




APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1


SELF INSPECTION SHEET

CONFIDENTIAL INFORMATION

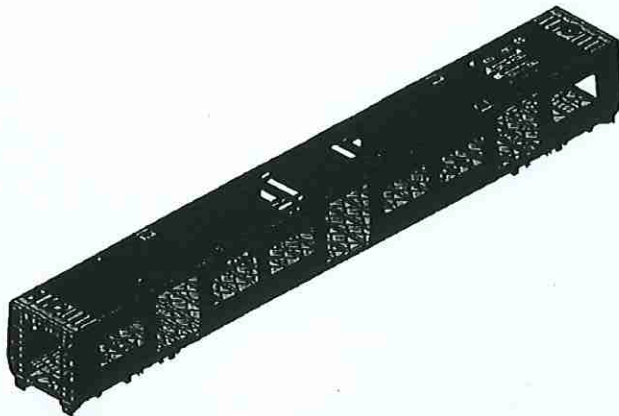
This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE							WORK INSTRUCTION	SAFETY ? 
				TC1	M4	M1	M2	M3	TC2			
<input checked="" type="checkbox"/>	DTR31374497/3	AAD0001413329	CARBODYSHELL M2 ASSEMBLY	CB1210				<input checked="" type="checkbox"/>			PRA.CB1210.DTR313744 97/3.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	12/12/2018	
									CHECKER	Nosizo Pindela	12/12/2018	
									REVISED BY	Ramokone Motama	12/12/2018	
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	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	Zwane Ntokozo	27/07/2023	
									REVISED BY	Mohlampe Amogelang	27/07/2023	
28	07/11/2023	Addition of welder 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		
216	m2	1.2.2023 140953			06/03/24		SI.CB1210.247.V28			17		

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB1210.247.V28
		Date 07/11/2023	

Car: M2	NCR:	Work station: CB1210
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I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
DTR31374497/3			X				28		✓	N/A	<i>[Signature]</i> 06/10/24

I.2 - Instruments Control

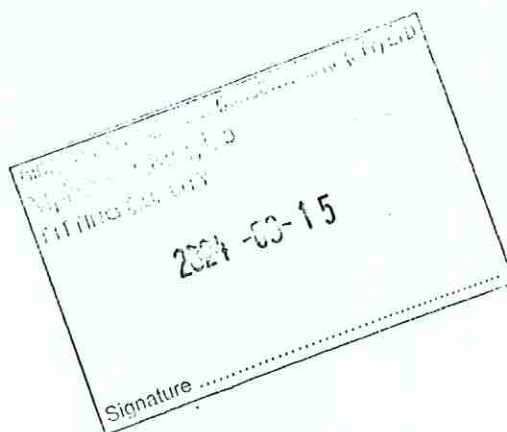
Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
1. tubular	22713	04/10/23	✓	<i>[Signature]</i>	<i>[Signature]</i> 06/10/24
2. Laser tape	125425924	08/01/24	✓	<i>[Signature]</i>	<i>[Signature]</i>
3. 30m tape	GIBTP0084	33/03/31	✓	<i>[Signature]</i>	<i>[Signature]</i>

1.3 - Consumables

Welding Consumable Control - Used for Special Process




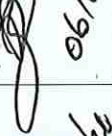
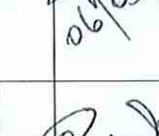
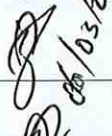
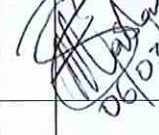
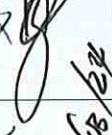



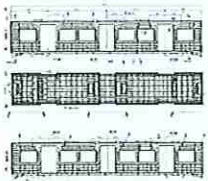




Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Hermisq 309	318394-747	Mig	✓	<i>[Signature]</i>	<i>[Signature]</i> 06/10/24
Hermisq 308L	299687-7232	Mig	✓	<i>[Signature]</i>	<i>[Signature]</i>



	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB1210.247.V28
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II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOX	Remark	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls,Endframes,Roof and Underframe)	AA00001375051	/			 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	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	/			 06/03/24	 06/03/24
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	/			 06/03/24	 06/03/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	/			 06/03/24	 06/03/24
06		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	/			 06/03/24	 06/03/24
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.	/			 06/03/24	 06/03/24



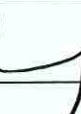

Signature: _____
Date: 2024-03-15
Quality: _____
GIBELQ

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB1210.247.V28
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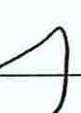
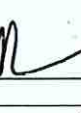
Welder traceability

Roof ring welds



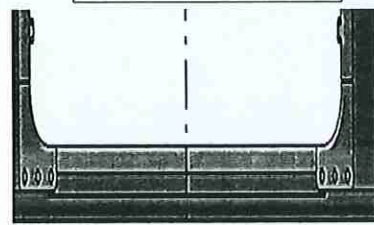
<p style="text-align: center;"><u>LHS</u></p> Boiler maker (Name & Sign): <u>JUSTICE</u> 	<p style="text-align: center;"><u>RHS</u></p> Boiler maker (Name & Sign): <u>JUSTICE</u> 
Welder (Name & Sign): <u>Capt</u> 	Welder (Name & Sign): <u>Capt</u> 


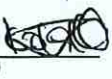
END 1


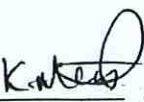
<p style="text-align: center;"><u>LHS</u></p> Boiler maker (Name & Sign): <u>SEAN</u> 	<p style="text-align: center;"><u>RHS</u></p> Boiler maker (Name & Sign): <u>SEAN</u> 
Welder (Name & Sign): <u>Capt</u> 	Welder (Name & Sign): <u>Capt</u> 

END 2

Door ring welds



<p style="text-align: center;"><u>LHS</u></p> Boiler maker (Name & Sign): <u>Tim</u> 
Welder (Name & Sign): <u>Therberg</u> 

<p style="text-align: center;"><u>RHS</u></p> Boiler maker (Name & Sign): <u>Tim</u> 
Welder (Name & Sign): <u>Kerru</u> 

2021-03-15
Signature



CARBODYSHELL M2 ASSEMBLY DTR31374497/3

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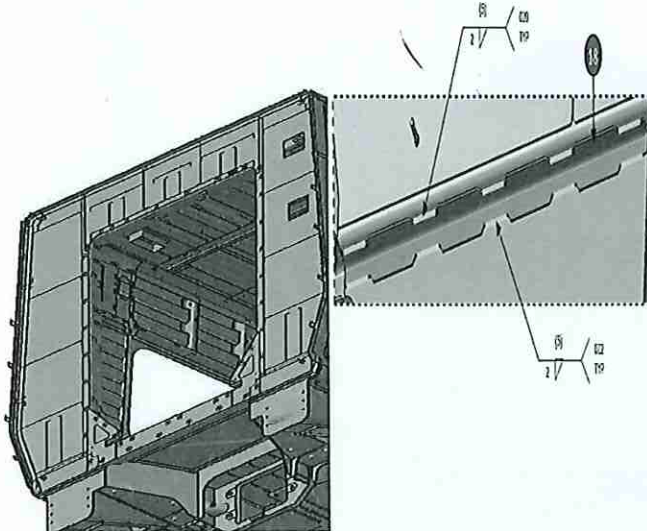
Project: PRASA

SI.CB1210.247.V28

Date

07/11/2023

EUFR Reinforcement Plates

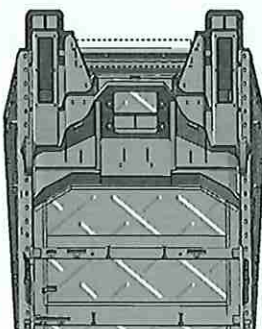


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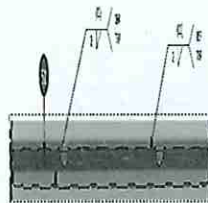
Boiler maker (Name & Sign): LAWRENCE Illiya

Welder (Name & Sign): Keru Kintan

END 2



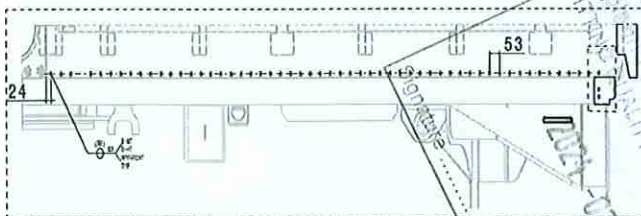
Underneath the CAR



END 2

Boiler maker (Name & Sign): Thabang Kintan

Welder (Name & Sign): Thabang Kintan



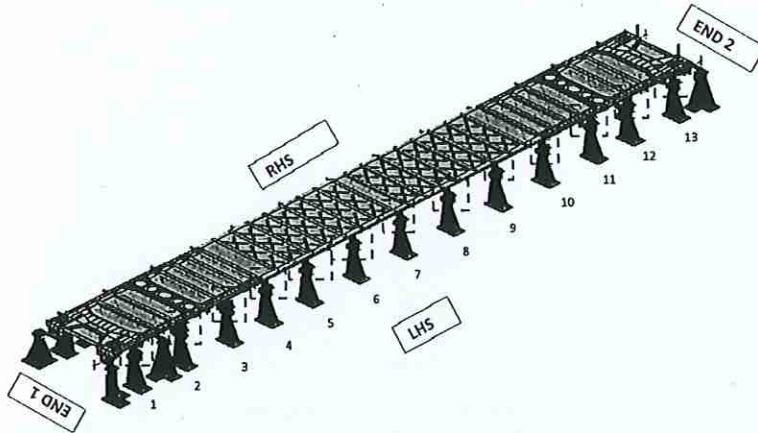
FEDOLI

OPERATOR:

LAWRENCE Illiya

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Specifications of Details for CBS measurement



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

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	2	0	1	2	0	0	0	0	0	0
Right Hand Side	0	0	0	1	0	2	0	0	0	0	0	0	0

Signature Operations:

Date:

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	1	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	0	0	1	0	0	0	0	0	0	0

Signature Industrial Quality:

Date:





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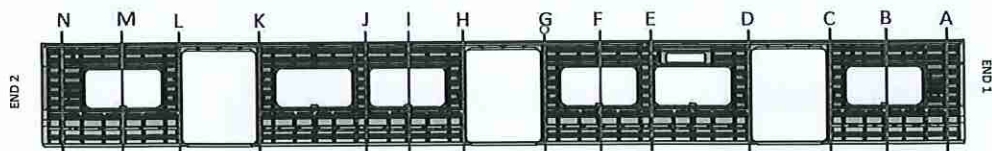
Date

07/11/2023

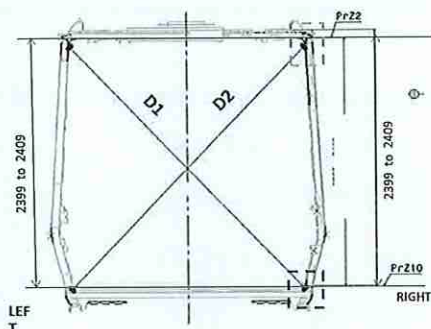
Project: PRASA

SI.CB1210.247.V28

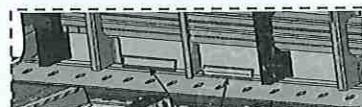
Specifications of Details for CBS measurement



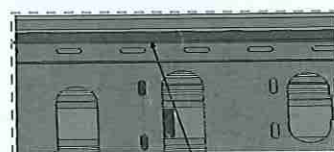
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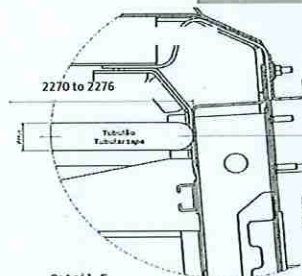
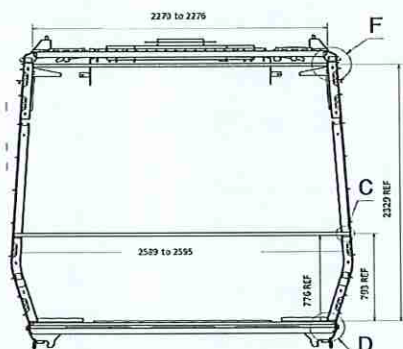
Measurement positions on roof rail and sidewall omega corner.



Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.



Detail F

Don't considering the reinforcement

Signature
2024-03-15
Fitting Quality
2024-03-15



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Date

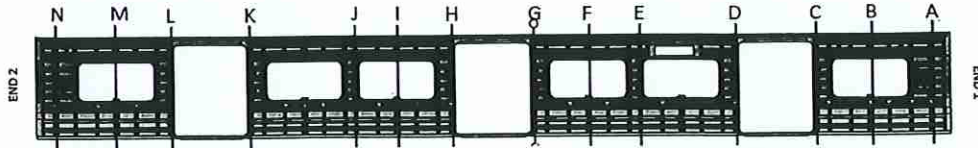
07/11/2023

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SI.CB1210.247.V28

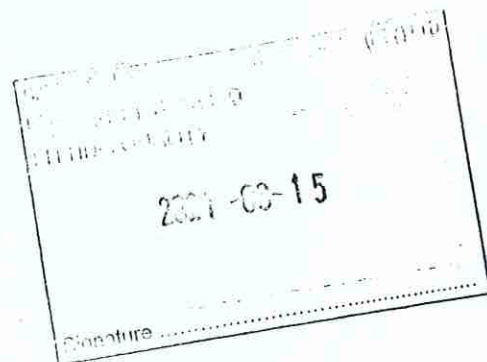
Specifications of Details for CBS measurement

BEFORE WELDING



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

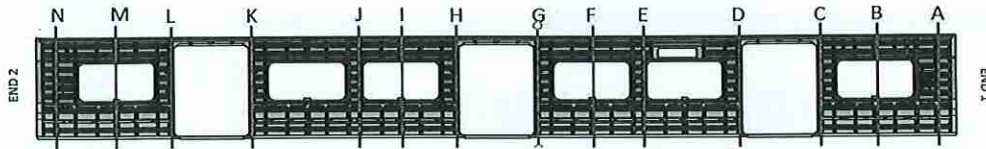
	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3267	3269	2	2403	2405	2
B	3265	3267	2	2404	2404	0
C	3266	3265	1	2406	2405	1
D	3265	3265	0	2406	2406	0
E	3268	3266	2	2405	2404	1
F	3265	3266	1	2403	2403	0
G	3267	3266	1	2404	2406	2
H	3267	3267	0	2406	2408	1
I	3267	3265	2	2407	2406	1
J	3268	3267	1	2406	2405	1
K	3266	3267	1	2405	2407	2
L	3265	3264	1	2404	2405	1
M	3268	3265	3	2406	2402	1
N	3267	3268	1	2407	2408	1



	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB1210.247.V28
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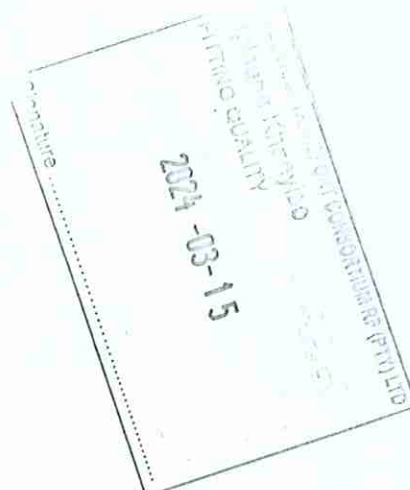
Specifications of Details for CBS measurement

AFTER WELDING



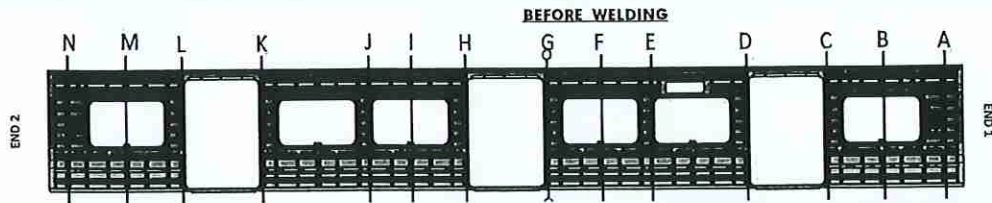
Note: The difference in Height values measured on the LHS and RHS should be $\leq 2\text{MM}$ on each point.

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3295	3297	2	2403	2404	1
B	3265	3266	1	2405	2406	1
C	3296	3297	1	2404	2405	1
D	3298	3296	2	2403	2404	1
E	3265	3266	1	2404	2404	0
F	3264	3266	2	2406	2405	1
G	3294	3294	0	2404	2403	1
H	3296	3297	1	2405	2405	0
I	3266	3266	0	2404	2406	2
J	3267	3268	1	2404	2405	1
K	3298	3297	1	2406	2406	0
L	3296	3295	1	2404	2405	1
M	3265	3267	2	2406	2403	3
N	3299	3298	1	2405	2406	1



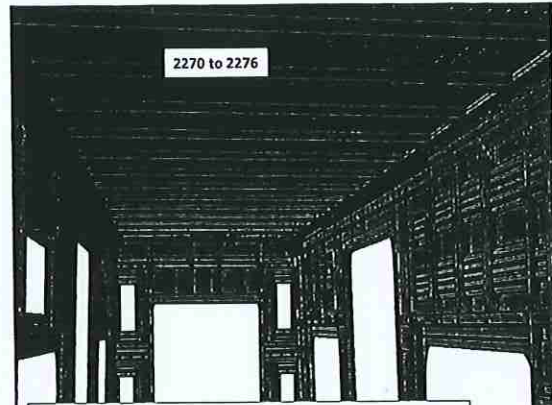
	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB1210.247.V28
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CBS measurement

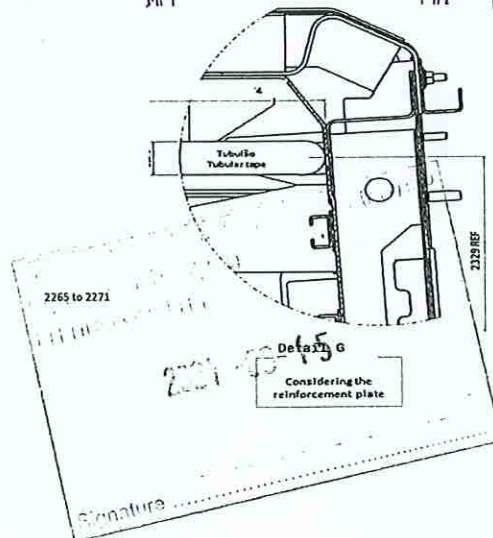
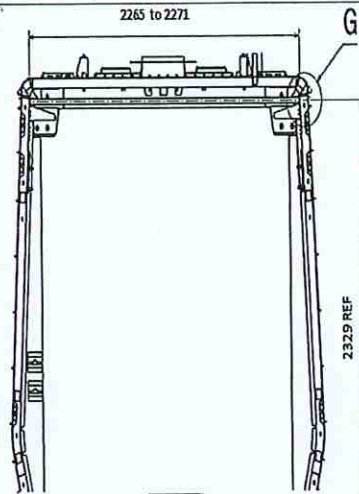



2270 to 2276

A	2271
B	2274
C	2276
D	2272
E	2275
F	2276
G	2270
H	2273
I	2274
J	2275
K	2271
L	2273
M	2276
N	2270

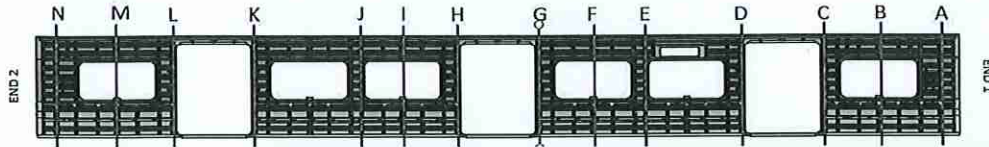


Do not consider reinforcement (Take measurements top area of zee profile



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		Date 07/11/2023	
		CBS measurement	

AFTER WELDING



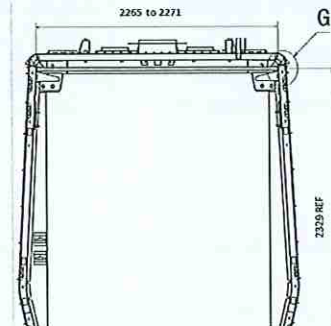
	2265 to 2271	2270 to 2276
A	2267	N/A
B	N/A	2276
C	2269	N/A
D	2268	N/A
E	N/A	2275
F	N/A	2273
G	2270	N/A
H	2269	N/A
I	N/A	2274
J	N/A	2276
K	2270	N/A
L	2271	N/A
M	N/A	2274
N	2269	N/A



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



Take measurement close to radius (considering reinforcement)



Detail G
Considering the reinforcement plate

Signature.....
2024-03-15
FITTING QUALITY
PRASA INTERDISO
PRASA INTERDISO CONSULTING (PT) LTD



CARBODYSHELL M2 ASSEMBLY DTR31374497/3

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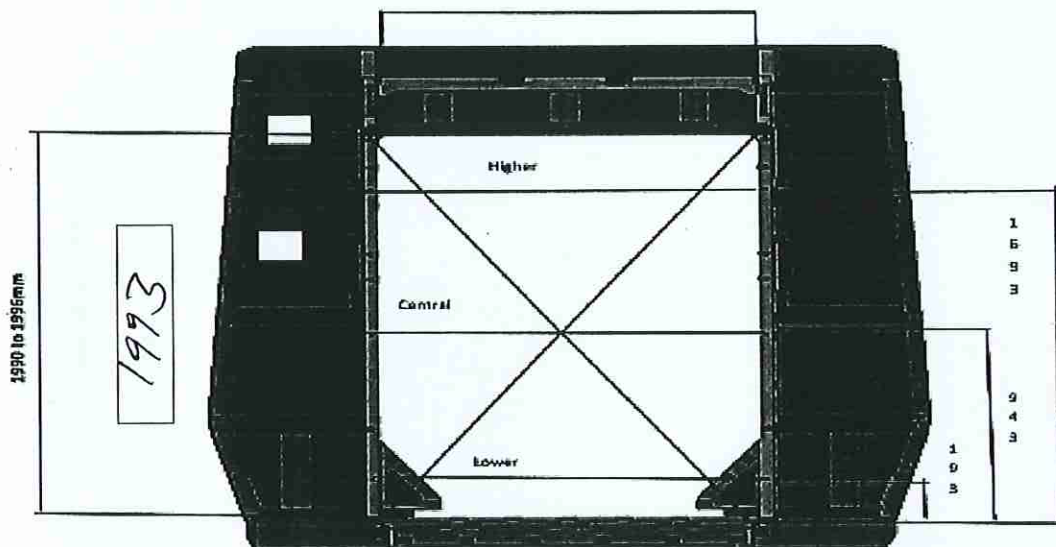
Date

07/11/2023

CBS measurement

End frame 1

1380 to 1382 mm



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1380

D1

2416

Central Dimension

1380

D2

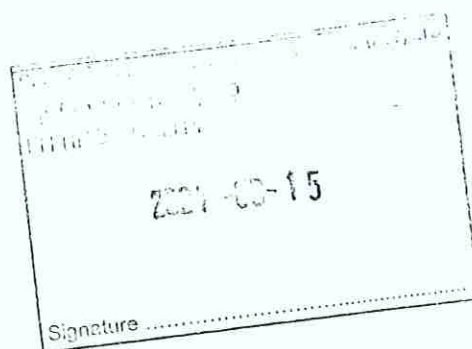
2415

Lower Dimension

1380

D1-D2

1



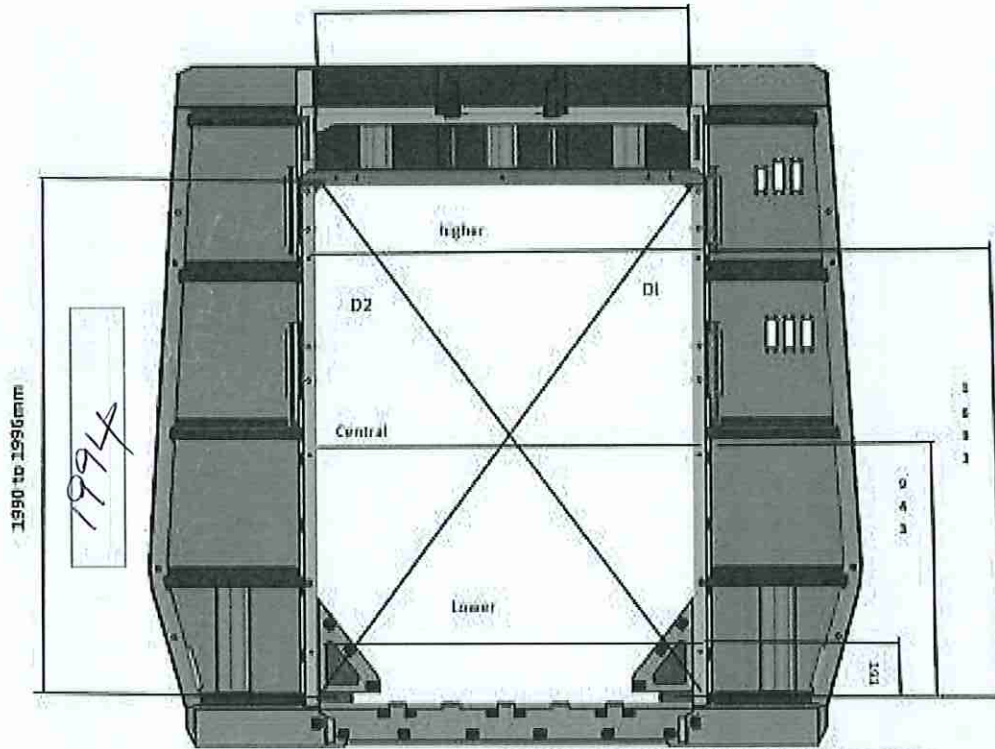


CARBODYSHELL M2 ASSEMBLY DTR31374497/3

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End frame 2



1380 to 1382 mm

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

Higher Dimension

1381

D1

2413

Central Dimension

1381

D2

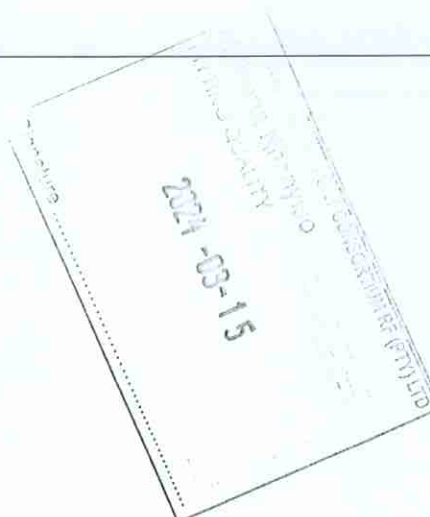
2415

Lower Dimension

1380

D1-D2

2





CARBODYSHELL M2 ASSEMBLY DTR31374497/3

Rev.

28

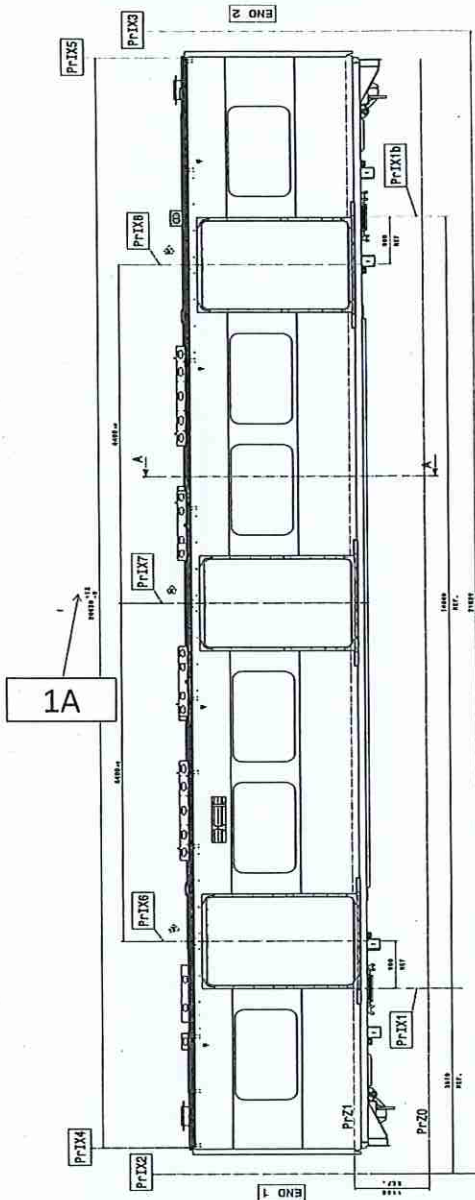
Project: PRASA

SI.CB1210.247.V28

Date

07/11/2023

Specifications of Details for CBS measurement




LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20629

RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20629

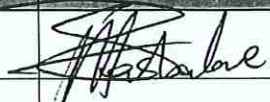

Dye penetrant test

Dye-penetration test to be performed by quality personnel



	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB1210.247.V28
		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		(If activities are not complete, the missing activities must not impact the next stage!)	06/03/24	Jelag Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	06/03/24	Ntokoro Industrial Quality	
		There are activities pendings 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





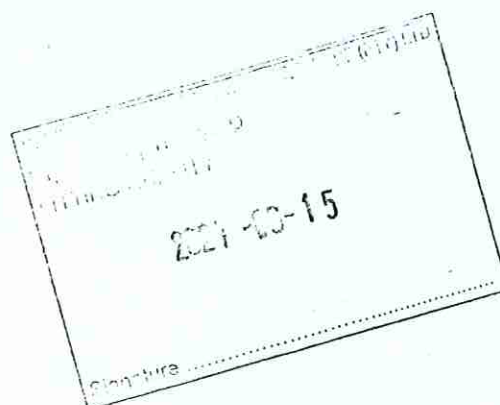

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1








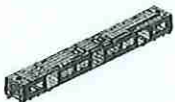


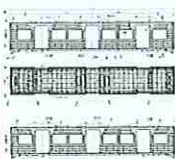









SELF INSPECTION SHEET

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	M1	M2	M3	TC2				
<input type="checkbox"/>	DTR313744/7/2	AAD0001413323	CARBODYSHELL M2 ASSEMBLY	CB1220				X			PRA.CB1220.DTR313744/7/2.V21	YES
<input type="checkbox"/>												
<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 DT0000336500			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 Remove			APPROVER	Itumeleng Modiba		13/03/2019				
					CHECKER	Nosizo Pindela		13/03/2019				
					REVISED BY	Nosizo Pindela		13/03/2019				
7	27/05/2019	Removed measurement positions on the display windows			APPROVER	Itumeleng Modiba		27/05/2019				
					CHECKER	Nosizo Pindela		27/05/2019				
					REVISED BY	Nosizo Pindela		27/05/2019				
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		20/02/2022				
					CHECKER	Andani Muthelo		20/02/2022				
					REVISED BY	Andani Muthelo		20/02/2022				
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	19/10/2022	Addition of traceability for sealant application and welding.			APPROVER	Mbhombi collins		19/10/2022				
					CHECKER	Ntokozo Zwane		19/10/2022				
					REVISED BY	Amogelang Mohlampe		19/10/2022				
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	Tyson Ngobeni		28/10/2023				
					CHECKER	Kelebone Mathapo		28/10/2023				
					REVISED BY	Amogelang Mohlampe		28/10/2023				
TRAINSET	CAR	OPERATOR NAME & ALPS NO		DATE	SELF INSPECTION NUMBER		PAGES					
216	M2	Mashudu / 410041		08/03/24	SI.CB1220.276.V29		15					

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev. 29	Project: PRASA SI.CB1220.276.V29												
		Date 28/10/2023													
Car: M2	NCR:	Work station: CB1220													
Safety Related															
I - Documentation and Instruments Control															
L1 - Documentation Control															
Document	Type (a)	Revision	Observation												
DTR31374497/2	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%; text-align: center;">3D</td> <td style="width: 10%; text-align: center;">M1</td> <td style="width: 10%; text-align: center;">M2</td> <td style="width: 10%; text-align: center;">M3</td> <td style="width: 10%; text-align: center;">M4</td> <td style="width: 10%; text-align: center;">M5</td> </tr> <tr> <td style="text-align: center;">✓</td> <td style="text-align: center;">✓</td> <td style="text-align: center;">✓</td> <td style="text-align: center;">✓</td> <td style="text-align: center;">✓</td> <td style="text-align: center;">✓</td> </tr> </table>	3D	M1	M2	M3	M4	M5	✓	✓	✓	✓	✓	✓	27	✓
3D	M1	M2	M3	M4	M5										
✓	✓	✓	✓	✓	✓										
		N/A	Signature/Date (Manufacturing) 08/03/24												
L2 - Instruments Control															
Monitoring and Measuring Instrument Control - Used for Special Process															
Instruments	Serial number	Calibration or Verification Validation Date	Signature/Date (Manufacturing)												
Tubular Measuring tape	22713	26/06/2024	✓												
	GIBELQ 394	05/04/2024	✓												
		N/A	Signature/Date (Quality) 08/03/24												
3.3 Consumables															
Welding Consumable Control - Used for Special Process															
Filler Material	Heat Number	Welding Process	Signature/Date (Manufacturing)												
308 1.0mm	E231067	MIG	✓												
		N/A	Signature/Date (Quality) 08/03/24												

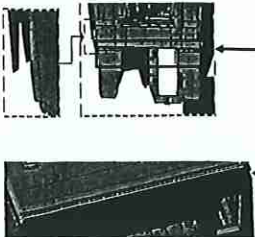


	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev. 29	Project: PRASA SI.CB1220.276.V29											
		Date 28/10/2023												
II - Self Inspection - Items to Check														
II.1 - Items to check														
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Not OK	Reason	Signature/Date (Manufacturing)	Signature/Date (Quality)						
01	N/A	Assembly according to Instruction Engineering n° PRA CB1220. DTR31374497/2 Verification of fitment for all reinforcement brackets.	PRA CB1220. DTR31374497/2	✓			 08/03/24	 08/03/24						
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓			 08/03/24	 08/03/24						
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓			 08/03/24	 08/03/24						
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓			 08/03/24	 08/03/24						
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			 08/03/24	 08/03/24						
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.	✓			 08/03/24	 08/03/24						
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 <table border="1"> <tr> <th colspan="2">Specified</th> </tr> <tr> <td>Temperature Min - Max (°C)</td> <td>Min-Max 10°C - 35°C</td> </tr> <tr> <td>Relative humidity Min - Max (%)</td> <td>Min-Max 25% - 60%</td> </tr> </table>	Specified		Temperature Min - Max (°C)	Min-Max 10°C - 35°C	Relative humidity Min - Max (%)	Min-Max 25% - 60%	Sealant Batch No: <u>LVT-03</u> Exp Date: <u>03/24</u> Actuals Temperature: <u>18</u> Humidity: <u>63</u>	✓			 07/03/24	 08/03/24
Specified														
Temperature Min - Max (°C)	Min-Max 10°C - 35°C													
Relative humidity Min - Max (%)	Min-Max 25% - 60%													
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001413329	✓			 07/03/24	 08/03/24						

Signature
 2024-03-15
 Fitting Quality


	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB1220.276.V29
		29	
		Date	
		28/10/2023	

SEALANT APPLICATION




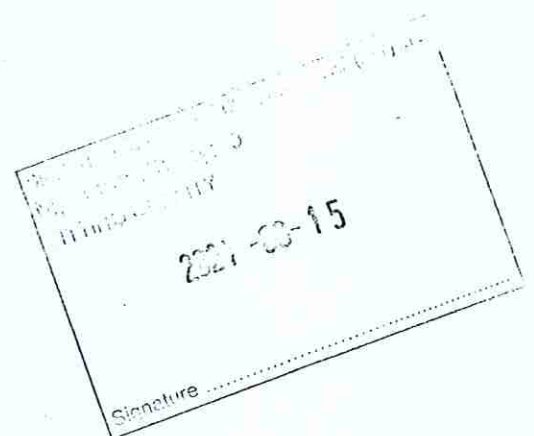
AREA 1 & 2 END 1

Operator (Name & sign):

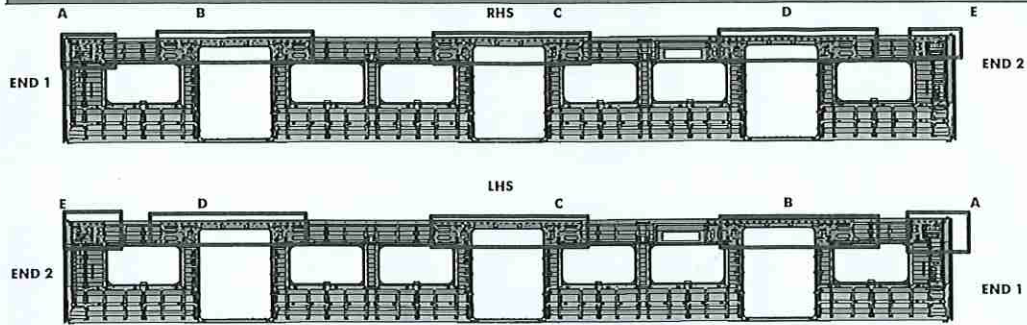
Mthokozisi: 

Operator (Name & sign):

Mthokozisi: 

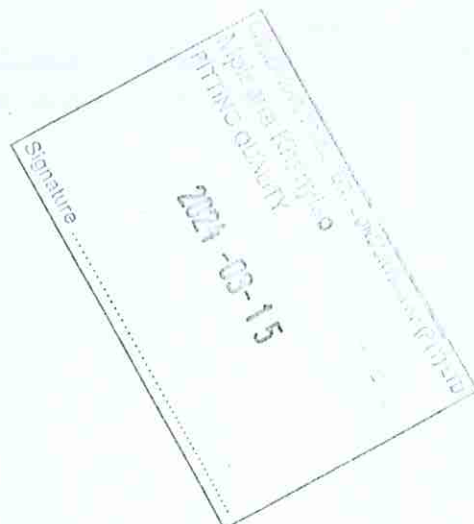


	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA
		29	
		Date	SI.CB1220.276.V29
		28/10/2023	
II - Self Inspection - Items to Check			



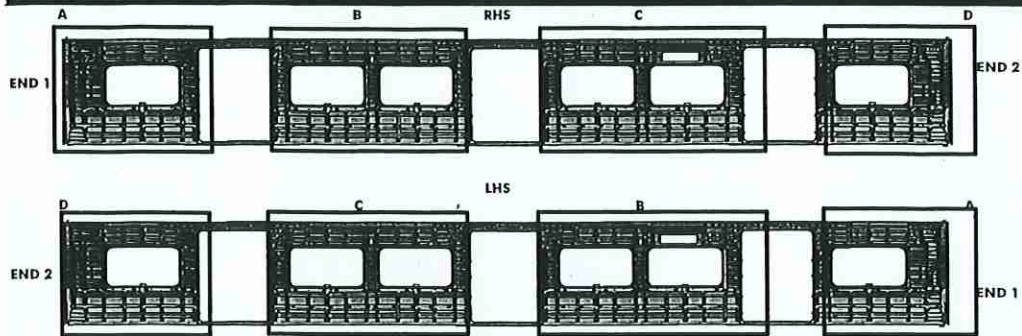
REINFORCEMENT WELDING

AREA	LHS	RHS
A	Operator (Name&sign): <u>NOKULUNGA Dwa</u>	<u>[Signature]</u>
B	Operator (Name&sign): <u>NOKULUNGA Dwa</u>	<u>[Signature]</u>
C	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>
D	Operator (Name&sign): <u>Sibya</u>	<u>THULANI</u>
E	Operator (Name&sign): <u>Sibya</u>	<u>THULANI</u>



	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB1220.276.V29
		29	
		Date	
		28/10/2023	

II - Self Inspection - Items to Check



BRACKETING

INSTALLATION

C-RAILS: Operator: Asanda

Operator: _____

DOOR MECHANISMS: Operator: Hithelozzi

Operator: _____

TAPPING PADS: Operator: Asanda

Operator: Asanda

INSTALLATION & VERIFICATION

SEAT & LUGGAGE BRACKETS: Operator: Mashudu

Operator: _____

SEAT BRACKETS VERIFICATION: Operator: Hithelozzi

Operator: _____

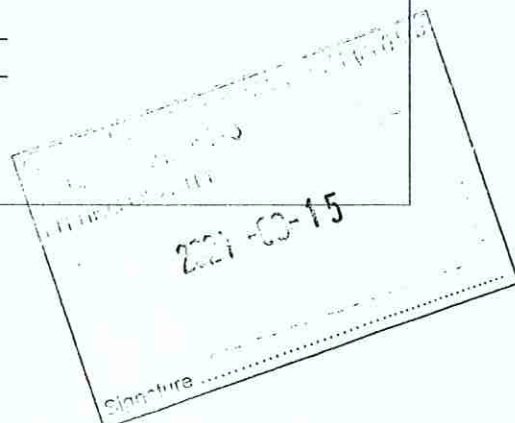
WELDING


AREA	LHS	RHS
A (Seat brackets)	: Operator (Name&sign): <u>Jolly D</u>	<u>Jolly D</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Jolly D</u>	<u>S. MASHUDU</u>
B (Seat brackets)	: Operator (Name&sign): <u>Jolly D</u>	<u>Jolly D</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Jolly D</u>	<u>S. MASHUDU</u>
C (Seat brackets)	: Operator (Name&sign): <u>MMAISHELO MASHUDU</u>	<u>MMAISHELO MASHUDU</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Sibiga</u>	<u>MMAISHELO MASHUDU</u>
D (Seat brackets)	: Operator (Name&sign): <u>MMAISHELO MASHUDU</u>	<u>MMAISHELO MASHUDU</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Sibiga</u>	

ENDS

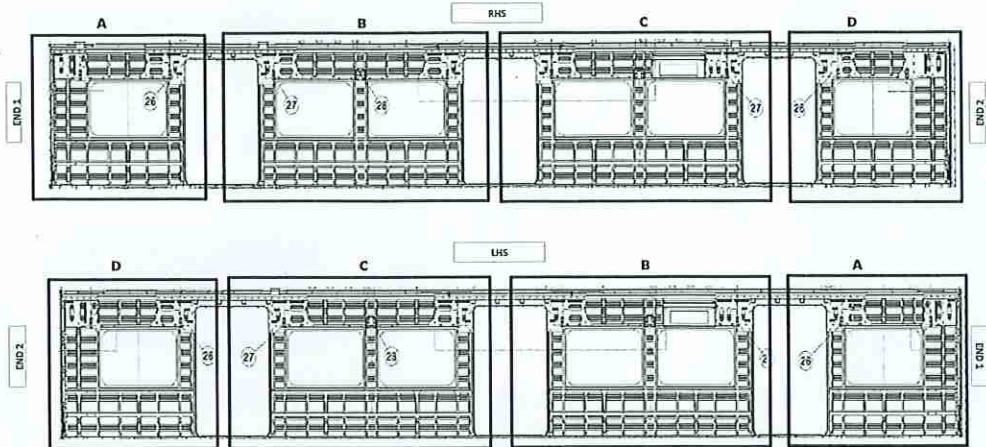
END 1 TAPPING PADS WELDING: Operator (Name&sign): Asanda

END 1 TAPPING PADS WELDING: Operator (Name&sign): Asanda



	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA
		29	
		Date	SI.CB1220.276.V29
		28/10/2023	

M2 BRACKET INSTALLATION



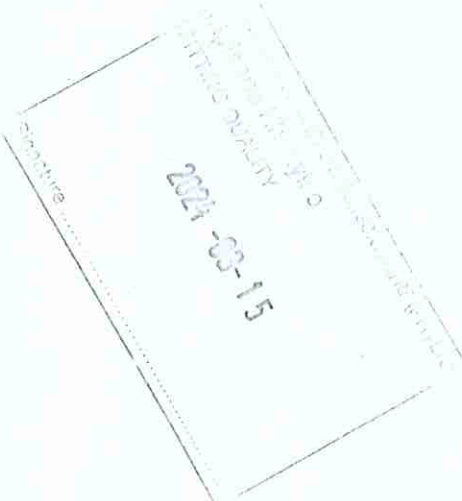
QUANTITIES (M2)

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

ROOF ENDS:
 CRAILS 2 OFF EACH END
 EARTH BUSH 6 OFF EACH END
 VERIFICATION BY: *Mashudh*

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	9	✓	
	B	11	✓	
	C	11	✓	
	D	12	✓	
SEAT BRACKETS	A	12	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	3	✓	
	B	7	✓	
	C	6	✓	
	D	2	✓	

ROOF ENDS:
 CRAILS 2 OFF EACH END
 EARTH BUSH 6 OFF EACH END
 VERIFICATION BY: *Mashudh*

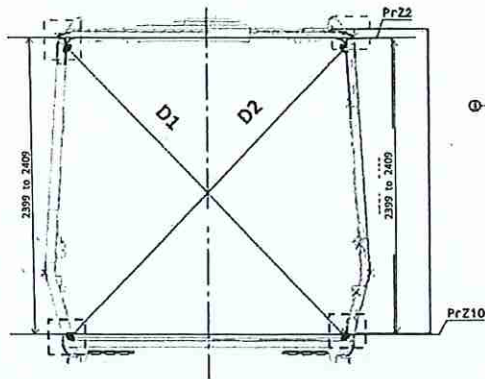




CARBODYSHELL M2 ASSEMBLY DTR31374497/2

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28/10/2023

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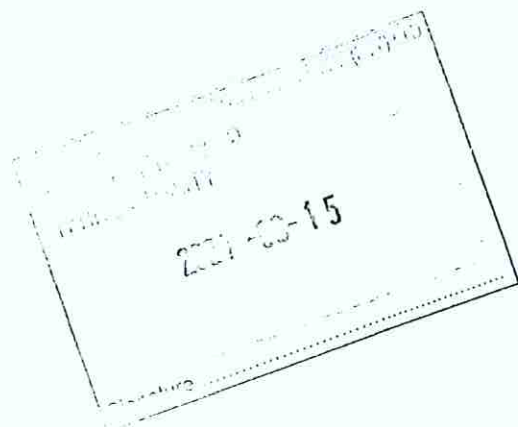
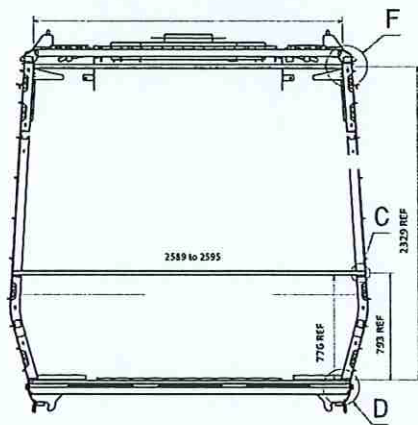
Measurement positions on roof rail and sidewall corner



Reinforcement area measurement position on roof reinforcement area



Measurement positions on sidewall and side sill corner



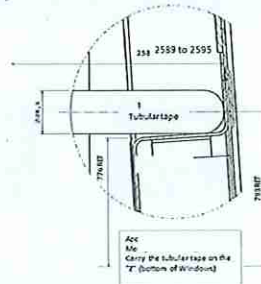
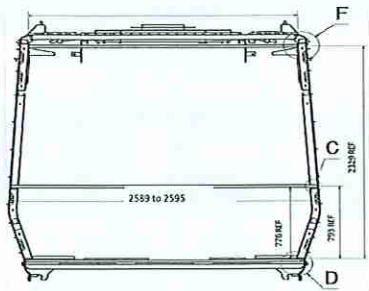


CARBODYSHELL M2 ASSEMBLY DTR31374497/2

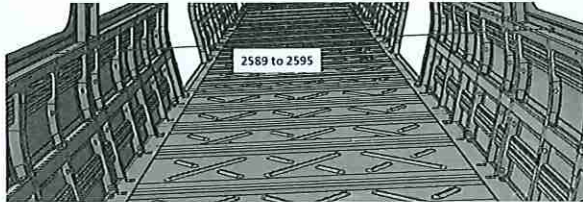
Rev.
29
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28/10/2023

Project: PRASA

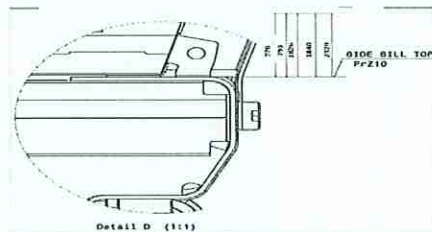
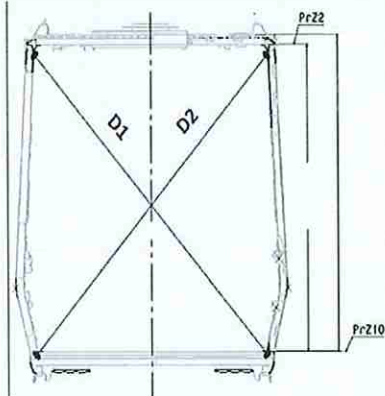
SI.CB1220.276.V29



Detail C




Take measurement close to radius

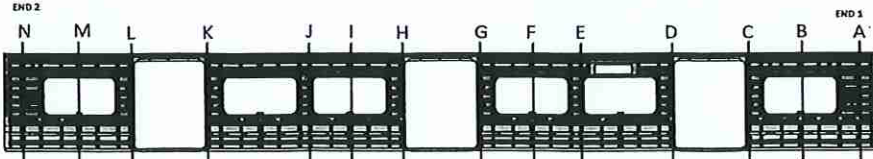


Detail D (1:1)



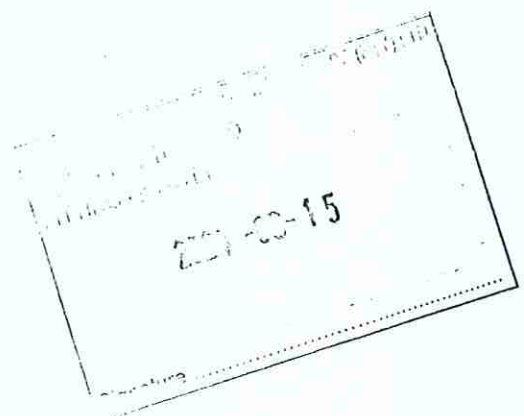
	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB1220.276.V29
		29	
		Date	
		28/10/2023	


CBS measurement



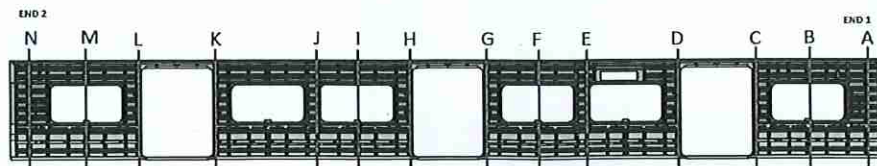
BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3297	3300	3	—
B	3269	3267	2	—
C	3301	3299	2	—
D	3301	3299	2	—
E	3268	3265	3	—
F	3267	3265	2	—
G	3300	3300	0	—
H	3300	3300	0	—
I	3265	3267	2	—
J	3268	3267	1	—
K	3297	3300	3	—
L	3299	3300	1	—
M	3269	3267	2	—
N	3299	3299	0	—



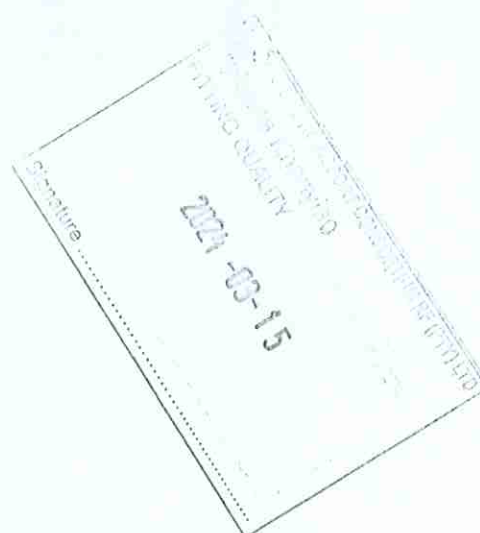
	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB1220.276.V29
		29	
		Date	
		28/10/2023	

CBS (measurement)

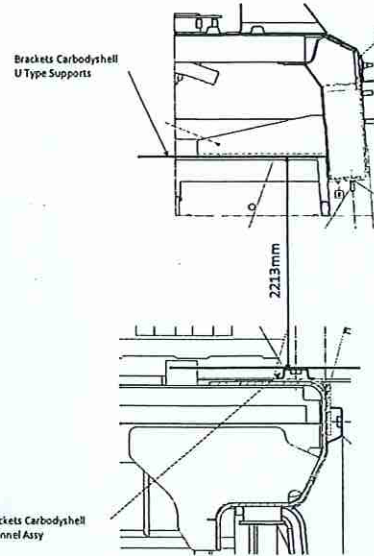
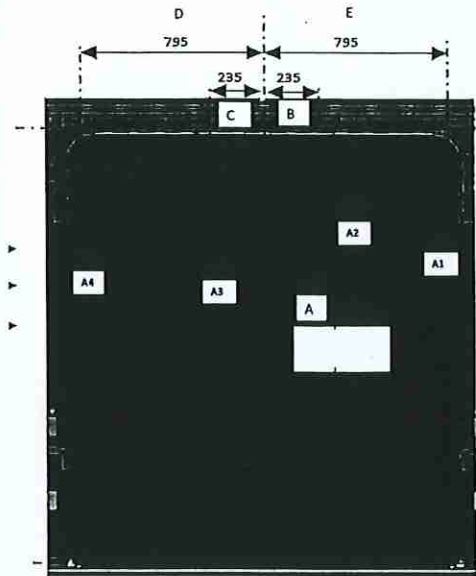


AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3299	3298	1	2595
B	3268	3267	1	2590
C	3298	3299	1	2591
D	3298	3300	2	2593
E	3267	3269	2	2590
F	3266	3267	1	2593
G	3298	3299	1	2594
H	3299	3299	0	2591
I	3266	3268	2	2591
J	3266	3268	2	2594
K	3298	3298	0	2593
L	3299	3298	1	2592
M	3268	3270	2	2593
N	3299	3299	0	2593

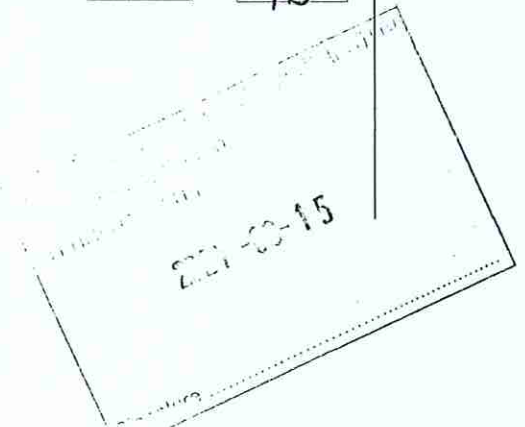


Specifications of Details for CBS measurement CB1220



DOOR 1 - LHS			DOOR 2 - LHS			DOOR 3 - LHS		
	VALUE	ACTUAL		VALUE	ACTUAL		VALUE	ACTUAL
A1	2230 to 2232	2232	A1	2230 to 2232	2233	A1	2230 to 2232	2232
A2	2230 to 2232	2232	A2	2230 to 2232	2232	A2	2230 to 2232	2232
A3	2230 to 2232	2231	A3	2230 to 2232	2232	A3	2230 to 2232	2232
A4	2230 to 2232	2232	A4	2230 to 2232	2233	A4	2230 to 2232	2232
B	234 to 236	235	B	234 to 236	236	B	234 to 236	235
C	234 to 236	235	C	234 to 236	235	C	234 to 236	235
D	794 to 796	795	D	794 to 796	796	D	794 to 796	795
E	794 to 796	795	E	794 to 796	795	E	794 to 796	795

DOOR 1 - RHS			DOOR 2 - RHS			DOOR 3 - RHS		
	VALUE	ACTUAL		VALUE	ACTUAL		VALUE	ACTUAL
A1	2230 to 2232	2232	A1	2230 to 2232	2233	A1	2230 to 2232	2234
A2	2230 to 2232	2232	A2	2230 to 2232	2232	A2	2230 to 2232	2232
A3	2230 to 2232	2231	A3	2230 to 2232	2232	A3	2230 to 2232	2232
A4	2230 to 2232	2232	A4	2230 to 2232	2233	A4	2230 to 2232	2233
B	234 to 236	236	B	234 to 236	235	B	234 to 236	235
C	234 to 236	235	C	234 to 236	234	C	234 to 236	235
D	794 to 796	795	D	794 to 796	795	D	794 to 796	795
E	794 to 796	795	E	794 to 796	794	E	794 to 796	795





CARBODYSHELL M2 ASSEMBLY DTR31374497/2

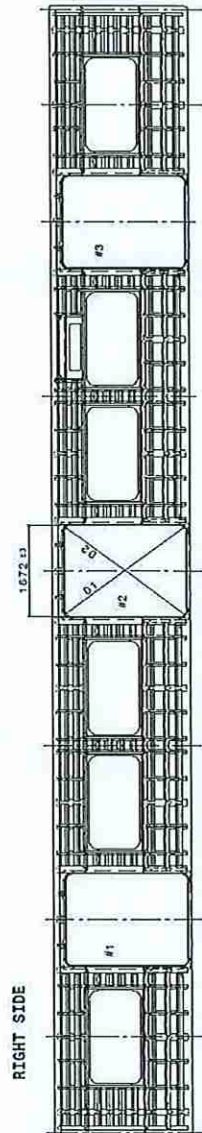
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Specifications of Details for CBS measurement CB1220

End #2



End #1

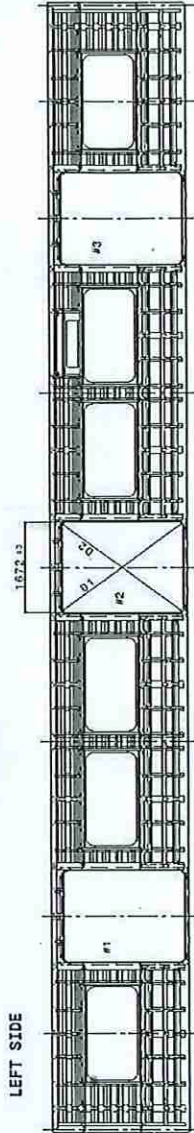
Doors diagonal D1-D2 maximum difference $\leq 4\text{mm}$

#1	#2	#3
D1	2748	2750
D2	2747	2749
D1-D2	2	1

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

Doors length - 1672 $\pm 3\text{mm}$

End #1

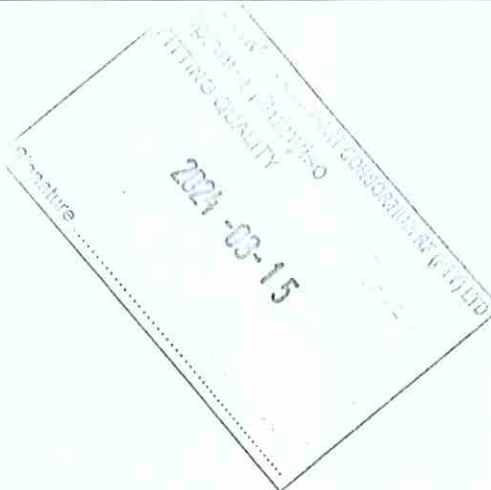



End #2


4mm

#1	#2	#3
D1	2749	2748
D2	2750	2747
D1-D2	1	2

#1	#2	#3
DIMENSAO SUPERIOR	1673	1671
HIGHER DIMENSION	1673	1671
CENTRAL DIMENSION	1672	1672
LOWER DIMENSION	1672	1670

Vão de Portas - 1672 $\pm 3\text{mm}$ 

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA		
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CBS measurement (Manufacturing)					
Dye penetrant test					
Dye-penetration test to be performed by quality personnel					
					

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

IL2 - Check List REX

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

2023-10-15
 2023-10-15
 2023-10-15

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB1 220.276.V29
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		Date	
		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)	08/03/24	Masadih	Masadih
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party)	08/03/24	Richmond	Masadih
		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)			

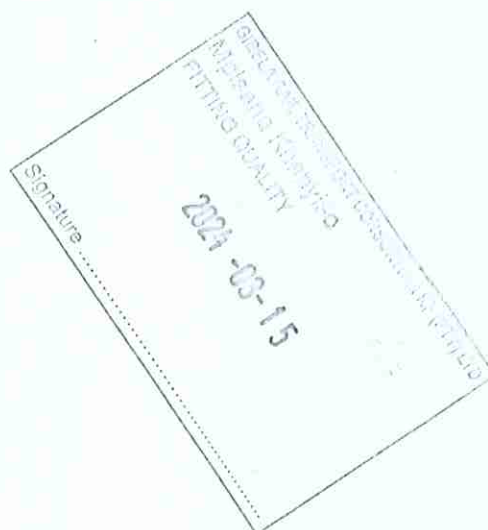
In case of "NO GO", describe blocking problems

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

Item	Description	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"/>	AA00001374497	AAD0001413329	CARBODYSHELL M2 ASSEMBLY	CB1230				X			PRA.CB1230.AA00001374497.V20	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE							
0	2018/08/02	GIBELA NEW CREATION	APPROVER	Philippe 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	Vanessa Ntuli	13/03/2019							
10	23/03/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	23/03/2019							
			CHECKER	Nosizo Pindela	23/03/2019							
			REVISED BY	Nosizo Pindela	23/03/2019							
	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							
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbombhni	20/02/2022							
			CHECKER	Andani Muthelo	20/02/2022							
			REVISED BY	Andani Muthelo	20/02/2022							
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbombhni	14/06/2022							
			CHECKER	Andani Muthelo	14/06/2022							
			REVISED BY	Andani Muthelo	14/06/2022							
27	26/07/2022	Threshold measurement addition	APPROVER	Collins Mbombhni	27/07/2022							
			CHECKER	Andani Muthelo	27/07/2022							
			REVISED BY	Andani Muthelo	27/07/2022							
28	17/10/2022	Addition of traceability for sealant application	APPROVER	Collins Mbombhni	17/10/2022							
			CHECKER	Ntokozo Zwane	17/10/2022							
			REVISED BY	Amogelang Mohlampe	17/10/2022							
29	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							
30	06/11/2023	Added traceability on thresholds for boiler makers and welders	APPROVER	Ngobeni Tyson	06/11/2023							
			CHECKER	Andani Muthelo	06/11/2023							
			REVISED BY	Ntokozo Zwane	06/11/2023							
TRAINSET	CAR	OPERATOR NAME&ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES							
216	MOQ	3inle 426955	08/03/24	SI.CB1230.277.V29	11							

Signature
 2024-03-15
 PRASA RAILPORT CONSORTIUM LTD
 RAILPORT QUALITY



CARBODYSHELL M2 ASSEMBLY AA00001374497

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Car:

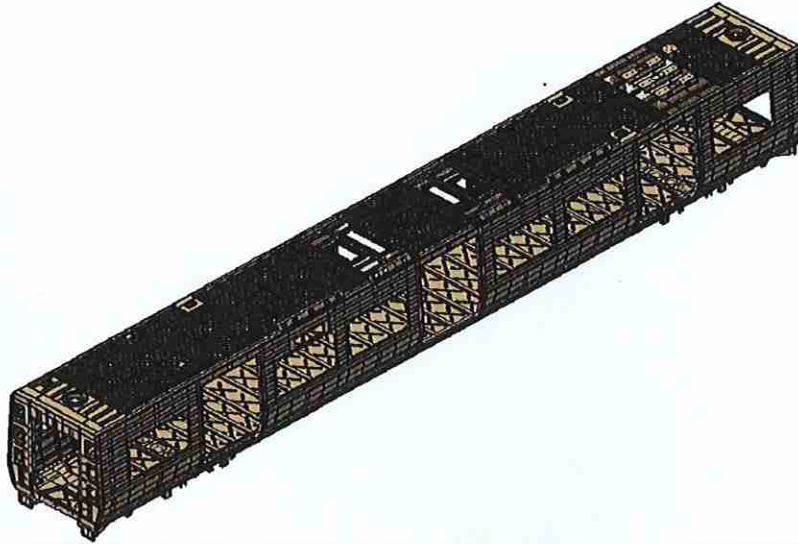
NCR:

Work station:

CB1230



Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	NOK	Rework	Signature/Date (Operations)	Signature/Date (Quality)
	TC1	M1	M2	M3	M4	TC2							
PRA.CB1230.AA00001374497			✓				30		OK		N/A	8 08/03/24	8 08/03/24

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	29/11/24	OK		8 08/03/24	8 08/03/24
Measuring tape	GIBTA 0394	2024/04/05	OK		8 08/03/24	8 08/03/24
Combination Square	GIBCS 0137	26/07/24	OK		8 08/03/24	8 08/03/24

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 L1	1210180	MIG welding	OK		8 08/03/24	8 08/03/24



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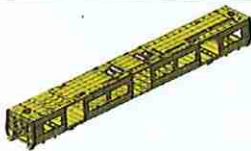
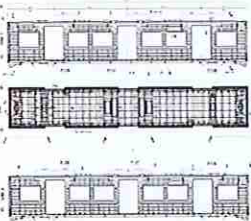
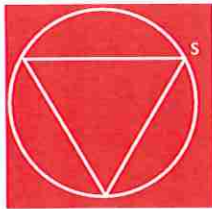
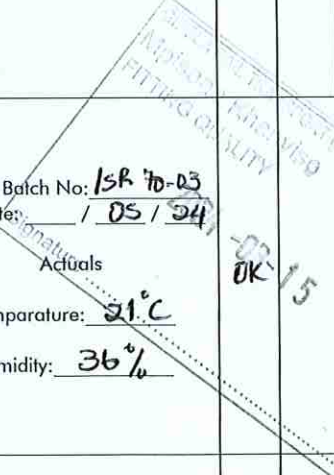
06/11/2023

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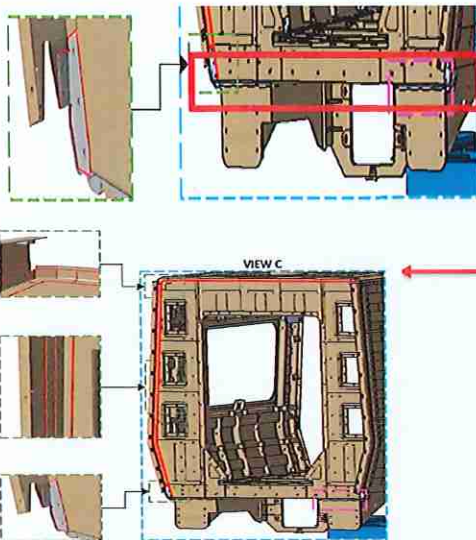
SI.CB1230.277.V29

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.AA00001374497 Verification of fitment for all brackets.	PRA.CB1230.AA00001374497	OK			08/03/24	08/03/24						
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	OK			08/03/24	08/03/24						
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	OK			Emmanuel 08/03/24	08/03/24						
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	OK			Emmanuel 08/03/24	08/03/24						
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			08/03/24	08/03/24						
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			Emmanuel 08/03/24	08/03/24						
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><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%	Sealant Batch No: 1SR 70-03 Exp Date: 05 / 24 Actuals Temperature: 21°C Humidity: 36% 	OK			08/03/24	08/03/24
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			08/03/24	08/03/24						

AREA 1



END 2 SEALANT

OPERATOR
(Name & sign):

Zanele

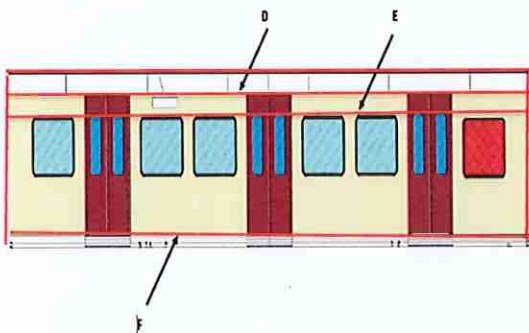
OPERATOR
(Name & sign):

Zanele

OPERATOR
(Name & sign):

Zanele

H



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

Operator (Name & sign):

LHS
F, (H, I) top

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

Operator (Name & sign):

Sinle

Sinle

Operator (Name & sign):

Ishendo

Operator (Name & sign):

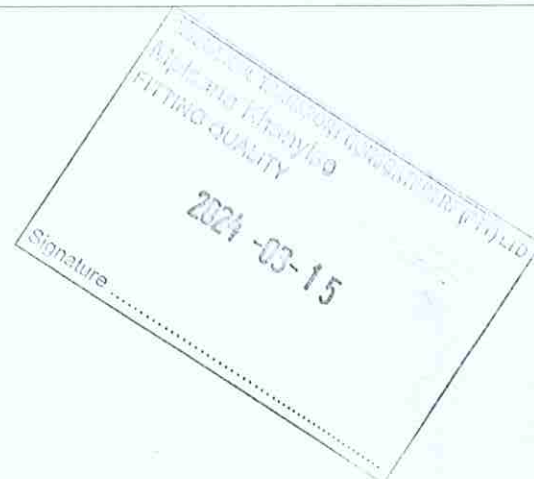
D, E (H, I) top

Ishendo

Operator (Name & sign):

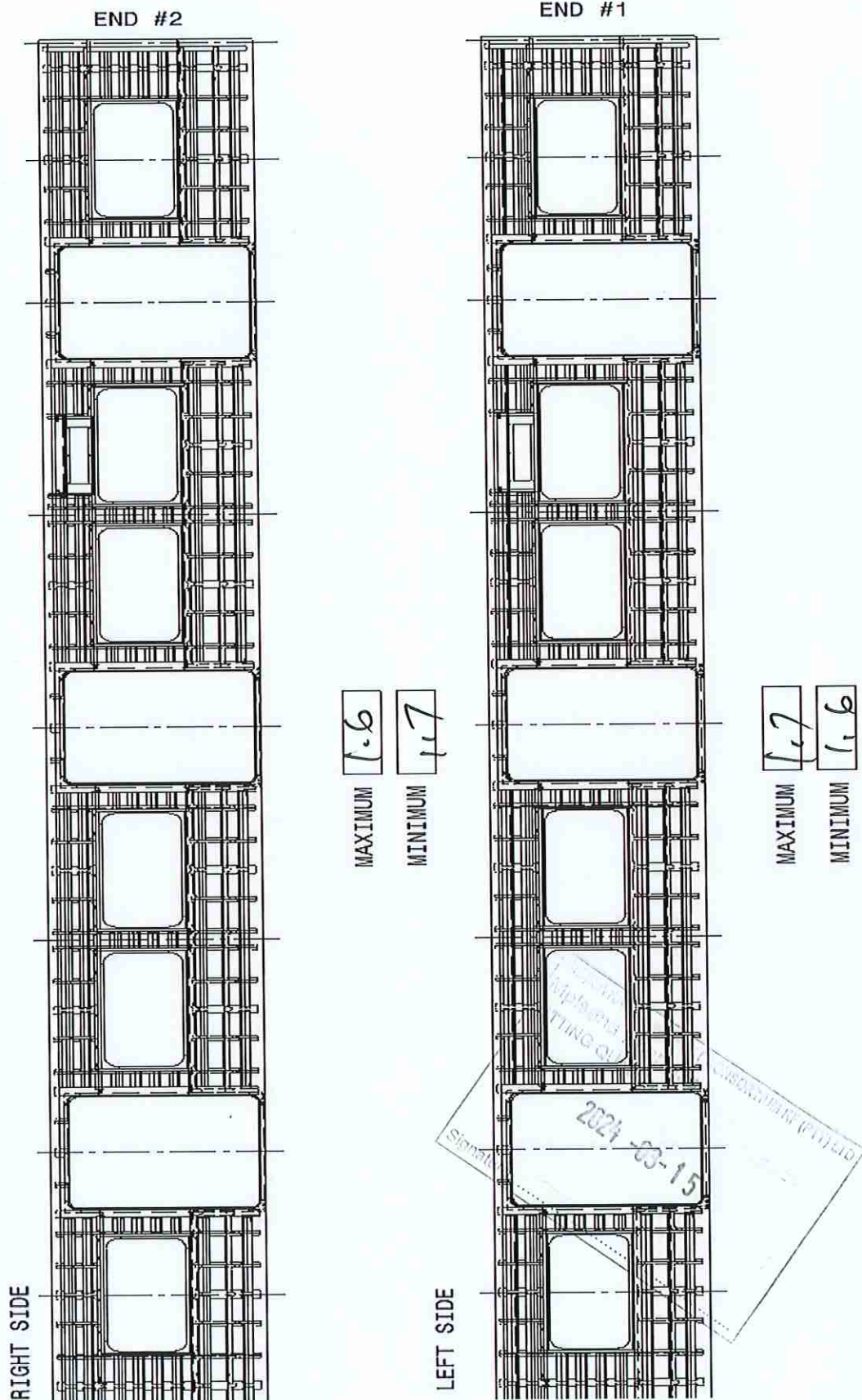
LERATO

Operator (Name & sign):



Specifications of Details for CBS measurement CB1230

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





CARBODYSHELL M2 ASSEMBLY AA00001374497

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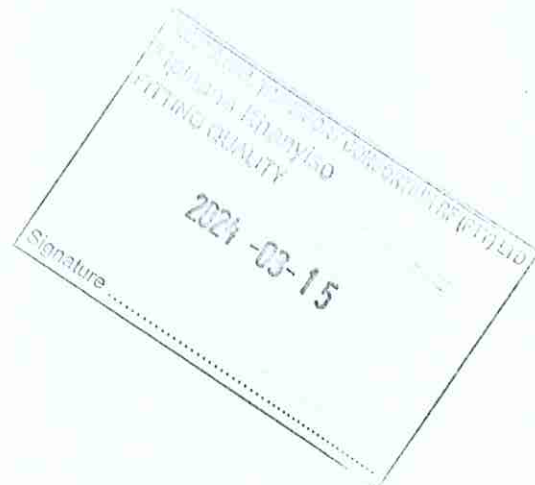
06/11/2023

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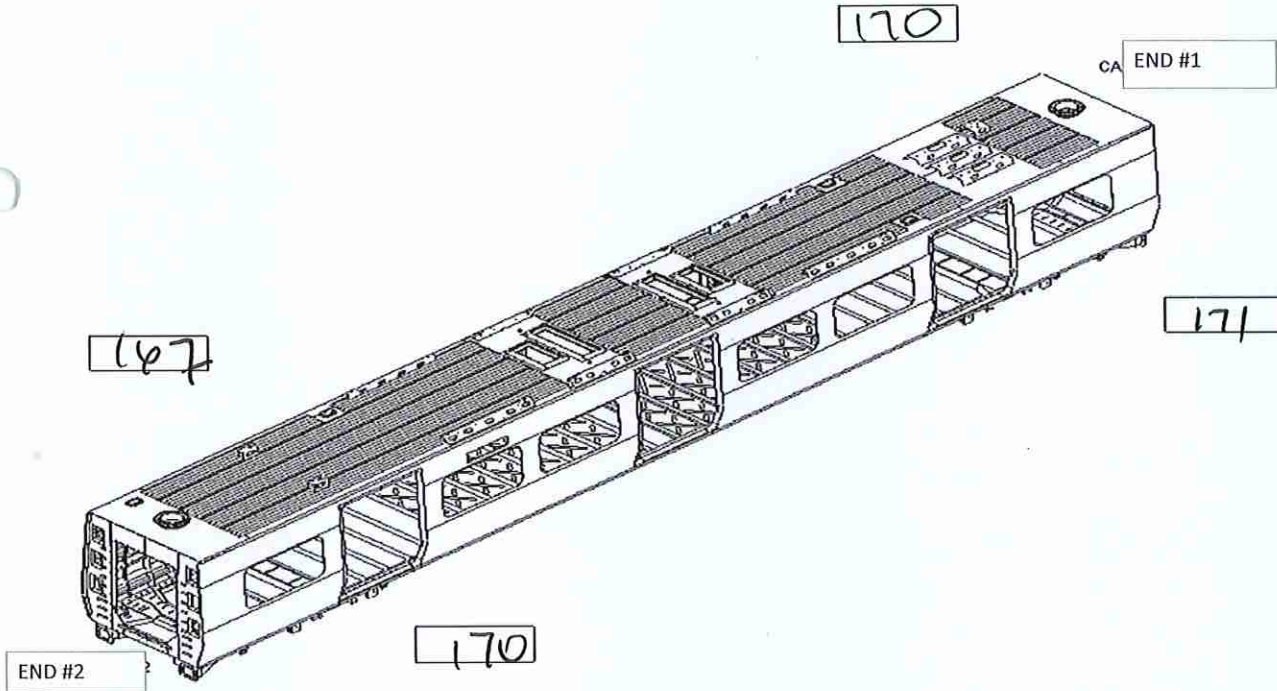
END #1

END #2



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

TRANVERSE

3

LONGITUDINAL

3

TWIST FOUND ON END 2

TRANVERSE

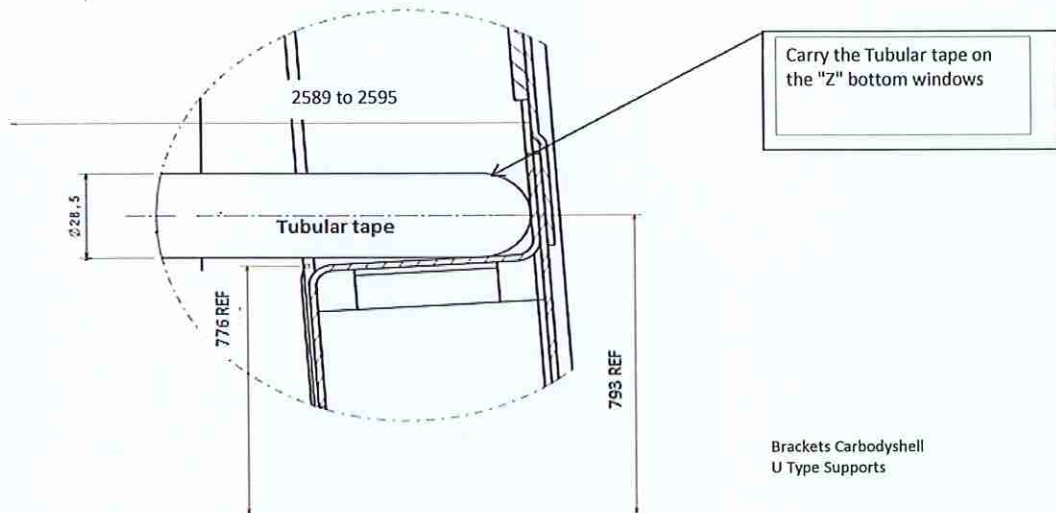
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LONGITUDINAL

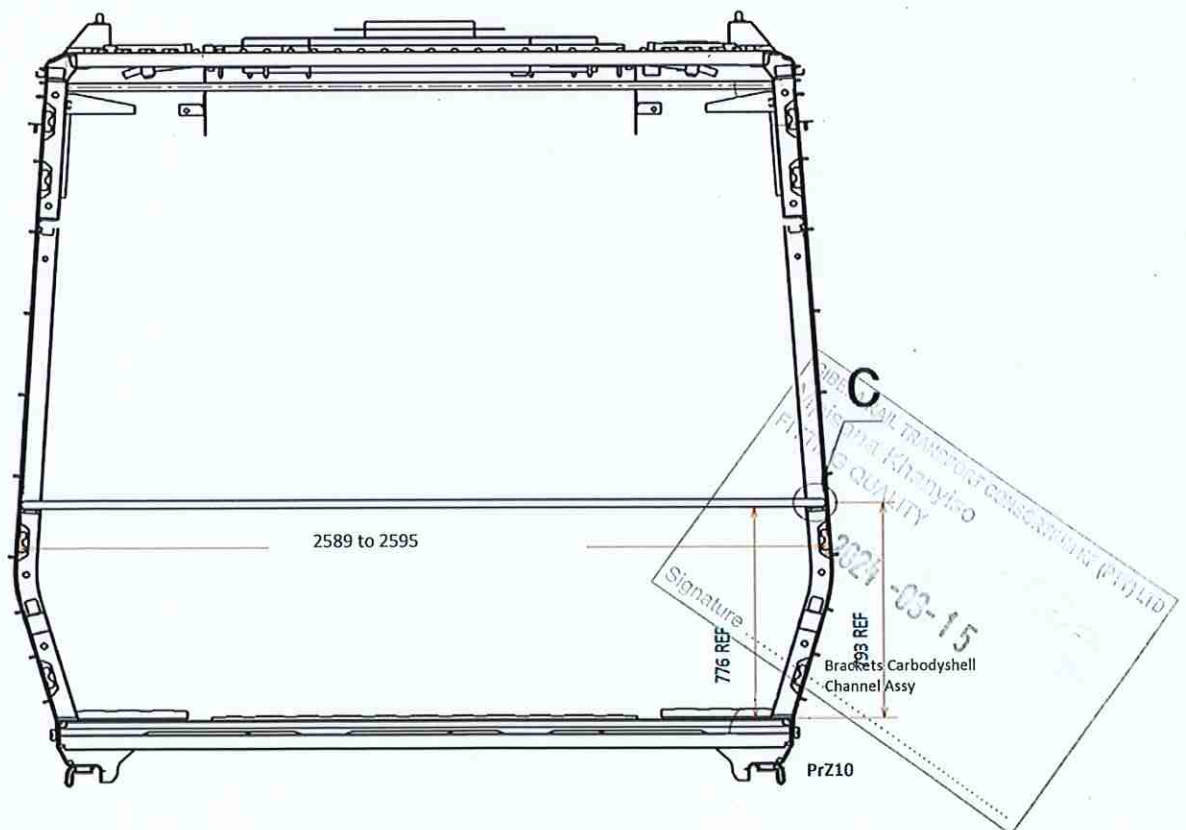
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GIBELA TRANSPORT GENERAL S.A. VTO 110
 IMPROVING KNOWLEDGE
 FITTING QUALITY
 2024-03-15
 Signature.....

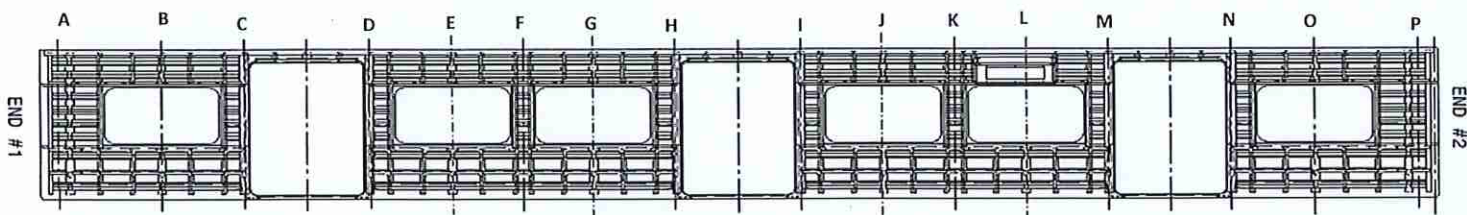
Specifications of Details for CBS measurement CB1230



Detail C

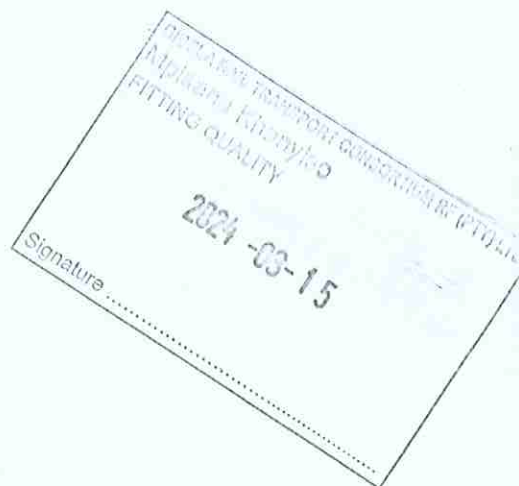


Specifications of Details for CBS measurement CB1230



2589 to 2595mm

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



Threshold verification

Nominal value :38

Door 1		Door 2		Door 3	
L	R	L	R	L	R
38	38	39	38	38	58
Door 4		Door 5		Door 6	
L	R	L	R	L	R
38	38	38	37	38	37

BOILER MAKER:

kgot30

WELDER:

EMMANUEL



CARBODYSHELL M2 ASSEMBLY AA00001374497

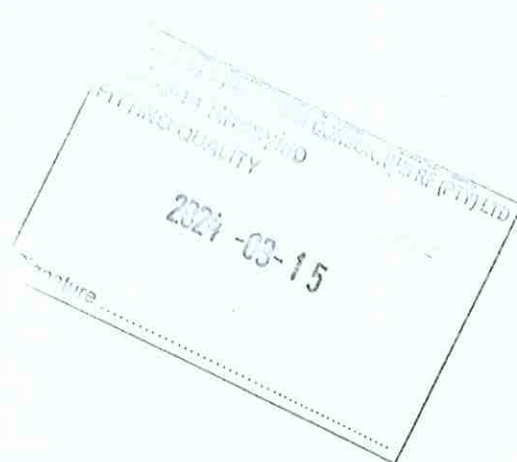
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Date

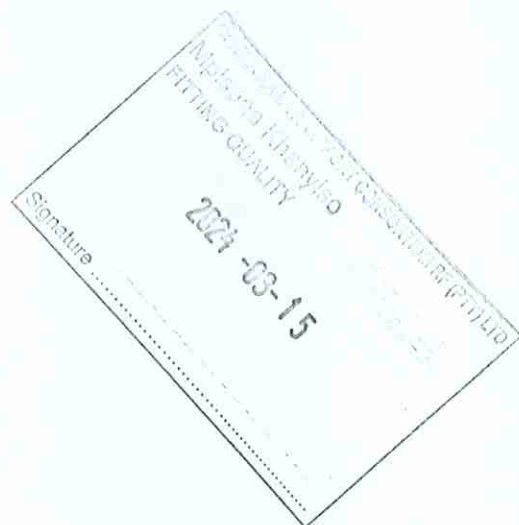
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Dye penetrant test

Dye-penetration test to be performed by quality personnel




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		06/11/2023	


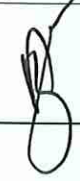
Specifications of Details for CBS measurement				
Item	Description of the issue	OK	Signature/Date (Operations)	Signature/Date (Quality)

II.2 - Check List REX								
Check List Items								
Item	Picture/Drawing	Description	Criteria /Record	OK	NOK	Rework	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX					

GIBELA S.p.A. - Via S. Maria Maddalena, 10 - 00187 Roma (RM) - Italy
Migliorata l'efficienza
FITTING QUALITY
2024-03-15
Signature

	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA SI.CB1230.277.V29
		Date	
		06/11/2023	

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!)	08/03/24	Smle	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	06/03/24	N. Tolon	
		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		Responsible	Due date	Status

Operations

Quality

