

GIBELA

PRASA PROJECT

APPLICABLE FROM TRAINSET 100+ 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		
<input type="checkbox"/>	DTR30225487/3	AAD0001278556	CARBODYSHELL M1 ASSEMBLY	CB1210			X			PRA.CB1210.DTR30225487/3.V25	YES
<input type="checkbox"/>											

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018
			CHECKER	Nosizo Pindela	10/01/2018
			COMPILER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change 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	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230	APPROVER	Itumeleng Modiba	2018/07/04
			CHECKER	Nosizo Pindela	2018/07/04
			REVISED BY	Ramokone Motama	2018/07/04
3	2018/12/12	Added dimensional check points to CB1210	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	13/03/2019	Added D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
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	19/04/2021	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	19/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	19/02/2022
			CHECKER	Andani Muthelo	19/02/2022
			REVISED BY	Andani Muthelo	19/02/2022
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	Zwane Ntokozo	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	Ntokozo Zwane	07/11/2023

TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
2516	M1	P. MALATSI 409964	05/03/24	SI.CB1210.254.V28	17

	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

Carr: M1	NCR:	Work station: CB1210
----------	------	----------------------


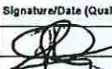


Safety Related



I - Documentation and Instruments Control

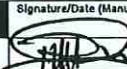



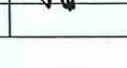

1.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	TC	M	SE	P	MA	P					
DTR30225487/3	X						V28		✓		

05/03/24

1.2 - Instruments Control





Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULAR	918TP0102	18/11/23	✓		
LASER TAPE	125425924	08/01/24	✓		
SON TAPE	22316	07/02/24	✓		

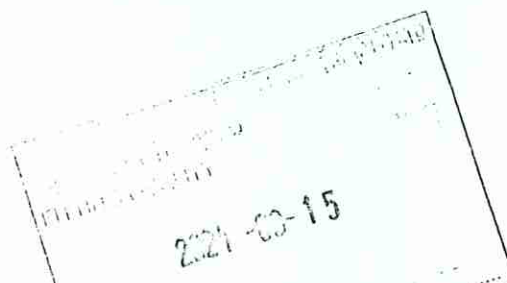
05/03/24

1.3 Consumables

Welding Consumable Control - Used for Special Process

Fiber Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSI	311018-74097	MIG	✓		
ER 308 L	299687-70022	TIG	✓		




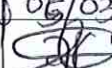



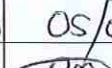



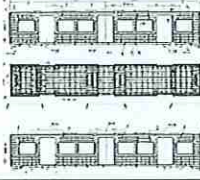

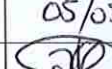

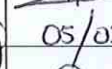
05/03/24




	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date	
		07/11/2023	

II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOK	Remark	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls, Endframes, Roof and Underframe)	DT00000311225	✓			 05/03/24	 05/03/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓			 05/03/24	 05/03/24
03	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓			 05/03/24	 05/03/24
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓			 05/03/24	 05/03/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓			 05/03/24	 05/03/24
06		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓			 05/03/24	 05/03/24
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. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓			 05/03/20	 05/03/24

GIBELA RAIL TRANSPORT CONSORTIUM (PTY) LTD
Mpisani Khanyiso
FITTING QUALITY
2024-03-15
Signature

	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

Welder Traceability

Roof ring welds



Boiler maker (Name & Sign): <u>GERALD G. Mads</u> ^{LHS}	Welder (Name & Sign): <u>Thabang</u>
Boiler maker (Name & Sign): <u>GERALD G. Mads</u> ^{RHS}	Welder (Name & Sign): <u>Sipho</u>

END 1

Boiler maker (Name & Sign): <u>GERALD G. Mads</u> ^{LHS}	Welder (Name & Sign): <u>Thabang</u>
Boiler maker (Name & Sign): <u>GERALD G. Mads</u> ^{RHS}	Welder (Name & Sign): <u>Sipho</u>

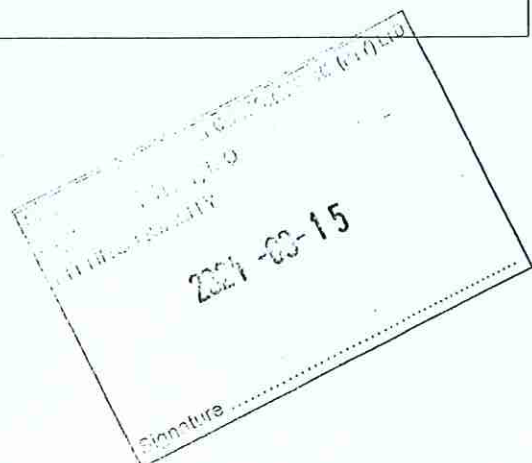
END 2


Door ring welds



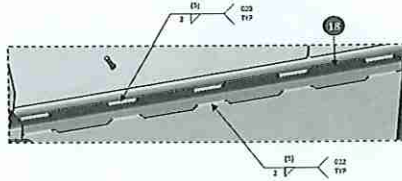
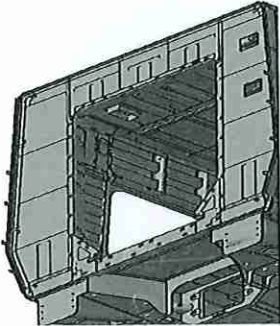
Boiler maker (Name & Sign): <u>Thabang</u> ^{LHS}
Welder (Name & Sign): <u>BOBBE</u>

Boiler maker (Name & Sign): <u>Thabang</u> ^{RHS}
Welder (Name & Sign): <u>BOBBE</u>



	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

EUF Reinforcement Plates

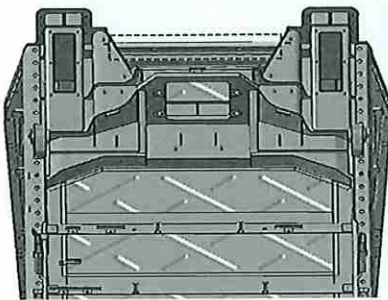


END 1

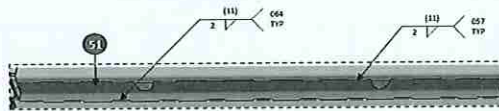
Boiler maker (Name & Sign): Innocent Mthethwa

Welder (Name & Sign): G. H. Mthethwa

END 2



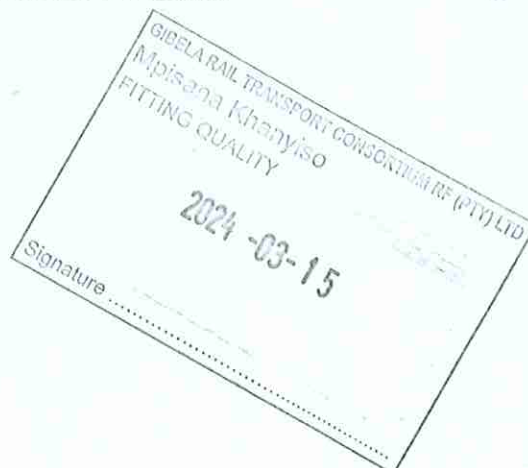
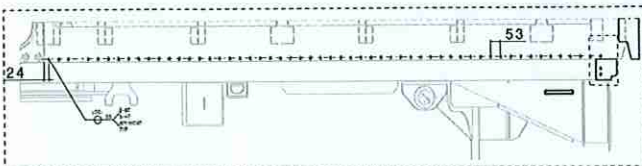
Underneath the CAR




END 2

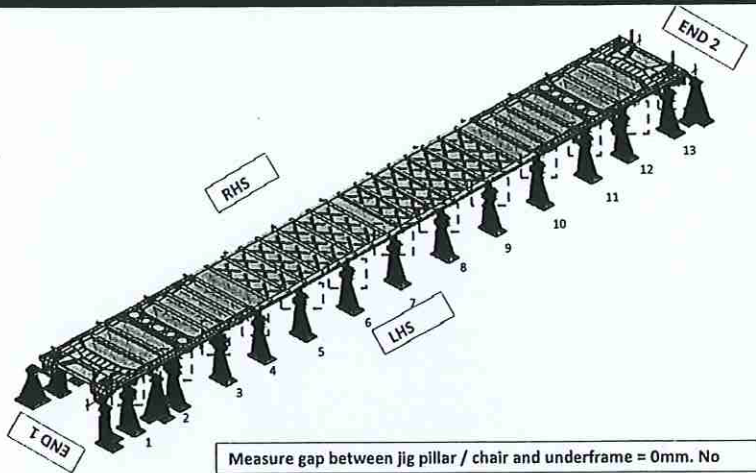
Boiler maker (Name & Sign): Tim R. R. R.

Welder (Name & Sign): Thabang Mthethwa



	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

Specifications of Details for CBS measurement



After loading and clamping

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

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0

Signature Operations

Date: 05/03/24

After Welding.

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

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side	0	0	0	0	0	0	0	0	0	0	1	0	0
Right Hand Side	0	0	0	0	0	0	0	1	0	0	0	0	0

Signature Industrial Quality

Date: 05/03/24

2024-03-15

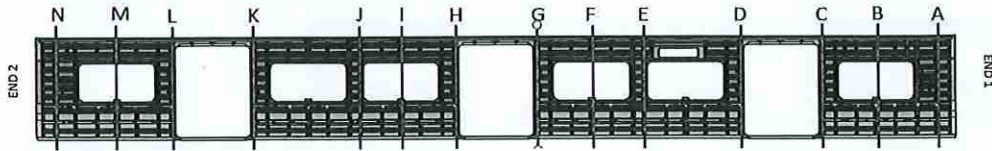


CARBODYSHELL M1 ASSEMBLY DTR30225487/3

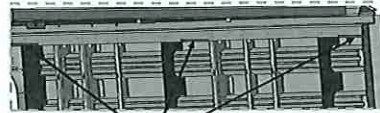
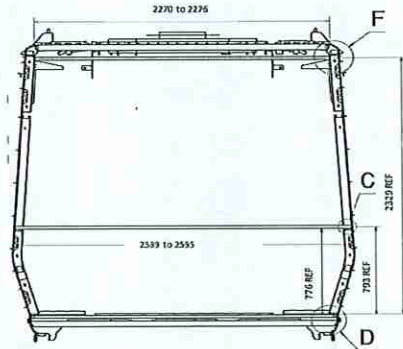
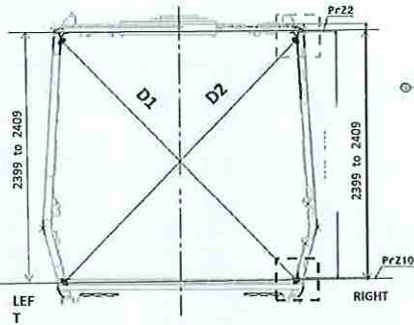
Rev.
28
Date
07/11/2023

Project: PRASA
SI.CB1210.254.V28

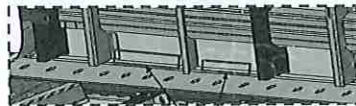
Specifications of Details for CBS measurement



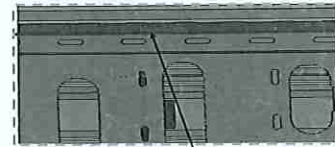
9



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.



Detail F

Don't consider the reinforcement

GIBELA RAIL TRANSPORT CONSORTIUM (PTY) LTD
Mpisani Khanyiso
FITTING QUALITY
2024-03-15
Signature



CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev.

28

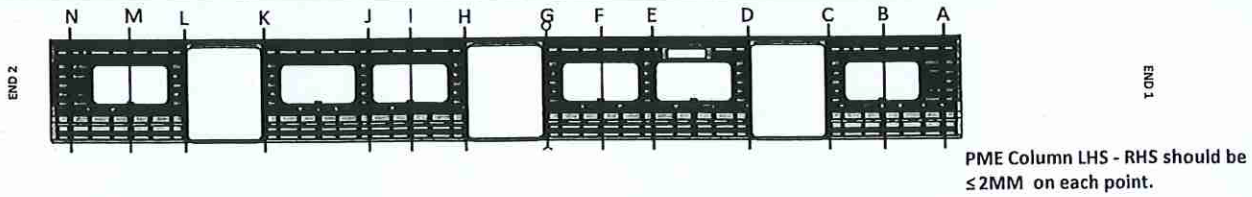
Project: PRA5A

SI.CB1210.254.V28

Date

07/11/2023

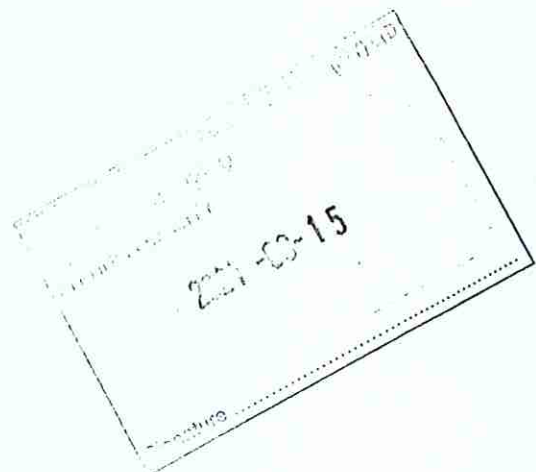
Specifications of Details for CBS measurement



BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3269	3269	0	2404	2404	0
B	3271	3269	2	2406	2404	2
C	3268	3269	1	2404	2405	1
D	3270	3272	2	2406	2404	2
E	3268	3268	0	2405	2404	1
F	3269	3268	1	2406	2404	2
G	3267	3269	2	2404	2404	0
H	3268	3269	1	2405	2404	1
I	3269	3268	1	2406	2404	2
J	3269	3269	0	2405	2404	1
K	3268	3266	2	2406	2404	2
L	3267	3269	0	2404	2406	2
M	3269	3268	1	2404	2404	0
N	3270	3271	1	2404	2406	2

409964
05/03/24

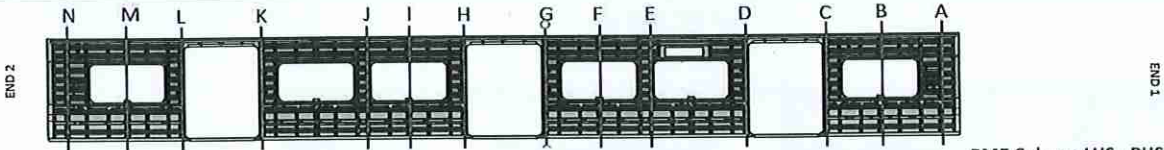




CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev.
28
Date
07/11/2023Project: PRASA
SI.CB1210.254.V28

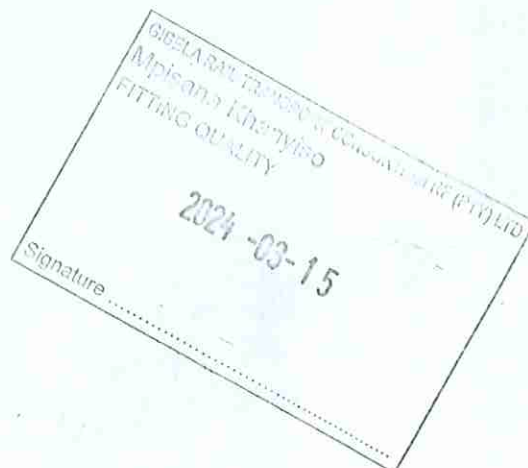
Specifications of Details for CBS measurement


PME Column LHS - RHS should be
≤ 2MM on each point.

AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3296	3297	1	2404	2404	0
B	3269	3268	1	2406	2404	2
C	3298	3298	0	2406	2405	1
D	3296	3297	1	2406	2404	2
E	3269	3268	1	2404	2404	0
F	3270	3271	1	2404	2406	2
G	3296	3298	2	2405	2404	1
H	3296	3296	0	2406	2404	2
I	3268	3270	2	2404	2404	0
J	3269	3269	0	2404	2405	1
K	3296	3298	2	2405	2404	1
L	3297	3297	0	2406	2404	2
M	3270	3269	1	2404	2404	0
N	3298	3296	2	2406	2404	2

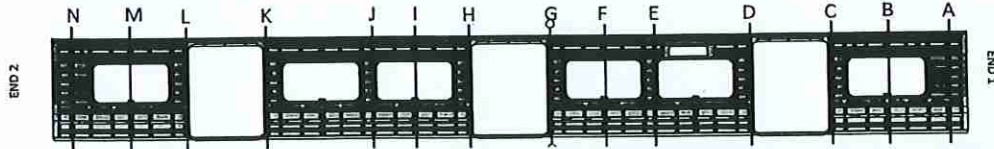
407964
05/03/24



	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

CBS measurement

BEFORE WELDING

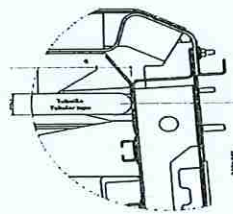
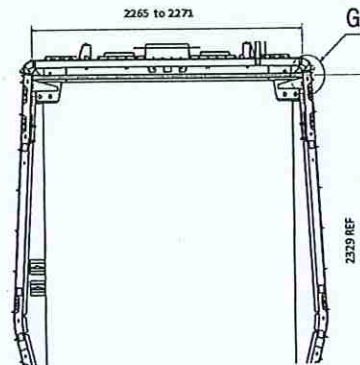


	2270 to 2276
A	2276
B	2274
C	2270
D	2274
E	2276
F	2276
G	2271
H	2274
I	2276
J	2276
K	2273
L	2274
M	2272
N	2271

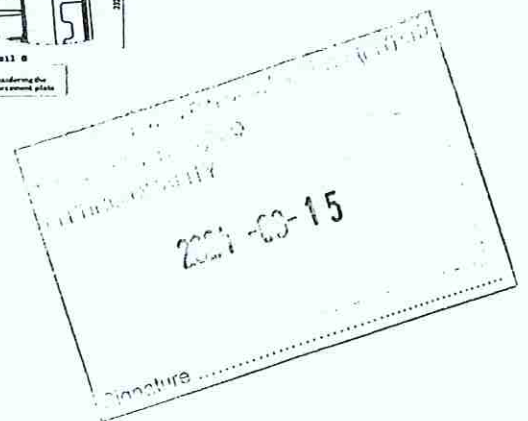
1990 to




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



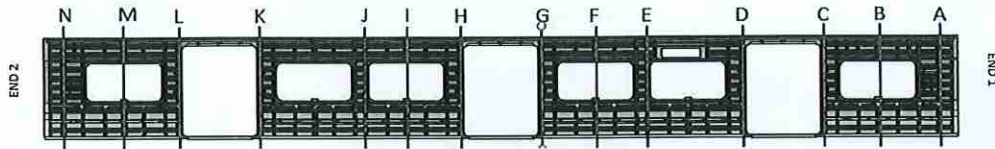
Detail B
Considering the reinforcement plate



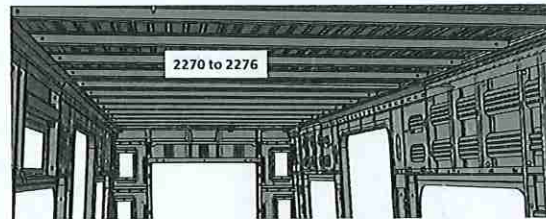
Handwritten signature and date: 05/03/24

	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	
CBS measurement			

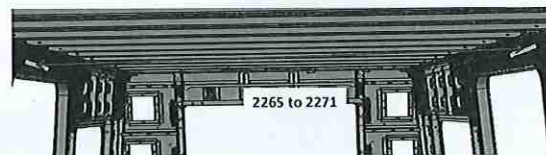
AFTER WELDING



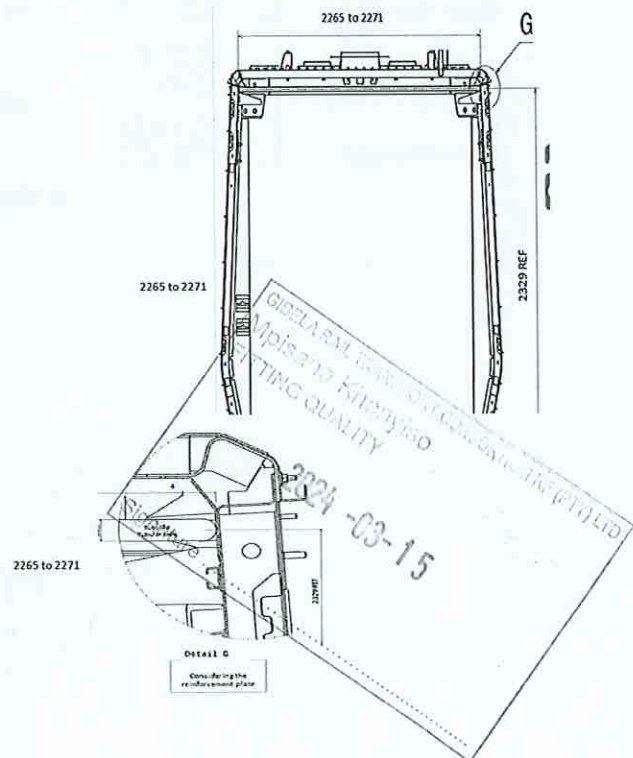
	2265 to 2271	2270 to 2276
A	2269	/
B	/	2274
C	2265	/
D	2268	/
E	/	2276
F	/	2277
G	2265	/
H	2269	/
I	/	2275
J	/	2276
K	2268	/
L	2266	/
M	/	2274
N	2269	/



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



Take measurement close to radius (considering reinforcement)



409764
05/03/24

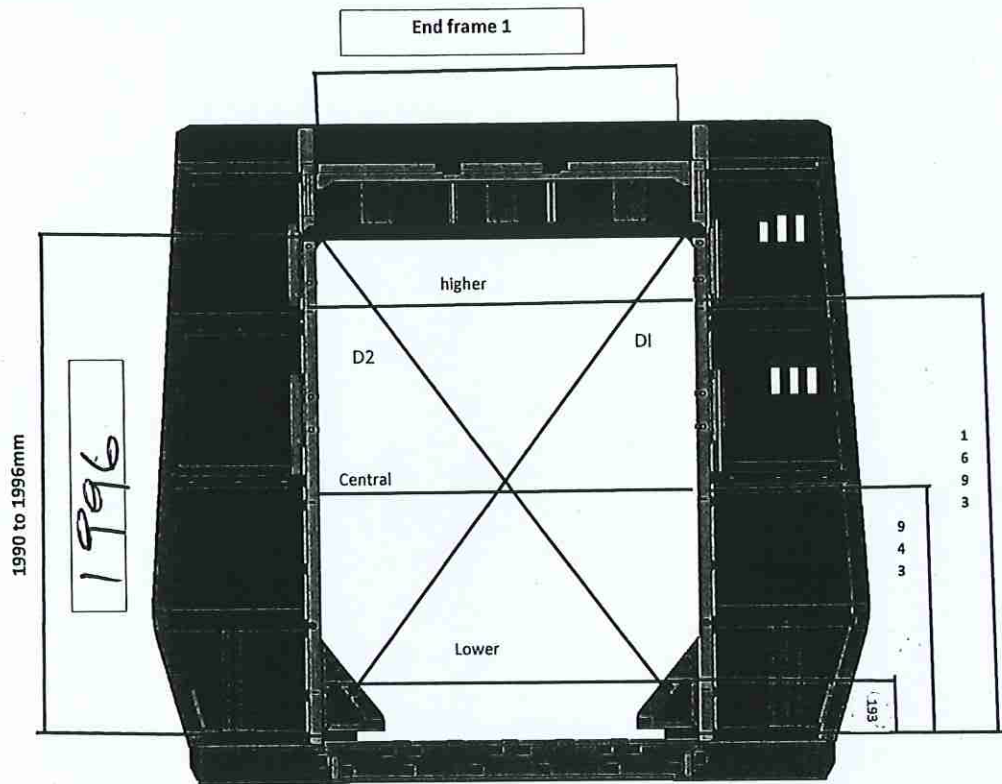


CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev.
28
Date
07/11/2023

Project: PRASA
SI.CB1210.254.V28

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3\text{mm}$

Higher Dimension

1381

D1

2416

Central Dimension

1381

D2

2415

Lower Dimension

1382

D1-D2

1

[Handwritten signature]
4099964
05/03/24

[Handwritten signature]
2021-03-15
Signature

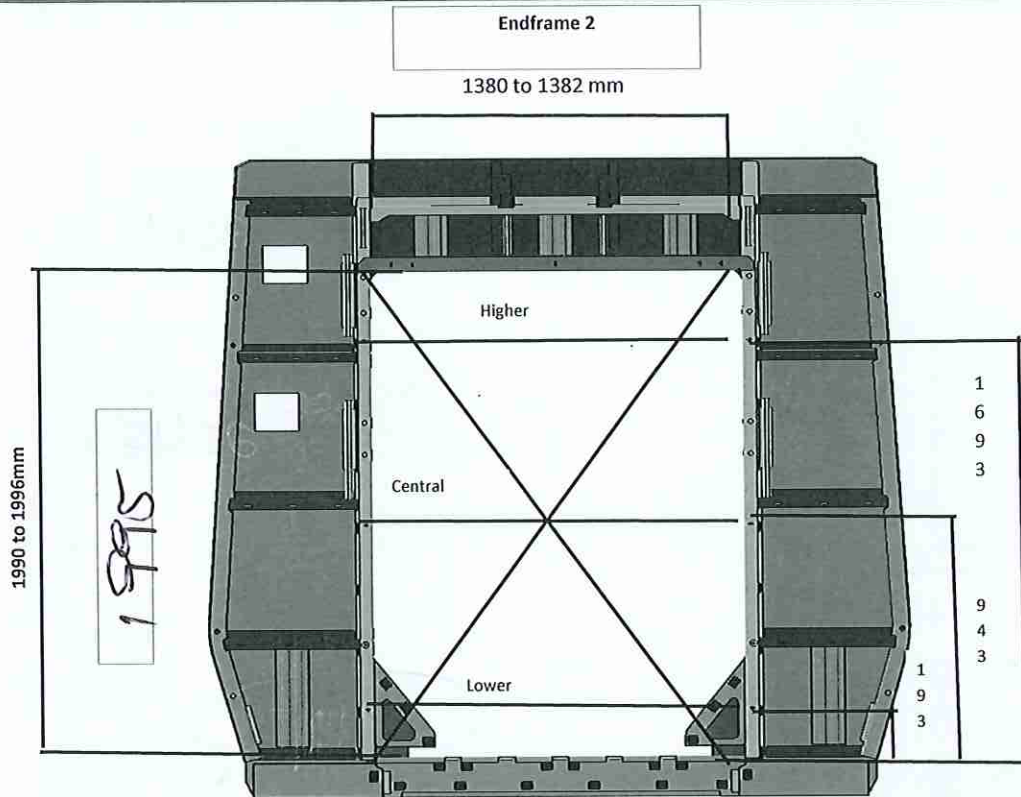


CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev.
28
Date
07/11/2023

Project: PRASA
SI.CB1210.254.V28

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3mm$

Higher Dimension

1880

D1

2415

Central Dimension

1382

D2

2415

Lower Dimension

1381

D1-D2

0

409964
05/04/24

GIBEL RAIL TRANSPORT EQUIPMENT (PTY) LTD
Mpisana Khanyiso
FITTING QUALITY
2024-03-15
Signature

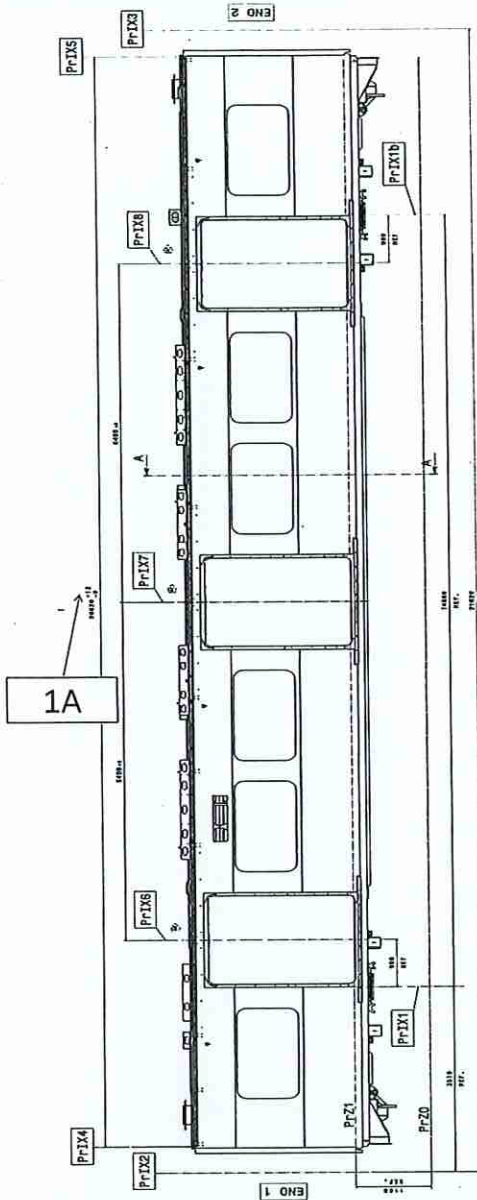


CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev.
28
Date
07/11/2023

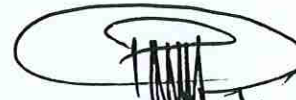
Project: PRASA
SI.CB1210.254.V28

Specifications of Details for CBS measurement



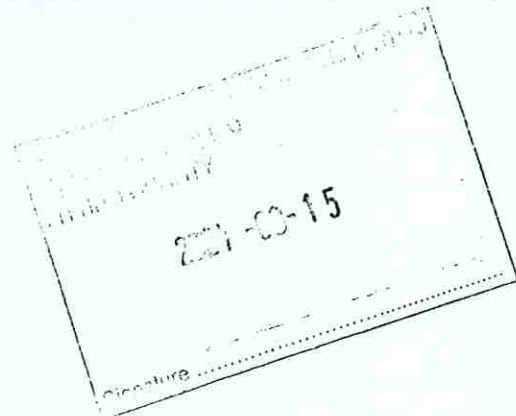
LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20615

RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20615



499960
05/03/24

Dye penetrant test

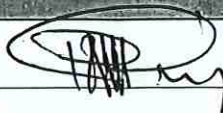

Dye-penetration test to be performed by quality personnel



2024-03-15

	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA
		Date 07/11/2023	SI.CB1210.254.V28

Self Inspection - Final Result

			DATE	NAME	SIGNATURE
HOLD POINT		(If activities are not complete, the missing activities must not impact the next stage)	05/03/24	P. MARATY	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	05/03/24	Amo	
		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

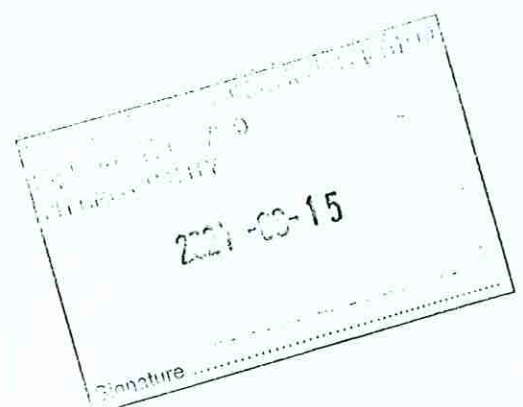
In case of "NO GO", the operations manager must define below action plan to ensure "GO":

Item	Description	Responsible	Due date	Status

Operations

Quality

9





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			
<input type="checkbox"/>	DTR3022549/2	AAD00012/6566	CARBODYSHELL M3,M3,M4 ASSEMBLY	CB1220		X	8		X		PRA.CB1220.DTR3022548 7/2.V21	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
REV	DATE	MODIFICATION CONTENT			RESPONSIBLE		NAME		DATE			
0	01/02/2018	GIBELA NEW CREATION			APPROVER	Itumeleng Modiba	01/02/2018					
					CHECKER	Nosizo Pindela	01/02/2018					
					COMPILER	Thanyani Mathegu	01/02/2018					
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager			APPROVER	Itumeleng Modiba	18/05/2018					
					CHECKER	Nosizo Pindela	18/05/2018					
					REVISED BY	Ramokone Motama	18/05/2018					
2	2018/07/05	Certain dimensional checks added and others moved to CB1210			APPROVER	Itumeleng Modiba	2018/07/05					
					CHECKER	Nosizo Pindela	2018/07/05					
					REVISED BY	Ramokone Motama	2018/07/05					
3	2018/06/12	Width tolerance as per DT0000336600			APPROVER	Itumeleng Modiba	2018/06/12					
					CHECKER	Nosizo Pindela	2018/06/12					
					REVISED BY	Nosizo Pindela	2018/06/12					
5	24/01/2019	As per Baseline 10.2			APPROVER	Itumeleng Modiba	24/01/2019					
					CHECKER	Nosizo Pindela	24/01/2019					
					REVISED BY	Vanessa Ntuli	24/01/2019					
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements			APPROVER	Itumeleng Modiba	13/03/2019					
					CHECKER	Nosizo Pindela	13/03/2019					
					REVISED BY	Nosizo Pindela	13/03/2019					
10	22/08/2019	New Baseline 10.2.5			APPROVER	Itumeleng Modiba	22/08/2019					
					CHECKER	Nosizo Pindela	22/08/2019					
					REVISED BY	Nosizo Pindela	22/08/2019					
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	19/04/2021	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	20/02/2022	New Baseline change 10.3.1			APPROVER	Mbhombi Collins	19/02/2022					
					CHECKER	Andani Muthelo	19/02/2022					
					REVISED BY	Andani Muthelo	19/02/2022					
26	14/06/2022	Update minimum temperature requirement for sealant application			APPROVER	Mbhombi Collins	14/06/2022					
					CHECKER	Andani Muthelo	14/06/2022					
					REVISED BY	Andani Muthelo	14/06/2022					
27	17/10/2022	Addition of traceability for sealant application and welding			APPROVER	Mbhombi Collins	17/10/2022					
					CHECKER	Ntokozo Zwane	17/10/2022					
					REVISED BY	Amogelang Mohlampe	17/10/2022					
28	14/04/2023	Added sealant batch number & welding consumables traceability			APPROVER	Vanessa Ntuli	14/04/2023					
					CHECKER	Ntokozo Zwane	14/04/2023					
					REVISED BY	Amogelang Mohlampe	14/04/2023					
29	28/10/2023	Addition of bracket quantity			APPROVER	Ngobeni Tyson	28/10/2023					
					CHECKER	Ntokozo Zwane	28/10/2023					
					REVISED BY	Amogelang Mohlampe	28/10/2023					
TRAINSET	CAR	OPERATOR NAME & ALPS NO		DATE	SELF INSPECTION NUMBER		PAGES					
216	M01	Mthchozwa 426954		06/03/24	SI.CB1220.250.V29		14					

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

Safety Related

I - Documentation and Instruments Control

1.1 - Documentation Control

Document	Type of car					Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	M1	M3	M4	M2	M5					
DTR30225487/2	X					29	06/03/24	✓	N/A	28/06/24











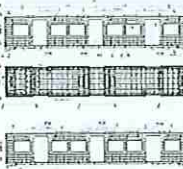












1.2 - Instruments Control


Monitoring and Measuring Instrument Control - Used for Special Process										
Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)					
Tape measure	GIBTA0067	2024/04/05	✓	28/06/24	28/06/24					
Tubular	12062-2	2025/02/19	✓	28/06/24	28/06/24					


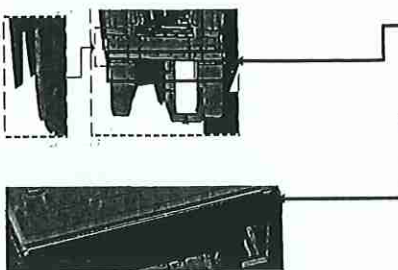
1.3 Consumables

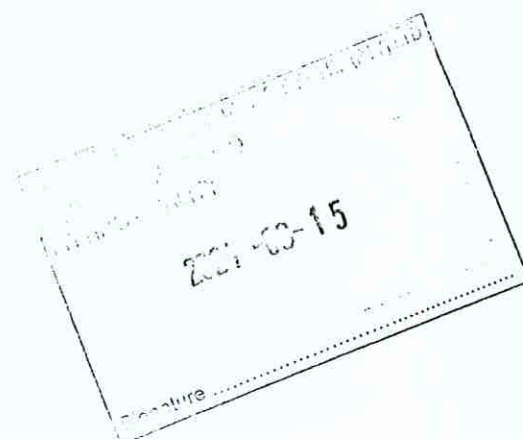
Welding Consumable Control - Used for Special Process						
Fiber Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)	
308	E81067	308 MIG	✓	28/06/24	28/06/24	


Signature

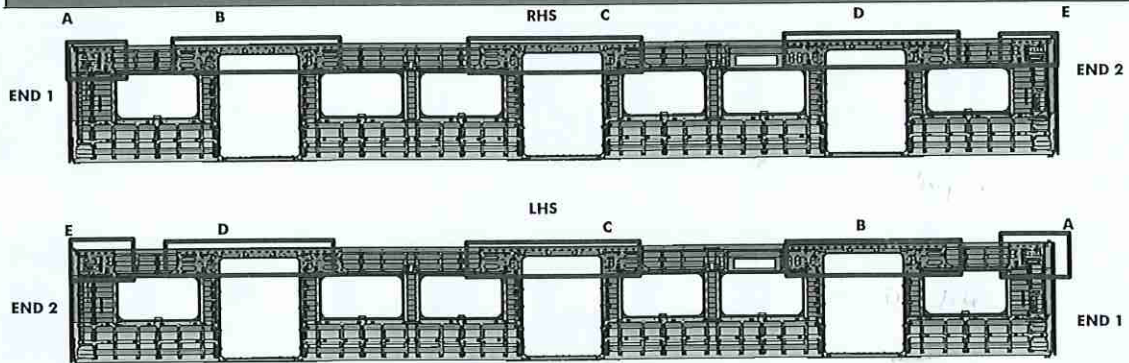
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB1220.250.V29					
		29						
		Date						
		28/10/2023						
II - Self Inspection - Items to Check								
II.1 - Items to check								
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOK	Review	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB1220.DTR30225487/2	✓			 06/03/24	 06/03/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓			 06/03/24	 06/03/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓			 06/03/24	 06/03/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓			 06/03/24	 06/03/24
05		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			 06/03/24	 06/03/24
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓			 06/03/24	 06/03/24
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: Temperature Min - Max (°C) Min-Max 35°C Relative humidity Min-Max 25% - Max (1) Min-Max 60%	Sealant Batch No: <u>SK 70-03</u> Exp Date: <u>1/03/24</u> Actuals Temperature: <u>30°C</u> Humidity: <u>60%</u>	✓			 06/03/24	 06/03/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓			 06/03/24	 06/03/24
09		Verification of safety welds	Approved according to DTD000210658 reference and Self inspection	✓			 06/03/24	 06/03/24


Signature
2024-03-15





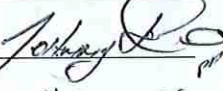

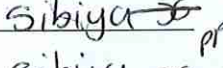
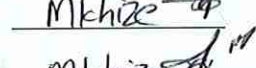
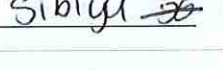
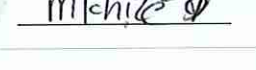
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA
		29	
		Date	
		28/10/2023	
		SI.CB1220.250.V29	
II - Self Inspection - Items to Check			
<div style="text-align: center;">SEALANT APPLICATION</div> <div style="display: flex; align-items: center;">  <div style="border: 1px solid black; padding: 5px; margin-left: 20px;"> <p>AREA 1 & 2 END 1</p> <p>Operator (Name & sign): <i>Piscilla</i></p> <p>Operator (Name & sign): <i>Piscilla</i></p> </div> </div>			

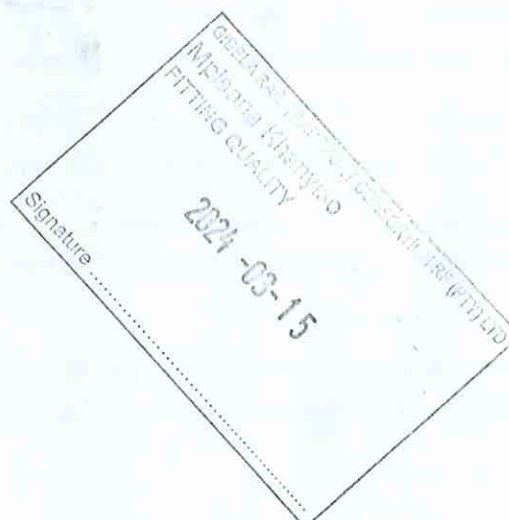



	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA
		29	
		Date	SI.CB1220.250.V29
		28/10/2023	
II - Self Inspection - Items to Check			

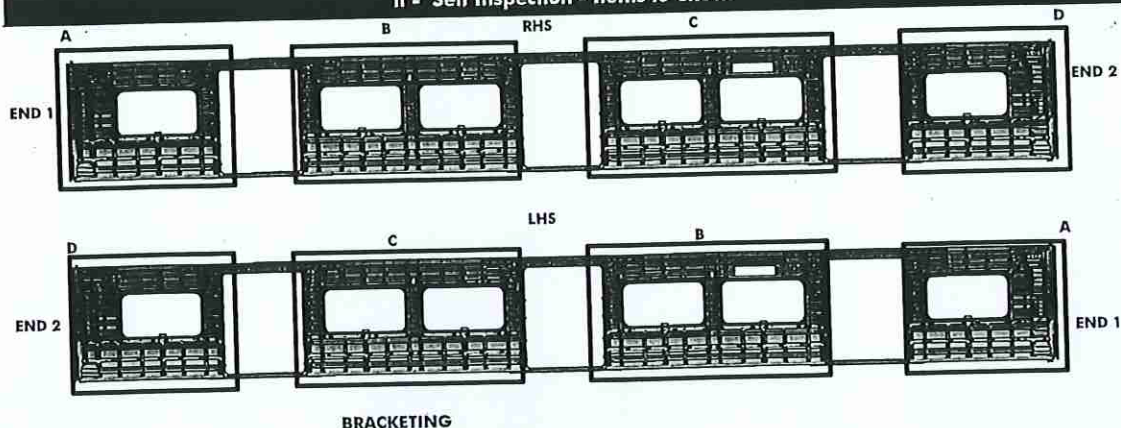



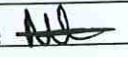




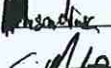
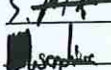
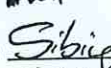
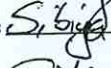
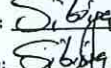
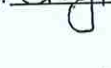
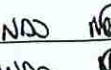


REINFORCEMENT WELDING

AREA	LHS	RHS
A	Operator (Name&sign): <u>LINDO</u> 	<u>MMAKHUKO</u> 
B	Operator (Name&sign): <u>LINDO</u> 	<u>MMAKHUKO</u> 
C	Operator (Name&sign): <u>Johannes</u> 	<u>S. Mkhize</u> 
D	Operator (Name&sign): <u>Sibiya</u> 	<u>Mkhize</u> 
E	Operator (Name&sign): <u>Sibiya</u> 	<u>Mkhize</u> 




	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA
		29	
		Date	SI.CB1220.250.V29
		28/10/2023	
II - Self Inspection - Items to Check			

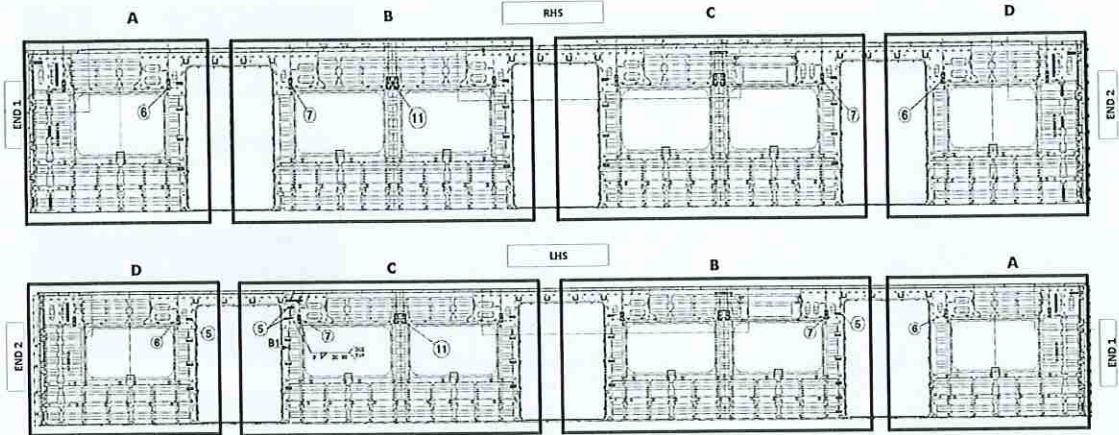


INSTALLATION	
C-RAILS:	Operator: <u>Assenda</u> 
	Operator: _____
DOOR MECHANISMS:	Operator: <u>Mthwazi</u> 
	Operator: _____
TAPPING PADS	Operator: <u>Tetelo</u> 
	Operator: _____
INSTALLATION & VERIFICATION	
SEAT & LUGGAGE BRACKETS:	Operator: <u>Mthwazi</u> 
	Operator: _____
SEAT BRACKETS VERIFICATION:	Operator: <u>Tetelo</u> 
	Operator: _____
WELDING	
AREA	LHS
A (Seat brackets)	: Operator (Name&sign): <u>Sibiga</u> 
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Sibiga</u> 
B (Seat brackets)	: Operator (Name&sign): <u>Sibiga</u> 
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Sibiga</u> 
C (Seat brackets)	: Operator (Name&sign): <u>Sibiga</u> 
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Sibiga</u> 
D (Seat brackets)	: Operator (Name&sign): <u>Sibiga</u> 
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Sibiga</u> 
ENDS	
END 1 TAPPING PADS WELDING:	Operator (Name&sign): <u>LINDO</u> 
END 1 TAPPING PADS WELDING:	Operator (Name&sign): <u>LINDO</u> 

Signature _____

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB1220.250.V29
		29	
		Date	
		28/10/2023	
II - Self Inspection - Items to Check			

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7		
	B	4		
	C	8		
	D	6		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	5		
	C	4		
	D	3		

ROOF ENDS:
 C-RAILS 2 OFF EACH END
 EARTH BUSH 6 OFF EACH END

VERIFICATION BY: _____

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	8		
	C	11		
	D	8		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	5		
	C	6		
	D	2		

ROOF ENDS:
 C-RAILS 2 OFF EACH END
 EARTH BUSH 6 OFF EACH END

VERIFICATION BY: _____

QUANTITIES (M1)

RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7	✓	
	B	4	✓	
	C	8	✓	
	D	6	✓	
SEAT BRACKETS	A	13	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	2	✓	
	B	4	✓	
	C	5	✓	
	D	3	✓	

ROOF ENDS:
 C-RAILS 2 OFF EACH END
 EARTH BUSH 6 OFF EACH END

VERIFICATION BY: *Melchioris*

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2	✓	
	B	10	✓	
	C	11	✓	
	D	6	✓	
SEAT BRACKETS	A	13	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	3	✓	
	B	7	✓	
	C	6	✓	
	D	2	✓	

ROOF ENDS:
 C-RAILS 2 OFF EACH END
 EARTH BUSH 6 OFF EACH END

VERIFICATION BY: *Melchioris*

GIBEL S.p.A. - 00144 ROMA (RM)
 Mpiand Khenybo
 FITTING QUALITY
 2024-03-15
 Signature _____

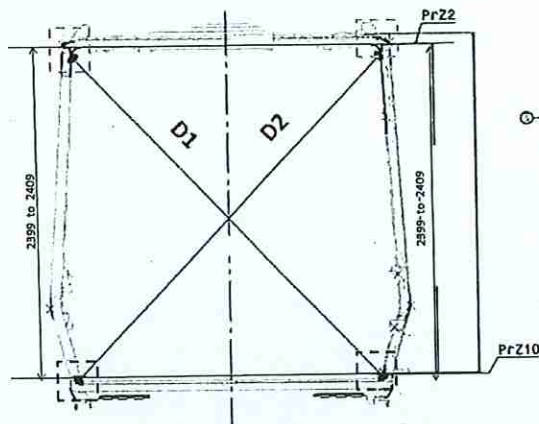


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30226487/2

Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB1220.250.V29

Specifications of Details for CBS measurement



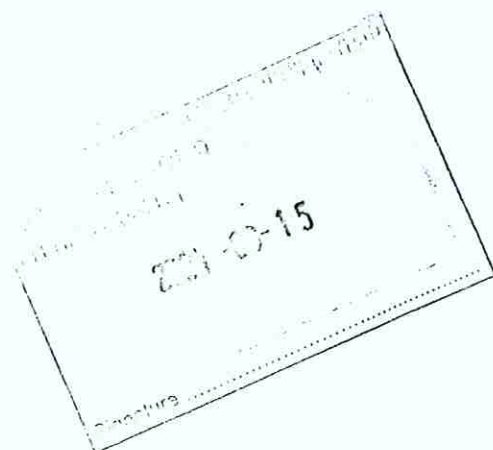
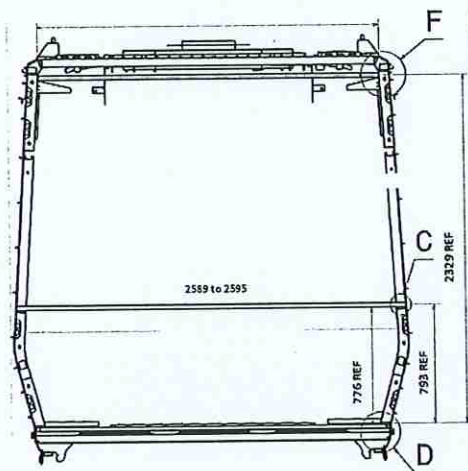
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



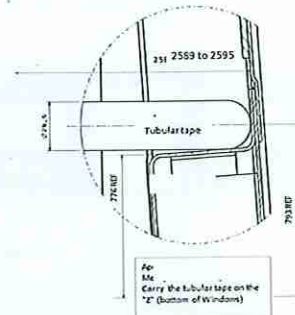
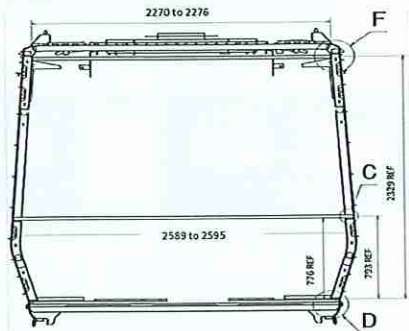


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

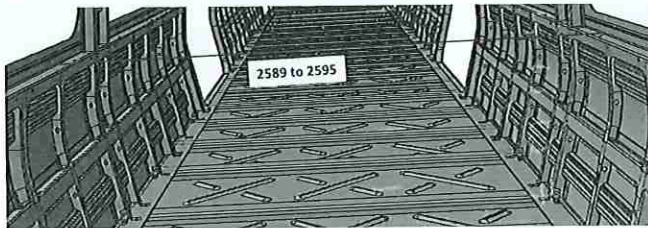
Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB1220.250.V29

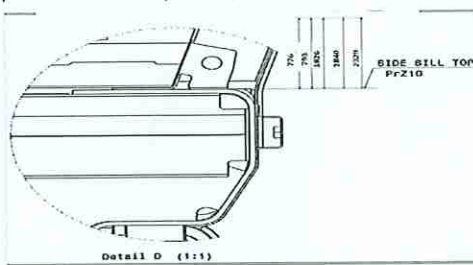
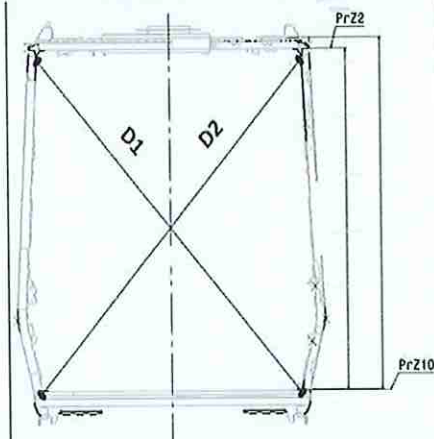
CBS measurement




Detail C

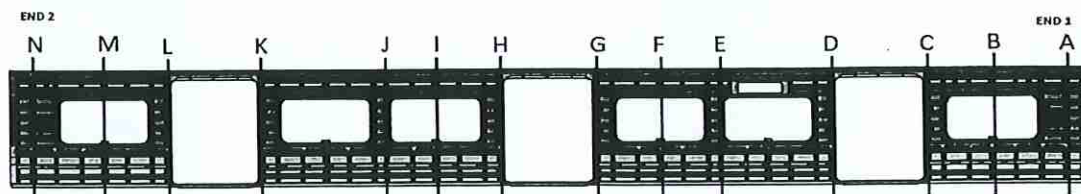


Take measurement close to radius



GIBELA-RAI TRANSPORT CONSULTANT (PTY) LTD
Mphahlele Khanyile
FITTING QUALITY
2024-03-15
Signature


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



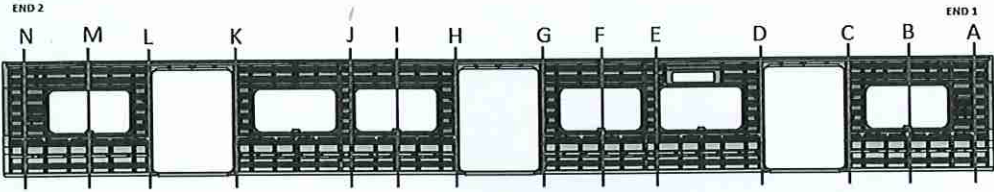
BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3295	3297	2	7
B	3297	3264	3	7
C	3294	3297	3	7
D	3296	3300	4	7
E	3266	3265	1	7
F	3265	3265	0	7
G	3298	3297	1	7
H	3297	3297	0	7
I	3265	3264	1	7
J	3264	3265	1	7
K	3296	3299	3	7
L	3297	3296	1	7
M	3267	3264	3	7
N	3297	3299	2	7



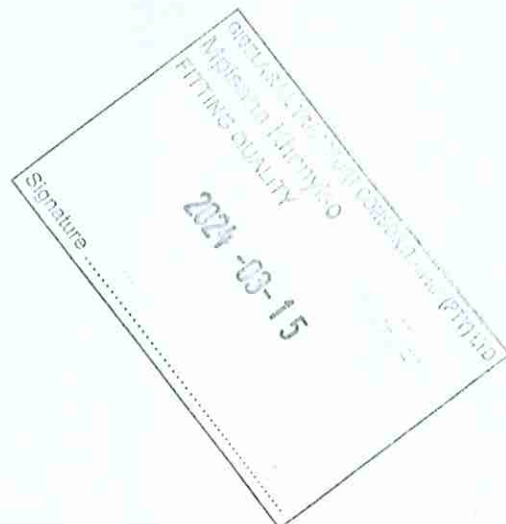
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB1220.250.V29
		29	
		Date	
		28/10/2023	

CBS measurement

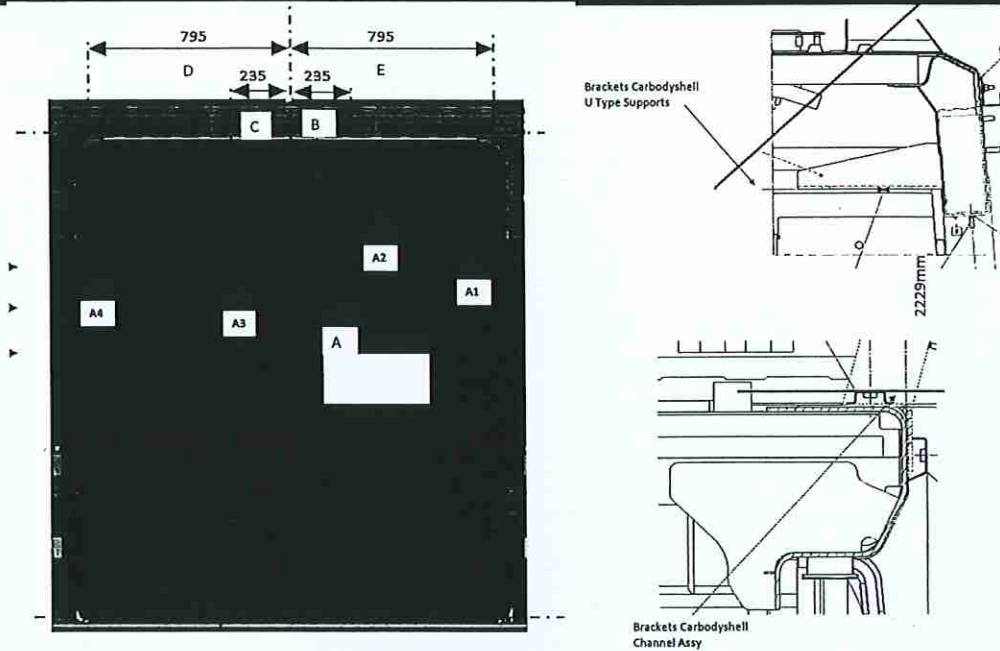


AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3292	3297	5	2595
B	3260	3267	7	2589
C	3295	3297	2	2589
D	3293	3300	7	2593
E	3264	3265	1	2591
F	3263	3264	1	2593
G	3293	3302	9	2591
H	3293	3298	5	2591
I	3263	3263	0	2594
J	3264	3270	6	2591
K	3292	3304	12	2595
L	3296	3304	12	2591
M	3263	3270	7	2591
N	3294	3295	1	2595



Specifications of Details for CBS measurement CB1220



DOOR 1 - LHS	
VALUE	ACTUAL
A1 2230 to 2232	2232
A2 2230 to 2232	2232
A3 2230 to 2232	2232
A4 2230 to 2232	2232
B 234 to 236	235
C 234 to 236	235
D 794 to 796	795
E 794 to 796	795

DOOR 2 - LHS	
VALUE	ACTUAL
A1 2230 to 2232	2234
A2 2230 to 2232	2234
A3 2230 to 2232	2234
A4 2230 to 2232	2234
B 234 to 236	235
C 234 to 236	235
D 794 to 796	795
E 794 to 796	795

DOOR 2 - RHS	
VALUE	ACTUAL
A1 2230 to 2232	2233
A2 2230 to 2232	2233
A3 2230 to 2232	2233
A4 2230 to 2232	2233
B 234 to 236	235
C 234 to 236	235
D 794 to 796	795
E 794 to 796	795

DOOR 1 - RHS	
VALUE	ACTUAL
A1 2230 to 2232	2231
A2 2230 to 2232	2231
A3 2230 to 2232	2231
A4 2230 to 2232	2231
B 234 to 236	235
C 234 to 236	235
D 794 to 796	795
E 794 to 796	795

DOOR 2 - RHS	
VALUE	ACTUAL
A1 2230 to 2232	2232
A2 2230 to 2232	2232
A3 2230 to 2232	2232
A4 2230 to 2232	2232
B 234 to 236	234
C 234 to 236	234
D 794 to 796	796
E 794 to 796	796

DOOR 3 - RHS	
VALUE	ACTUAL
A1 2230 to 2232	2232
A2 2230 to 2232	2232
A3 2230 to 2232	2232
A4 2230 to 2232	2232
B 234 to 236	234
C 234 to 236	234
D 794 to 796	796
E 794 to 796	796

2021-03-15

Signature

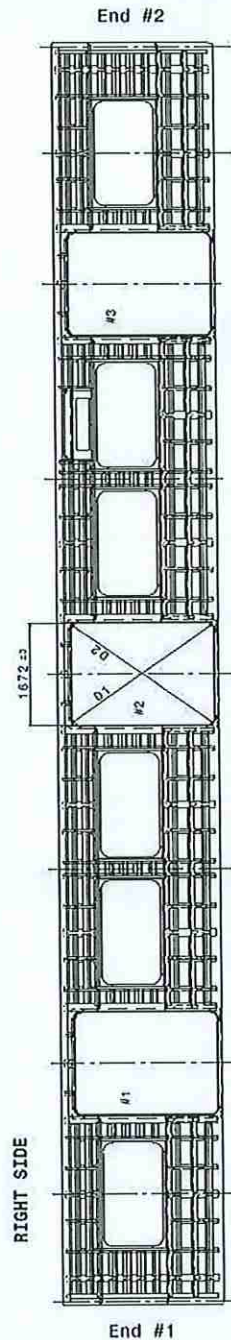


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB1220.250.V29

Specifications of Details for CBS measurement CB1220

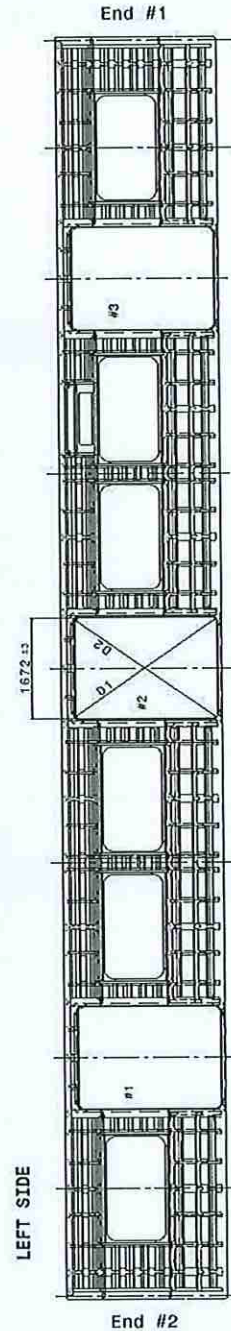


Doors diagonal D1-D2 maximum difference ≤4mm

	#1	#2	#3
D1	2750	2749	2751
D2	2744	2745	2749
D1-D2	6	1	2

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

Doors length - 1672 ±3mm



Doors diagonal D1-D2 maximum difference ≤4mm

	#1	#2	#3
D1	2750	2752	2749
D2	2751	2750	2745
D1-D2	1	2	4





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

Doors length - 1672 ±3mm

GIBELA PROJECT CONSULTING LTD
REGISTERED COMPANY
FITTING QUALITY
Signature.....
2024-03-15

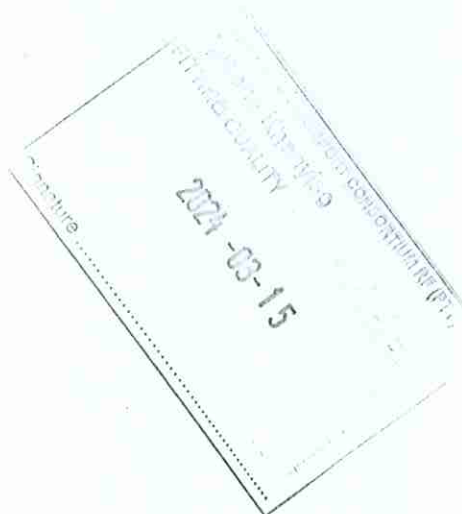
2001-00-15

Signature

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA		
		29			
		Date	SI.CB1220.250.V29		
		28/10/2023			
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	(If activities are not complete, the missing activities must not impact the next stage!)	06/03/24	Mthokozisi Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party)	11/03/24	Androni Industrial Quality	
	NO GO	There are activities pending that impact/stop 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)	06/03/24	Androni Industrial Quality	
In case of "NO GO", describe blocking problems					
side wall repairs not done.					
In case of "NO GO", the operations manager must define below action plan to ensure "GO":					
Item	Description	Responsible	Due date	Status	

Operations

Quality




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				
<input type="checkbox"/>	DT00000225487	AAD0001278566	CARBODYSHELL M1,M3,M4 ASSEMBLY	CB1230		X	X			X		PRA.CB1230.DT000002 25487.V20	YES
<input type="checkbox"/>													
<input type="checkbox"/>													
	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE								
0	2018/08/02	GIBELA NEW CREATION	APPROVER	Philipe Marques	2018/08/02								
			CHECKER	Nosizo Pindela	2018/08/02								
			COMPILER	Nosizo Pindela	2018/08/02								
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	30/5/2018								
			CHECKER	Nosizo Pindela	30/5/2018								
			REVISED BY	Nosizo Pindela	30/5/2018								
2	2018/05/07	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	2018/05/07								
			CHECKER	Nosizo Pindela	2018/05/07								
			REVISED BY	Ramokone Motama	2018/05/07								
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019								
			CHECKER	Nosizo Pindela	24/01/2019								
			REVISED BY	Vanessa Ntuli	24/01/2019								
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements	APPROVER	Itumeleng Modiba	13/03/2019								
			CHECKER	Nosizo Pindela	13/03/2019								
			REVISED BY	Nosizo Pindela	13/03/2019								
10	23/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	23/08/2019								
			CHECKER	Nosizo Pindela	23/08/2019								
			REVISED BY	Nosizo Pindela	23/08/2019								
	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela									
			CHECKER	Bongane Masina	06/08/2020								
			REVISED BY	Bongane Masina									
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela									
			CHECKER	Bongane Masina	19/04/2021								
			REVISED BY	Bongane Masina									
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbombhi									
			CHECKER	Andani Muthelo	20/02/2022								
			REVISED BY	Andani Muthelo									
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbombhi									
			CHECKER	Andani Muthelo	14/06/2022								
			REVISED BY	Andani Muthelo									
27	19/10/2022	Addition of traceability for sealant application	APPROVER	Collins Mbombhi									
			CHECKER	Ntokozo Zwane	19/10/2022								
			REVISED BY	Amogelang Mohlampe									
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli									
			CHECKER	Ntokozo Zwane	14/04/2023								
			REVISED BY	Amogelang Mohlampe									
29	06/11/2023	Added thresholds traceability for boiler makers and welders	APPROVER	Tyson Ngobeni									
			CHECKER	Andani Muthelo	06/11/2023								
			REVISED BY	Ntokozo Zwane									
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES								
216	M1	Ishelelo 440654	06/03/24	SI.CB1230.256.V28	11								

GIBELA RAIL TRANSPORT CONSULTING (Pty) Ltd
Mphahlele Kileshyiso
FITTING QUALITY
Signature
2024-03-15



CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
29

Date

06/11/2023

Project: PRASA

SI.CB1230.256.V28

Car:

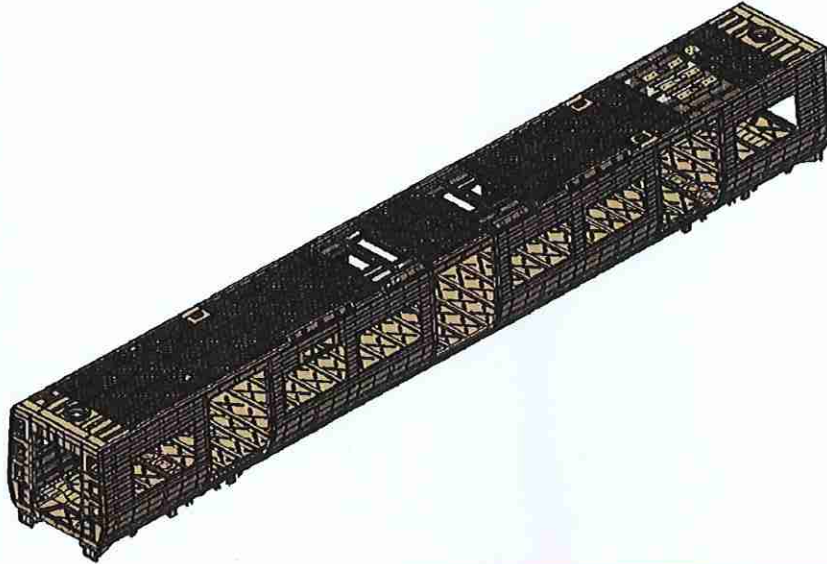
NCR:

Work station:

CB1230



Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car					Revision	Obsevation	OK	NOK	Rework	Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4	TC2							
PRA.CB1230.DT00000225487	X					29		OK		N/A	11/11/24 06/03/24	20/03/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
Tubular	22713-1	29/11/2024	OK		11/11/24 06/03/24	20/03/24
Combination Square	C1605034	2023/10/11	OK		11/11/24 06/03/24	20/03/24
Measuring tape.	C1157A 0394	2023/04/05	OK		11/11/24 06/03/24	20/03/24

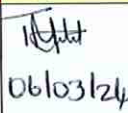

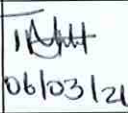

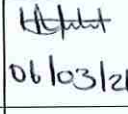

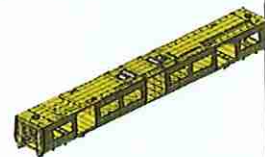
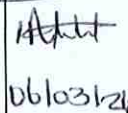

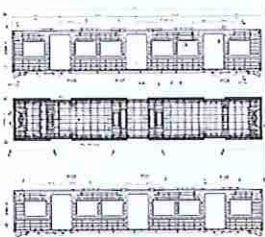



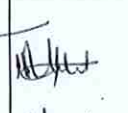

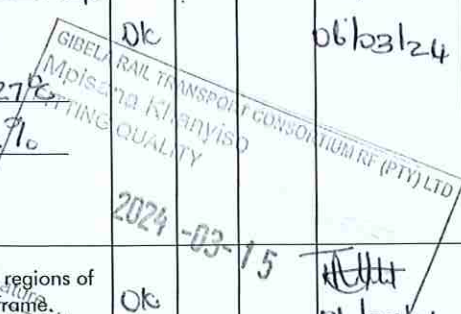
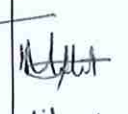
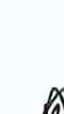
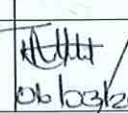

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308 Lsi 1.0mm	310180	Mig welding	OK		11/11/24 06/03/24	20/03/24

II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOK	Rework	Signature/Date (Operations)	Signature/Date (Quality)						
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	OK			 06/03/24	 06/03/2024						
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	OK			 06/03/24	 06/03/2024						
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	OK			 06/03/24	 06/03/24						
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	OK			 06/03/24	 06/03/24						
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	OK			 06/03/24	 06/03/24						
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	OK			 06/03/24	 06/03/24						
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: <table data-bbox="397 1789 715 1901"><tr><td>Temperature Min - Max (1)</td><td>Min-Max</td><td>10°C - 35°C</td></tr><tr><td>Relative humidity Min - Max (1)</td><td>Min-Max</td><td>25% - 80%</td></tr></table>	Temperature Min - Max (1)	Min-Max	10°C - 35°C	Relative humidity Min - Max (1)	Min-Max	25% - 80%	ISR Sealant Batch No: 10-03 Exp Date: 1/05/24 Actuals Temperature: 27°C Humidity: 62% 	OK			 06/03/24	 06/03/24
Temperature Min - Max (1)	Min-Max	10°C - 35°C												
Relative humidity Min - Max (1)	Min-Max	25% - 80%												
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.	OK			 06/03/24	 06/03/24						



CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
29

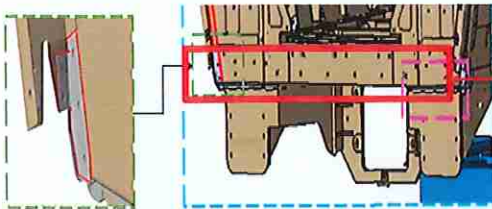
Date

06/11/2023

Project: PRASA

SI.CB1230.256.V28

AREA 1



END 2 SEALANT

OPERATOR
(Name & sign):

Leroy

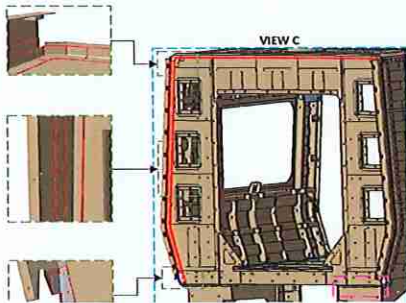
OPERATOR
(Name & sign):

Zanele

OPERATOR
(Name & sign):

Leroy

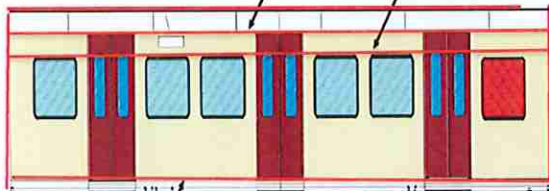
VIEW C



D

E

H



F

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

Operator (Name & sign):

LHS

DEFGHI

RHS

DEFGHI

Operator (Name & sign):

Ishendo

Ishendo

Operator (Name & sign):

THH

THH

Operator (Name & sign):

Sing

Sing

Operator (Name & sign):

VS

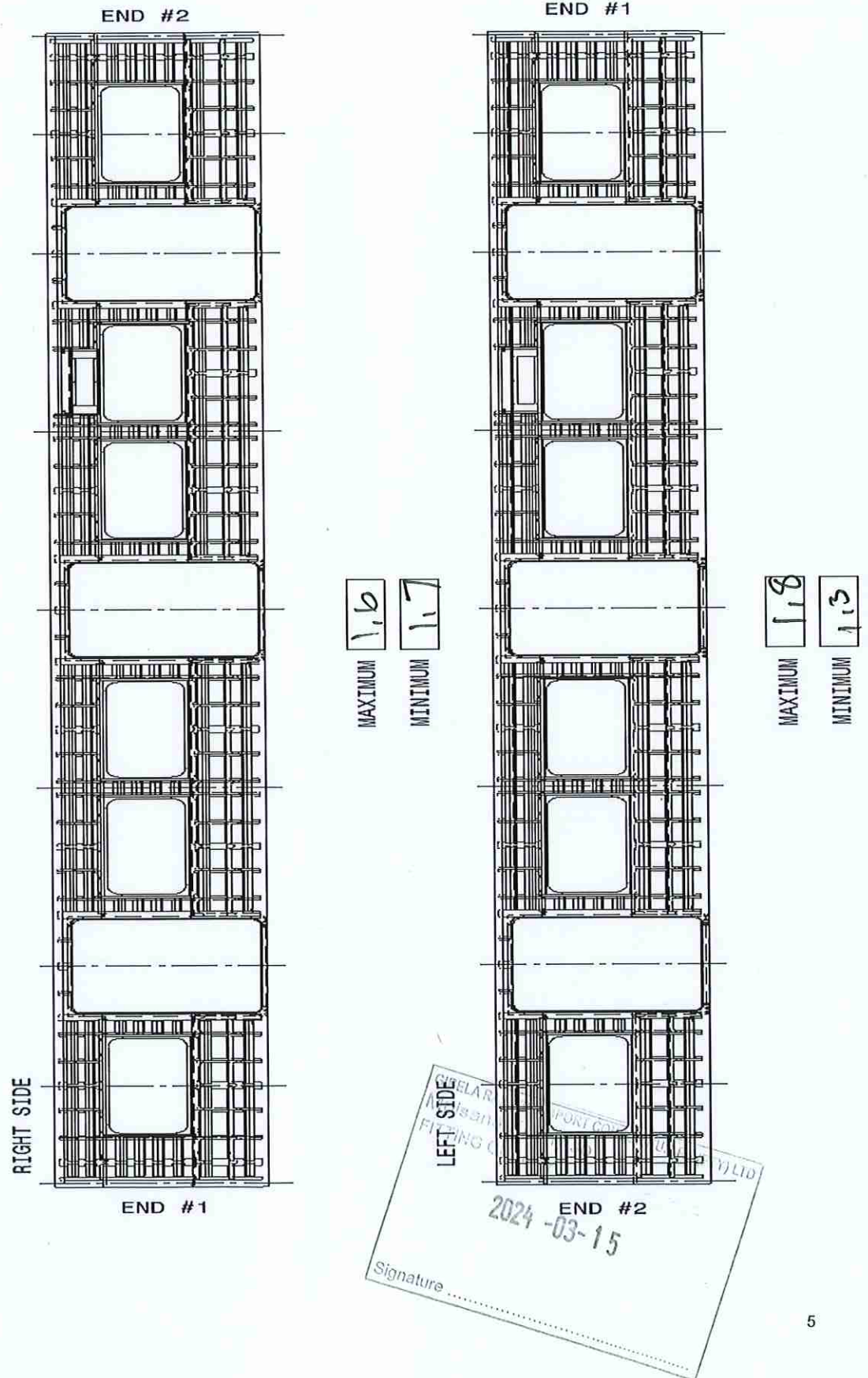
VS

Operator (Name & sign):

GIBELARAIL TRANSPORT CONSORTIUM (PTY) LTD
Mphahlele Khanyiso
FITTING QUALITY
2024-03-15
Signature

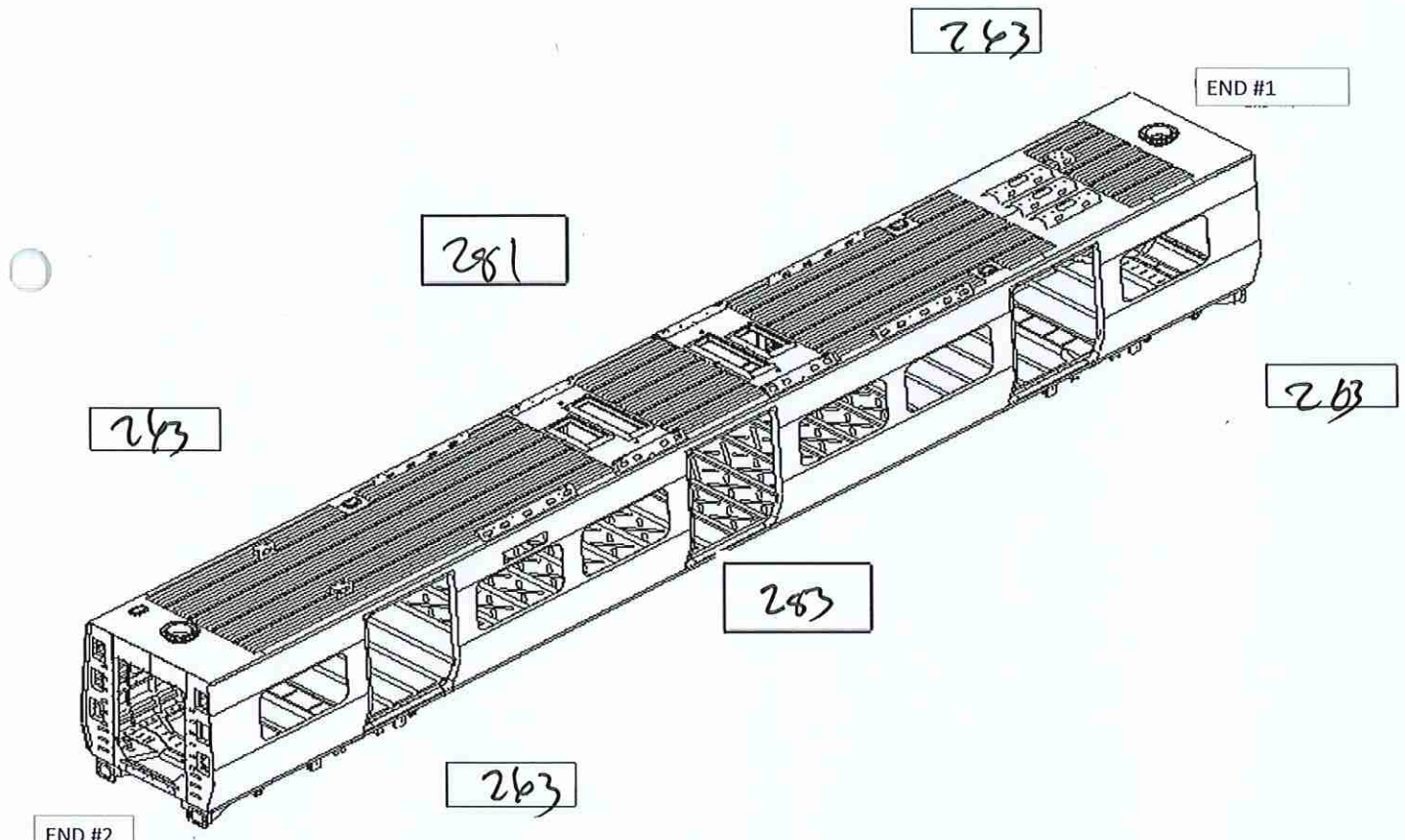
Specifications of Details for CBS measurement CB1230

Flatness side left and right maximum of 2mm in the valley to peak measured in 900mm. Recod the maximum and minimum value found and indicate the corresponding region.



Specifications of Details for CBS measurement CB1230

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



MEASURED CAMBER VALUES

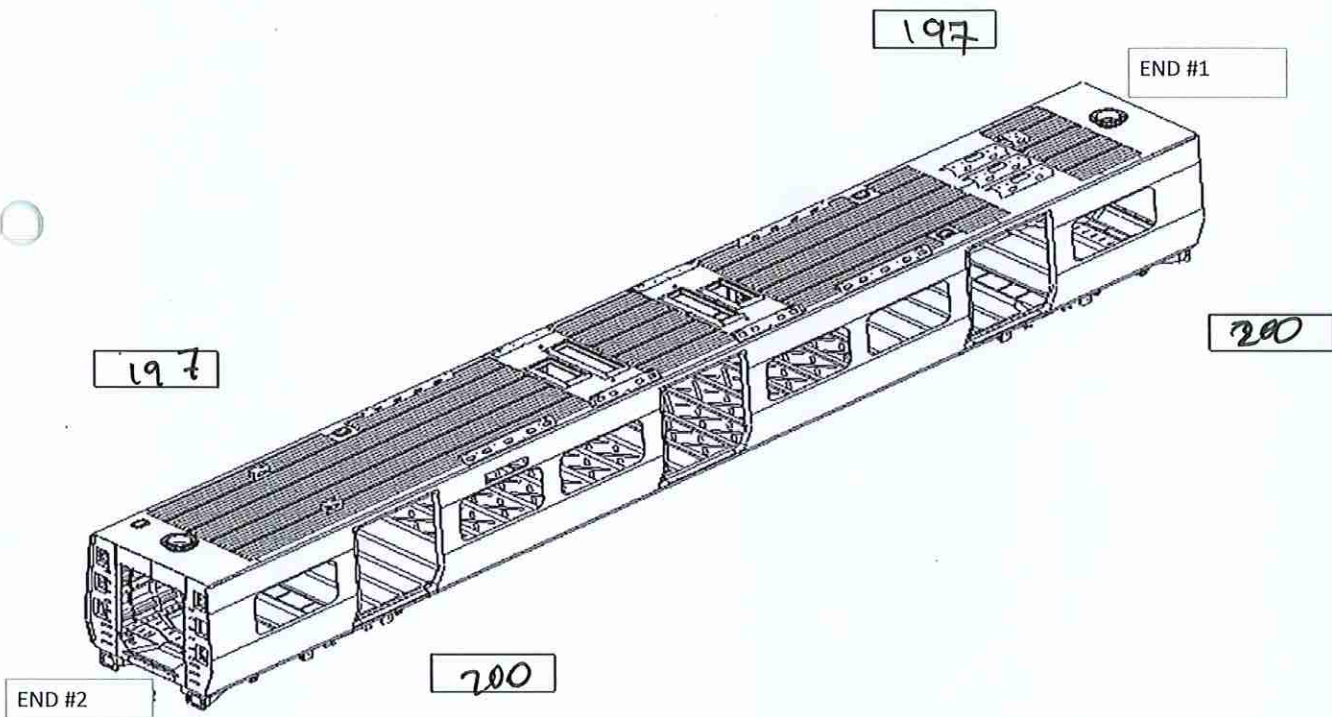
RIGHT ^e 1 20

LEFT ^{a1} 18

GIBELA RAIL TRANSPORT CONSORTIUM RF (PTY) LTD
Mpisana Khanyiso
FITTING QUALITY
2024-03-15
Signature

Specifications of Details for CBS measurement CB1230

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



TWIST FOUND ON END 1

TRANVERS

3

LONGITUDIN

0

TWIST FOUND ON END 2

TRANVERSE

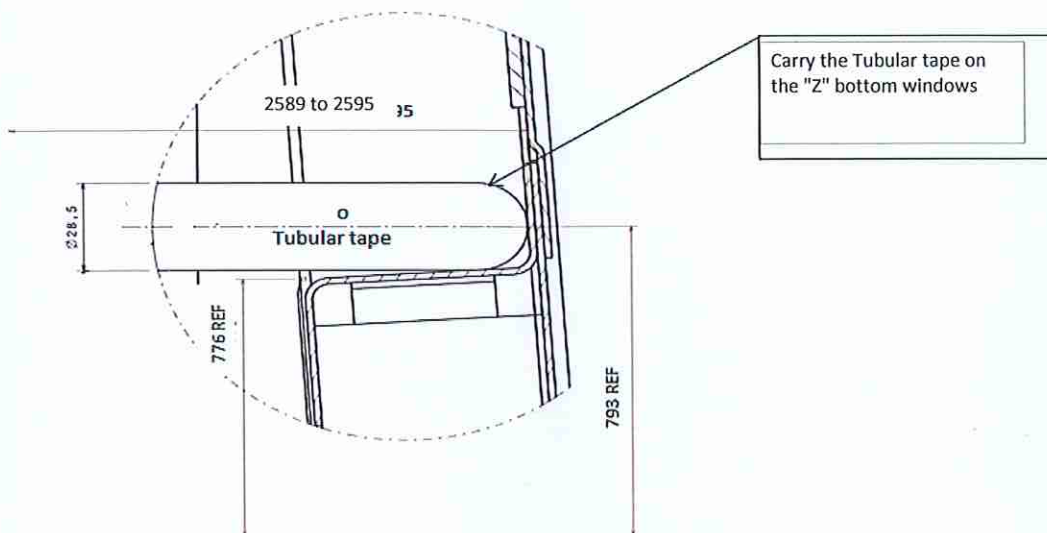
3

LONGITUDINAL

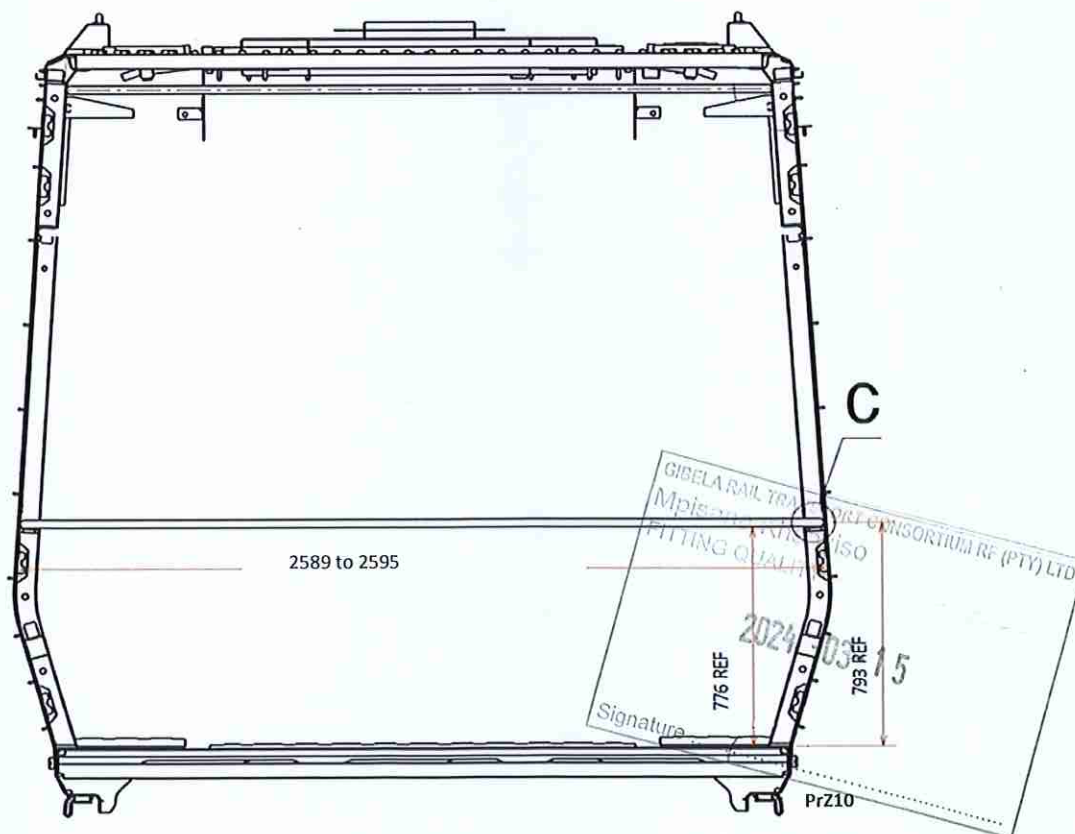
0

GIBELA RAIL TRANSPORT CONSORTIUM RF (PTY) LTD
Mpisana Khanyiso
FITTING QUALITY
2024-03-15
Signature

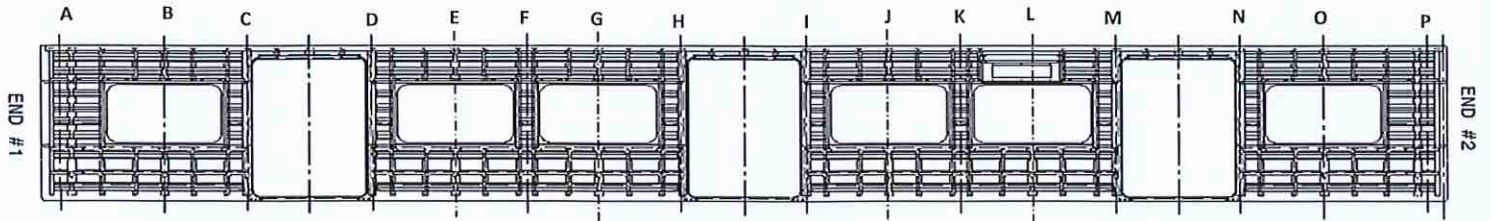
Specifications of Details for CBS measurement CB1230



Detail C



Specifications of Details for CBS measurement CB1230



2589 to 2595mm



A	2591
B	2592
C	2594
D	2591
E	2589
F	2591
G	2592
H	2590
I	2591
J	2591
K	2593
L	2595
M	2595
N	2591
O	2594
P	2590

GIBELA RAIL TRANSPORT CONSORTIUM RF (PTY) LTD
Mpisana Khanyiso
FITTING QUALITY
2024-03-15
Signature

Threshold verification

Nominal value :38

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

BOILER MAKER: Kgoliso

Welder: Zanele



CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
29

Date

06/11/2023

Project: PRASA

SI.CB1230.256.V28

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!)	06/03/24	IShenolo Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	06/03/24	Mokwe Industrial Quality	
		NO GO	There are activities pending that impact/stop 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	Responsible	Due date	Status

Operations

Quality

