

GIBELA

PRASA PROJECT

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

CONFIDENTIAL INFORMATION


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

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE							WORK INSTRUCTION	SAFETY ?
				TC1	MA	M1	M2	M3	TC2			
DTR30223319/3	AADC001241033	Carshell Assembly TC	CB1210	X						X	PRA.CB1210.DTR3022331 9/3.V25	YES

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	09/04/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	09/04/2018
			CHECKER	Nosizo Pindela	09/04/2018
			COMPILER	Thanyani Mathegu	06/04/2018
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	2018/06/18	MODIFICATION CONTENT	APPROVER	Itumeleng Modiba	2018/06/18
			CHECKER	Nosizo Pindela	2018/06/18
			REVISED BY	Ramokone Motama	2018/05/18
3	2018/12/12	Additional checkpoints	APPROVER	Itumeleng Modiba	2018/12/12
			CHECKER	Nosizo Pindela	2018/12/12
			REVISED BY	Ramokone Motama	2018/12/12
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	22/01/2019
			CHECKER	Nosizo Pindela	22/01/2019
			REVISED BY	Vanessa Ntuli	22/01/2019
6	2019/11/03	Record D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	2019/11/03
			CHECKER	Nosizo Pindela	2019/11/03
			REVISED BY	Nosizo Pindela	2019/11/03
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	21/08/2019
			CHECKER	Nosizo Pindela	21/08/2019
			REVISED BY	Nosizo Pindela	2019/11/03
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	06/08/2020
20	19/04/2020	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2020
			CHECKER	Bongane Masina	19/04/2020
			REVISED BY	Bongane Masina	19/04/2020
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi Collins	17/08/2021
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISED BY	Mpho Mulaudzi	17/08/2021
25	21/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi Collins	21/02/2022
			CHECKER	Andani Muthelo	21/02/2022
			REVISED BY	Andani Muthelo	21/02/2022
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlampe Amogelang	14/04/2023
			REVISED BY	Mohlampe Amogelang	14/04/2023
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023
			CHECKER	Mathapo Kelebene	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

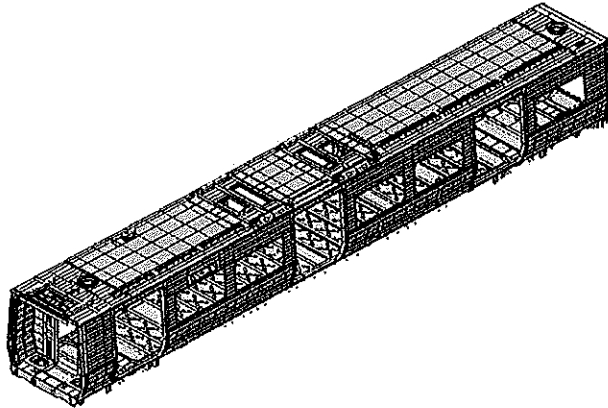
TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
224	TC1	IEBOSO 482833	19/10/24	SI.CB1210.322.V28	16

	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA SI.CB1210.322.V28
		Date- 07/11/2023	

Car: TC1 & TC2	NCR:	Work station: CB1210
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Safety Related



I - Documentation and Instruments

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
	P	F	U	D	S	T						
DTR30223319/3	X								✓		N/A	19/04/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Validation	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
Tubular	32823-2	15/03/25	✓		19/04/24	19/04/24
3mm tape	GIBTP0102	18/11/24	✓		19/04/24	19/04/24
Leber tape	125425924	08/10/28	✓		19/04/24	19/04/24

1.3 Consumables


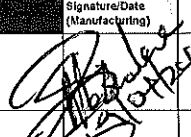
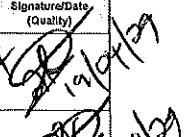


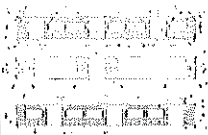
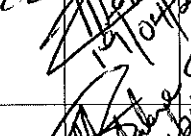
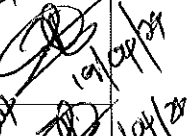
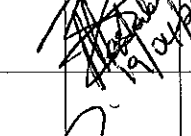
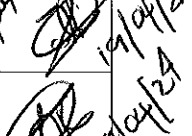

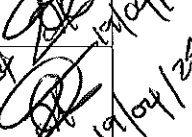
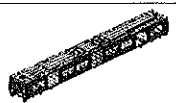


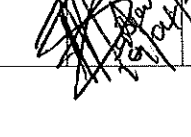
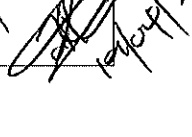
Welding Consumable Control - Used for Special Process

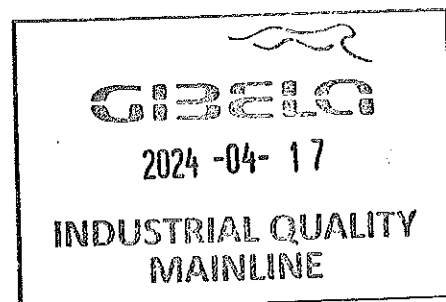
Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
ER308LSi	314018-74097	MIG	✓		19/04/24	19/04/24
ER308L	299687-70322	MIG	✓		19/04/24	19/04/24




2024-04-17

INDUSTRIAL QUALITY
MAINLINE

		DTR30223319/3 Carshell Assembly TC		Rev. V28	Project: PRASA		
				Date: 07/11/2023	SI.CB1210.322.V28		
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls,Endframes,Roof and Underframe)	DT00000284980	✓		 19/04/24	 19/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓		 19/04/24	 19/04/24
03		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		 19/04/24	 19/04/24
04	REFER TO ANNEXURE A	Spot Welding inspected and approved according procedure	IND-SAL-WMS-016 e DTD0000210675	✓		 19/04/24	 19/04/24
05	REFER TO ANNEXURE B	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 19/04/24	 19/04/24
06		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 19/04/24	 19/04/24
07	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658	✓		 19/04/24	 19/04/24



	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA SI.CB1210.322.V28
		Date- 07/11/2023	

Welder traceability

Roof ring welds

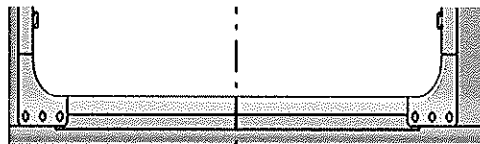


Boiler maker (Name & Sign): <u>Teboho Mphahlela</u> ^{LHS}	Welder (Name & Sign): <u>Siphokazi</u> ^{RHS}
Boiler maker (Name & Sign): <u>Sean</u> ^{RHS}	Welder (Name & Sign): <u>Siphokazi</u> ^{RHS}

END 1

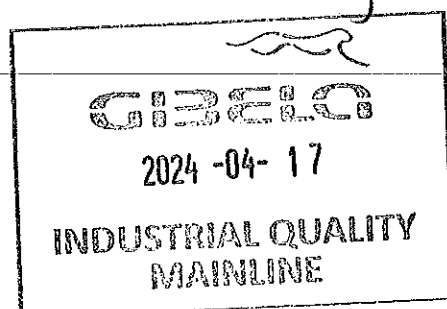
Boiler maker (Name & Sign): <u>Teboho Mphahlela</u> ^{LHS}	Welder (Name & Sign): <u>Siphokazi</u> ^{RHS}
Boiler maker (Name & Sign): <u>Sean</u> ^{RHS}	Welder (Name & Sign): <u>Siphokazi</u> ^{RHS}


END 2



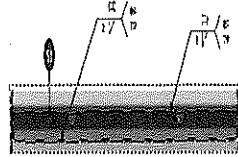
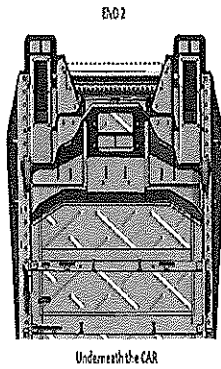
Boiler maker (Name & Sign): <u>Tim Ledeb</u> ^{LHS}
Welder (Name & Sign): <u>Thabang Kado</u> ^{RHS}

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




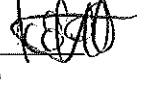
	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date: 07/11/2023	SI.CB1210.322.V28

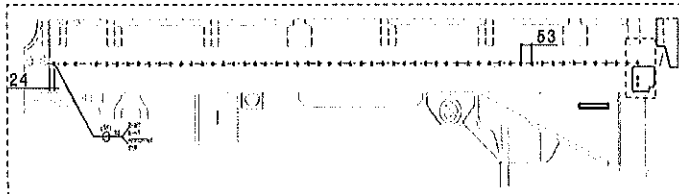
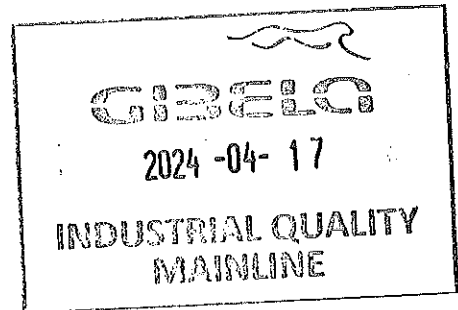
EUF Reinforcement Plates




END 2


Boiler maker (Name & Sign): JUSTICE 

Welder (Name & Sign): Thabang 

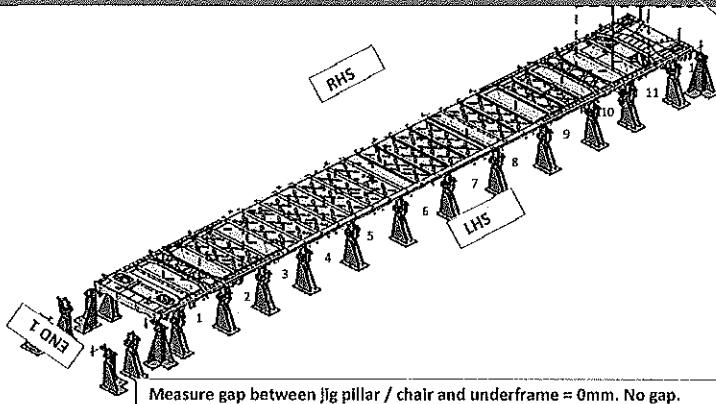


FEDOLI

Operator: LEWGA 

	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA SI.CB1210.322.V28
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Specifications of Details for CBS measurement



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

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

After Loading Underframe and Clamping.

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

Signature Operations:

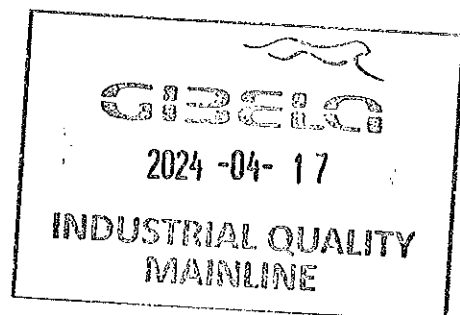
Date:

After Welding.

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

Signature Industrial Quality:

Date:



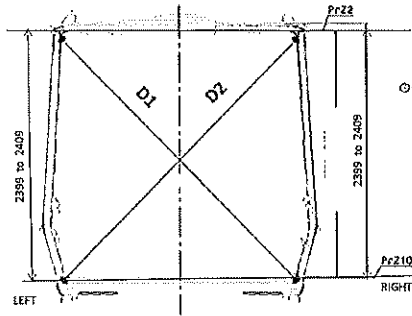
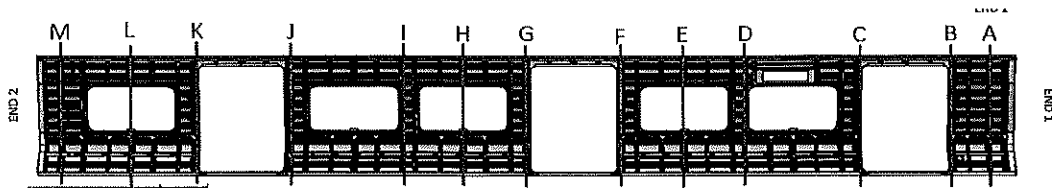


DTR30223319/3 Carshell Assembly TC

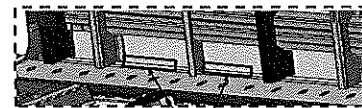
Rev.
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07/11/2023

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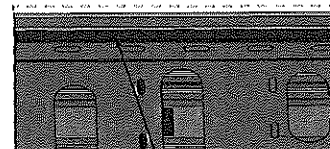
Specifications of Details for CBS measurement



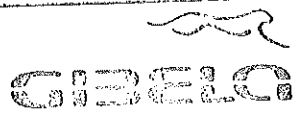
Measurement positions on roof rail and sidewall omega corner.



Measurement positions on sidewall and side sill corner.




Reinforcement area measurement positions on roof reinforcement area.

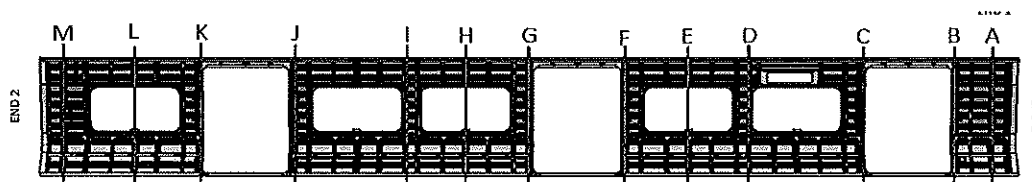


2024-04-17

INDUSTRIAL QUALITY
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	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
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Specifications of Details for CBS measurement			

BEFORE WELDING




PME: The difference in Height values measured on the LHS and RHS should be ≤ 2MM on each point.

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3264	3266	2	2405	2404	1
B	3265	3266	1	2404	2405	1
C	3267	3266	1	2404	2406	2
D	3266	3266	0	2406	2405	1
E	3266	3265	1	2406	2406	0
F	3265	3264	1	2405	2404	1
G	3265	3265	0	2405	2406	1
H	3266	3267	1	2406	2407	1
I	3265	3267	2	2405	2407	2
J	3265	3266	1	2406	2405	1
K	3267	3264	3	2406	2404	2
L	3265	3266	1	2404	2405	1
M	3267	3268		2406	2405	1

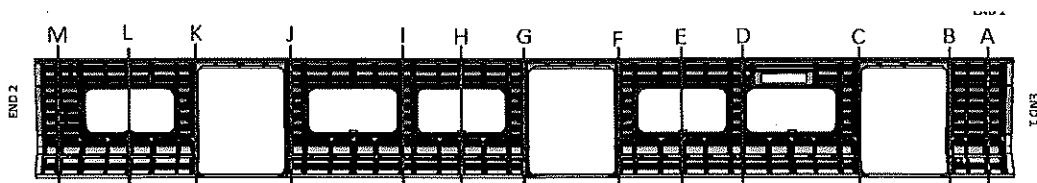


2024-04-17

INDUSTRIAL QUALITY
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	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	
Specifications of Details for CBS measurement			

AFTER WELDING



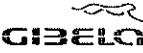
PME: The difference in Height values measured on the LHS and RHS should be $\leq 2\text{MM}$ on each point.

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3265	3267	2	2405	2405	0
B	3297	3296	1	2406	2405	1
C	3296	3295	1	2404	2406	2
D	3266	3266	0	2403	2404	1
E	3265	3264	1	2405	2404	1
F	3297	3295	2	2406	2406	0
G	3294	3296	2	2404	2405	1
H	3266	3267	1	2406	2405	1
I	3265	3266	1	2404	2405	1
J	3295	3295	0	2406	2405	1
K	3297	3296	1	2406	2407	1
L	3265	3266	3	2406	2406	0
M	3296	3298	2	2406	2407	1

GIBELQ

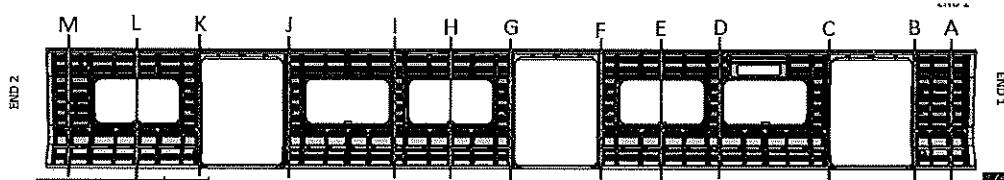
2024-04-17

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	DTR30223319/3 Garshelt Assembly TC	Rev. V28	Project: PRASA
		Date: 07/11/2023	SI.CB1210.322.V28

CBS measurement

BEFORE WELDING



2270 to 2276

2268 a 2274

A 2270

B 2275

C 2273

D 2276

E 2274

F 2271

G 2270

H 2272

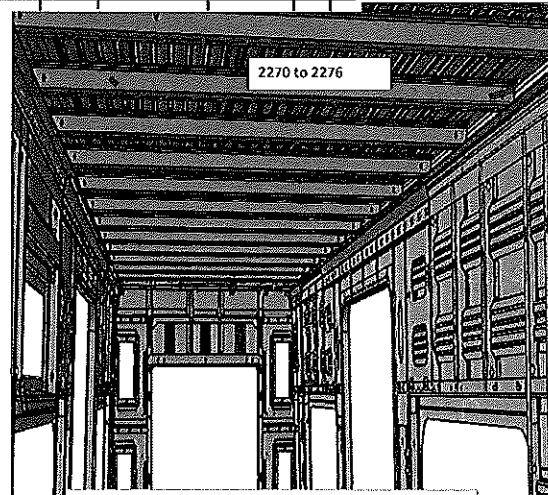
I 2274

J 2276

K 2273

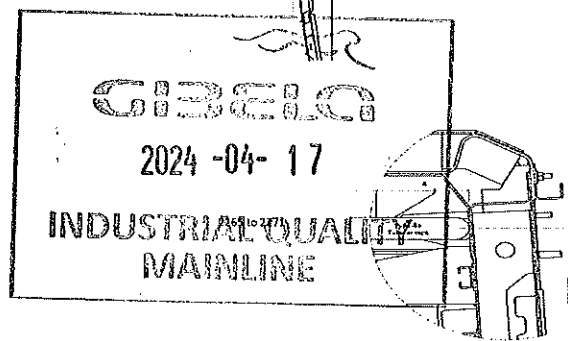
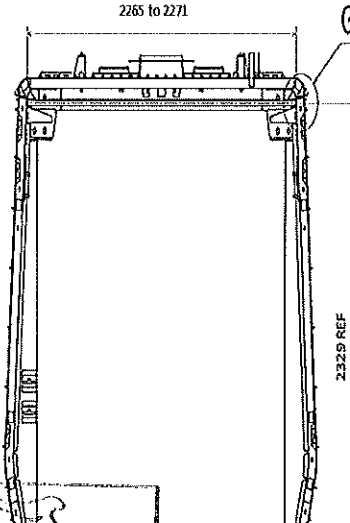
L 2275


M 2271



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

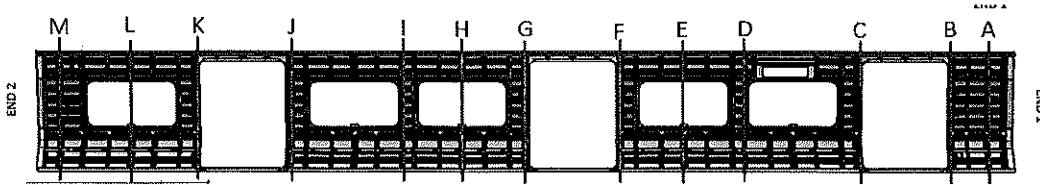
2265 to 2271



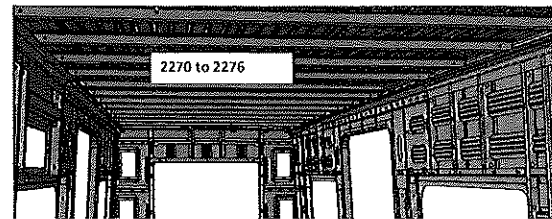
	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

Specifications of Details for CBS measurement

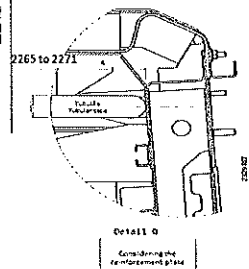
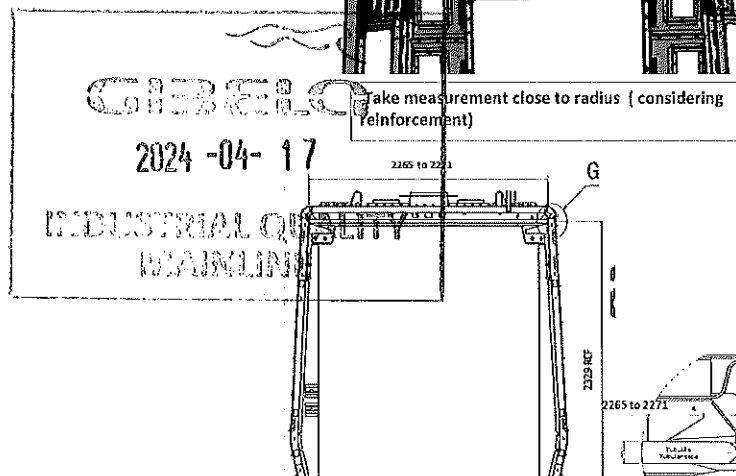
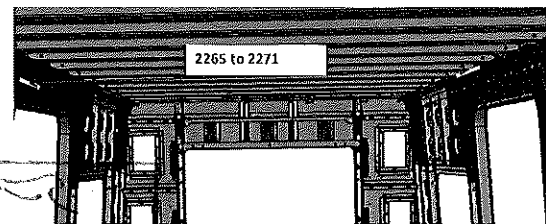
AFTER WELDING



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



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





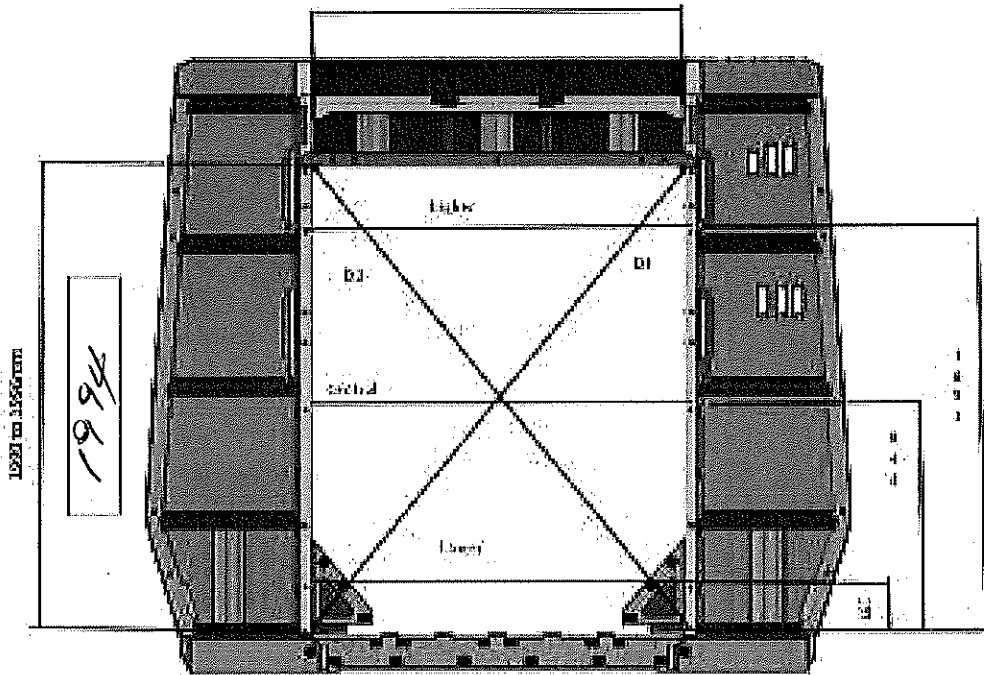
DYR30223319/3 Carshell Assembly TC

Rev.
V28
Date:
07/11/2023

Project: PRASA
SI.CB1210.322.V28

Specifications of Details for CBS measurement

Endframe 2



Height of the box

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Height of the box

1381

D1

2416

Central Diameter

1381

D2

2415

Low Diameter

1380

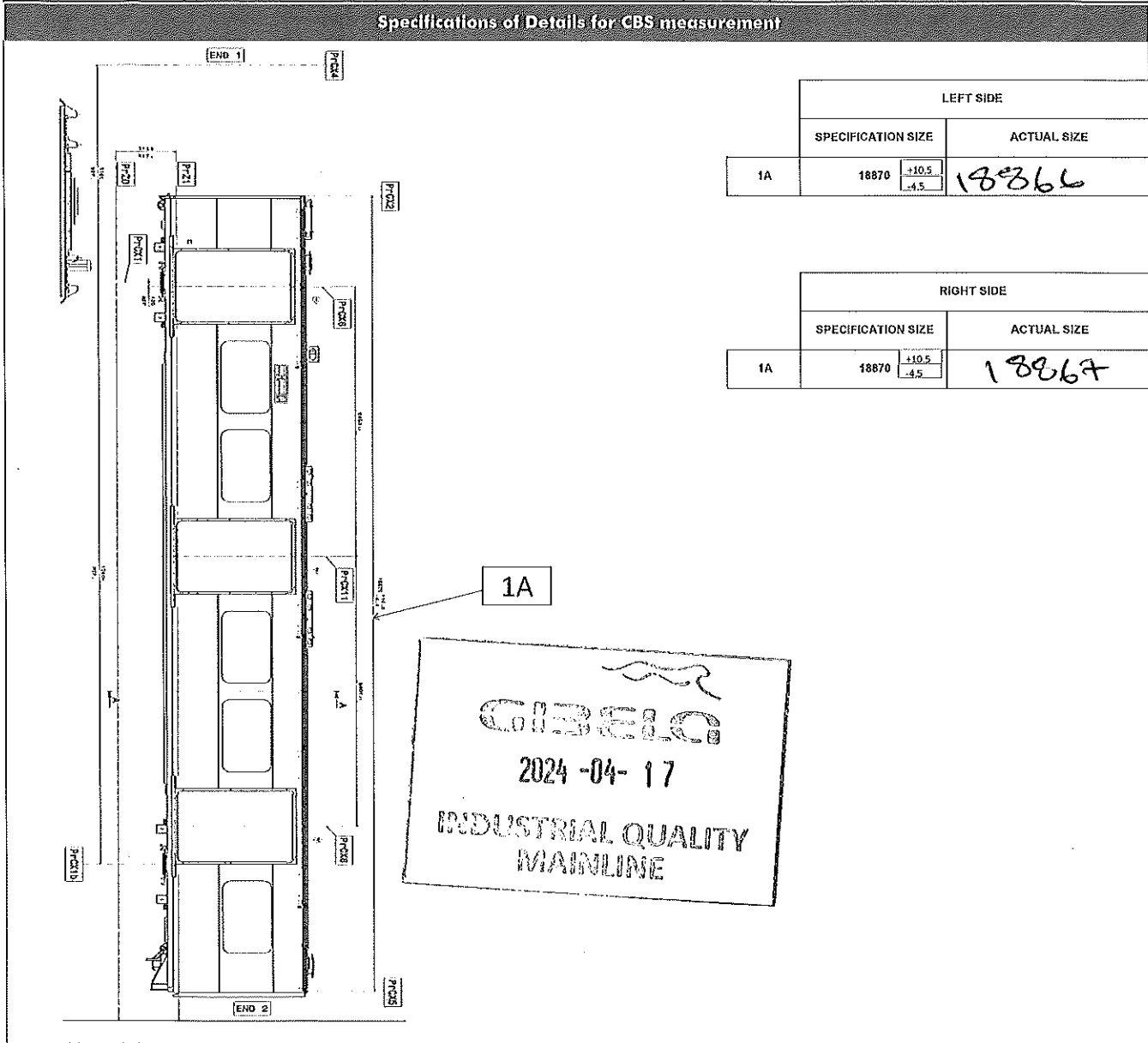
D1-D2

1

GIBELCO


2024-04-17


INDUSTRIAL QUALITY
MAINLINE




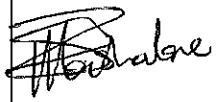

Dye penetrant test

Dye-penetration test to be performed by quality personnel



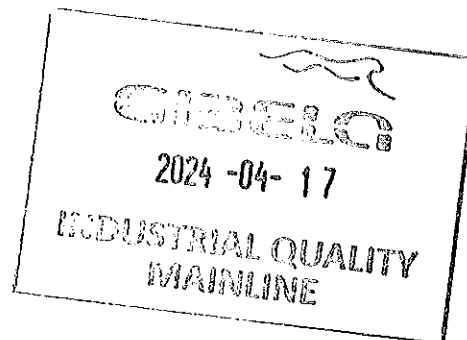
		DTR30223319/3 Carshell Assembly TC		Rev. V28	Project: PRASA			
				Date. 07/11/2023	SI.CB1210.322.V28			
Item	Description of the Issue				OK	Signature/Date (Manufacturing)	Signature/Date (Quality)	
II.2 - Check List REX								
Check List Items								
Item	Picture/Drawing	Description	Criteria /Record	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)	
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX					



2024-04-17
INDUSTRIAL QUALITY
MAINLINE

		DTR30223319/3 Carshell Assembly TC		Rev. V28	Project: PRASA	
				Date- 07/11/2023		
Self Inspection - Final Result						
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	GO	If activities are not complete, the missing activities must not impact the next stage!	19/04/24	Tebo		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	19/04/24	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	Action	Responsible	Due date	Status	

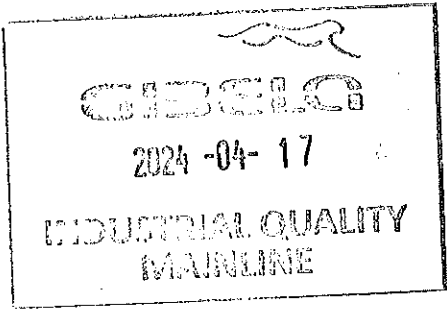
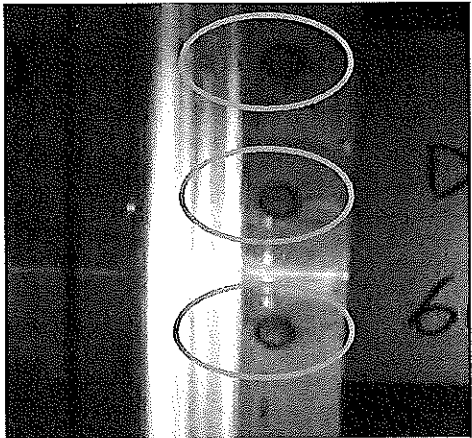
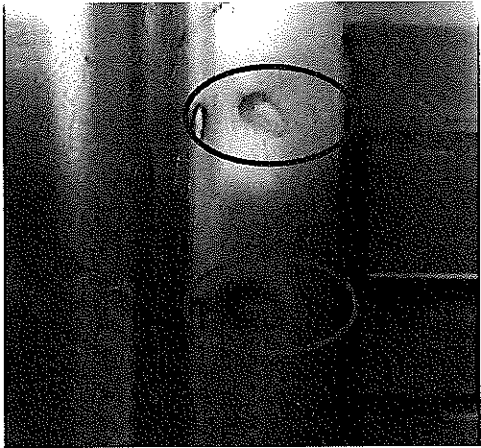
Operations



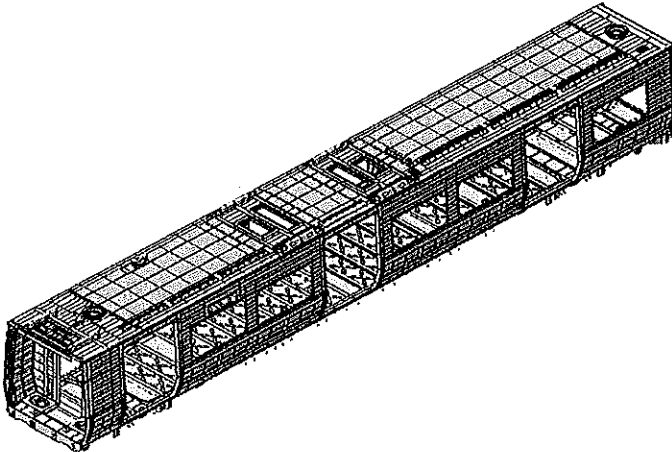
Quality










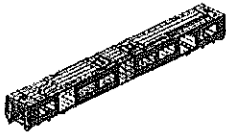




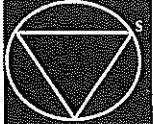







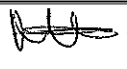
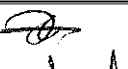
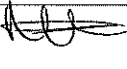
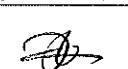
	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

ANNEXURE A: Spot Welding Quality Acceptance Standard



		DTR30223319/2 Carshell Assembly TC		Rev. 29	Project: PRASA																															
				Date- 28/10/2023	SI.CB1220.323.V29																															
Carro Car: TC1, TC2		NCR:		Work station: CB1220																																
 Safety Related																																				
																																				
I - Documentation and Instruments																																				
I.1 - Documentation Control																																				
<table border="1"><thead><tr><th rowspan="2">Document</th><th colspan="6">Type of car</th><th rowspan="2">Revision</th><th rowspan="2">Observation</th><th rowspan="2">OK</th><th rowspan="2">Signature/Date (Manufacturing)</th><th rowspan="2">Signature/Date (Quality)</th></tr><tr><th>TC1</th><th>M1</th><th>M2</th><th>M3</th><th>M4</th><th>TC2</th></tr></thead><tbody><tr><td>DTR30223319/2</td><td>✓</td><td></td><td></td><td></td><td></td><td></td><td>29</td><td>22/04/24</td><td>✓</td><td>N/A</td><td>22/04/24</td></tr></tbody></table>							Document	Type of car						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)	TC1	M1	M2	M3	M4	TC2	DTR30223319/2	✓						29	22/04/24	✓	N/A	22/04/24
Document	Type of car							Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)																								
	TC1	M1	M2	M3	M4	TC2																														
DTR30223319/2	✓						29	22/04/24	✓	N/A	22/04/24																									
I.2 - Instruments Control																																				
Monitoring and Measuring Instrument Control - Used for Special Process																																				
<table border="1"><thead><tr><th>Instruments</th><th>Validation</th><th>Calibration or Verification Validation Date</th><th>OK</th><th>Signature/Date (Manufacturing)</th><th>Signature/Date (Quality)</th></tr></thead><tbody><tr><td>Turbular</td><td>2823-2</td><td>15/03/2025</td><td>✓</td><td>22/04/24</td><td>22/04/24</td></tr><tr><td>Measuring - Tape</td><td>GIBEL</td><td>12/04/25</td><td>✓</td><td>22/04/24</td><td>22/04/24</td></tr></tbody></table>							Instruments	Validation	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)	Turbular	2823-2	15/03/2025	✓	22/04/24	22/04/24	Measuring - Tape	GIBEL	12/04/25	✓	22/04/24	22/04/24												
Instruments	Validation	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)																															
Turbular	2823-2	15/03/2025	✓	22/04/24	22/04/24																															
Measuring - Tape	GIBEL	12/04/25	✓	22/04/24	22/04/24																															
1.3 Consumables																																				
Welding Consumable Control - Used for Special Process																																				
<table border="1"><thead><tr><th>Filler Material</th><th>Heat Number</th><th>Welding Process</th><th>OK</th><th>Signature/Date (Manufacturing)</th><th>Signature/Date (Quality)</th></tr></thead><tbody><tr><td>Welding - wire</td><td>E231061</td><td>MIG Welding</td><td>✓</td><td>22/04/24</td><td>22/04/24</td></tr></tbody></table>							Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)	Welding - wire	E231061	MIG Welding	✓	22/04/24	22/04/24																		
Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)																															
Welding - wire	E231061	MIG Welding	✓	22/04/24	22/04/24																															

		DTR30223319/2 Carshell Assembly TC		Rev. 29 Date- 28/10/2023	Project: PRASA SI.CB1220.323.V29		
II - Control Activities of Production							
II.1 - Items to check							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Not OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	DTR30223319/2	✓		 22/04/24	 22/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓		 22/04/24	 22/04/24
03	REFER TO ANNEXURE A	Spot Welding inspected and approved according procedure	IND-SAL-WMS-016 e DTD0000210675	✓		 22/04/24	 22/04/24
04	REFER TO ANNEXURE B	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 22/04/24	 22/04/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 22/04/24	 22/04/24
06	N/A	Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		 22/04/24	 22/04/24
07		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018, Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658	✓		 22/04/24	 22/04/24
08	N/A	<p>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:</p> <p>Temperature Min - Max (t) : Min-Max : 10°C - 35°C Relative humidity Min - Max (t) : Min-Max : 25% - 80%</p>	<p>Sealant Batch No: <u>2001349</u> Exp Date: <u>1/06/26</u></p> <p>Actuals Temperature: <u>28°C</u> Humidity: <u>53%</u></p>	✓		 22/04/24	 22/04/24

		DTR30223319/2 Carshell Assembly TC		Rev. 29	Project: PRASA			
				Date- 28/10/2023	SI.CB1220.323.V29			
09	NA	Verification of sealant application in certain regions in the drawing.	AAD0001241033	✓			 22/04/24	 22/04/24
10	NA	Verification of sealant application on the roof and sidewall finishers	Sealant must be: -Applied straight and even (1.5mm) -Free of gaps,cracks,damage and debris (flashes, dirt, dust) Refer to Annexure B	✓			 22/04/24	 22/04/24





DTR30223319/2 Carshell Assembly TC

Rev.
29
Date-
28/10/2023

Project: PRASA
SI.CB1220.323.V29



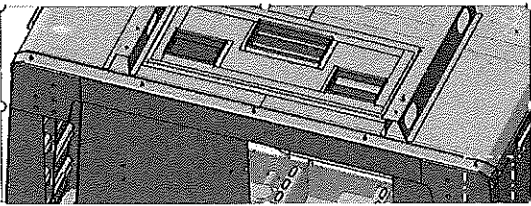
END 1
SEALANT


OPERATOR
(Name & sign):

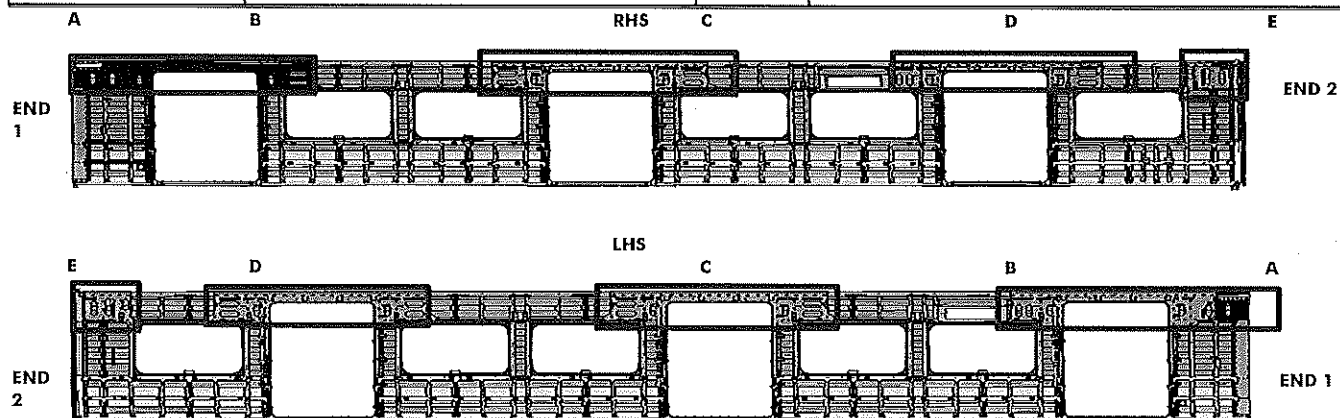
Mthokozisi

OPERATOR
(Name & sign):

Mthokozisi

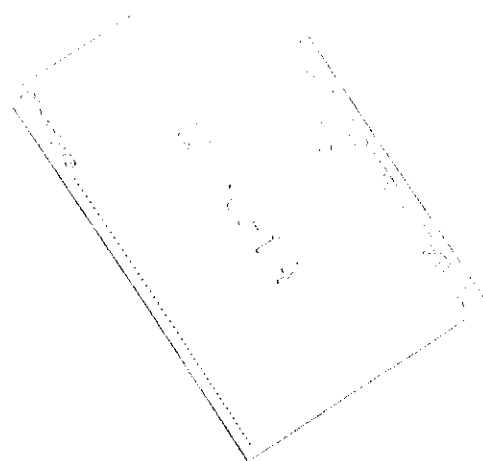



	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA SI.CB1220.323.V29
		Date-	
		28/10/2023	

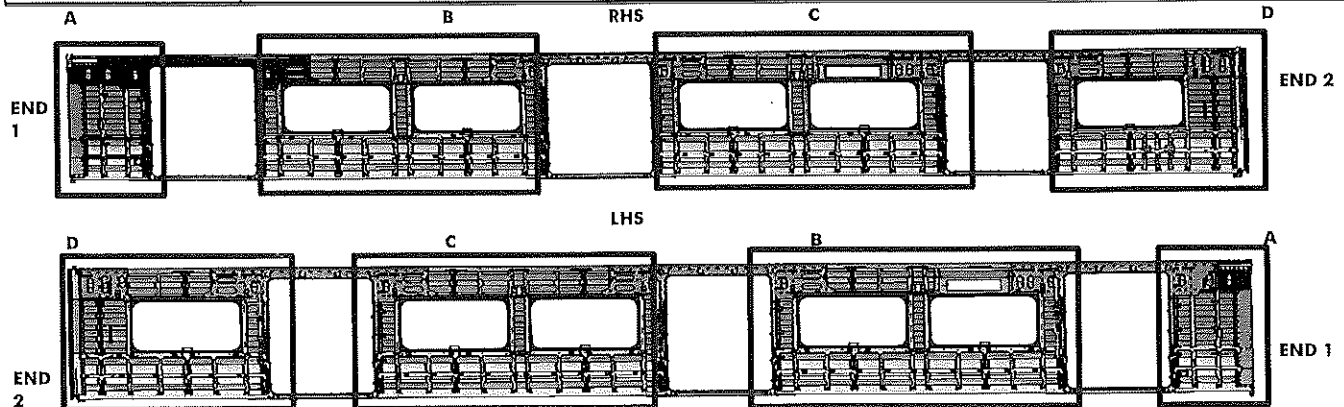


REINFORCEMENT WELDING

AREA	LHS	RHS
A	Operator (Name&sign): <u>NOKULUNGA DZICU</u>	<u>NOKULUNGA DZICU</u>
B	Operator (Name&sign): <u>NOKULUNGA DZICU</u>	<u>[Signature]</u>
C	Operator (Name&sign): <u>S. M. [Signature]</u>	<u>S. M. [Signature]</u>
D	Operator (Name&sign): <u>Sibiga [Signature]</u>	<u>THULANI [Signature]</u>
E	Operator (Name&sign): <u>Sibiga [Signature]</u>	<u>THULANI [Signature]</u>




	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA SI.CB1220.323.V29
		Date-	
		28/10/2023	



BRACKETING

		INSTALLATION	
C-RAILS:	Operator:	<u>Thulani</u>	
	Operator:	<u>Tetelo</u>	
DOOR MECHANISMS:	Operator:		
	Operator:	<u>deni</u>	
TAPPING PADS	Operator:		
	Operator:		
INSTALLATION & VERIFICATION			
SEAT & LUGGAGE BRACKETS:	Operator:	<u>Xulu</u>	
	Operator:	<u>Mashudu</u>	
SEAT BRACKETS VERIFICATION:	Operator:	<u>Xulu</u>	
	Operator:		

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

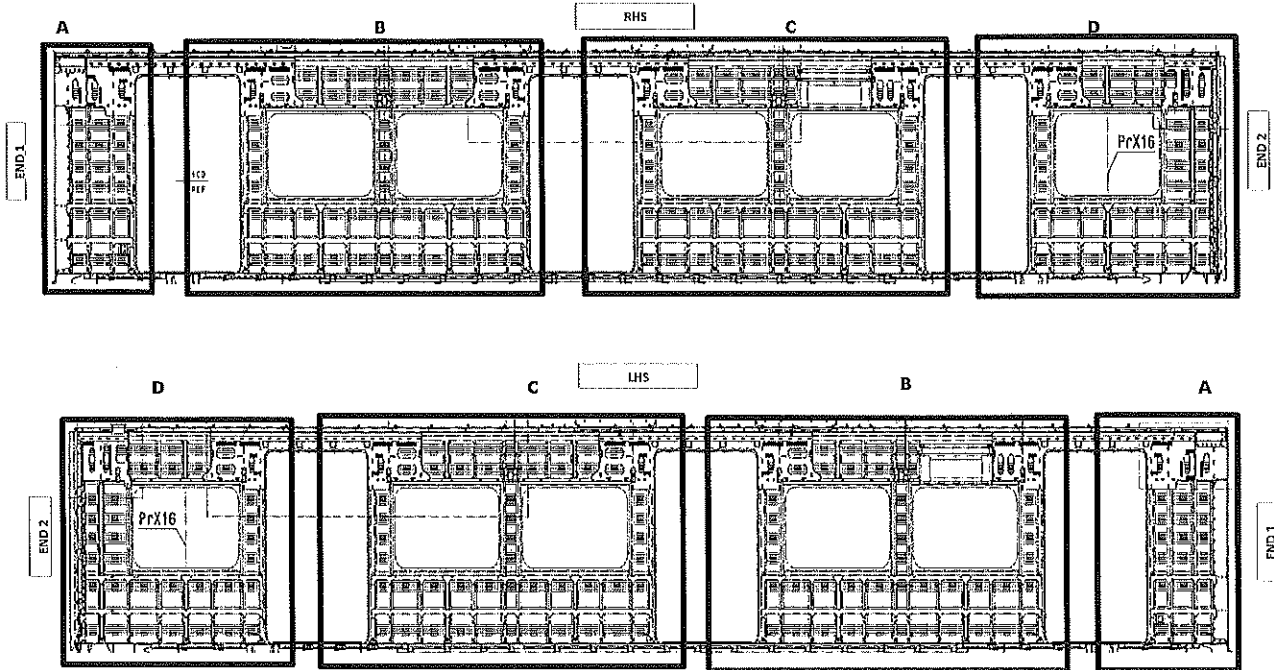
	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA SI.CB1220.323.V29
		Date-	
		28/10/2023	

ENDS

END 2 TAPPING PADS WELDING: Operator (Name&sign):

Sibiya B

TC BRACKET INSTALLATION



QUANTITIES {TC}

		RHS			
		SECTION	QUANTITY	OK	NOK
C-RAILS		A	4	✓	
		B	4		
		C	8		
		D	12		
SEAT BRACKETS		A	0	✓	
		B	21		
		C	21		
		D	4		
EARTH BUSH		A	1	✓	
		B	4		
		C	5		
		D	4		

ROOF ENDS:

CRAILS 2 OFF END 2
EARTH BUSH 4 OFF END 2

VERIFICATION BY:

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	4	✓	
	B	8	✓	
	C	4	✓	
	D	6	✓	
SEAT BRACKETS	A	0	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	1	✓	
	B	4	✓	
	C	4	✓	
	D	2	✓	

ROOF ENDS:

CRAILS 2 OFF END 2
EARTH BUSH 4 OFF END 2

VERIFICATION BY: leelo



DTR30223319/2 Carshell Assembly TC

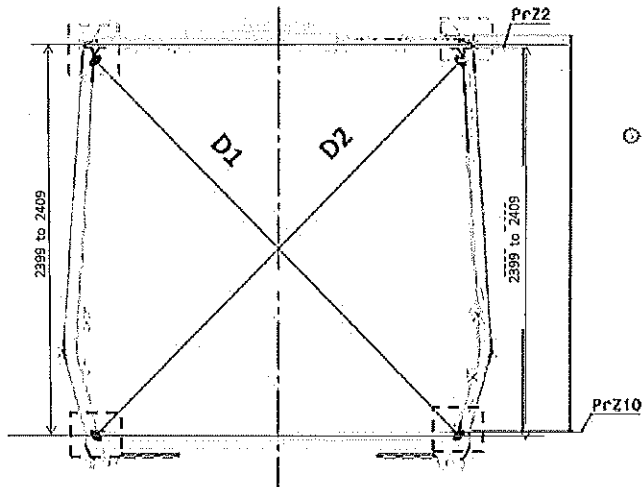
Rev.
29

Project: PRASA

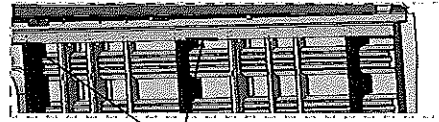
Date-

SI.CB1220.323.V29

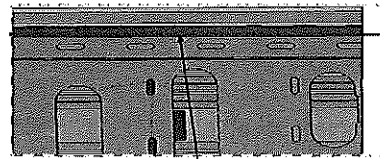
28/10/2023



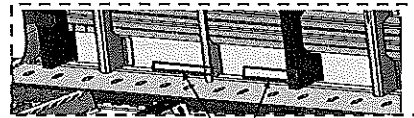
Take measurement close to radius



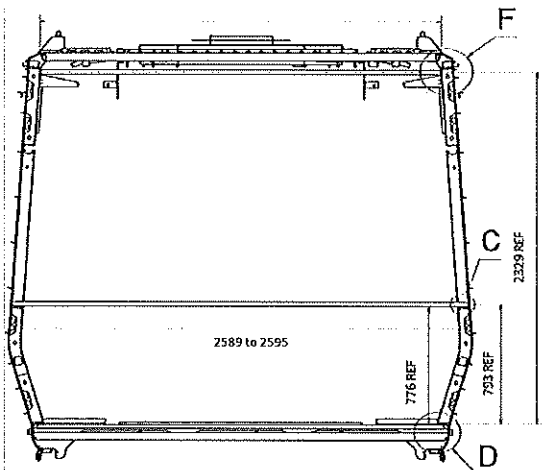
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



Take measurement close to radius



DTR30223319/2 Carshell Assembly TC

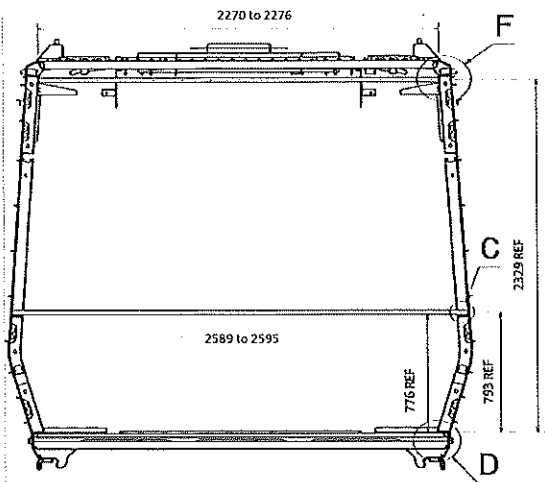
Rev.
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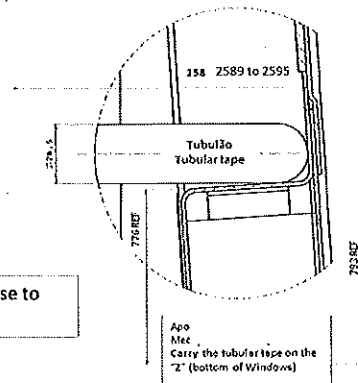
Date-

SI.CB1220.323.V29

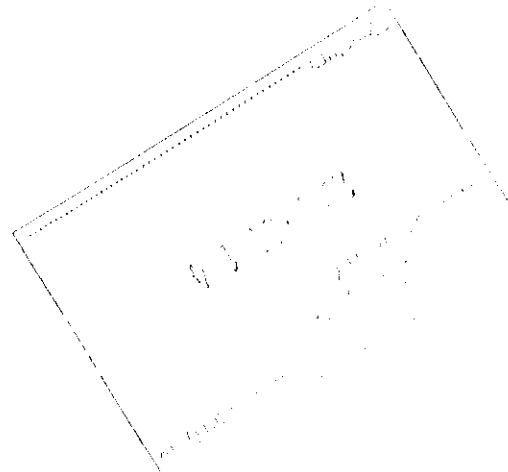
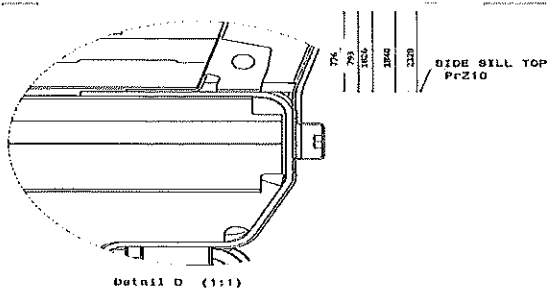
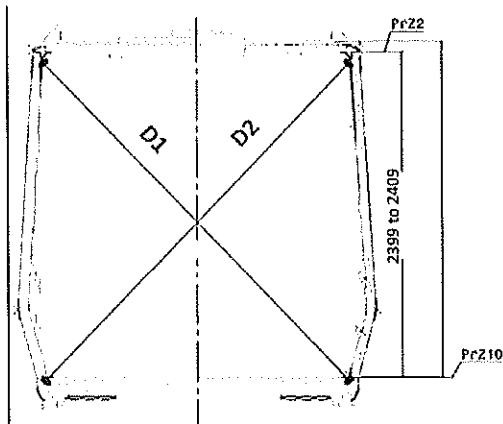
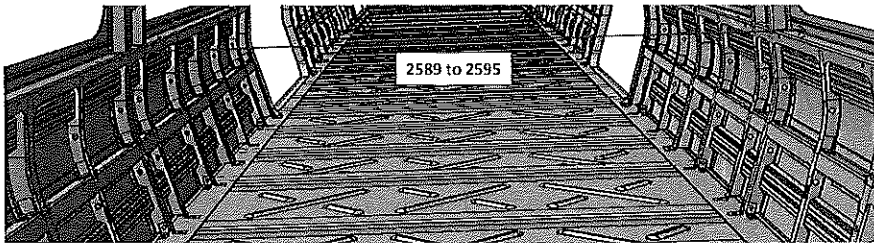
28/10/2023



Take measurement close to
radius



Detail C





DTR30223319/2 Carshell Assembly TC

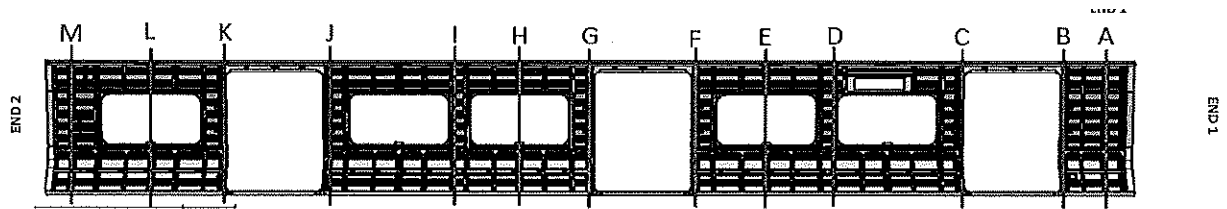
Rev.
29

Project: PRASA

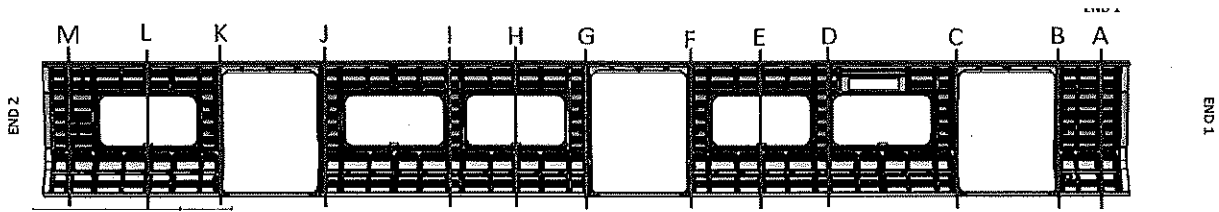
Date-

28/10/2023

SI.CB1220.323.V29


BEFORE WELDING

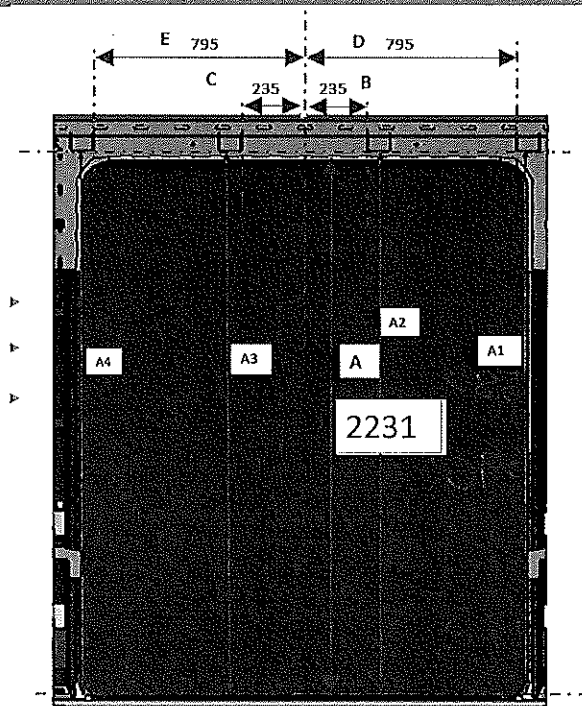
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3297	3	✓
B	3267	3265	2	✓
C	3295	3291	2	✓
D	3268	3267	1	✓
E	3267	3269	2	✓
F	3300	3299	1	✓
G	3300	3297	3	✓
H	3266	3268	2	✓
I	3267	3268	1	✓
J	3300	3300	0	✓
K	3300	3299	1	✓
L	3268	3269	1	✓
M	3269	3269	0	✓



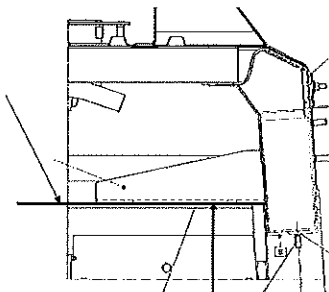
AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3299	1	2589
B	3267	3269	2	2596
C	3299	3300	1	2591
D	3267	3265	2	2593
E	3267	3269	2	2591
F	3298	3297	1	2596
G	3300	3300	2	2592
H	3268	3269	1	2591
I	3267	3268	1	2592
J	3300	3299	1	2590
K	3300	3298	2	2591
L	3267	3269	2	2592
M	3294	3296	2	2597

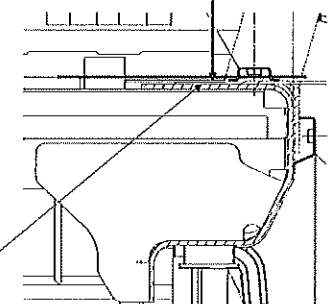
	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA SI.CB1220.323.V29
		Date-	
		28/10/2023	
Specifications of Details for CBS measurement			



Brackets Carbodyshell
U Type Supports



Brackets Carbodyshell
Channel Assy



DOOR 1 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	1237
A2	2230 to 2232	2232
A3	2230 to 2232	2232
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 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2230
A3	2230 to 2232	2230
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 3 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2232
A3	2230 to 2232	2230
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 1 - RHS

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

DOOR 3 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2230
A3	2230 to 2232	2231
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



DTR30223319/2 Carshell Assembly TC

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29

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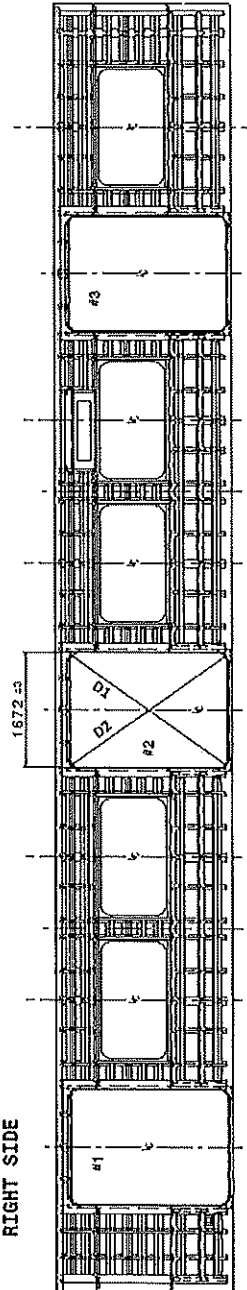
Date-

SI.CB1220.323.V29

28/10/2023

Specifications of Details for CBS measurement

End #2



End #1

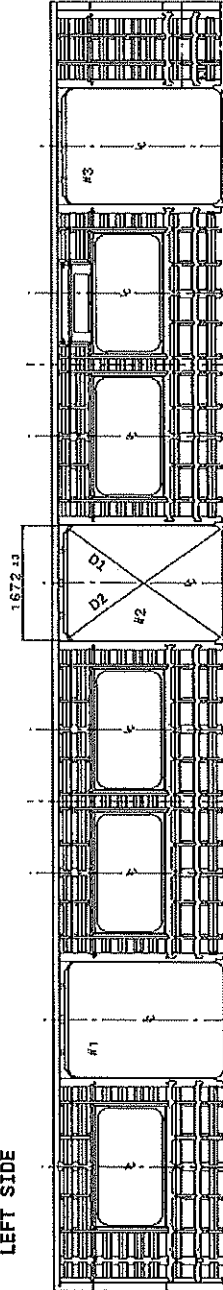
Doors diagonal D1-D2 maximum difference ≤4mm

	#1	#2	#3
D1	2750	2752	2750
D2	2751	2751	2751
D1-D2	1	1	1

Doors length - 1672 ±3mm

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

End #1





End #2


Diagonal de portas - diferença D1-D2 <4mm

	#1	#2	#3
D1	2749	2751	2750
D2	2748	2748	2748
D1-D2	1	3	1


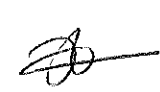
Vão de Portas - 1672 ±3mm

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

	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA SI.CB1220.323.V29				
		Date-					
		28/10/2023					
Specifications of Details for CBS measurement							
Dye penetrant test							
<div style="border: 1px solid black; padding: 5px; margin-bottom: 10px;">Dye-penetration test to be performed by quality personnel</div> 							
Item	Description of the Issue				OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
II.2 - Check List REX							
Check List Items							
Item	Picture/Drawing	Description	Criteria /Record	OK	Not OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX				

	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA	
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		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!	22/04/24	Tetelo	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	22/04/24	Andani	
		NO GO	There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)			
			There are non-conformities Impact the quality of the product and there is no corrective action defined yet)			

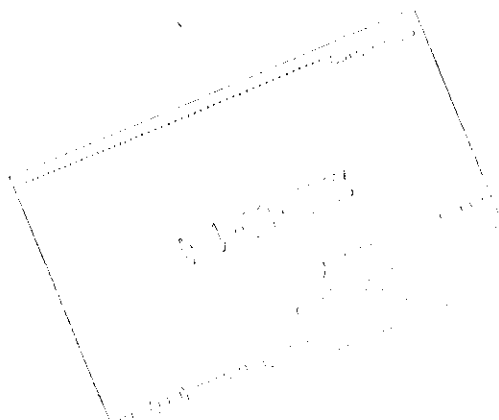
In case of "NO GO", describe blocking problems


In case of "NO GO", the operations manager must define below action plan to ensure "GO":					
Item	Description	Action	Responsible	Due date	Status

Tetelo
Operations

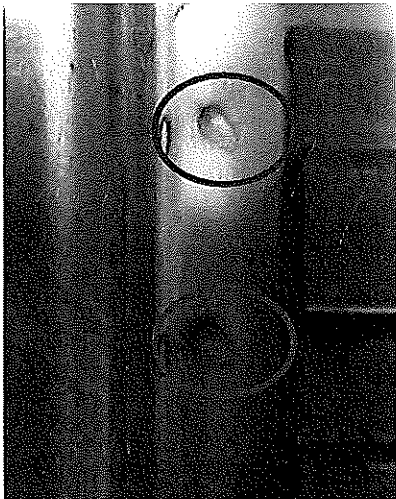


Quality



	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA SI.CB1220.323.V29
		Date-	
		28/10/2023	

ANNEXURE A: Spot Welding Quality Acceptance Standard







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 1	
				TCA	MA	M1	M2	M3	TCA			
<input type="checkbox"/>	DT00000223319	AP00001238963	DT00000223319 Carshell Assembly TC	CB1220	X					X	PRA.CB1230.DT00000123319.V20	YES
<input type="checkbox"/>												

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	06/04/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	09/04/2018
			CHECKER	Nosizo Pindela	09/04/2018
			COMPILER	Thanyani Mathesgu	06/04/2018
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	05/07/2018	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	05/07/2018
			CHECKER	Nosizo Pindela	05/07/2018
			COMPILER	Ramokone Matlana	05/07/2018
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
			COMPILER	Nosizo Pindela	13/03/2019
7	17/09/2019	Added Cab Fire Barrier Flatness Measurements	APPROVER	Itumeleng Modiba	17/09/2019
			CHECKER	Nosizo Pindela	17/09/2019
			COMPILER	Nosizo Pindela	17/09/2019
10	20/09/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	20/09/2019
			CHECKER	Nosizo Pindela	20/09/2019
			COMPILER	Nosizo Pindela	20/09/2019
15	28/01/2021	New Baseline 10.2.6	APPROVER	Timothy Maimela	28/01/2021
			CHECKER	Bongane Masina	28/01/2021
			COMPILER	Bongane Masina	28/01/2021
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			COMPILER	Bongane Masina	19/04/2021
25	20/04/2022	New Baseline change 10.3.1	APPROVER	Colins Mhombhli	20/02/2022
			CHECKER	Andani Muthelo	20/02/2022
			COMPILER	Andani Muthelo	20/02/2022
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Colins Mhombhli	14/06/2022
			CHECKER	Andani Muthelo	
			COMPILER	Andani Muthelo	
27	26/07/2022	Threshold measurements addition	APPROVER	Colins Mhombhli	26/07/2022
			CHECKER	Andani Muthelo	
			COMPILER	Andani Muthelo	
28	17/10/2022	Addition of traceability for sealant application	APPROVER	Colins Mhombhli	17/10/2022
			CHECKER	Ntokozi Zwane	
			COMPILER	Amogelang Mohlame	
29	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozi Zwane	
			COMPILER	Amogelang Mohlame	
30	06/11/2023	Added traceability for thresholds for boiler makers and welders	APPROVER	Tyson Ngweni	06/11/2023
			CHECKER	Andani Muthelo	
			COMPILER	Ntokozi Zwane	

TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
224	TC1	ELHOSE HITHO	23/04/24	SI.CB1230.324.V28	14



1. *Phragmites australis* (Cav.) Trin. ex Steud.
 2. *Scirpus americanus* (L.) Link.
 3. *Eleocharis acicularis* (L.) Rostk Schmidt
 4. *Sagittaria arifolia* (L.) Link.
 5. *Alisma plantaginifolia* (L.) Rostk Schmidt
 6. *Sparganium angustifolium* Michx.
 7. *Najas* sp.
 8. *Chara* sp.
 9. *Utricularia* sp.
 10. *Hydrocotyle* sp.
 11. *Salvinia* sp.
 12. *Wolffia* sp.
 13. *Elodea canadensis* (Mill.) B. S. P.
 14. *Hydrilla* sp.
 15. *Valoniopsis spiralis* (L.) Link.
 16. *Utricularia* sp.
 17. *Hydrocotyle* sp.
 18. *Salvinia* sp.
 19. *Wolffia* sp.
 20. *Elodea canadensis* (Mill.) B. S. P.
 21. *Hydrilla* sp.
 22. *Valoniopsis spiralis* (L.) Link.
 23. *Utricularia* sp.
 24. *Hydrocotyle* sp.
 25. *Salvinia* sp.
 26. *Wolffia* sp.
 27. *Elodea canadensis* (Mill.) B. S. P.
 28. *Hydrilla* sp.
 29. *Valoniopsis spiralis* (L.) Link.
 30. *Utricularia* sp.
 31. *Hydrocotyle* sp.
 32. *Salvinia* sp.
 33. *Wolffia* sp.
 34. *Elodea canadensis* (Mill.) B. S. P.
 35. *Hydrilla* sp.
 36. *Valoniopsis spiralis* (L.) Link.
 37. *Utricularia* sp.
 38. *Hydrocotyle* sp.
 39. *Salvinia* sp.
 40. *Wolffia* sp.
 41. *Elodea canadensis* (Mill.) B. S. P.
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 43. *Valoniopsis spiralis* (L.) Link.
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 45. *Hydrocotyle* sp.
 46. *Salvinia* sp.
 47. *Wolffia* sp.
 48. *Elodea canadensis* (Mill.) B. S. P.
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 50. *Valoniopsis spiralis* (L.) Link.
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 52. *Hydrocotyle* sp.
 53. *Salvinia* sp.
 54. *Wolffia* sp.
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 61. *Wolffia* sp.
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 63. *Hydrilla* sp.
 64. *Valoniopsis spiralis* (L.) Link.
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 66. *Hydrocotyle* sp.
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 68. *Wolffia* sp.
 69. *Elodea canadensis* (Mill.) B. S. P.
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 71. *Valoniopsis spiralis* (L.) Link.
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 73. *Hydrocotyle* sp.
 74. *Salvinia* sp.
 75. *Wolffia* sp.
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 101. *Hydrocotyle* sp.
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 152. *Wolffia* sp.
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 157. *Hydrocotyle* sp.
 158. *Salvinia* sp.
 159. *Wolffia* sp.
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 164. *Hydrocotyle* sp.
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 185. *Hydrocotyle* sp.
 186. *Salvinia* sp.
 187. *Wolffia*



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Date-

06/11/2023

Project: PRASA

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Carro
Car:

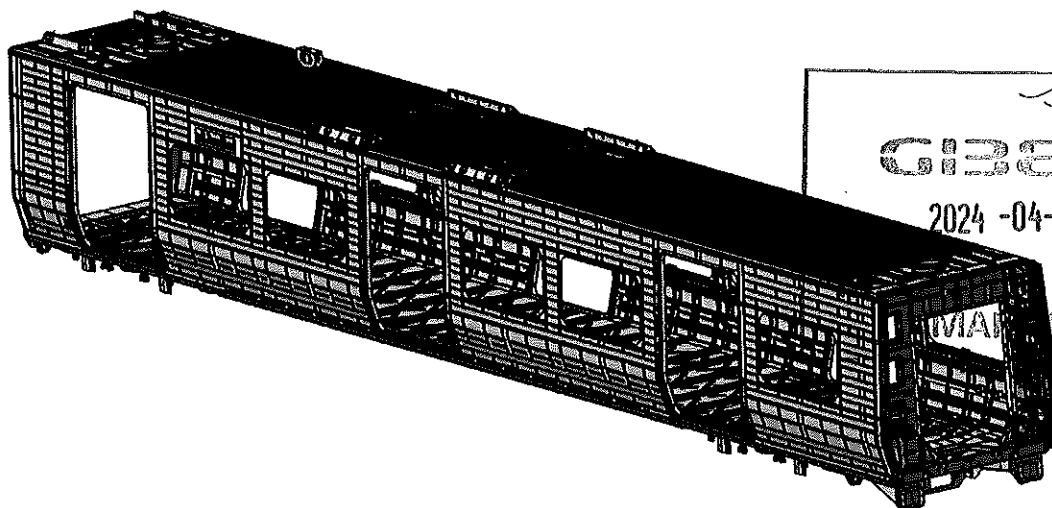
NCR:

Work station:

CB1230



Safety Related



I - Documentation and Instruments

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	NOK	Re-work	Signature/Date (Operations)	Signature/Date (Quality)
	TC1	M1	M2	M3	M4	TC2							
DT00000223319	X						V30		OK		N/A	E 23/04/24	A 23/04/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Validation	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
MEASURING TAPE	GIBTA0378	22/04/2025	OK		E 23/04/24	A 23/04/24
TUBULAR	12062-2 GIBS00596	2025/02/19	OK		E 23/04/24	A 23/04/24
COMBINATION SQUARE	21/01/2024	21/01/2024	OK		E 23/04/24	A 23/04/24

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
WELDING WIRE 308LS	E021880	MIG	OK		E 23/04/24	A 23/04/24
ER 308 L	14343-A-WPFL	TIG	OK		E 23/04/24	A 23/04/24



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II - Control Activities of Production

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NG	Rework	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° DT00000223319	DT00000223319	OK			23/04/24	23/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	OK			23/04/24	23/04/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 DTD0000210675	OK			23/04/24	23/04/24
04	N/A	Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	OK			23/04/24	23/04/24
05	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658	OK			23/04/24	23/04/24
06	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: Temperature Min - Max (1) 10°C - 35°C Relative humidity Min - Max (1) 25% - 80%	Sealant Batch No: 158 70-83 Exp Date: 1/05/24 Actuals Temperature: 21°C Humidity: 60%	OK			23/04/24	23/04/24
07	N/A	Verification of sealant application in regions of roof and sideframe finishers.	Sealant must be: -Applied straight and even (1.5mm) -Free of gaps, cracks, damage and debris (flashes, dirt, dust) Refer to Annexure B	OK			23/04/24	23/04/24

GIBELQ

2024-04-22

INDUSTRIAL QUALITY
MAINLINE



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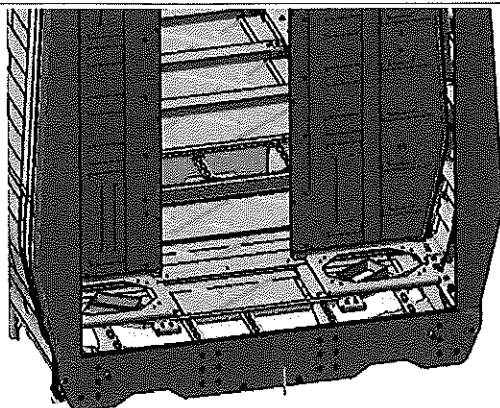
Date:

06/11/2023

Project: PRASA

SI.CB1230.324.V29

VIEW A



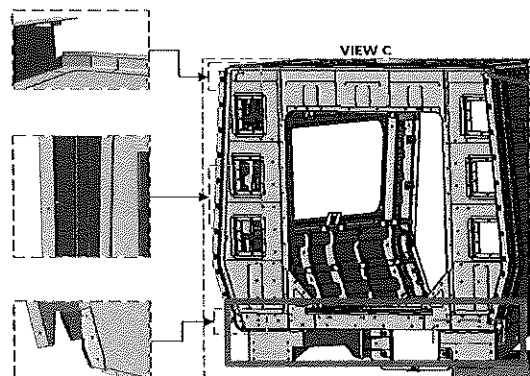
**END 1
SEALANT**

OPERATOR
(Name & sign):

Boitumelo (LHS) *[Signature]*

OPERATOR
(Name & sign):

Boitumelo (RHS) *[Signature]*



OPERATOR
(Name&sign):

Leroy *[Signature]*

OPERATOR
(Name&sign):

Leroy *[Signature]*

OPERATOR
(Name&sign):

Leroy *[Signature]*

GIBELQ

2024 -04- 22

INDUSTRIAL QUALITY
MAINLINE



DT00000223319 Carshell Assembly TC

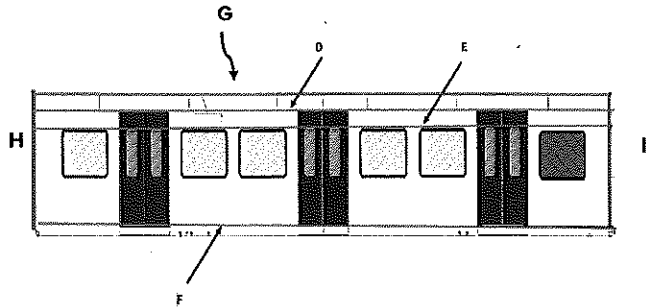
Rev.
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Date-

06/11/2023

Project: PRASA

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

Operator (Name & sign) :

(D) LHS F G/H I top

(E) RHS

Operator (Name & sign) :

Sihle

Sihle

Operator (Name & sign) :

(F)

Tshendo

Operator (Name & sign) :

Tshendo

Tshendo

Operator (Name & sign) :

(H I) Bottom

DE, G HE

Operator (Name & sign) :

Boltumelo

Boltumelo

GIBELQ

2024-04-22

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MAINLINE



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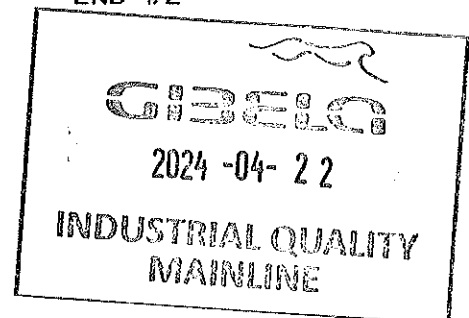
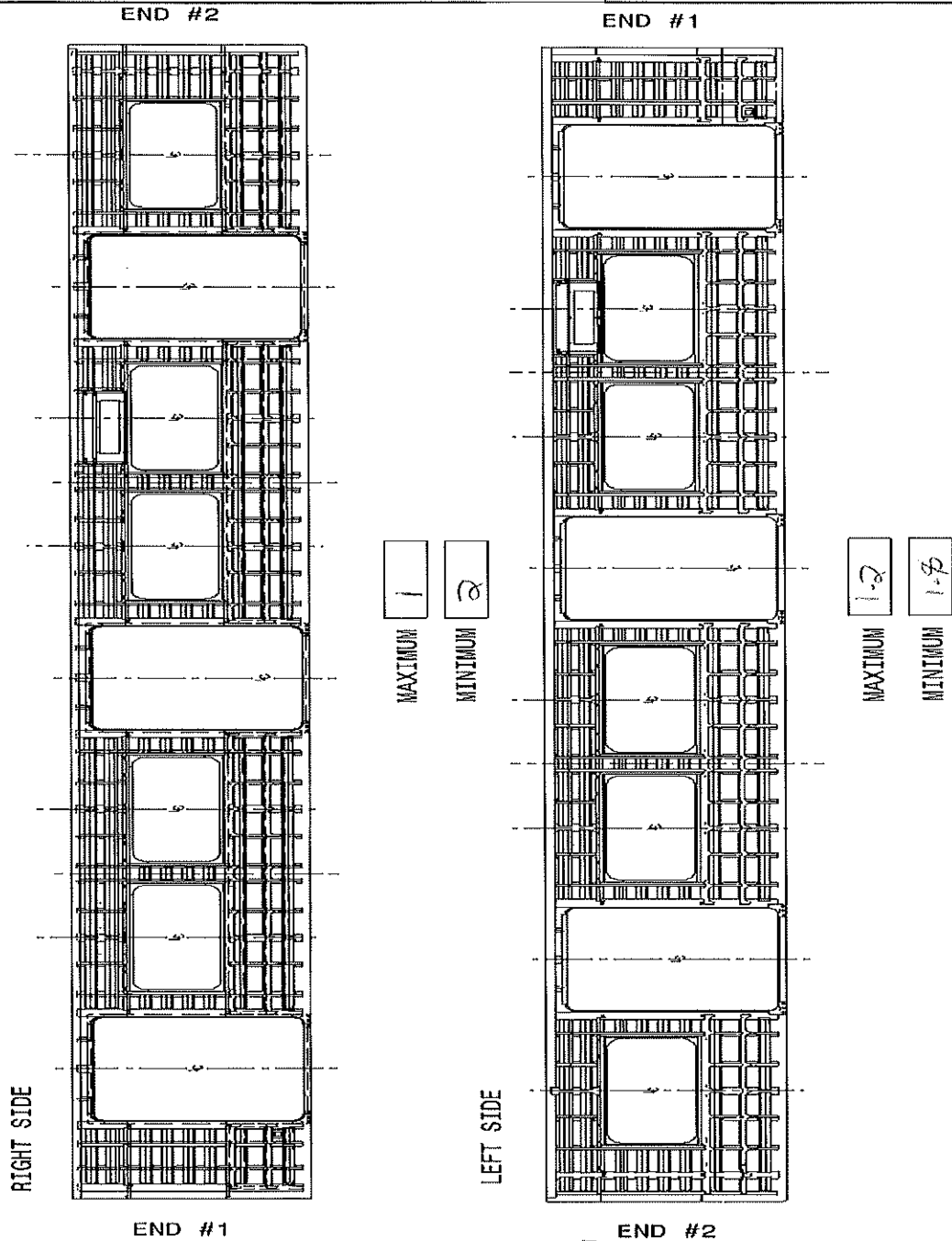
Date-

06/11/2023

Project: PRASA

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





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Date-

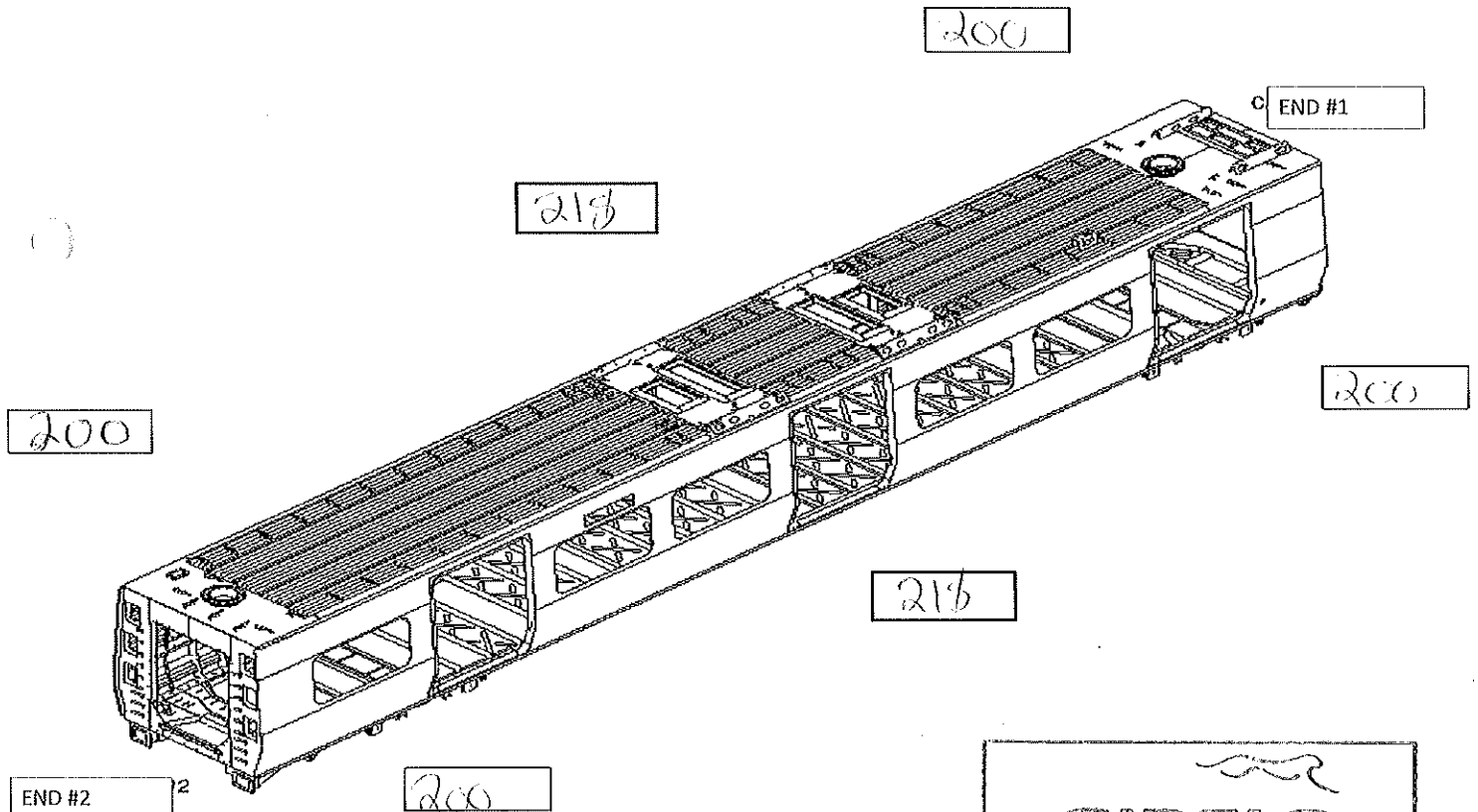
06/11/2023

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Specifications of Details for CBS measurement CB1230

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



MEASURED CAMBER VALUES

RIGHT \rightarrow
LEFT \leftarrow

GIBELQ

2024-04-22

INDUSTRIAL QUALITY
MAINLINE



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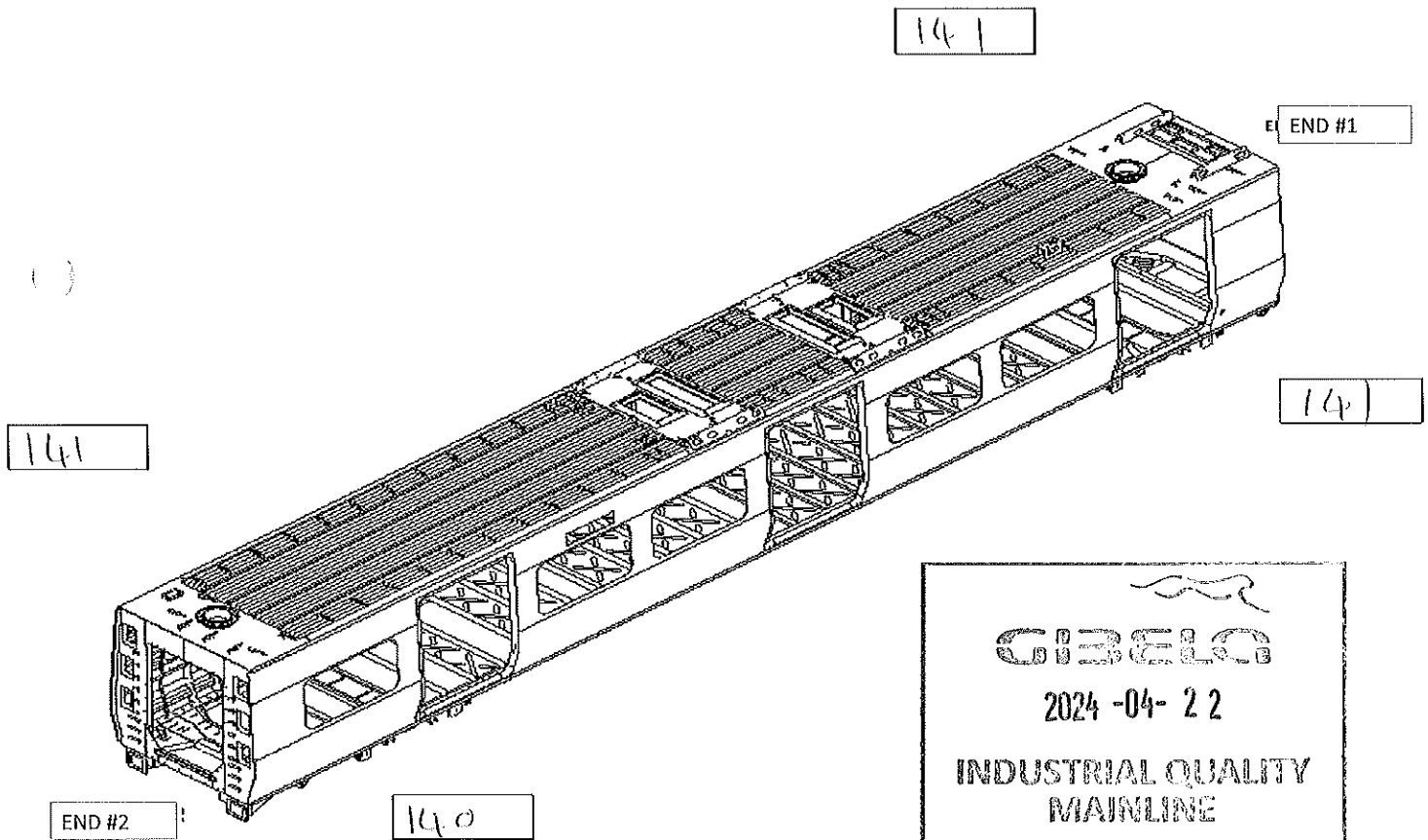
Date-
06/11/2023

Project: PRASA

SI.CB1230.324.V29

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.



MEASURED TWIST VALUES END 1

LATERAL

0

LONGITUDINAL

1

1

MEASURED TWIST VALUES END 2

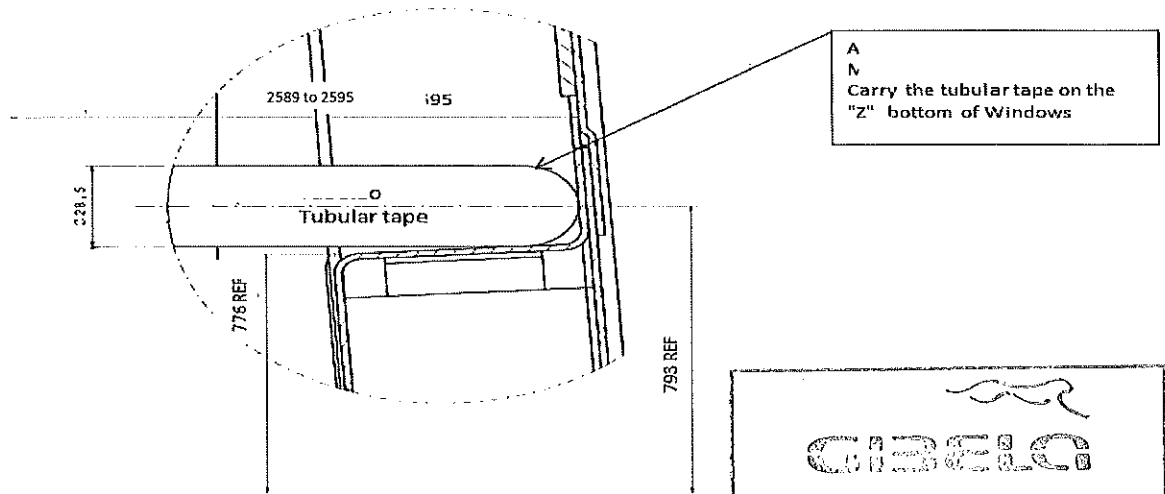
LATERAL

1

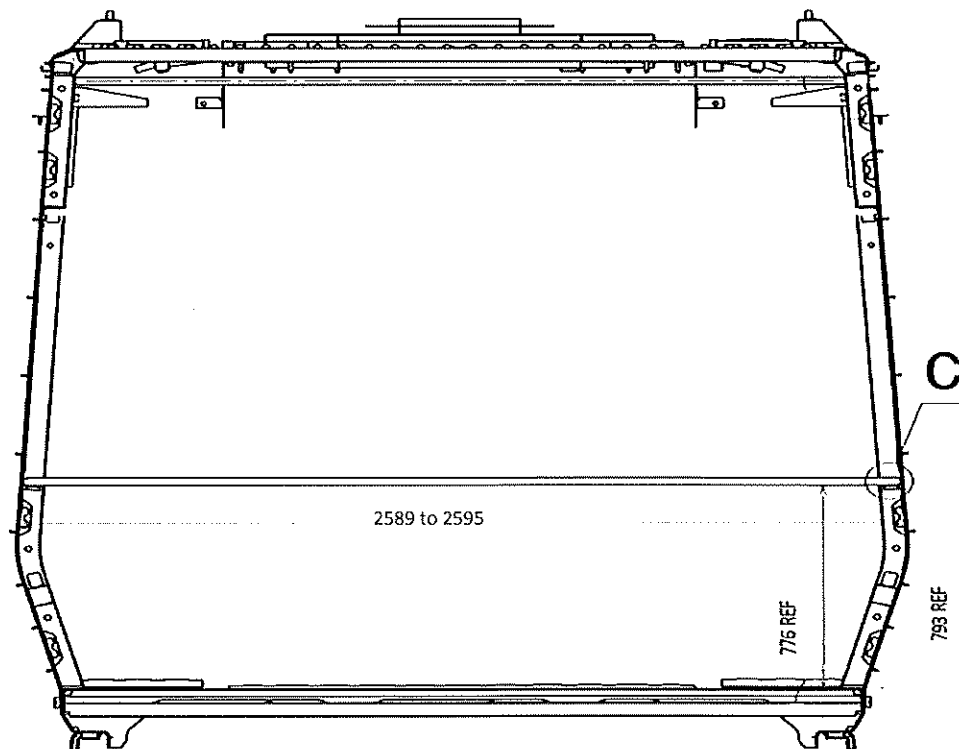
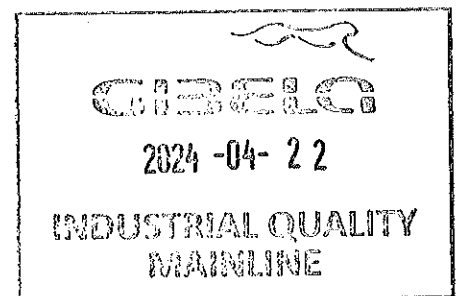
LONGITUDINAL

0

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



Detail C





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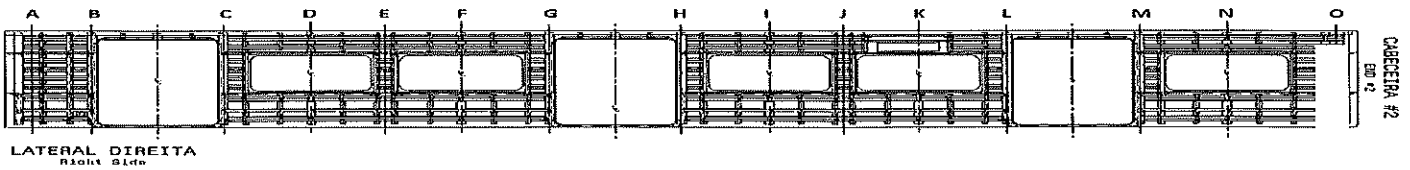
Date-

06/11/2023

Project: PRASA

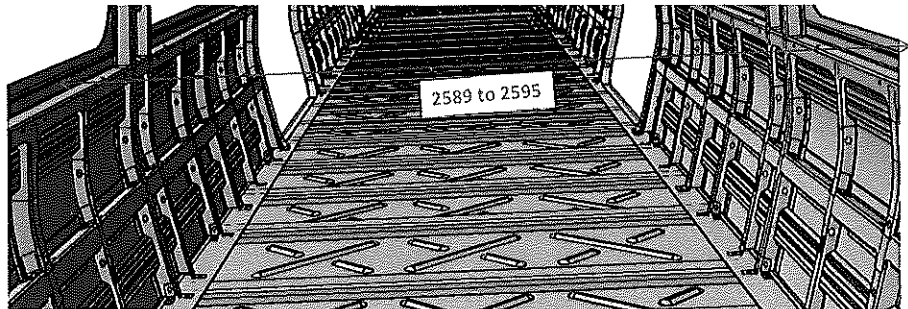
SI.CB1230.324.V29

Specifications of Details for CBS measurement



2589 to 2595mm

A	2594
B	2594
C	2594
D	2596
E	2596
F	2596
G	2590
H	2594
I	2596
J	2595
K	2596
L	2592
M	2594
N	2597
O	2599



Threshold verification

Nominal value :38

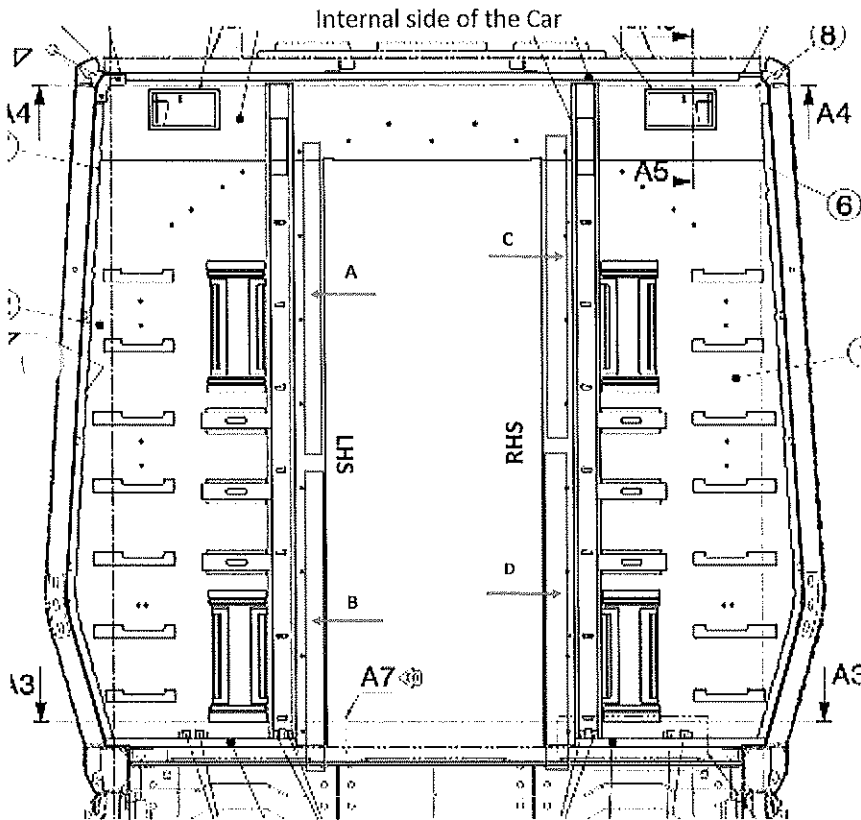
Door 1		Door 2		Door 3	
L	R	L	R	L	R
38	38	38	38	38	38
Door 4		Door 5		Door 6	
L	R	L	R	L	R
38	38	38	38	38	38

BOILER MAKER: mm THAPELO MelindaWELDER: ZARILE Anna

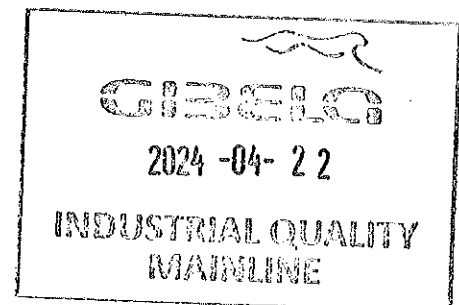
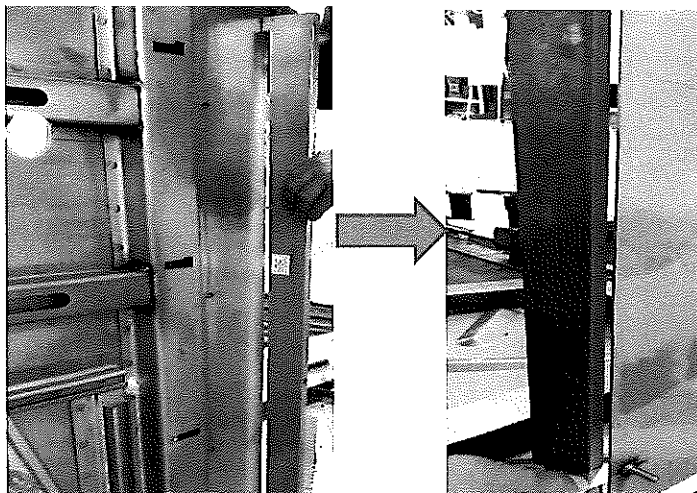
Specifications of Details for CBS measurement

Measure the flatness on the Cab Fire Barrier after installation and welding. Measure positions A, B, C and D using 1000mm flatness ruler and taper gauge.

Specified Maximum Flatness deviation on Cab Fire Barrier = 2mm



Measured Values			
	Minimum	Maximum	Deviation
A	11.9	12.0	0.2
B	2.0	12.0	0
C	8.1	8.2	0.1
D	4.5	10.3	1





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Dye penetrant test

Dye-penetration test to be performed by quality personnel



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

II.2 - Check List REX**Check List Items**

Item	Picture/Drawing	Description	Criteria /Record	OK	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					



2024 -04- 22

INDUSTRIAL QUALITY
MAINLINE



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Self Inspection - Final Result

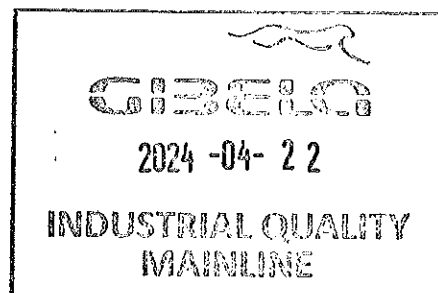
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	GO	If activities are not complete, the missing activities must not impact the next stage!		23/04/24	KHOI	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)		23/04/24	Andani	
	NO GO	There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)				
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)				

In case of "NO GO", describe blocking problems

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

Item	Description	Action	Responsible	Due date	Status

Operations



Quality

