

CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	436	Checks Updated:	2021/07/07

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

No.	Description of inspection	Disposition	Validation after rework		Sign
			Repairer	Disposition	
1	WELDS ARE CLOSED	0			
2	NO PIN HOLES ON CAB STRUCTURE	0			
3	SEALANT IS APPLIED CORRECTLY <ul style="list-style-type: none">JOINTS ARE CLOSEDNO BREAKS IN THE SEALANTCORRECT BEAD	0			
4	RIVET NUTS ARE PROPERLY CRIMPED <ul style="list-style-type: none">RIVETS ARE MARKEDCORRECT GRIP RANGE USED	0			
5	NO MISS WELDS PRESENT AFTER SANDBLASTING	0			
6	NO VISUAL MISS WELDS (INSPECTION AFTER SEALING)	0			
7					
8					
9					
10					
11					
12					
13					
14					

Quality approval for release Signature	CO. NO:	DATE
	2285	21.02.2024

FAULT TRACKING

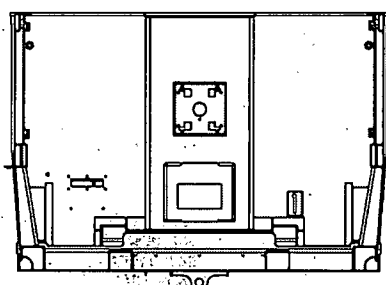
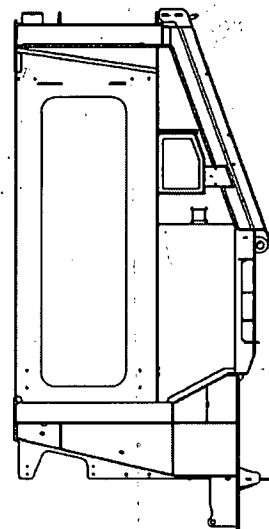
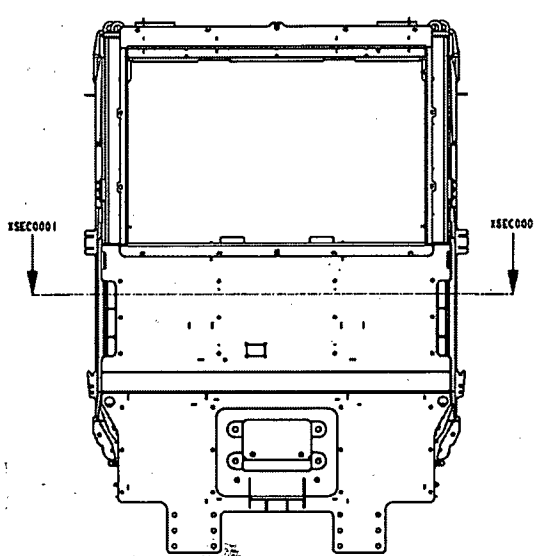
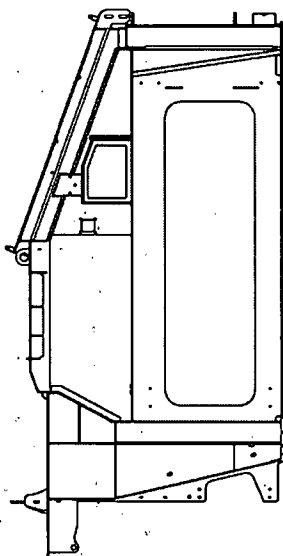
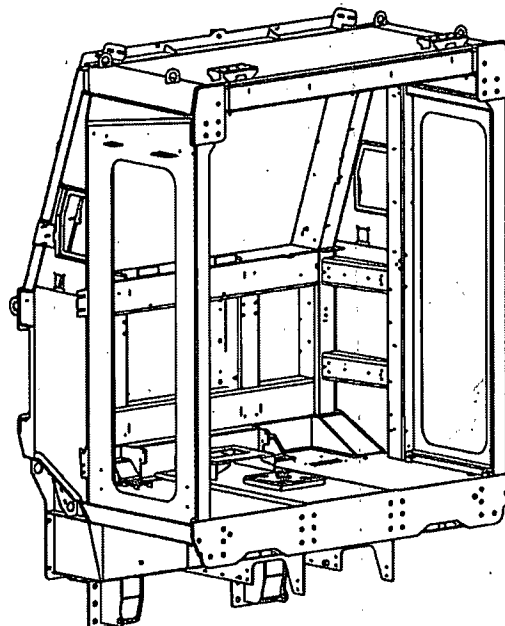
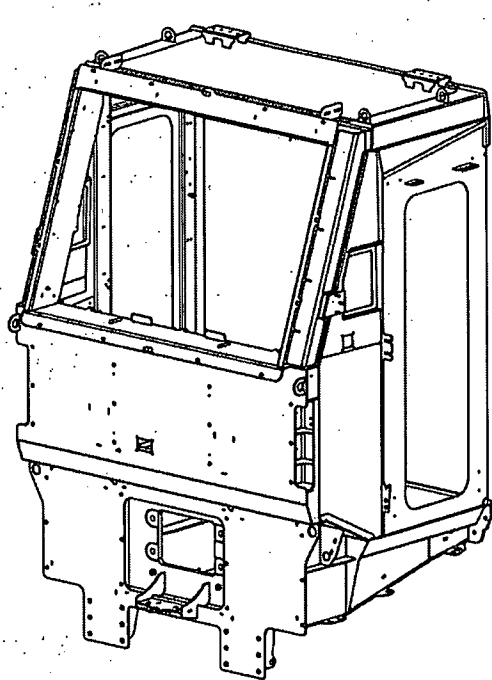
[illegible]

REMINERS / COMMENTS

[illegible]

REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)


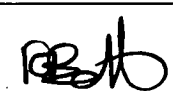




CABIN WAXING					
CABIN IS WAXED				Confirmed	YES <input checked="" type="checkbox"/> NO <input type="checkbox"/>
SIGN OFF					
CLOCK No	2400	OPERATOR SIGN	Aphile	DATE	22.02.2024

Request for Weld Repair

[illegible]

Record of RAL 7012							
Start Time:	04:00		End Time:	06:00			
Temperature $\geq 15^{\circ}$:	28°C		Humidity $\leq 75\%$:	39%			
Paint Batch No.:	8096599		Paint Expiry Date:	21-09-2024			
Hardener Batch No.:	7250479041		Hardener Expiry Date:	04/24			
Desolvation Start Time:	06:00		Desolvation End Time:	06:15			
Stoving Start Time:	06:15		Stoving End Time:	07:15			
Stoving Temp:	60°C						
Operator:	NEUTHUKO		Sign:	nn Shangf			
Date:	2024/02/27						
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 193	5: 141.8	1: 140.3	5: 126.9	1: 160	5: 84.3	1: 164.8	5: 76.9
2: 124	6: 124.3	2: 124.3	6: 120.8	2: 117	6: 96	2: 163.9	6: 109
3: 126	7: 131.6	3: 113.6	7: 104.6	3: 124	7: 108	3: 162.4	7: 180
4: 170	8: 156.9	4: 98	8: 113.3	4: 116.8	8: 76	4: 161.3	8: 84.3
Min:	104	Min:	98	Min:	76	Min:	76.9
Max:	193	Max:	140.3	Max:	160	Max:	180
Average:	143.45	Average:	117.92	Average:	110.26	Average:	137.82
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 102.6	5: 114.3	1: 166.8	5: 113.9	1: 113.9	5: 113.9	1: 113.9	5: 96.8
2: 96.9	6: 193.6	2: 102.8	6: 155.3	2: 102.6	6: 102.4	2: 102.8	6: 74.3
3: 120.6	7: 108.2	3: 120.6	7: 141.8	3: 161.8	7: 102.6	3: 88.6	7: 88.8
4: 90.8	8: 91.8	4: 109.8	8: 102.6	4: 174.3	8: 118.6	4: 89.6	8: 108.3
Min:	90.3	Min:	102.6	Min:	102.4	Min:	74.3
Max:	193.6	Max:	166.8	Max:	174.3	Max:	113.9
Average:	114.18	Average:	126.63	Average:	123.76	Average:	95.26
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 113.8	5: 96.8	1: 166.6	5: 74.2				
2: 102.6	6: 116.8	2: 174.3	6: 116.8				
3: 116.9	7: 102.6	3: 154.3	7: 140.8				
4: 104.3	8: 161.8	4: 113.6	8: 98.6				
Min:	96.8	Min:	74.2				
Max:	161.8	Max:	174.3				
Average:	114.45	Average:	129.9				
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	39.8		
QC Inspector:		Reece		Sign:	RBD		
Date:		27/02/24					
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	APH/LE		DATE	27-02-24


Record of Painting Blue NCSS1565-B			
Start Time:	13:00	End Time:	13:30
Temperature $\geq 15^{\circ}$:	25°C	Humidity $\leq 75\%$:	39%
Paint Batch No.:	8176318	Paint Expiry Date:	02-02-25
Hardener Batch No.:	750 215 121	Hardener Expiry Date:	12/24
Desolvation Start Time:	13:30	Desolvation End Time:	13:45
Stoving Start Time:	13:45	Stoving End Time:	14:45
Stoving Temp:	60°C		
Operator:	Colin	Sign:	
Date:	20/02/26		
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: 16	5: 116	1: 174.3	5: 124
2: 102	6: 102	2: 69.8	6: 116.9
3: 118	7: 134.3	3: 74.6	7: 124.3
4: 102	8: 191.8	4: 180.6	8: 116.8
Min:	102	Min:	69.8
Max:	191.8	Max:	180.6
Average:	128.38	Average:	117.46
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	90.6
QC Inspector:	Reece	Sign:	
Date:	27/02/24		

Record of Painting NCSS3010 R90B					
Start Time: 11		10:00		End Time: 10:30	
Temperature $\geq 15^{\circ}$:		25°C		Humidity $\leq 75\%$: 39%	
Paint Batch No.:		813 6210		Paint Expiry Date: 17/11/24	
Hardener Batch No.:		750 2115 121		Hardener Expiry Date: 12/24	
Desolvation Start Time:		10:30		Desolvation End Time: 10:45	
Stoving Start Time:		10:45		Stoving End Time: 11:45	
Stoving Temp:		60°C			
Operator: Colin				Sign: 	
Date: 20/04/2024					
Painting NCSS3010 R90B Control					
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)	
1: 126.8	5: 113.9	1: 113.9	5: 12.6		
2: 131.4	6: 161.8	2: 112	6: 113.9		
3: 104.2	7: 102.4	3: 104	7: 98.6		
4: 124.6	8: 113.8	4: 133	8: 104.3		
Min:	102.4	Min:	98.6		
Max:	161.8	Max:	133		
Average:	122.36	Average:	110.28		
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	40.1
QC Inspector:		Reece		Sign: 	
Date:		27/02/24			

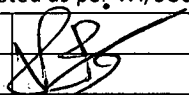
Record of Priming							
Start Time:		09:00		End Time:		09:30	
Temperature $\geq 15^{\circ}$:		25°C		Humidity $\leq 75\%$:		39%	
Paint Batch No.:		7296866		Paint Expiry Date:		06/24	
Hardener Batch No.:		728 752		Hardener Expiry Date:		15-04-24	
Desolvation Start Time:		11:30		Desolvation End Time:		11:45	
Stoving Start Time:		11:45		Stoving End Time:		12:45	
Stoving Temp:		60°C					
Operator:		Craig		Sign:		Craig	
Date:		20/02/25					
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 79.3	5: 73.8	1: 71.1	5: 42.9	1: 78.1	5: 41.6	1: 44.3	5: 59.0
2: 66.2	6: 68.0	2: 60.8	6: 44.7	2: 86.8	6: 40.4	2: 67.8	6: 53.0
3: 59.4	7: 59.1	3: 43.9	7: 38.7	3: 57.1	7: 60.9	3: 57.5	7: 34.8
4: 45.1	8: 76.6	4: 52.2	8: 67.0	4: 79.0	8: 50.5	4: 44.2	8: 48.5
Min:	45.1	Min:	35.7	Min:	40.4	Min:	34.8
Max:	79.3	Max:	71.1	Max:	86.8	Max:	67.8
Average:	62.2	Average:	46.534	Average:	63.6	Average:	51.3
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 42.7	5: 62.3	1: 59.4	5: 45.1	1: 74.1	5: 69.1	1: 73.7	5: 65.9
2: 65.6	6: 68.6	2: 71.3	6: 47.7	2: 78.0	6: 61.6	2: 72.2	6: 56.8
3: 78.6	7: 51.8	3: 79.2	7: 48.1	3: 56.4	7: 61.6	3: 78.5	7: 63.4
4: 55.4	8: 52.8	4: 59.3	8: 66.5	4: 52.2	8: 49.4	4: 44.6	8: 45.7
Min:	42.7	Min:	45.1	Min:	49.4	Min:	44.6
Max:	78.6	Max:	79.2	Max:	78.0	Max:	78.5
Average:	60.6	Average:	62.1	Average:	63.7	Average:	61.5
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 63.2	5: 76.8	1: 43.9	5: 75.8	1: 71.0	5: 53.2	1: 75.5	5: 42.9
2: 48.5	6: 50.2	2: 68.0	6: 64.3	2: 56.3	6: 48.7	2: 59.2	6: 47.1
3: 47.7	7: 61.1	3: 77.4	7: 71.6	3: 66.7	7: 58.3	3: 80.9	7: 70.3
4: 84.6	8: 73.4	4: 40.3	8: 53.0	4: 74.0	8: 69.8	4: 62.1	8: 67.0
Min:	47.7	Min:	40.3	Min:	48.7	Min:	42.9
Max:	84.6	Max:	77.4	Max:	74.0	Max:	80.9
Average:	66.1	Average:	58.8	Average:	61.3	Average:	61.9
Primer has been inspected and is free of defects				Confirmed		Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>	
QC Inspector:		Zothule		Sign:		[Signature]	
Date:		26.02.2024					

Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Fasteners positioned in all Rivnuts and Bosses		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Masked as per GMS-SOS-GIBELA-CABIN-001		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator: DAVID		Sign:		TD [Signature]	
Date: 20 24/02/24					
Record of Shot Blasting					
Operator:		Date:		20 24/02/24	
Start Time: 08 H 16		End Time:		11 H 39	
Temperature ($\geq 15^\circ$): 20 - 03 °C		Humidity ($\leq 75\%$):		64 - 05 %	
Shot Blasting Self Inspection					
Interior of Cabin: Sa 1 - Light Stripping		Confirmed	Yes	<input checked="" type="checkbox"/>	No
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping		Confirmed	Yes	<input checked="" type="checkbox"/>	No
		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator: DAVID		Sign:		TD [Signature]	
Date: 20 24/02/24					
Shot Blasting Cleaning					
Cabin free of all sand		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator: DAVID		Sign:		TD [Signature]	
Date: 20 24/02/24					
Shot Blasting Control					
Temperature $\geq 15^\circ$: 22 - 07 °C		Humidity $\leq 75\%$:		67 - 02 %	
Internal Roughness $3.2 \leq Ra \leq 12.5$		External Roughness $3.2 \leq Ra \leq 12.5$			
QC Inspector:		Sign:			
Date:					

Cabin Bracket Assembly: GN002833

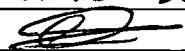
Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLOEM	Assembly Date:	20 24/02/02			
Sign:		Wire Batch No.:	2202152			

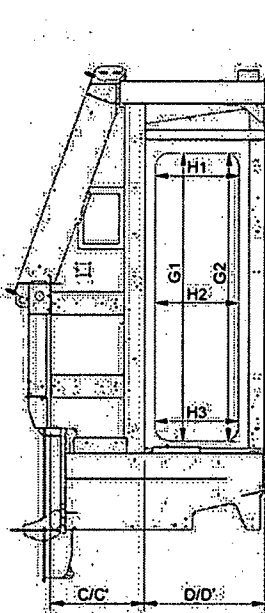
Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:		Assembly Date:	20 24/02/12			
Sign:		Wire Batch No.:				

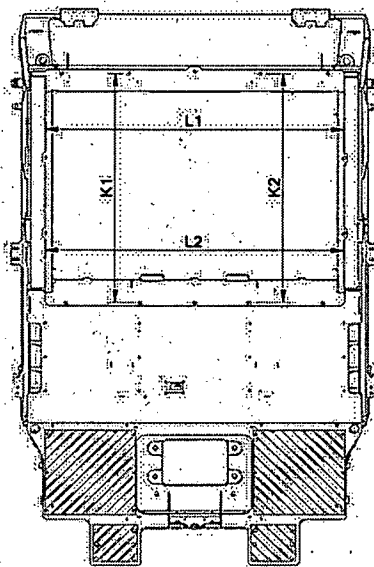
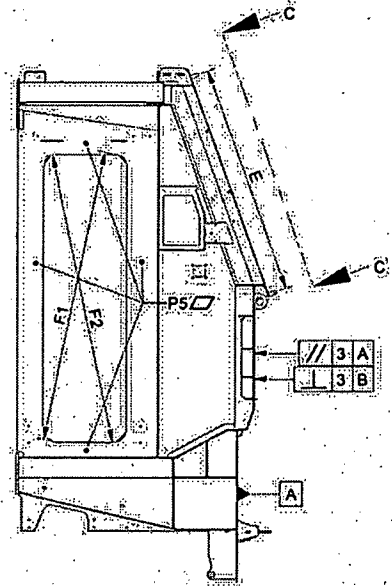
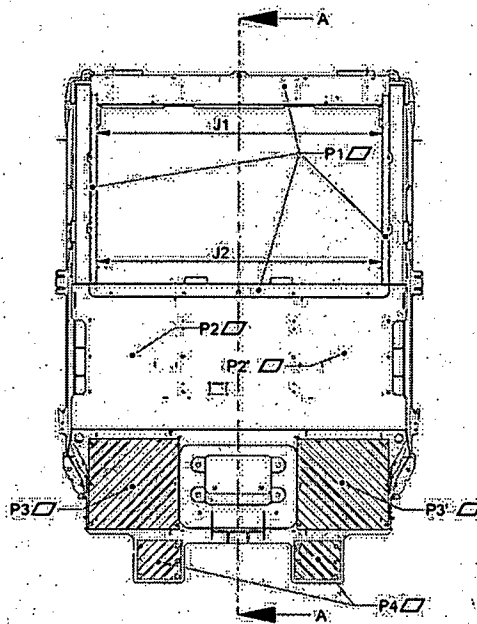
Welding Control											
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed		Yes		<input checked="" type="checkbox"/> No		
QC Inspector:		<i>Ridley</i>		Sign:		<i>[Signature]</i>		Date:		2024/02/01	
Dimensional Control											
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations						
C / C'	625	± 2	625	625	Acceptable						
D' / D'	813	± 2,5	814	815	Acceptable						
E	1531,5	± 3	1528		Acceptable						
G1 / G'1	Height 1900	+1	1989		Acceptable						
G2 / G'2		-3	1989		1988		Acceptable				
H1 / H'1	Width 560	+1 -3	559								
H2 / H'2			559								
H3 / H'3			558								
F1' / F'1	Diagonals 1939		1937		1935		Acceptable				
F2 / F'2			1937		1937		Acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	0		2		Acceptable				
J	Gap of Doors	± 1,5									
K1 / K2	1515	± 3	1512		1513		Acceptable				
L1 / L'2	1996	± 3	1997		1998		Acceptable				
M1 / M'1	2306	± 3	2476		2477		Acceptable				
M2 / M'2			2465		2465		Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2129		2129		Acceptable				
T2 / T'2	2230 Top/Bottom		2230		2230		Acceptable				
Difference	U - U' (3522)	≤ 4mm	3518		3520		Acceptable				
QC Inspector:		<i>Ridley</i>		Sign:		<i>[Signature]</i>		Date:		2024/02/01	
Geometrical Control											
Nature of checks				Toler.	LHS / Dimension Measured / RHS						
P1 / P'1	Planeity			2 mm	Passed		Acceptable				
P2 / P'2	Planeity			2 mm	Passed		Acceptable				
P3 / P'3	Planeity			4 mm	Passed		Acceptable				
P4 / P'4	Planeity			4 mm	Passed		Acceptable				
P5 / P'5	Planeity			4 mm							
P6 Roof	Planeity			6 With 2m Ruler	Passed		Acceptable				
Shield	//	3	A	3	Passed		Acceptable				
Shield	⊥	3	A	3	Passed		Acceptable				
Door Post	⊥	3	A	Front	Passed		Acceptable				
				Back	Passed		Acceptable				
QC Inspector:		<i>Ridley</i>		Sign:				Date:		2024/02/01	

Cabin Structure Assembly: GN002834

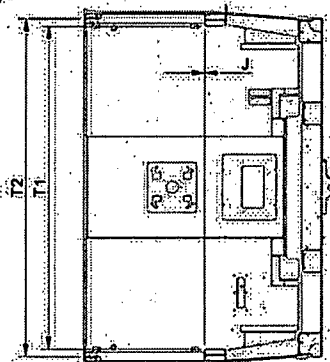
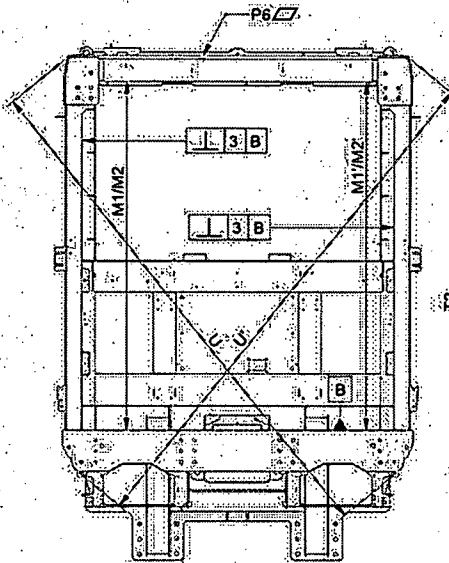
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLEN	Assembly Date:	20 24/02/03			
Sign:		Wire Batch No.:	2202152			



SECTION A-A



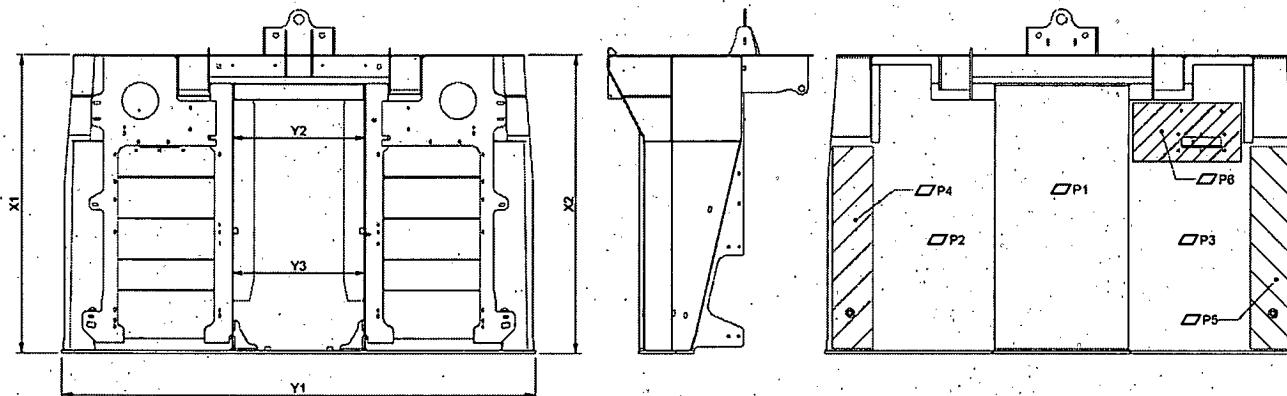
AUX VIEW C



SECTION B-B

Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	2024/02/02	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202165	



Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date: 2024/02/02

Dimensional Control

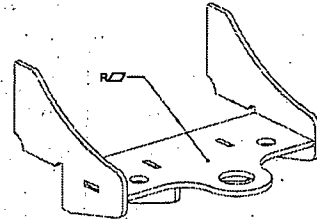
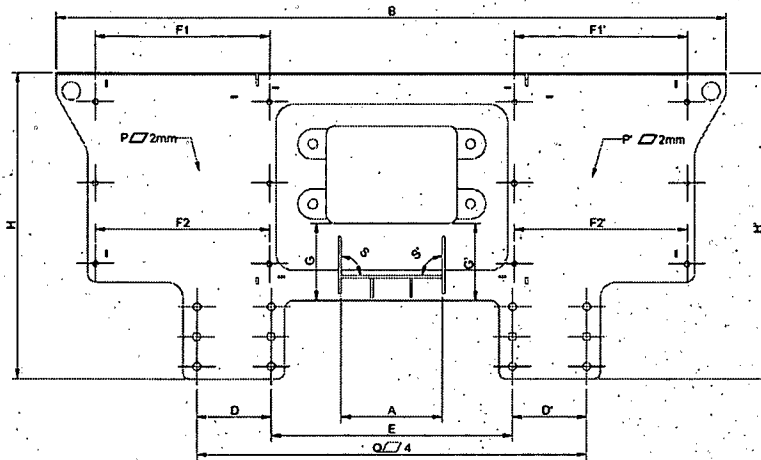
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1486	1485	Tape Measure	<i>Auss Hh</i>
Y1	2354	± 3				<i>Auss Hh</i>
Y2 / Y3	666	± 1	667	667		
QC Inspector:		<i>LEON</i>	Sign:		<i>[Signature]</i>	Date: 2024/02/02

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Ruler	
P2 / P3 : Planeity	4 mm	Ruler	
P4 / P5 : Planeity	2 mm	Ruler	
P6 : Planeity	2 mm	Ruler	
QC Inspector:		Sign:	Date: 20__/__/__

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>TR Booth</i>	Assembly Date:	2024/01/30			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202/52			



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:	2024/01/30	

Dimensional Control

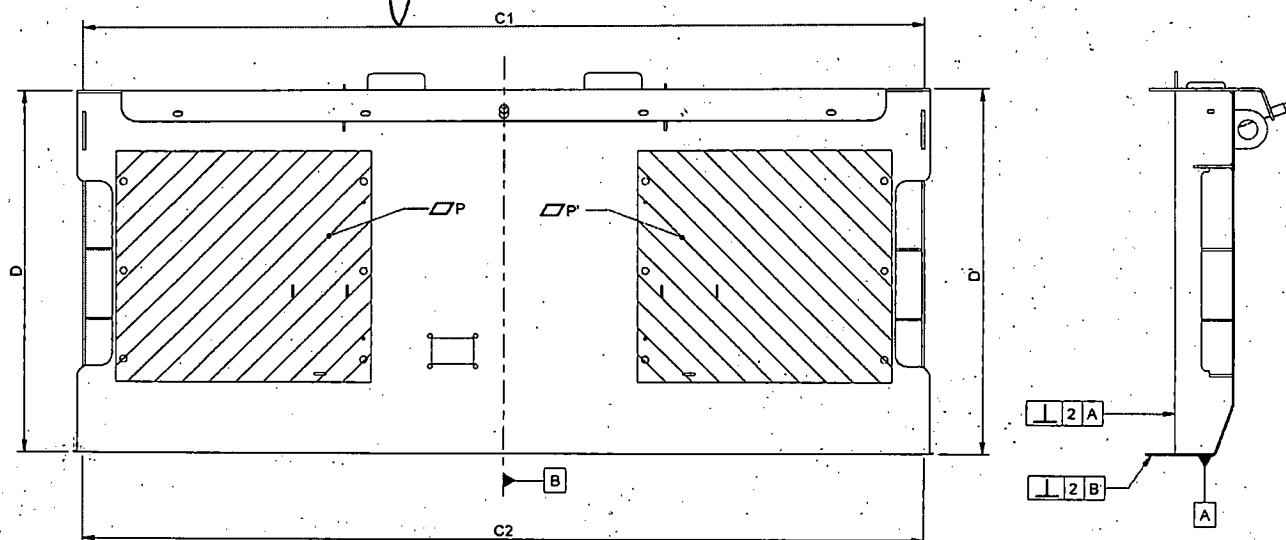
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	± 1	339		Tape Measure	Acceptable
B	2240	± 4	2244			Acceptable
D / D'	250	± 1	251	251		Acceptable
E	808	± 2	808			Acceptable
F1 / F1'	580	± 1	581	581		Acceptable
F2 / F2'			581	581		Acceptable
G / G'	258	± 1	259	259		Acceptable
H / H'	1019	± 2	1020	1020		Acceptable
QC Inspector:		Leon		Sign:		Date: 2024/01/30

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
O: Planeity of global assembly	4 mm	Ruler	Acceptable
P / P': Planeity	2 mm	Ruler	Acceptable
Q: Planeity Surface of Supports	4 mm	Ruler	Acceptable
R: Planeity Coupler Support	2 mm	Ruler	Acceptable
S: Perpendicularity coupler	1mm	Square	Acceptable
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>
Date:	2024/01/30		

Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	BEVAN JAVENHILL	Assembly Date:	20 24/02/02	
Sign:		Wire Batch No.:	2202152	



Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	LEON	Sign:		Date: 20 24 / 02 / 02

Dimensional Control

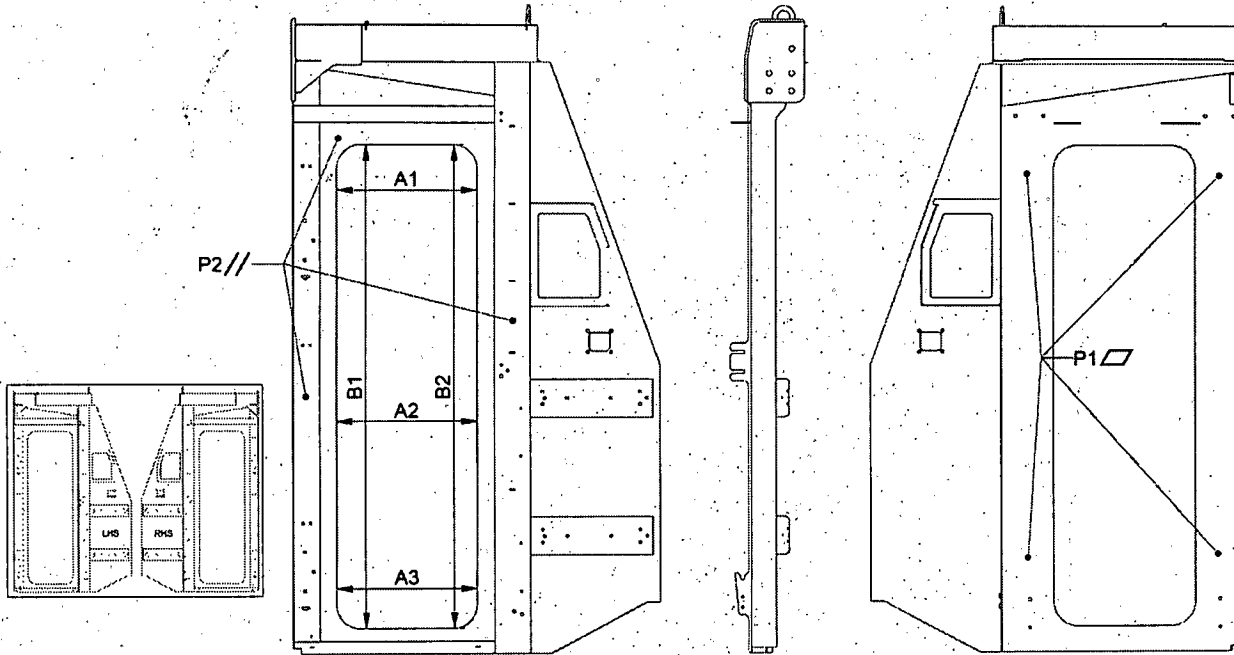
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2013	2010	Tape Measure	Accepted
D / D'	956	± 2	956	955		Accepted
QC Inspector:		LEON		Sign:		Date: 20 24 / 02 / 02

Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planarity P / P'		2 mm			Ruler	
Perpendicularity	2	A	Passed		Set Square	Accepted
	2	B	Passed		Set Square	Accepted
QC Inspector:		LEON		Sign:		Date: 20 24 / 02 / 02

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:	2024/01/24	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202165	




Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	<i>Low</i>	Sign:	<i>[Signature]</i>	Date: 2024/02/04

Dimensional Control

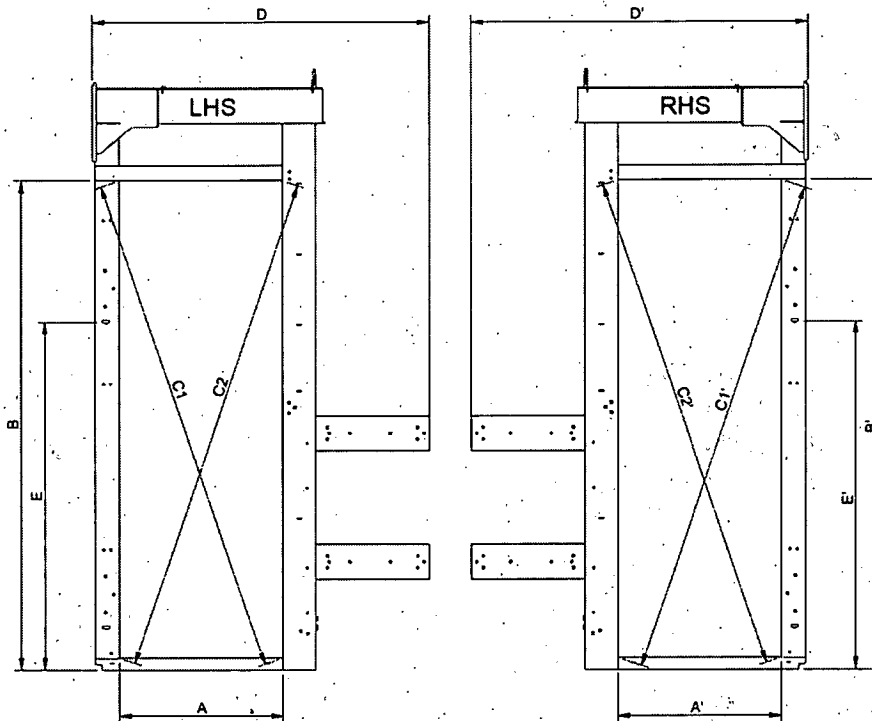
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	558	558	Tape Measure	Accepted
A2			559	559		Accepted
A3			559	559		Accepted
B1	1900	± 2	1898	1898		Accepted
B2			1898	1898		Accepted
QC Inspector:		Low	Sign:		Date:	20 24/02/04

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Pass	Ruler	Accepted
P2 : Planeity	2 mm		Ruler	
QC Inspector:	Low	Sign:		Date: 2024/02/04

Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Glenn	Assembly Date:	2024/01/20			
Sign:		Wire Batch No.:	2202152			



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Leon	Sign:		Date:	2024/01/24	

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	695	696	Tape Measure	Acceptable
B	2086	+1/-3	2085	2086		Acceptable
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2153	2152		Acceptable
C1 - C2			2153	2152		Acceptable
D	1438	+2/-3	1437	1440		Acceptable
E			1482			Acceptable
QC Inspector:		Leon	Sign:		Date:	2024/01/24

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	Pass	Ruler	Acceptable
QC Inspector:		Leon	Sign:	
			Date:	2024/01/24

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:	2024/01/19			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202165			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

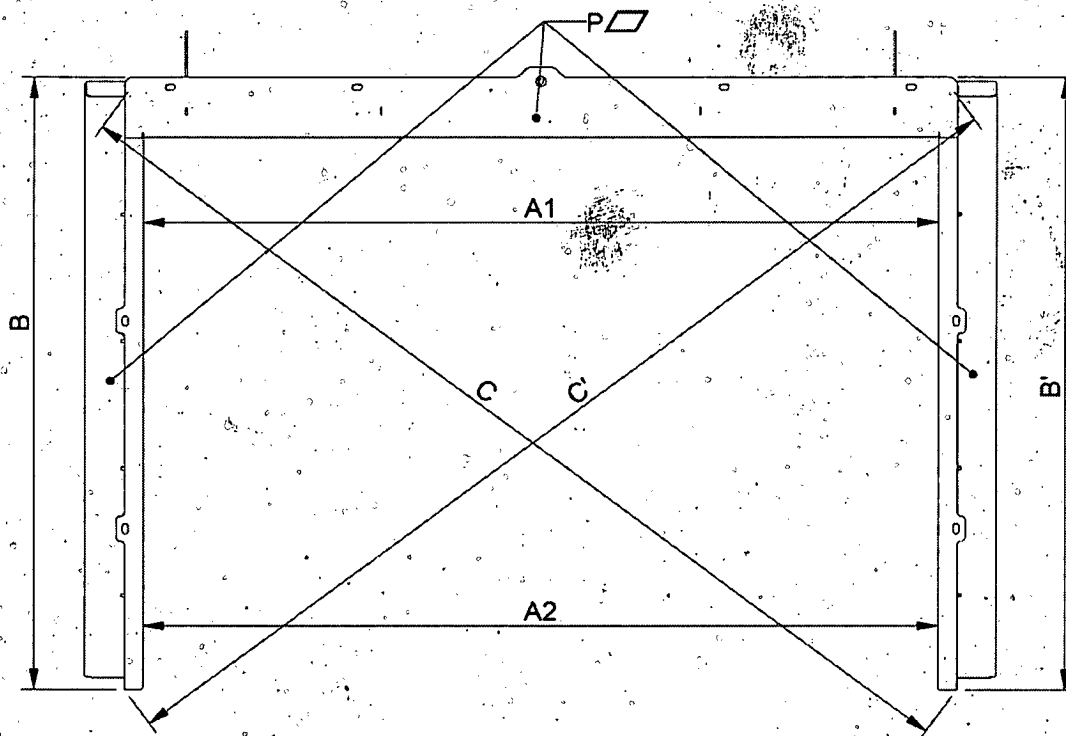
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>Glenn</i>	Assembly Date:	2024/01/19			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

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:	2024/01/19			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

Cabin Front Frame Assembly: GN002840


Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<u>Bomihelo G. Man.</u>	Assembly Date:	<u>2024/02/02</u>			
Sign:	<u>[Signature]</u>	Wire Batch No.:	<u>2202152</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	<input type="checkbox"/>
QC Inspector:	<u>Leon</u>	Sign:	<u>[Signature]</u>	Date:	<u>2024/02/02</u>	


Dimensional Control

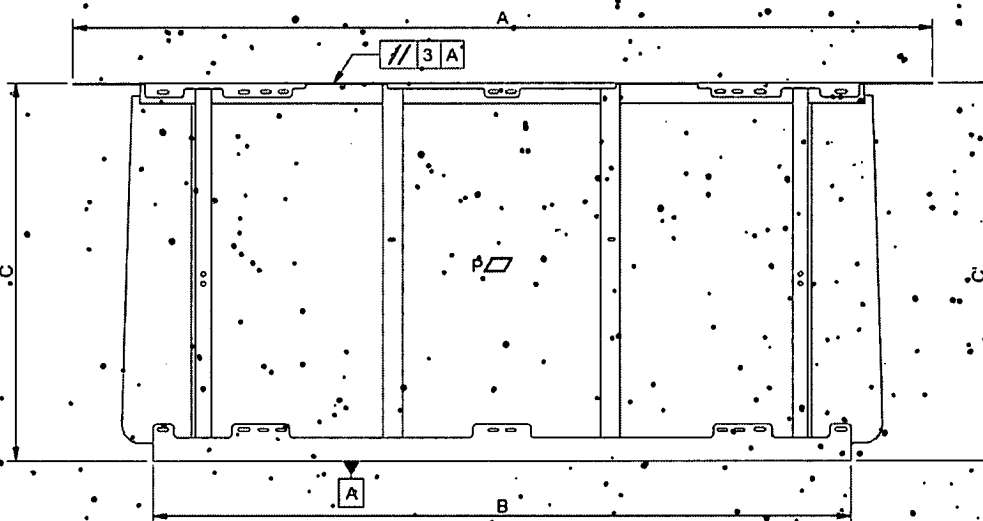
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	1910	± 2	1912		Tape Measure	Acceptable	
A2	1910		1911			Acceptable	
B	1475	± 1	1474	1474		Acceptable	
C	Diagonals C - C' ≤ 3		2476	2475		Acceptable	
QC Inspector:		LEON		Sign:		Date:	2024/02

Geometrical Control


Nature of checks		Dimension Measured	Measuring Equipment	Observations
P : Planeity	4 mm	Pass	Ruler	Acceptable
QC Inspector:	Leon	Sign:	A	Date: 2024/02/02

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:	<u>2024/02/03</u>	
Sign:		Wire Batch No.:	<u>107238201</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 <input type="checkbox"/>
QC Inspector:	<u>Lee</u>	Sign:		Date: <u>2024/02/03</u>

Dimensional Control

Rep	Toler.	Dimension measured	Measuring Equipment	Observations
A	2216	+5/-0	Tape Measure	<u>Accepted</u>
B	1800	± 4		<u>Accepted</u>
C	976	+2/-3		<u>Accepted</u>
QC Inspector:			Sign:	
				Date: <u>2024/02/03</u>

Geometrical Control

Nature of Checks		Dimension Measured	Measuring Equipment	Observations
Planeity P	6 mm		Ruler	
//	3	A	Set Square	<u>Accepted</u>
QC Inspector:			Sign:	
				Date: <u>2024/02/03</u>

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	5 Feb 2024	178247 104828 01	LD49402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	14.02.2024	178819 104640 01	VHF 72725	
RCS 355	3 mm					
RCS 355	3 mm					

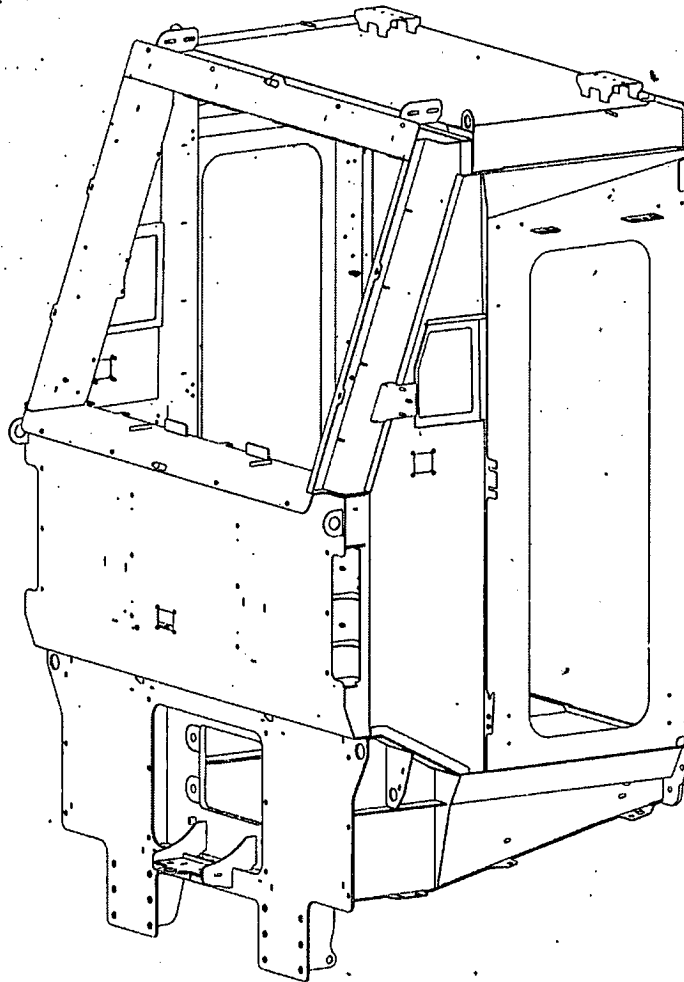
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegasus	08.02.2024	178488 104640 01	VPK 97566	
RCS 355	20 mm					

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

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	14.02.2024	178815 104640 01	VHL 36678	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	08.02.2024	178489 104640 01	F207905 VHL 28402	
RCS 450	6 mm					
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	14.02.2024	178523 104640 01	F207906 VHSS 8432	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					



CABIN STRUCTURE QUALITY CARD

CAB No.: CAB436

WEIGHT: 1482 Kg