

GIBELA

PRASA PROJECT


APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET


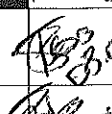
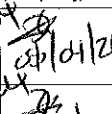
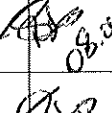
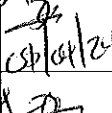
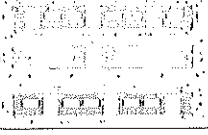
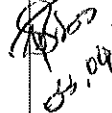

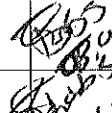
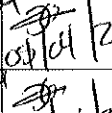
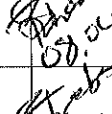
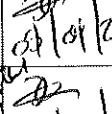
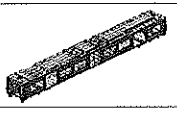
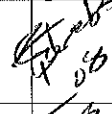
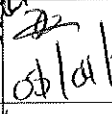
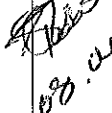
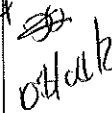
CONFIDENTIAL INFORMATION

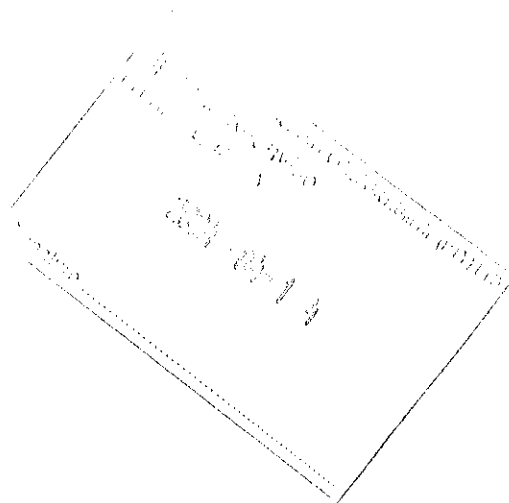
This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.


APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE							WORK INSTRUCTION	SAFETY ?	
				TC1	M4	M1	M2	M3	TC2				
DTR30223319/3	AAD0001241033	Carshell Assembly TC	CB2210	X						X	PRA.CB2210.DTR3022331 9/3.V25	YES	
										Y			

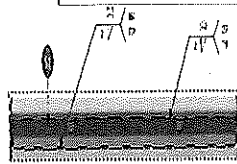
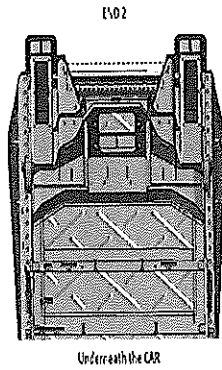
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	09/04/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	09/04/2018
			CHECKER	Nosizo Pindela	09/04/2018
			COMPILED	Thanyani Mathegu	06/04/2018
1	2018/05/18	Team leader and Quality Technician to sign final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motama	2018/05/18
2	2018/06/18	MODIFICATION CONTENT	APPROVER	Itumeleng Modiba	2018/06/18
			CHECKER	Nosizo Pindela	2018/06/18
			REVISED BY	Ramokone Motama	2018/06/18
3	2018/12/12	Additional checkpoints	APPROVER	Itumeleng 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	Itumeleng 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	Itumeleng 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	Itumeleng 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	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			REVISED BY	Bongane Masina	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi Collins	17/08/2021
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISED BY	Mpho Mulaudzi	17/08/2021
25	21/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi Collins	21/02/2022
			CHECKER	Andani Muthelo	21/02/2022
			REVISED BY	Andani Muthelo	21/02/2022
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlampe Amogelang	14/04/2023
			REVISED BY	Mohlampe Amogelang	14/04/2023
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023
			CHECKER	Mathapo Kelebone	27/07/2023
			REVISED BY	Mohlampe Amogelang	27/07/2023
28	07/11/2023	Addition of welding traceability	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Andani Muthelo	07/11/2023
			REVISED BY	Ntekozi Zwane	07/11/2023
TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
1221	TC2	Itumeleng 440081	08.04.24	SI.CB2210.322.V28	16

		DTR30223319/3 Carshell Assembly TC		Rev. V28 Date- 07/11/2023	Project: PRA5A 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)	DT00000284980	✓		 08.04.24	 08/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓		 08.04.24	 08/04/24
03		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		 08.04.24	 08/04/24
04	REFER TO ANNEXURE A	Spot Welding inspected and approved according procedure	IND-SAL-WMS-016 DTD0000210675	✓		 08.04.24	 08/04/24
05	REFER TO ANNEXURE B	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 08.04.24	 08/04/24
06		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 08.04.24	 08/04/24
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 DTD0000210658	✓		 08.04.24	 08/04/24



	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB2210.322.V28

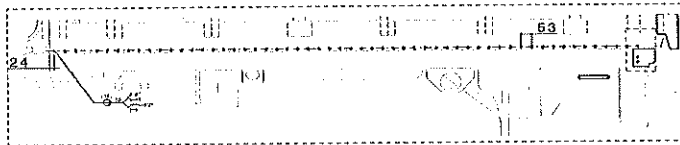
EUFR Reinforcement Plates



END-2

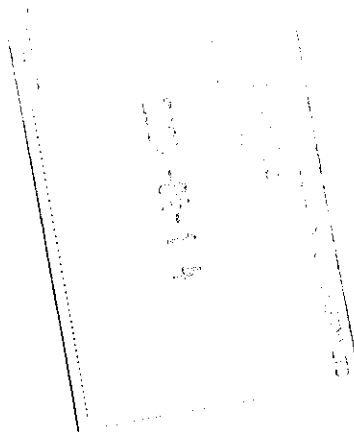
Boiler maker (Name & Sign): *Isobayo Mthembu*

Welder (Name & Sign): *Mthokozisi*



FEDOLI

Operator: *Isobayo Mthembu*



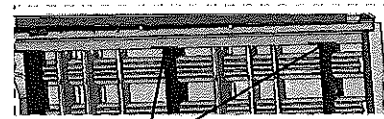
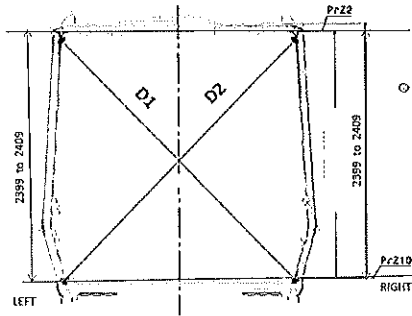
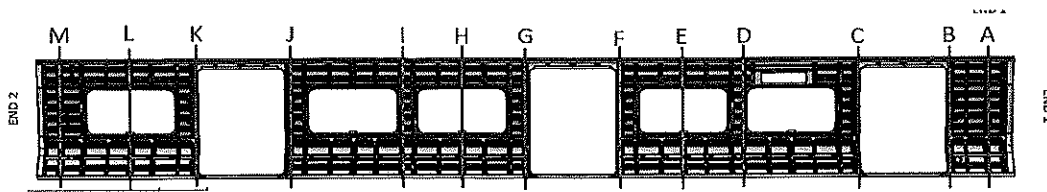


DTR30223319/3 Carshell Assembly TC

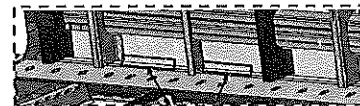
Rev.
V28
Date-
07/11/2023

Project: PRASA
SI.CB2210.322.V28

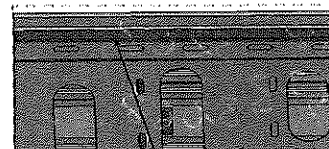
Specifications of Details for CBS measurement



Measurement positions on roof rail and sidewall omega corner

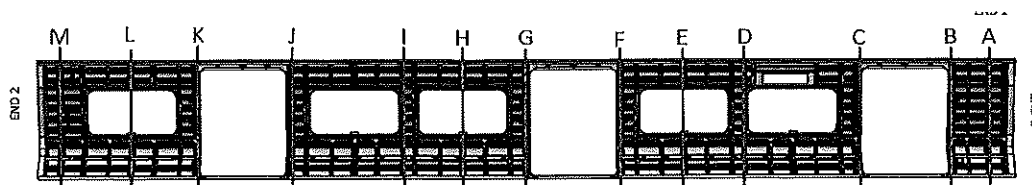


Measurement positions on sidewall and side sill corner




Reinforcement area measurement positions on roof reinforcement area


AFTER WELDING



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

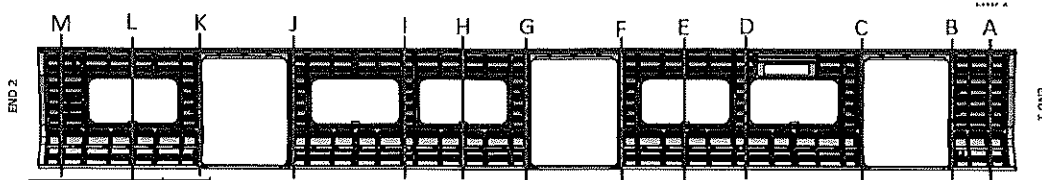
	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3270	3270	0	2405	2405	0
B	3298	3298	0	2406	2405	1
C	3297	3297	0	2406	2406	0
D	3269	3270	1	2406	2405	1
E	3268	3266	2	2405	2405	0
F	3297	3297	0	2406	2406	0
G	3297	3297	0	2406	2406	0
H	3269	3267	2	2405	2406	1
I	3269	3270	1	2406	2405	1
J	3296	3296	0	2406	2406	0
K	3297	3297	0	2406	2406	0
L	3268	3265	3	2406	2405	1
M	3297	3297	0	2406	2406	0


 03.04.24
 2024-04-03 10:00:00
 2024-04-03 10:00:00

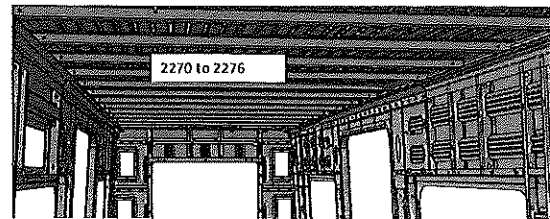
	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA SI.CB2210.322.V28
		Date: 07/11/2023	

Specifications of Details for CBS measurement

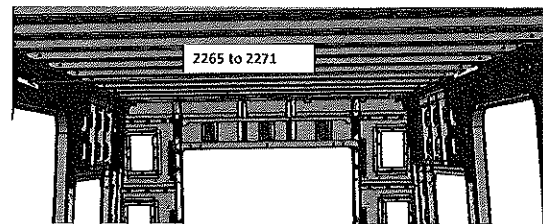
AFTER WELDING



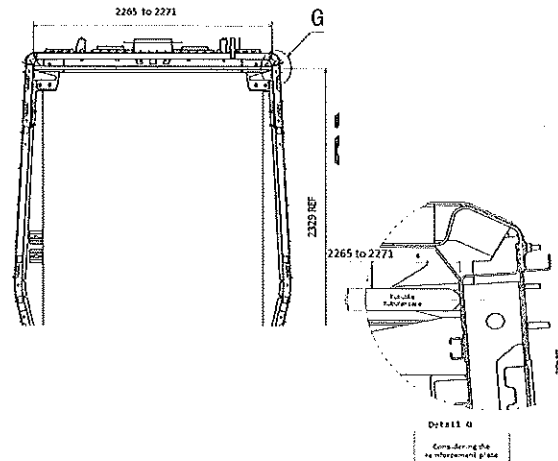
	2265 to 2271	2270 to 2276
A	N/A	2278
B	2268	N/A
C	2270	N/A
D	N/A	2274
E	N/A	2273
F	2271	N/A
G	2269	N/A
H	N/A	2272
I	N/A	2274
J	2270	N/A
K	2271	N/A
L	N/A	2278
M	2269	N/A



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



Take measurement close to radius (considering reinforcement)



08.04.24



DTR30223319/3 Carshell Assembly TC

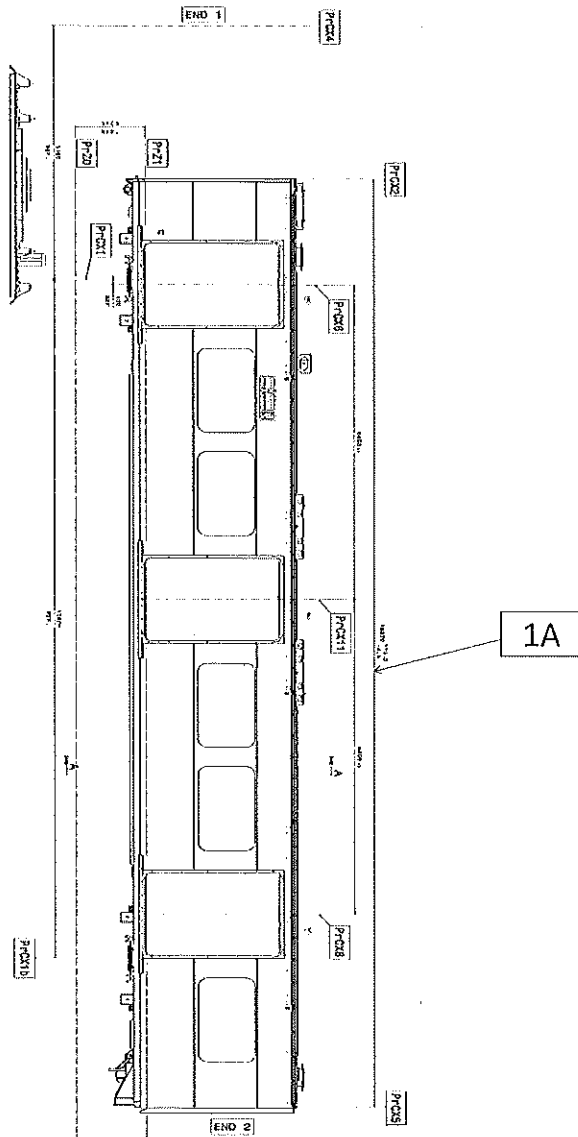
Rev.
V28

Project: PRASA

Date-
07/11/2023

SI.CB2210.322.V28

Specifications of Details for CBS measurement



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	18870 $\begin{matrix} +10.5 \\ -4.5 \end{matrix}$	18871




RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	18870 $\begin{matrix} +10.5 \\ -4.5 \end{matrix}$	18872

08.04.24

Dye penetrant test

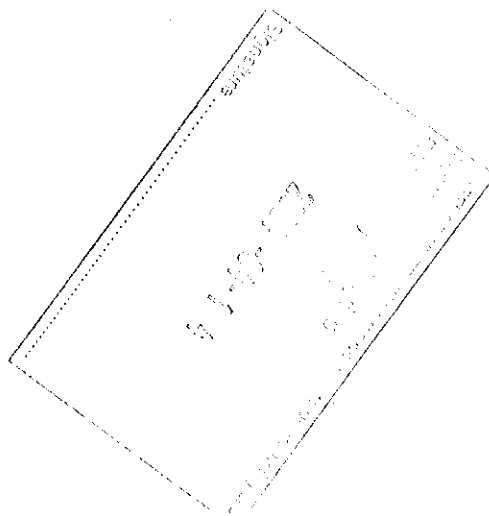
Dye-penetration test to be performed by quality personnel










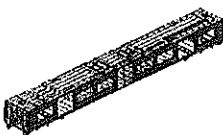




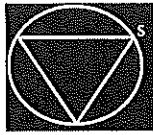


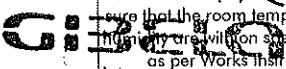
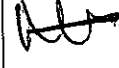



		DTR30223319/3 Carshell Assembly TC		Rev. V28	Project: PRASA	
				Date- 07/11/2023		
Self Inspection - Final Result						
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	GO	If activities are not complete, the missing activities must not impact the next stage!	08.04.24	THOMAS		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	08/04/24	Andoni		
	NO GO	There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)				
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)				
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



		DTR30223319/2 Carshell Assembly TC		Rev. 29 Date- 28/10/2023	Project: PRASA SI.CB2220.323.V29		
II - Control Activities of Production							
II.1 - Items to check							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Not OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB2220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	DTR30223319/2	✓		 09/04	 10/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓		 09/04	 10/04/24
03	REFER TO ANNEXURE A	Spot Welding inspected and approved according procedure	IND-SAL-WMS-016 e DTD0000210675	✓		 09/04	 10/04/24
04	REFER TO ANNEXURE B	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 09/04	 10/04/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 09/04	 10/04/24
06	N/A	Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		 09/04	 10/04/24
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	✓		 09/04	 10/04/24
08	N/A	 Before application of sealant, record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: Temperature (Min - Max (°)) : Min-Max 10°C - 35°C Humidity (Max (%)) : 25% - 60% INDUSTRIAL QUALITY MAINLINE	Sealant Batch No: <u>W-70</u> Exp Date: <u>04/24</u> Actuals Temperature: <u>17</u> Humidity: <u>60</u>	✓		 10/04/24	 10/04/24



DTR30223319/2 Carshell Assembly TC

Rev.
29

Project: PRASA

Date-

28/10/2023

SI.CB2220.323.V29



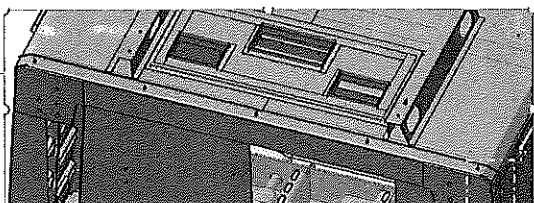
END 1
SEALANT

OPERATOR
(Name & sign):

M. Thokozis:

OPERATOR
(Name & sign):


M. Thokozis:

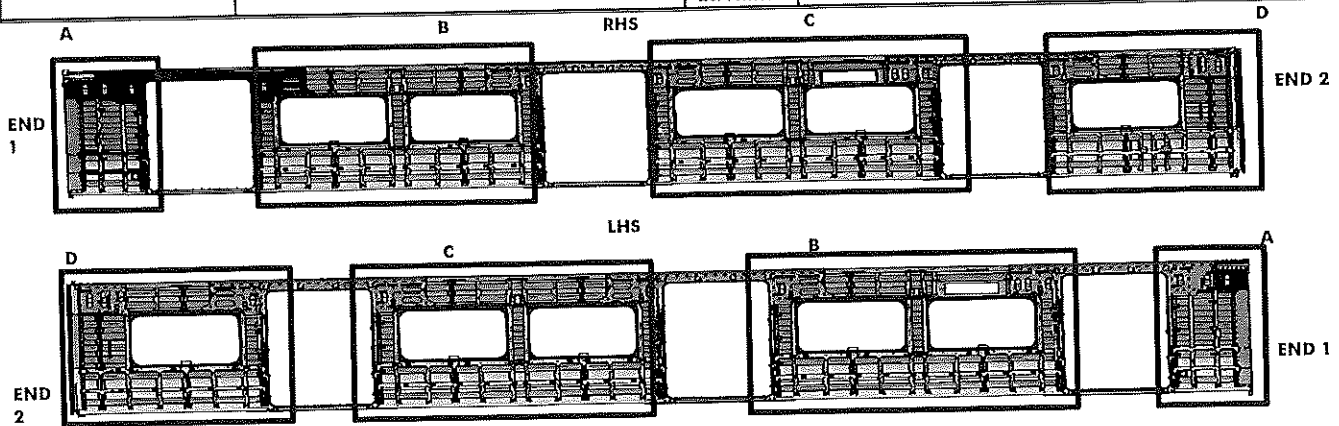


GIBELO

2024 -04- 09

INDUSTRIAL QUALITY
MAINLINE

	DTR30223319/2 Carsheli Assembly TC	Rev. 29	Project: PRASA SI.CB2220.323.V29
		Date-	
		28/10/2023	



C-RAILS: Operator: INSTALLATION
Mthethwa

DOOR MECHANISMS: Operator: Teelo
T.B.

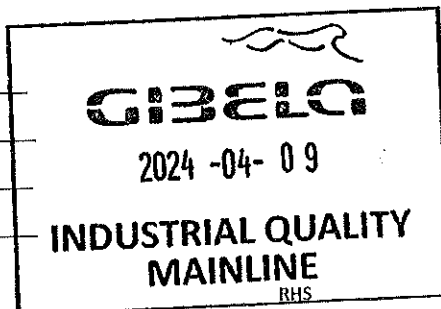
TAPPING PADS: Operator: Teelo
T.B.

Operator:

SEAT & LUGGAGE BRACKETS: Operator: INSTALLATION & VERIFICATION
Teelo
T.B.

SEAT BRACKETS VERIFICATION: Operator: Thulani
T.B.

Operator:



AREA LHS WELDING

A (Seat brackets) : Operator (Name&sign): S. Mthethwa

(C-rails, Luggage and earth bushes) : Operator (Name&sign): S. Mthethwa

B (Seat brackets) : Operator (Name&sign): S. Mthethwa

(C-rails, Luggage and earth bushes) : Operator (Name&sign): S. Mthethwa

C (Seat brackets) : Operator (Name&sign): S. Mthethwa

(C-rails, Luggage and earth bushes) : Operator (Name&sign): S. Mthethwa

D (Seat brackets) : Operator (Name&sign): THULANI

(C-rails, Luggage and earth bushes) : Operator (Name&sign): THULANI

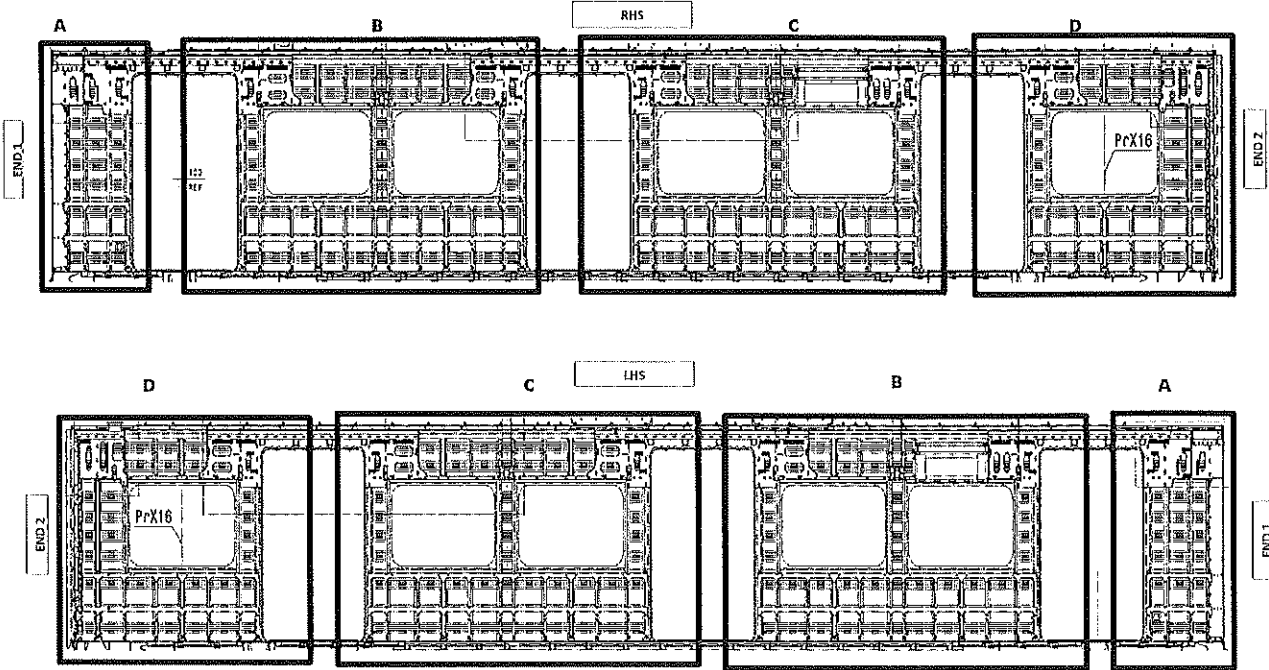
S. Mthethwa

S. Mthethwa

THULANI

THULANI

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:
CRAILS 2 OFF END 2
EARTH BUSH 4 OFF END 2

VERIFICATION BY: *Tetelo*

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:
CRAILS 2 OFF END 2
EARTH BUSH 4 OFF END 2

VERIFICATION BY: *Tetelo*

GIBELO
2024-04-09
INDUSTRIAL QUALITY
MAINLINE



DTR30223319/2 Carshell Assembly TC

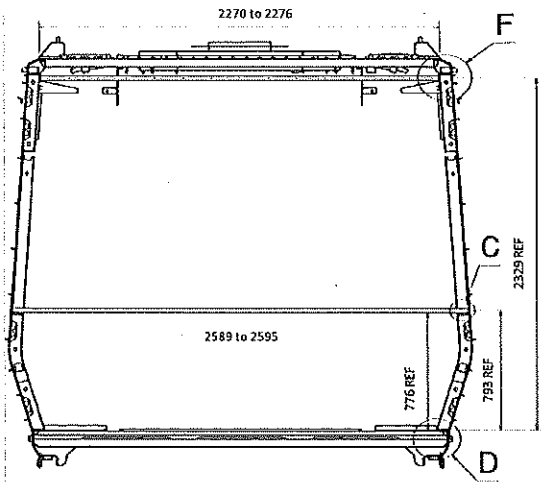
Rev.
29

Project: PRASA

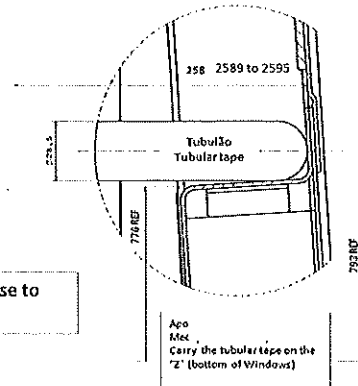
Date-

SI.CB2220.323.V29

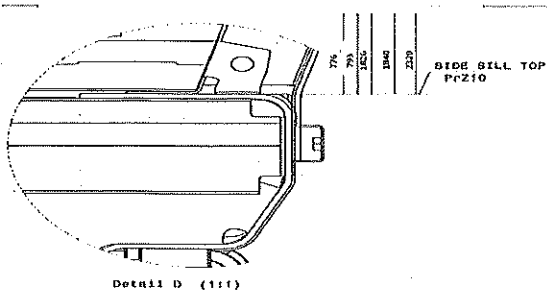
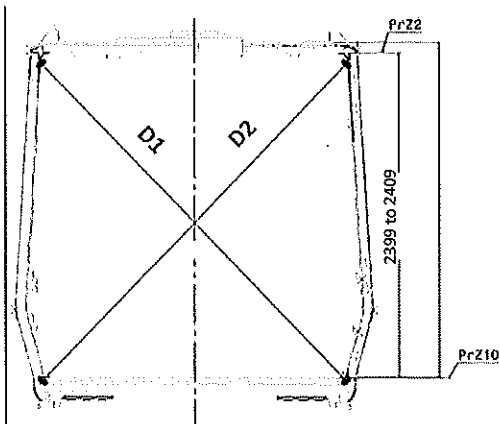
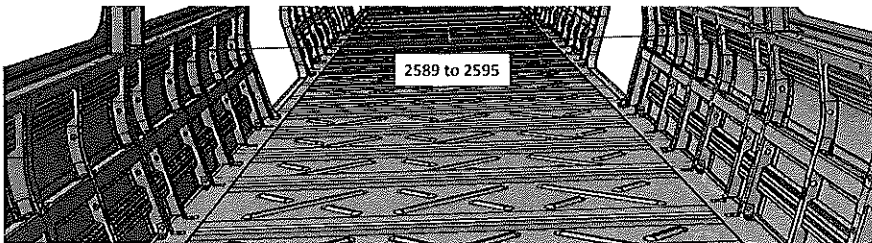
28/10/2023



Take measurement close to
radius



Detail C



Detail D (1:1)



2024 -04- 09

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DTR30223319/2 Carshell Assembly TC

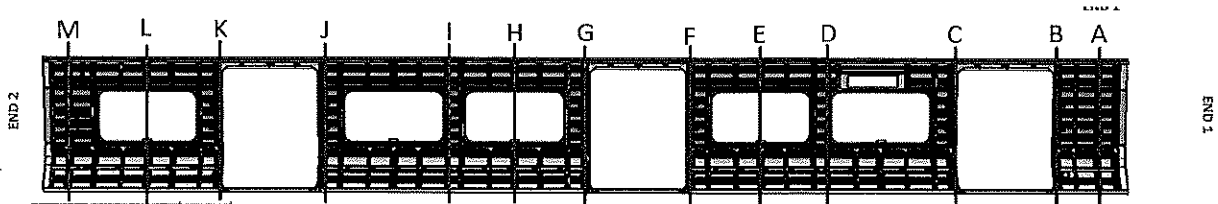
Rev.
29

Project: PRASA

Date-

SI.CB2220.323.V29

28/10/2023

**AFTER WELDING**

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3269	3268	1	2589
B	3295	3297	2	2590
C	3299	3297	2	2592
D	3267	3265	2	2590
E	3265	3268	3	2590
F	3297	3298	1	2593
G	3300	3298	2	2593
H	3267	3265	2	2591
I	3268	3269	1	2591
J	3298	3296	2	2593
K	3295	3297	2	2593
L	3267	3268	1	2589
M	3297	3298	1	2593

2024-04-09

INDUSTRIAL QUALITY
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DTR30223319/2 Carshell Assembly TC

Rev.

29

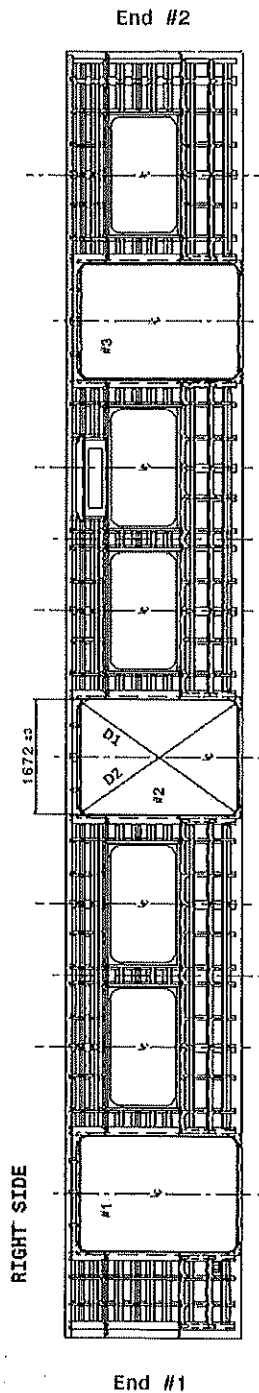
Project: PRASA

Date-

28/10/2023

SI.CB2220.323.V29

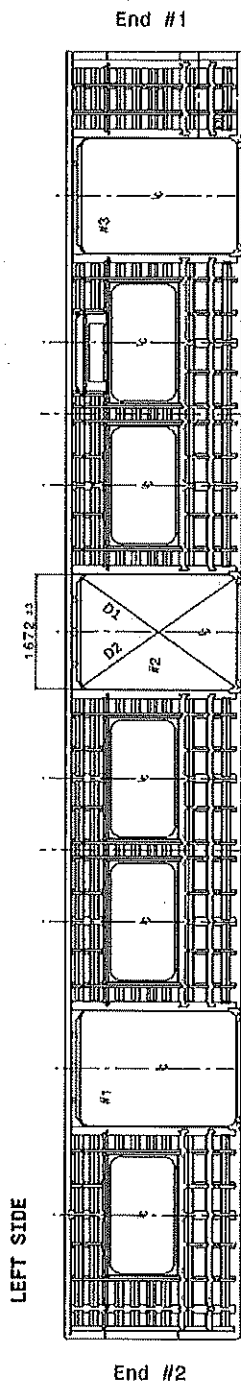
Specifications of Details for CBS measurement

Doors diagonal D1-D2 maximum difference ≤ 4 mm

	#1	#2	#3
D1	2750	2748	2751
D2	2751	2750	2750
D1-D2	1	2	1

Doors Length - 1672 ± 3 mm

	#1	#2	#3
HIGHER DIMENSION	1673	1672	1673
CENTRAL DIMENSION	1672	1671	1671
LOWER DIMENSION	1672	1672	1672

Diagonal da montac - diferença D1-D2 ≤ 4 mm


	#1	#2	#3
D1	2750	2748	2751
D2	2751	2750	2750
D1-D2	1	2	1

Vão de Portas - 1672 ± 3 mm

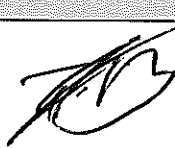

	#1	#2	#3
DIMENSÃO SUPERIOR	1673	1672	1673
HIGHER DIMENSION	1672	1671	1671
CENTRAL DIMENSION	1672	1672	1672
LOWER DIMENSION	1672	1672	1672

2024 -04- 09

INDUSTRIAL QUALITY
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	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA	
		Date-		SI.CB2220.323.V29
		28/10/2023		

Self Inspection - Final Result


Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	✓	GO	If activities are not complete, the missing activities must not impact the next stage!	09/04/24	Tetelo	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	10/04/24	Armo	
			There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)			
			There are non-conformities Impact the quality of the product and there is no corrective action defined yet)			

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



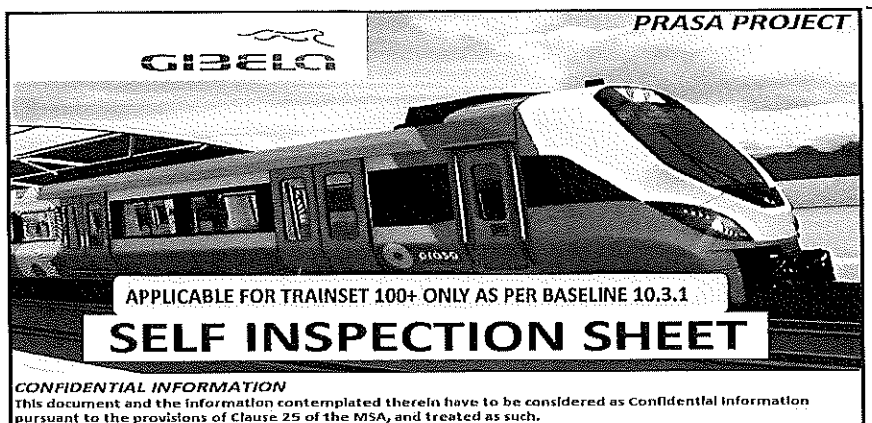
Operations



Quality

2024 -04- 09

INDUSTRIAL QUALITY
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DT00000223319 Carshell Assembly TC

Rev.
30

Date-

06/11/2023

Project: PRASA

SI.CB2230.324.V29

Carro
Car:

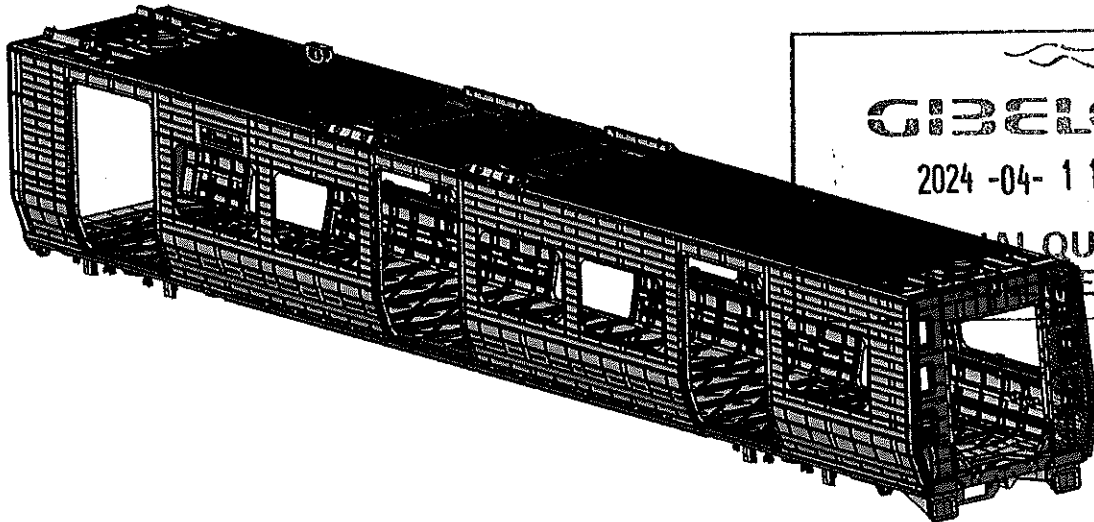
NCR:

Work station:

CB2230



Safety Related



GIBELO

2024 -04- 11

QUALITY

I - Documentation and Instruments

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	NOK	Reason	Signature/Date (Operations)	Signature/Date (Quality)
	TC1	M1	M2	M3	M4	TC2							
DT00000223319						X			X		N/A	11/04/24	11/04/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Validation	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
Combination Square	GIBCS0073	2024/05/11	X		11/04/24	11/04/24
Measuring Tape	GIBTA0378	2024/04/05	X		11/04/24	11/04/24
Tubular	12062-2	2024/02/19	X		11/04/24	11/04/24

I.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308 CSI	E231067	MIG	X		11/04/24	11/04/24
308 CSI	310442	TIG	X		11/04/24	11/04/24



DT00000223319 Carshell Assembly TC

Rev.
30

Date-

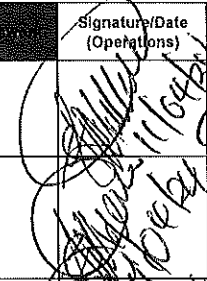

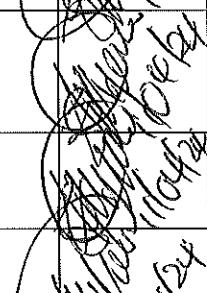
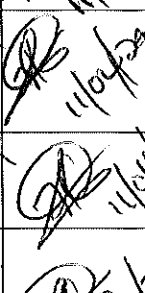
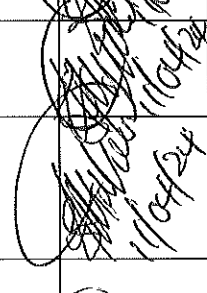
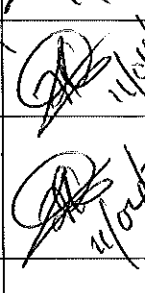
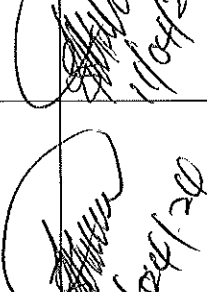
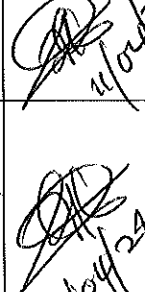
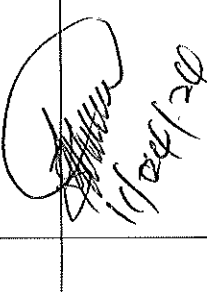
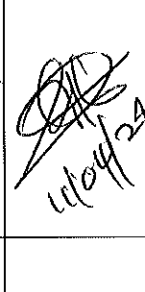
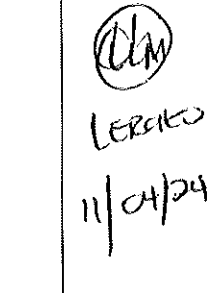
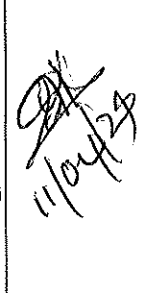
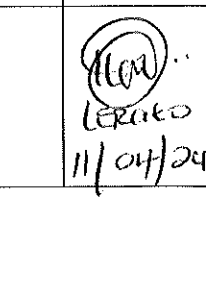
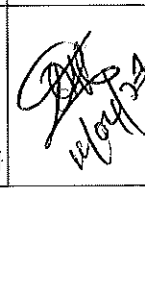
06/11/2023

Project: PRASA

SI.CB2230.324.V29

II - Control Activities of Production

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Not OK	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° DT00000223319	DT00000223319	✓		 11/04/24	 11/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓		 11/04/24	 11/04/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 DTD0000210675	✓		 11/04/24	 11/04/24
04	N/A	Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		 11/04/24	 11/04/24
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	✓		 11/04/24	 11/04/24
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: Temperature Min - Max (1) Min-Max 10°C - 35°C Relative humidity Min - Max (1) Min-Max 25% - 60%	Sealant Batch No: 200194350 Exp Date: 03 / 03 / 24 Actuals Temperature: 15 °C Humidity: 60%	✓		 11/04/24	 11/04/24
07	N/A	Verification of sealant application in regions of roof and sideframe finishers.	Sealant must be: -Applied straight and even (1.5mm) -Free of gaps,cracks,damage and debris (flashes, dirt, dust) Refer to Annexure B	✓		 11/04/24	 11/04/24

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2024 -04- 11

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DT00000223319 Carshell Assembly TC

Rev.
30
Date-
06/11/2023

Project: PRASA
SI.CB2230.324.V29

VIEW A

END 1
SEALANT

OPERATOR
(Name & sign):

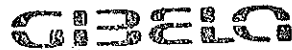
Lerato

(Signature)

OPERATOR
(Name & sign):

Boitumelo

(Signature)



2024-04-11

INDUSTRIAL QUALITY
MAXIPLANE

OPERATOR
(Name & sign):

Leroy

(Signature)

OPERATOR
(Name & sign):

Leroy

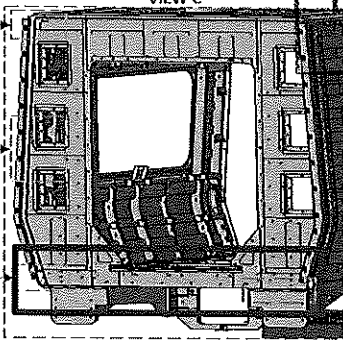
(Signature)

OPERATOR
(Name & sign):

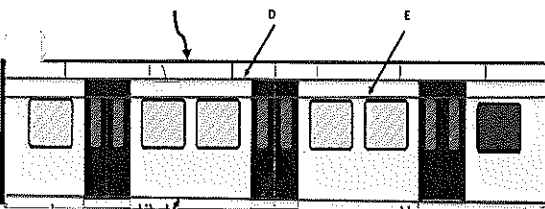
Leroy

(Signature)

VIEW C



G



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

Operator (Name & sign):

D, E, F, G, H, I

Operator (Name & sign):

Lerato

(Signature)

Operator (Name & sign):

Boitumelo

Operator (Name & sign):

1

Operator (Name & sign):

Operator (Name & sign):

LHS

RHS

H I Bottom

Lerato *(Signature)*

Boitumelo *(Signature)*

D, E, G (H, I) Top

Simle *(Signature)*

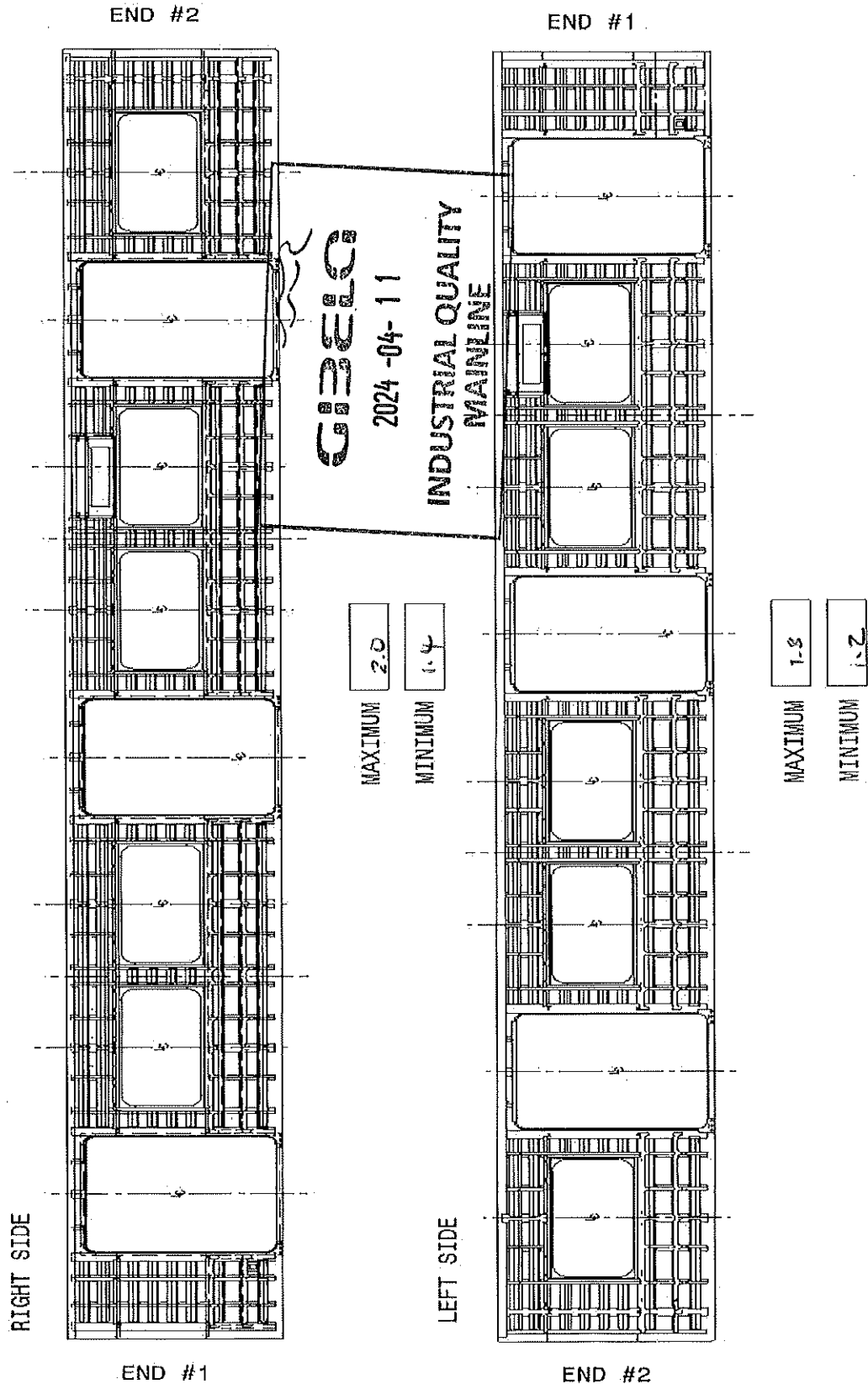
Tshenola *(Signature)*

1000

1000

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.





DT00000223319 Carshell Assembly TC

Rev.
30

Date-

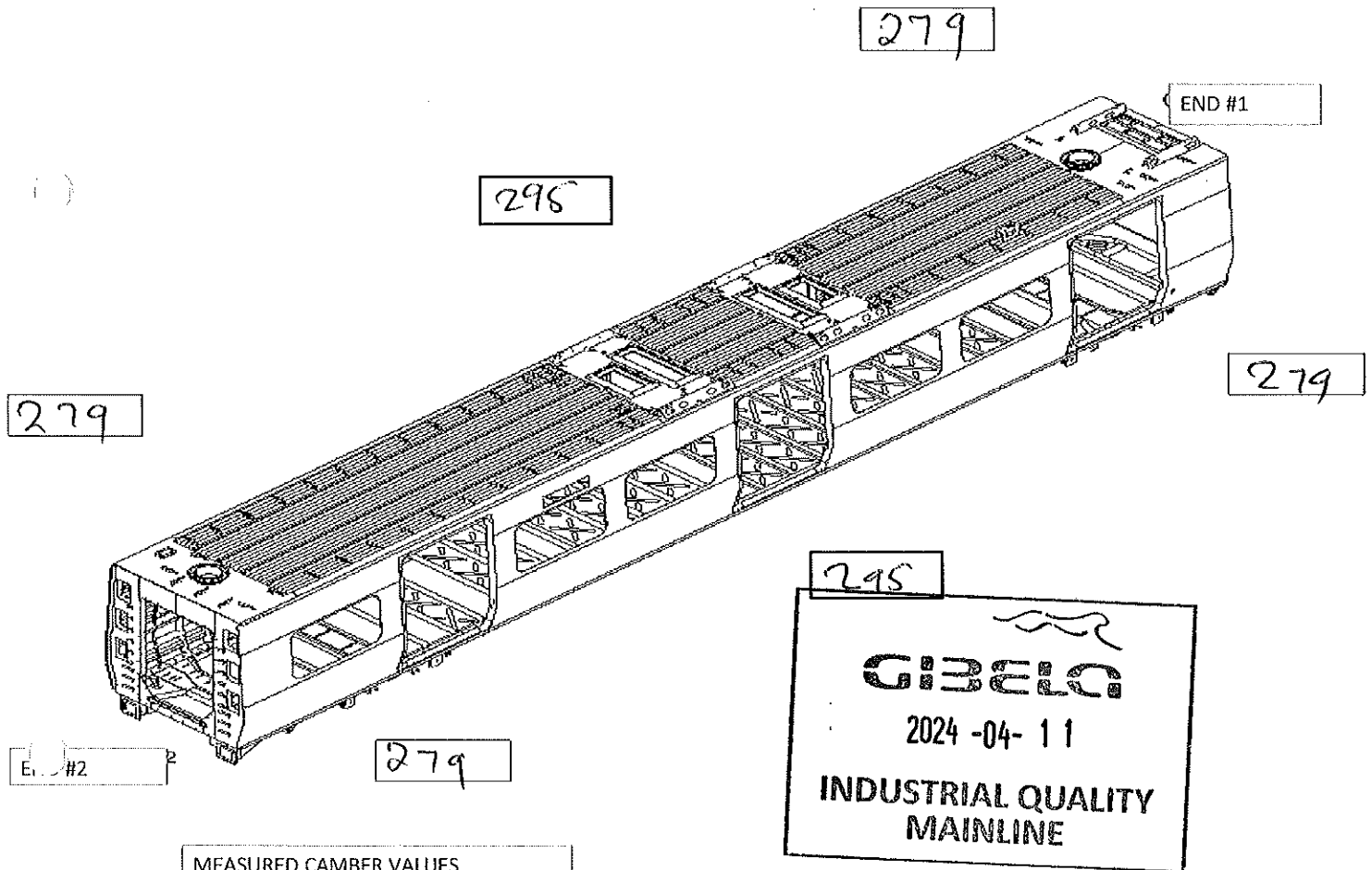
06/11/2023

Project: PRASA

SI.CB2230.324.V29

Specifications of Details for CBS measurement CB2230

Specified Camber for car out of jig is 16mm (-0mm + 2mm)



MEASURED CAMBER VALUES

RIGHT

16

LEFT

16



DT00000223319 Carshell Assembly TC

Rev.
30

Date-

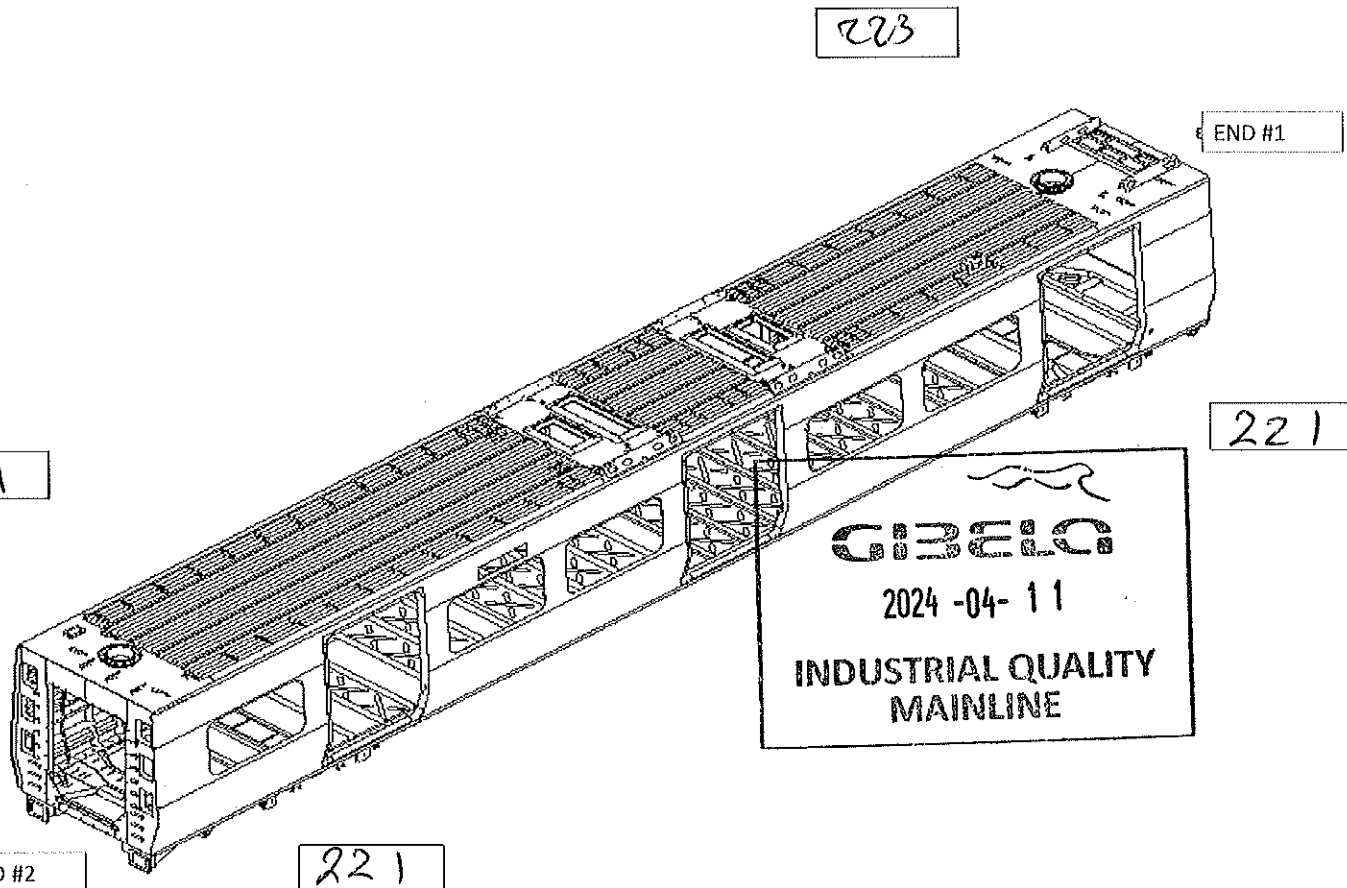
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Project: PRASA

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.



MEASURED TWIST VALUES END 1

LATERAL

0

LONGITUDINAL

2

MEASURED TWIST VALUES END 2

LATERAL

2

LONGITUDINAL

0



DT00000223319 Carshell Assembly TC

Rev.
30

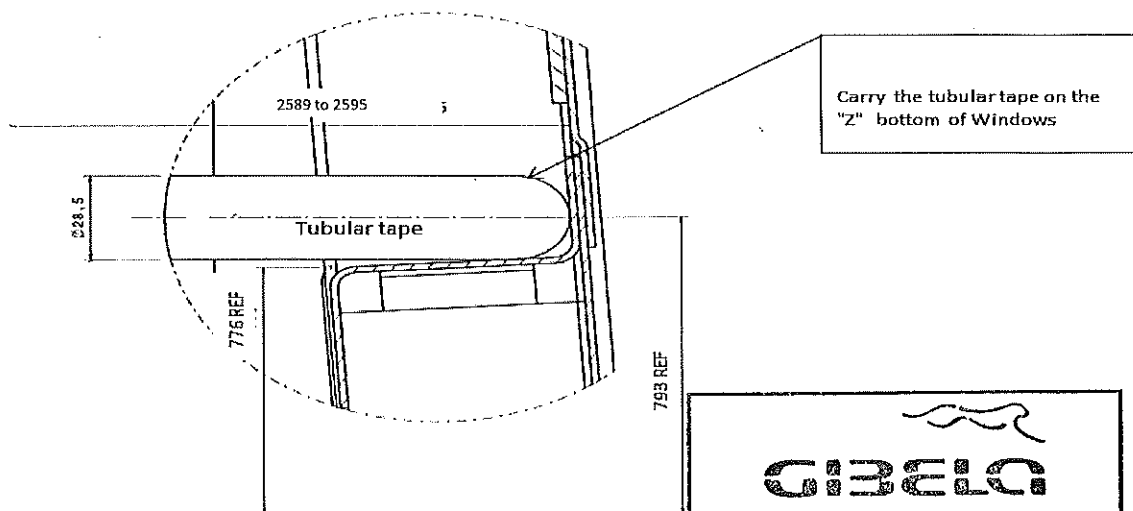
Date-

06/11/2023

Project: PRASA

SI.CB2230.324.V29

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

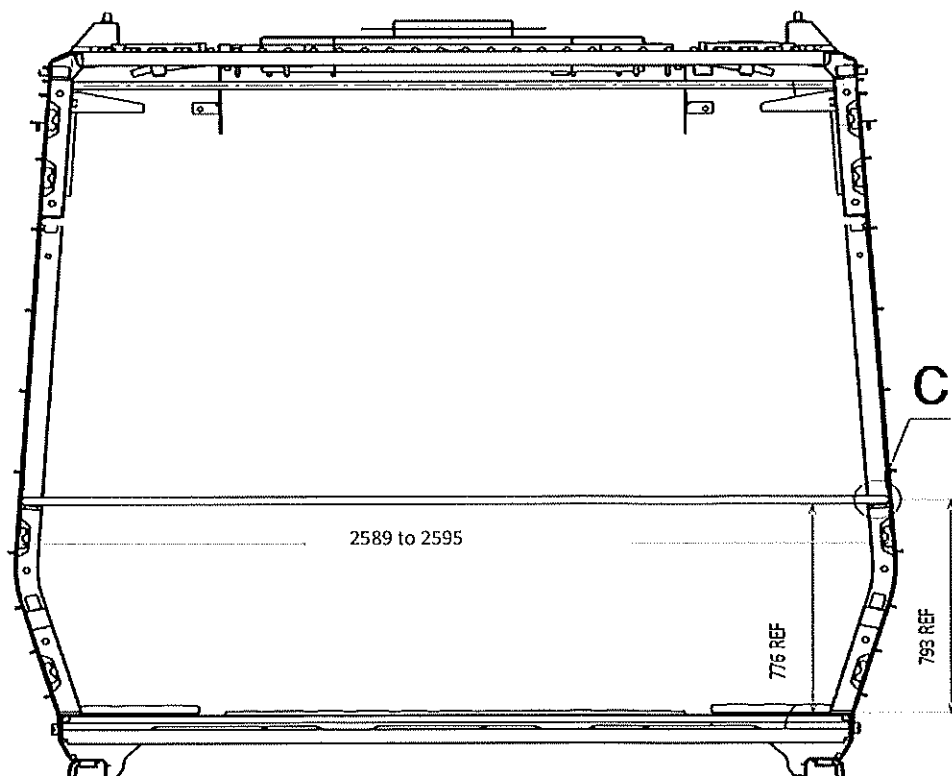


Detail C



2024 -04- 11

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DT00000223319 Carshell Assembly TC

Rev.
30

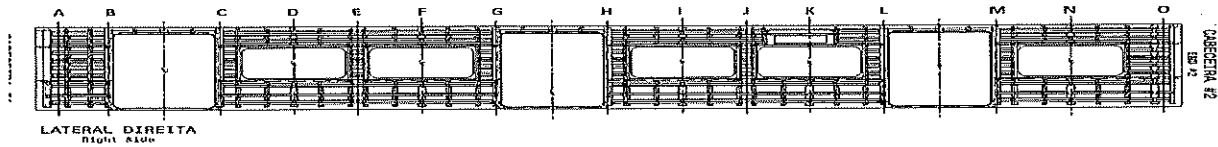
Project: PRASA

Date-

06/11/2023

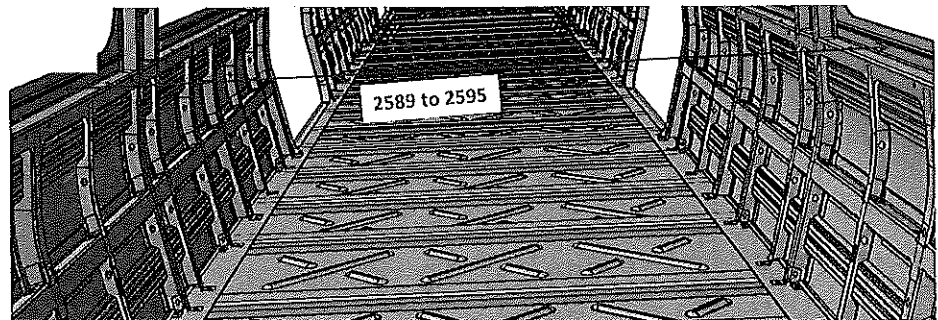
SI.CB2230.324.V29

Specifications of Details for CBS measurement



2589 to 2595mm

A	2589
B	2590
C	2596
D	2592
E	2589
F	2591
G	2590
H	2590
I	2592
J	2589
K	2589
L	2589
M	2591
N	2590
O	2592



2024 -04- 11

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Threshold verification

Nominal value :38

Door 1

Door 2

Door 3

Door 4

Door 5

Door 6

L	R	L	R	L	R
38	38	38	39	38	39
L	R	L	R	L	R
39	38	38	38	37	37

BOILER MAKER:

Sihle

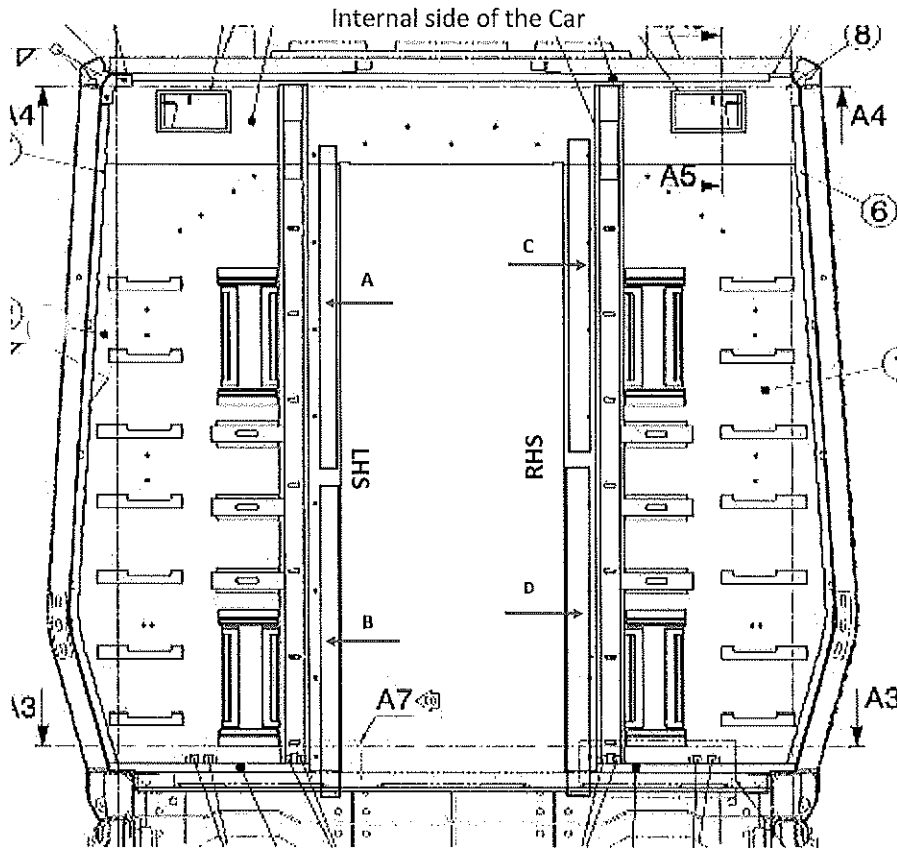
WELDER:

Mmabagabo Maseda

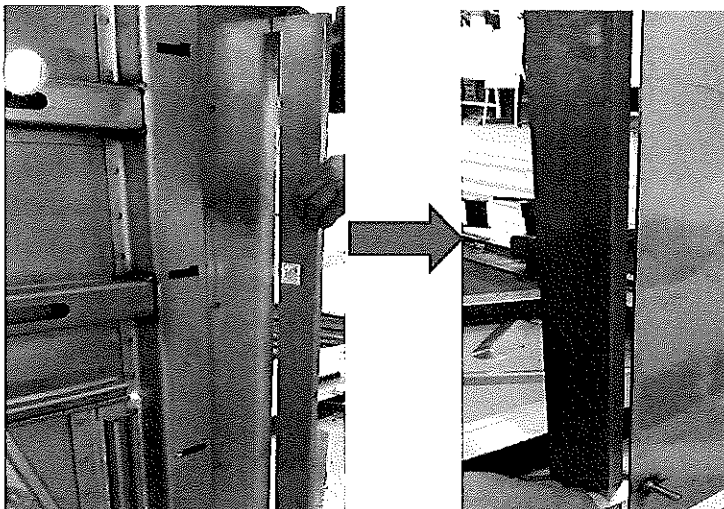
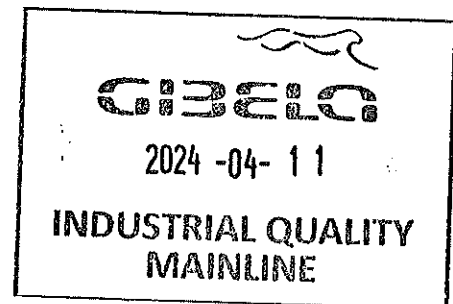
Specifications of Details for CBS measurement

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



Measured Values			
	Minimum	Maximum	Deviation
A	8	9	1
B	8.2	9.0	0.8
C	8.5	9.5	1.0
D	10.5	11.0	0.5





DT00000223319 Carshell Assembly TC

Rev.
30

Date-

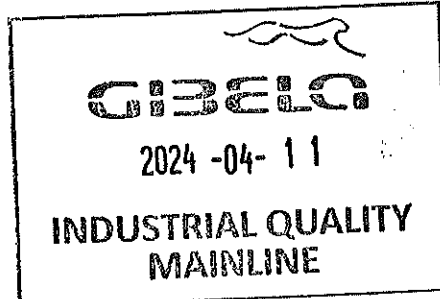
06/11/2023

Project: PRASA

SI.CB2230.324.V29

Dye penetrant test

Dye-penetration test to be performed by quality personnel



Item	Description of the issue	OK	Signature/Date (Operations)	Signature/Date (Quality)
()				

II.2 - Check List REX

Check List Items

Item	Picture/Drawing	Description	Criteria /Record	OK	Not OK	Signature/Date (Team Leader)	Signature/Date (Quality Technician)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX				



DT00000223319 Carshell Assembly TC

Rev.
30

Date-

06/11/2023

Project: PRASA

SI.CB2230.324.V29

Self Inspection - Final Result

Is the car good to advance to the next workstation/process? (Approval of Operations Manager and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	GO	If activities are not complete, the missing activities must not impact the next stage!		11/04/24	Ketiso MDAOSE Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)		11/04/24	Anno Industrial Quality	
	NO GO	There are activities pendings that impact/slop the activities of the next process Obs: (To describe problems below)			Operations	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)			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

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2024 -04- 11

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Quality