acceptable					
Difference	U - U' (3522)	≤ 4mm	3523	3520	Acceptable					
QC Inspector:		Leon			Sign:				Date: 2024/02/28	
Geometrical Control										
Nature of checks				Toler.	LHS / Dimension Measured / RHS		Observations			
P1 / P'1	Planeity			2 mm	Passes		Acceptable			
P2 / P'2	Planeity			2 mm	Passes		Acceptable			
P3 / P'3	Planeity			4 mm	Passes		Acceptable			
P4 / P'4	Planeity			4 mm	Passes		Acceptable			
P5 / P'5	Planeity			4 mm			Acceptable			
P6 Roof	Planeity			6 With 2m Ruler	Passes		Acceptable			
Shield	//	3	A	3	Passes		Acceptable			
Shield	⊥	3	A	3	Passes		Acceptable			
Door Post	⊥	3	A	Front	Passes		Acceptable			
				Back	Passes		Acceptable			
QC Inspector:		Leon			Sign:				Date: 2024/02/28	

Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator: <i>Daniel</i>	Assembly Date:	2024/02/28			
Sign: <i>[Signature]</i>	Wire Batch No.:	2202152			

Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator: <i>[Signature]</i>	Assembly Date:	2024/03/19			
Sign: <i>[Signature]</i>	Wire Batch No.:				

Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Fasteners positioned in all Rivnuts and Bosses	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Masked as per GMS-SOS-GIBELA-CABIN-001	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID	Sign:			
Date:	2024/03/19				
Record of Shot Blasting					
Operator:		Date:	2024/03/19		
Start Time:	07:13	End Time:	11:05		
Temperature ($\geq 15^\circ$):	20.04°C	Humidity ($\leq 75\%$):	67.02%		
Shot Blasting Self Inspection					
Interior of Cabin: Sa 1 - Light Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID	Sign:			
Date:	2024/03/19				
Shot Blasting Cleaning					
Cabin free of all sand.	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID	Sign:			
Date:	2024/03/19				
Shot Blasting Control					
Temperature $\geq 15^\circ$:	21.08°C	Humidity $\leq 75\%$:	69.06%		
Internal Roughness $3.2 \leq Ra \leq 12.5$	10.973	External Roughness $3.2 \leq Ra \leq 12.5$	09/07.776		
QC Inspector:	LOW	Sign:			
Date:	19/03/24				

Record of Priming									
Start Time:		19:00		End Time:		20:00			
Temperature $\geq 15^{\circ}$:		25 $^{\circ}$		Humidity $\leq 75\%$:		65%			
Paint Batch No.:		7978267		Paint Expiry Date:		06/25			
Hardener Batch No.:		7331119		Hardener Expiry Date:		01-11-24			
Desolvation Start Time:		20:00		Desolvation End Time:		20:15			
Stoving Start Time:		20:15		Stoving End Time:		21:15			
Stoving Temp:		60 $^{\circ}$							
Operator:		NTUTLWHO		Sign:					
Date:		2024/03/19				NTUTLWHO			
Priming Control									
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front			
1: 64.3	5: 57.1	1: 56.0	5: 63.8	1: 77.0	5: 54.6	1: 60.4	5: 55.4		
2: 51.5	6: 79.9	2: 75.2	6: 59.2	2: 81.4	6: 72.8	2: 63.9	6: 78.3		
3: 49.9	7: 78.7	3: 50.1	7: 52.6	3: 73.2	7: 67.5	3: 56.7	7: 74.0		
4: 45.7	8: 84.8	4: 62.6	8: 76.8	4: 53.3	8: 58.1	4: 50.7	8: 61.5		
Min:	45.7	Min:	56.1	Min:	53.3	Min:	50.7		
Max:	84.8	Max:	76.8	Max:	81.4	Max:	78.3		
Average:	63.9	Average:	62.0	Average:	67.2	Average:	62.6		
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside			
1: 81.1	5: 64.8	1: 73.3	5: 64.9	1: 45.3	5: 64.8	1: 62.0	5: 83.7		
2: 68.7	6: 71.1	2: 58.1	6: 73.4	2: 64.4	6: 75.0	2: 71.9	6: 81.1		
3: 42.7	7: 55.8	3: 44.9	7: 77.1	3: 58.3	7: 69.3	3: 79.3	7: 72.2		
4: 58.7	8: 49.9	4: 68.5	8: 83.2	4: 71.4	8: 60.9	4: 85.6	8: 78.6		
Min:	42.7	Min:	44.9	Min:	45.3	Min:	63.0		
Max:	81.1	Max:	83.2	Max:	75.0	Max:	85.5		
Average:	61.5	Average:	67.9	Average:	63.6	Average:	76.9		
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS			
1: 63.2	5: 41.9	1: 78.5	5: 63.0	1: 84.3	5: 72.3	1: 65.3	5: 68.9		
2: 76.6	6: 65.5	2: 75.8	6: 72.3	2: 78.7	6: 65.5	2: 79.2	6: 73.6		
3: 51.8	7: 79.8	3: 63.3	7: 59.6	3: 69.2	7: 79.6	3: 71.4	7: 65.8		
4: 47.1	8: 44.3	4: 77.8	8: 72.6	4: 81.9	8: 72.1	4: 83.5	8: 81.0		
Min:	41.9	Min:	59.6	Min:	65.5	Min:	65.3		
Max:	79.8	Max:	78.5	Max:	84.3	Max:	83.5		
Average:	58.7	Average:	70.3	Average:	75.4	Average:	73.5		
Primer has been inspected and is free of defects				Confirmed		Yes		No	
QC Inspector:		Zotule		Sign:					
Date:		20 Mar 2024							

Record of Painting NCSS3010 R90B			
Start Time:	1:00	End Time:	2:00
Temperature $\geq 15^{\circ}$:	29°C	Humidity $\leq 75\%$:	42%
Paint Batch No.:	8156903	Paint Expiry Date:	23-01-25
Hardener Batch No.:	7502115121	Hardener Expiry Date:	12-24
Desolvation Start Time:	2:00	Desolvation End Time:	2:15
Stoving Start Time:	2:15	Stoving End Time:	3:15
Stoving Temp:	60°C		
Operator:	Ntuthuko	Sign:	Ntuthuko
Date:	2024/03/02		
Painting NCSS3010 R90B Control			
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS	
1: 136.9	5: 100	1: 74	5: 126.9
2: 108	6: 113	2: 130.8	6: 96.8
3: 79.8	7: 98	3: 102.9	7: 113.4
4: 104	8: 84.6	4: 116.7	8: 102.2
Min: 79.8		Min: 74	
Max: 136.9		Max: 130.8	
Average: 103		Average: 107	
Painting NCSS3010 R90B has been inspected and is free of defects		Confirmed	Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	46.8
QC Inspector:	Reece	Sign:	Reece
Date:	21/3/24		

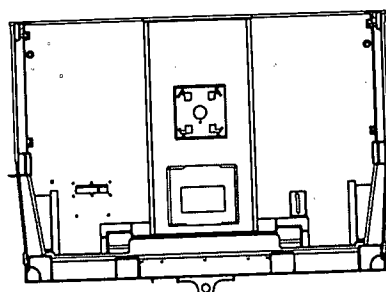
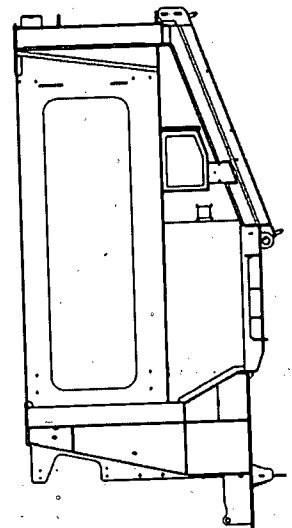
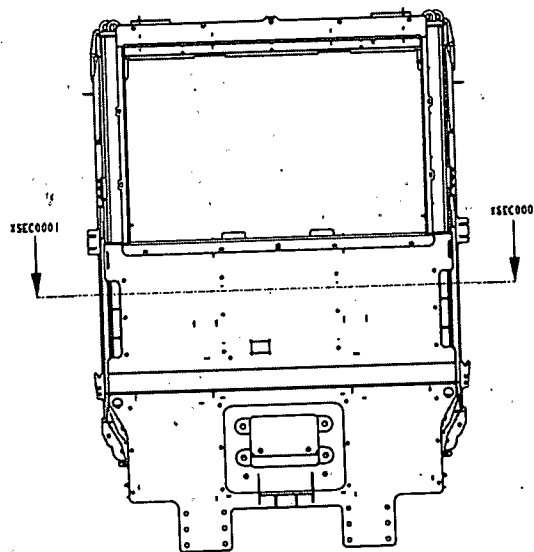
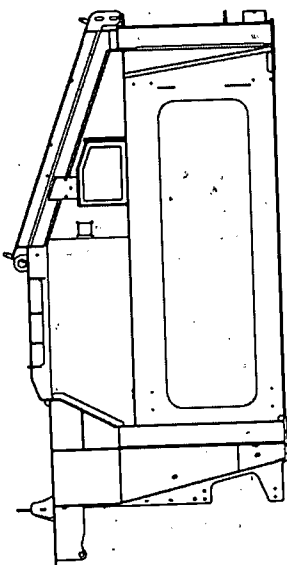
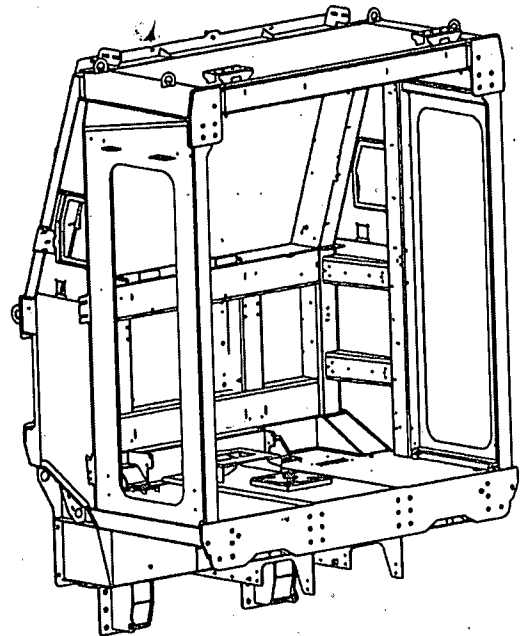
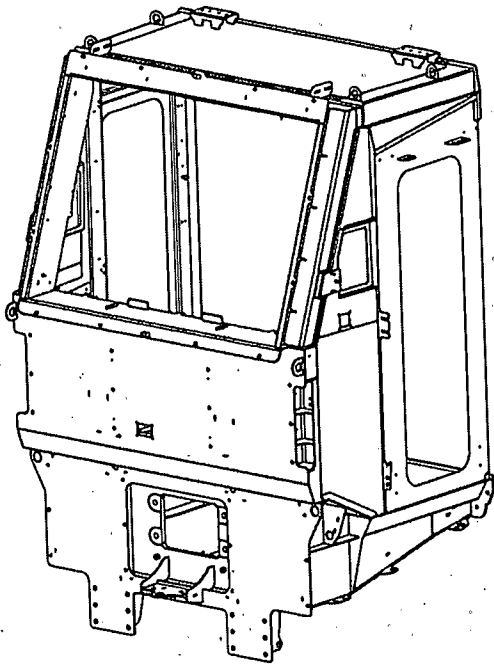
Record of Painting Blue NCSS1565 B					
Start Time:		4:00		End Time:	
Temperature $\geq 15^{\circ}$:		28 $^{\circ}$ C		Humidity $\leq 75\%$:	
Paint Batch No.:		8176318		Paint Expiry Date:	
Hardener Batch No.:		7802115121		Hardener Expiry Date:	
Desolvation Start Time:		5:00		Desolvation End Time:	
Stoving Start Time:		5:15		Stoving End Time:	
Stoving Temp:		60 $^{\circ}$ C			
Operator:		Ntuthuko		Sign:	
Date:		2024/03/20			
Painting Blue NCSS1565 B Control					
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)	
1: 127.6	5: 104.9	1: 116.8	5: 116.8		
2: 102.6	6: 131.8	2: 102.4	6: 112.3		
3: 111.3	7: 104.2	3: 113.8	7: 116.8		
4: 141.8	8: 100.6	4: 103.2	8: 150.4		
Min:	100.6	Min:	102.4		
Max:	127.6	Max:	150.4		
Average:	115.6	Average:	117		
Painting NCSS3010 R90B has been inspected and is free of defects					
				Yes	<input checked="" type="checkbox"/>
				No	<input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	
				90.1	
QC Inspector:		Deece		Sign:	
Date:		2/03/21			

Record of RAL 7012							
Start Time:		16:00		End Time:		18:00	
Temperature $\geq 15^{\circ}$:		20.2		Humidity $\leq 75\%$:		70%	
Paint Batch No.:		8156853		Paint Expiry Date:		06-02-2025	
Hardener Batch No.:		7502115 121		Hardener Expiry Date:		12-24	
Desolvation Start Time:		18:00		Desolvation End Time:		18:15	
Stoving Start Time:		18:15		Stoving End Time:		19:15	
Stoving Temp:		60.2					
Operator:		musa,		Sign:		musa,	
Date:		2024/03/20					
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 82.3	5: 90.8	1: 113.8	5: 102.3	1: 93.2	5: 103.6	1: 130.6	5: 102.9
2: 83.2	6: 116.8	2: 121.8	6: 112.6	2: 110.6	6: 87.8	2: 116.3	6: 103.6
3: 118.2	7: 140.8	3: 108.3	7: 108.9	3: 151.8	7: 99.8	3: 108.6	7: 118.4
4: 109.8	8: 84.6	4: 116.8	8: 113.6	4: 108.3	8: 86.9	4: 124.1	8: 113.6
Min:	83.2	Min:	102.3	Min:	86.9	Min:	102.9
Max:	140.8	Max:	116.8	Max:	108.3	Max:	130.6
Average:	112	Average:	111	Average:	100	Average:	114.8
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 96.8	5: 102.9	1: 102.6	5: 104.8	1: 110.8	5: 107.4	1: 124.6	5: 102.6
2: 102.4	6: 113.8	2: 80.6	6: 131.8	2: 102.3	6: 99.8	2: 79.8	6: 116.8
3: 123.8	7: 116.6	3: 113.9	7: 124.3	3: 84.3	7: 90.6	3: 86.4	7: 131.8
4: 130.6	8: 108.4	4: 108.6	8: 114.8	4: 89.6	8: 127.6	4: 104.8	8: 116.8
Min:	96.8	Min:	80.6	Min:	84.6	Min:	86.4
Max:	123.8	Max:	131.8	Max:	127.6	Max:	131.8
Average:	112	Average:	112	Average:	101	Average:	93.9
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 112.6	5: 98.6	1: 124.3	5: 104.6				
2: 113.8	6: 108.6	2: 126.8	6: 113.6				
3: 103.6	7: 124.6	3: 104.8	7: 114.9				
4: 118	8: 114.6	4: 113.6	8: 169.8				
Min:	98.6	Min:	104.6				
Max:	124.6	Max:	169.8				
Average:	111	Average:	121				
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	45.3		
QC Inspector:		Peece		Sign:		Peece	
Date:		21/03/24					
SEALING OF CABIN							
All areas where there is no welding has been sealed with SIKA				Confirmed	YES	<input checked="" type="checkbox"/>	NO
All sealants have been neatly applied along joints				Confirmed	YES	<input checked="" type="checkbox"/>	NO
SIGN OFF							
CLOCK No	2400		OPERATOR SIGN	Aprile		DATE	21/03/24

[illegible]

REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)



FAULT TRACKING

[illegible]

<div style="text-align: center;"> REMINDERS / COMMENTS </div>	
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[illegible]



CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	0446	Checks Updated:	2022/08/26

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

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

Quality approval for release Signature	CO NO:	DATE
	2291	21/03/24