

CABIN STRUCTURE
QUALITY CARD

CAB No.: CAB 4 4 7

WEIGHT: 14 88 Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Regulus	5/10/14	17847 104285 01	C149402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Regulus	19/10/14	178822 104610 01	C10272	
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Regulus	24/10/14	178488 104640 01	P300091	
RCS 355	20 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Regulus	12/10/14			
RCS 355	30 mm					

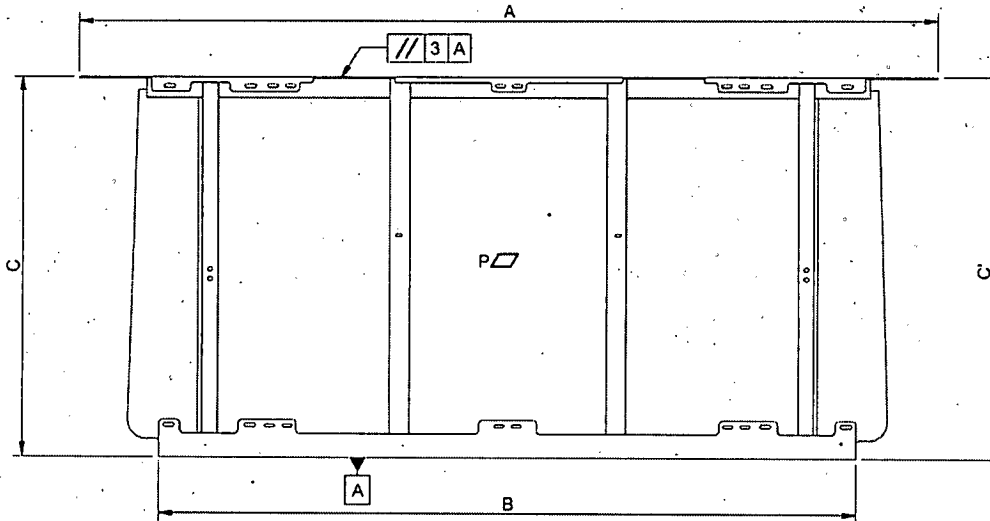
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Regulus	8/10/14	178489 104640 01	VHC 35578	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Regulus	14/10/14	175569 104410 01	F107908 VHC 28402	
RCS 450	6 mm					
RCS 450	6 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Regulus	22/11/14	175569 102206 01	C207466 VHS58432	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

Cabin Roof Assembly: GN002839


Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	TYLAN DAVIDS	Assembly Date:	20 24/02/27	
Sign:		Wire Batch No.:	107238201	




Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	LEON	Sign:		Date: 20 24/02/27

Dimensional Control

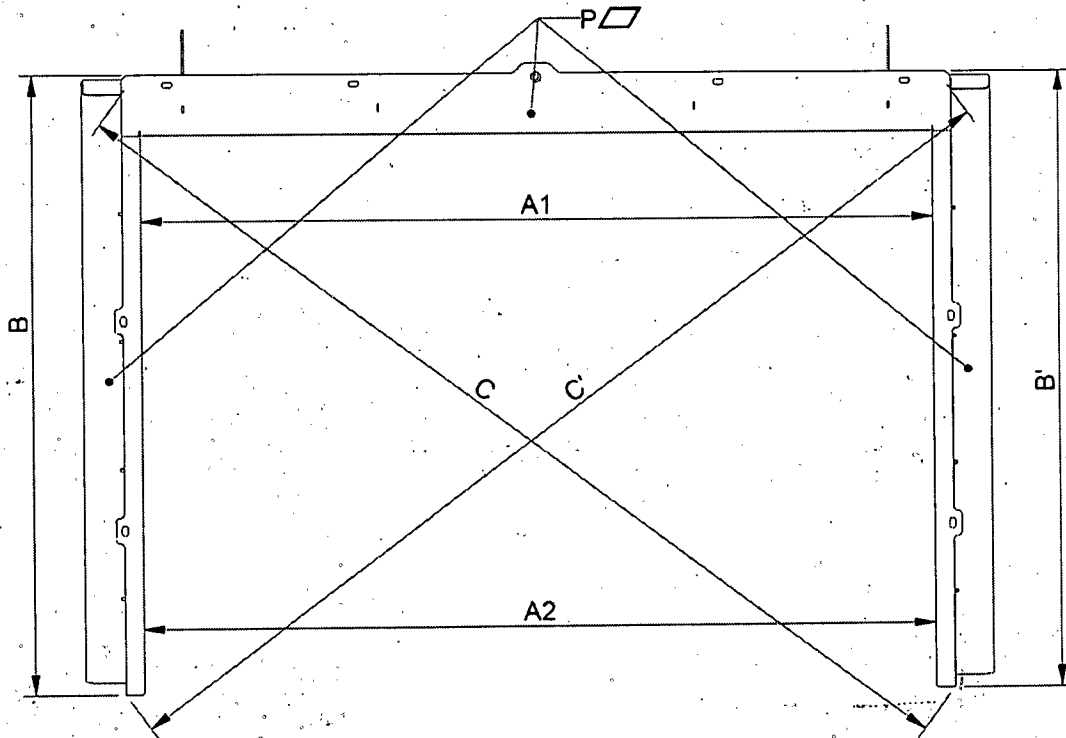
Rep	Toler.	Dimension measured		Measuring Equipment	Observations	
A	2216	+5/-0	2216	Tape Measure	Accepted	
B	1800	± 4	1800		Accepted	
C	976	+2/-3	976		Accepted	
QC Inspector:		LEON		Sign:		Date: 20 24/02/27

Geometrical Control

Nature of Checks		Dimension Measured	Measuring Equipment	Observations		
Planarity P	6 mm	P 0.300	Ruler	Accepted		
//	3	A 0.800	Set Square	Accepted		
QC Inspector:		LEON		Sign:		Date: 20 24/02/27

Cabin Front Frame Assembly: GN002840


Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	No
Operator:	Bambelo Genua	Assembly Date:	20/02/13	
Sign:	<i>[Signature]</i>	Wire Batch No.:	7202152	



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 EN ISO 10042		Confirmed	Yes	✓	No
QC Inspector:	Leon	Sign:	<i>[Signature]</i>	Date:	20/02/27

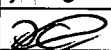
Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	1910	± 2	1912		Tape Measure	Ausphe	
A2	1910		1911			Ausphe	
B	1475	± 1	1475	1475		Ausphe	
C	Diagonals C - C' ≤ 3		2476	2475		Ausphe	
QC Inspector:		LEON		Sign:		Date:	20_24/_02/_27

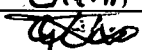
Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P : Planeity	4 mm	Pu880	Ruler	Ausphe
QC Inspector:		Leon	Sign:	
			<i>[Signature]</i>	Date: 20/02/27

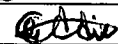
Cabin LHS/RHS Wing Mirror Plate Assembly: GN002846/GN002844

Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Xander	Assembly Date:	2024/02/19			
Sign:		Wire Batch No.:	2202152			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	2024/02/15			
Sign:		Wire Batch No.:	2202152			

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	2024/02/15			
Sign:		Wire Batch No.:	2202152			

Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078

Confirmed

Yes

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No

Operator:

Glenn

Assembly Date:

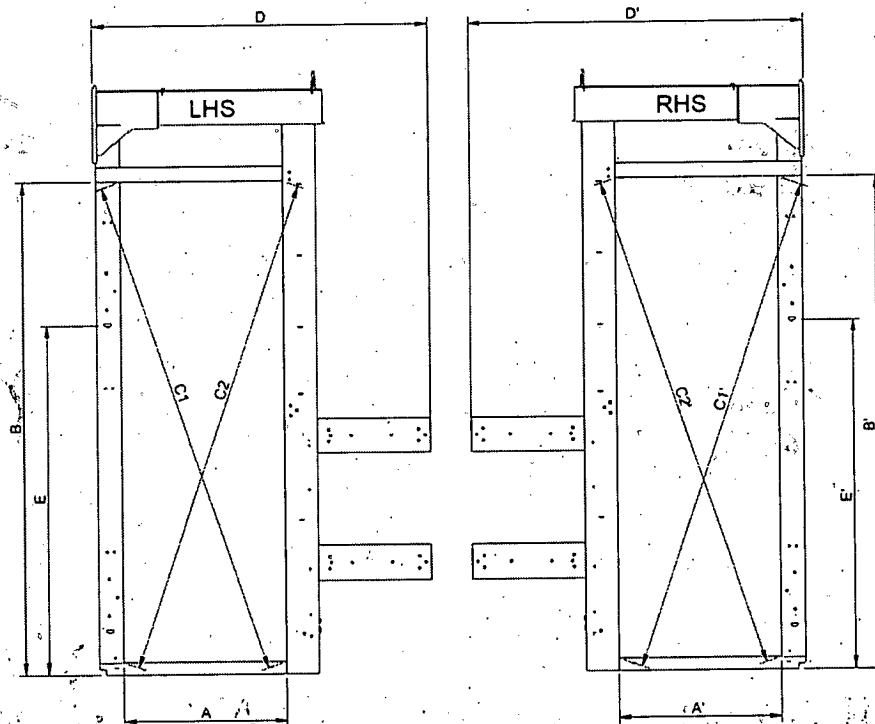
20 24/02/16

Sign:

[Signature]

Wire Batch No.:

2202152



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042

Confirmed

Yes

☒

No

QC Inspector:

Leow

Sign:

[Signature]


Date:

20 24/02/20

Dimensional Control

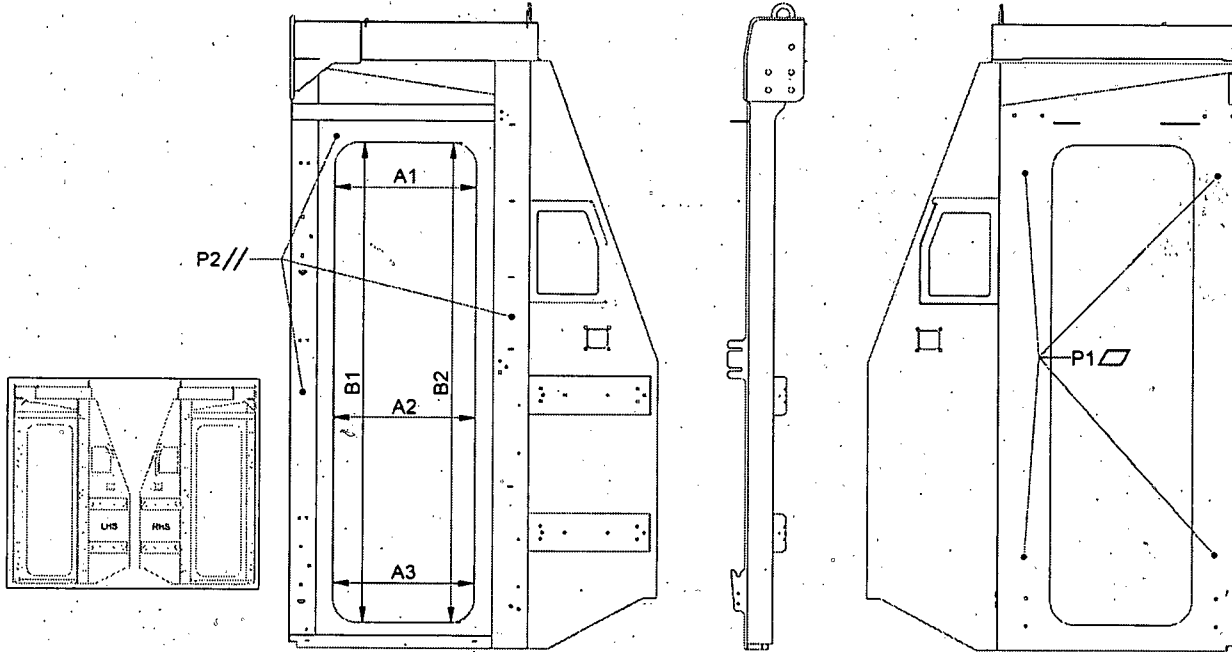
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	695	697	Tape Measure	Acceptable
B	2086	+1/-3	2086	2087		Acceptable
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2154	2154		Acceptable
C1 - C2			2153	2151		Acceptable
D	1438	+2/-3	1436	1436		Acceptable
E			1483	1484		Acceptable
QC Inspector:		Leow	Sign:		<i>[Signature]</i>	Date: 20 24/02/20

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations	
P1 : planeity of 2 edges	4 mm	Pass	Ruler	Acceptable	
QC Inspector:	Leow	Sign:		Date:	20 24/02/20

Cabin LHS/RHS Side Assembly: GN002838/GN002837

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	<i>Xander</i>	Assembly Date:	2024/02/20		
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152		



Welding Control


Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	LEON	Sign:	<i>[Signature]</i>	Date:	2024/02/27

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	558	559	Tape Measure	Accept
A2			589	559		Accept
A3			589	560		Accept
B1	1900	± 2	1898	1898		Accept
B2			1898	1898		Accept

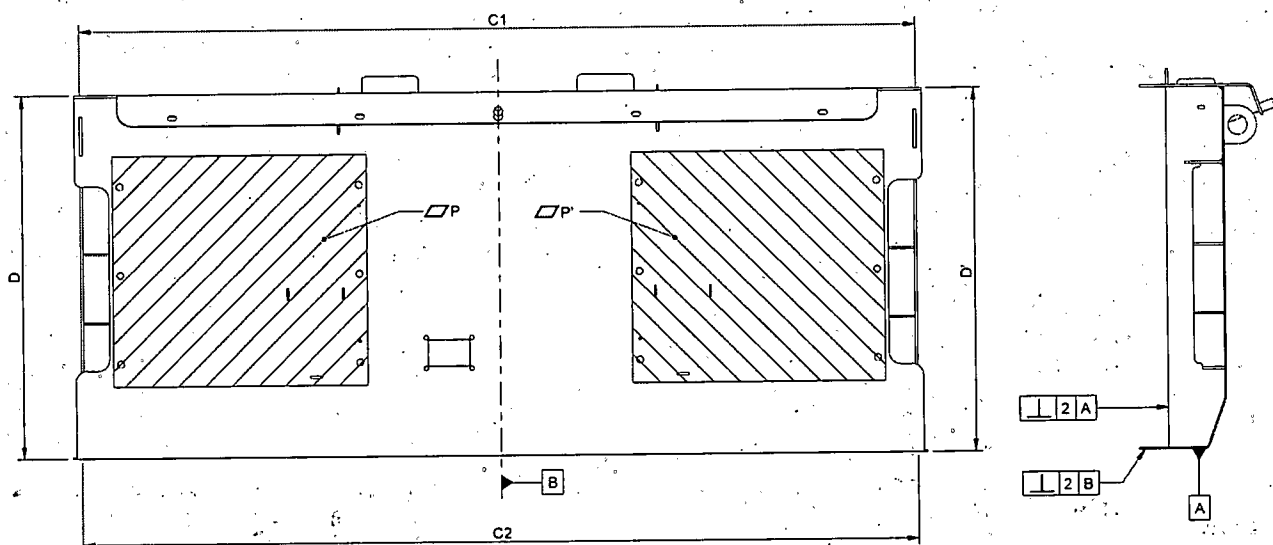
QC Inspector:	LEON	Sign:	<i>[Signature]</i>	Date:	2024/02/27
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Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations	
P1 : Planeity	4 mm	Pass	Ruler	Accept	
P2 : Planeity	2 mm	Pass	Ruler	Accept	
QC Inspector:	LEON	Sign:		Date:	2024/02/27

Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	BEVAN J. DAUENHILL	Assembly Date:	2024/02/27	
Sign:		Wire Batch No.:	2202152	



Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	LEON	Sign:		Date: 2024/02/27

Dimensional Control

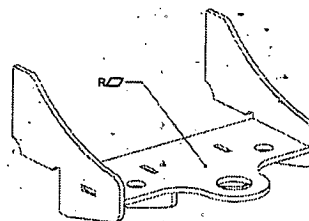
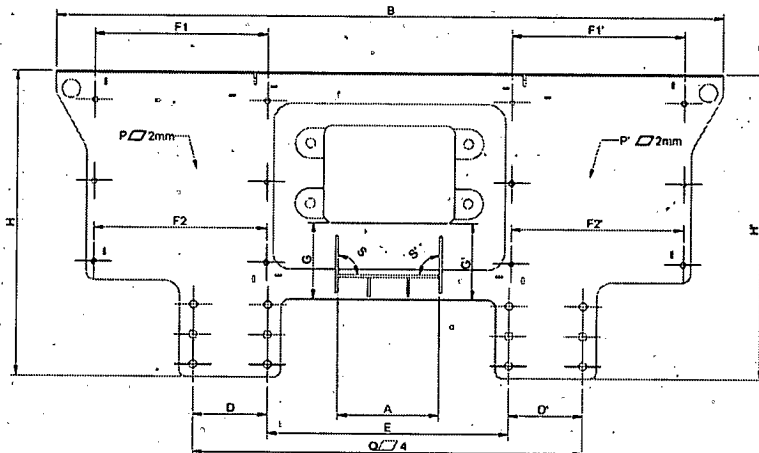
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2213	2294	Tape Measure	Acceptable Acceptable
D / D'	956	± 2	956	956		
QC Inspector:	LEON		Sign:		Date:	2024/02/27

Geometrical Control

Nature of Checks			Dimension Measured	Measuring Equipment	Observations
Planarity P / P'	2 mm		Passes	Ruler	Acceptable
Perpendicularity	2	A	Passes	Set Square	Acceptable
	2	B	Passes	Set Square	Acceptable
QC Inspector:	LEON		Sign:		Date: 2024/02/27

Cabin Front Headstock Assembly: GN002841


Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	T.K Booth	Assembly Date:	2024/02/23			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	LEON	Sign:	<i>[Signature]</i>	Date:	2024/02/22	

Dimensional Control

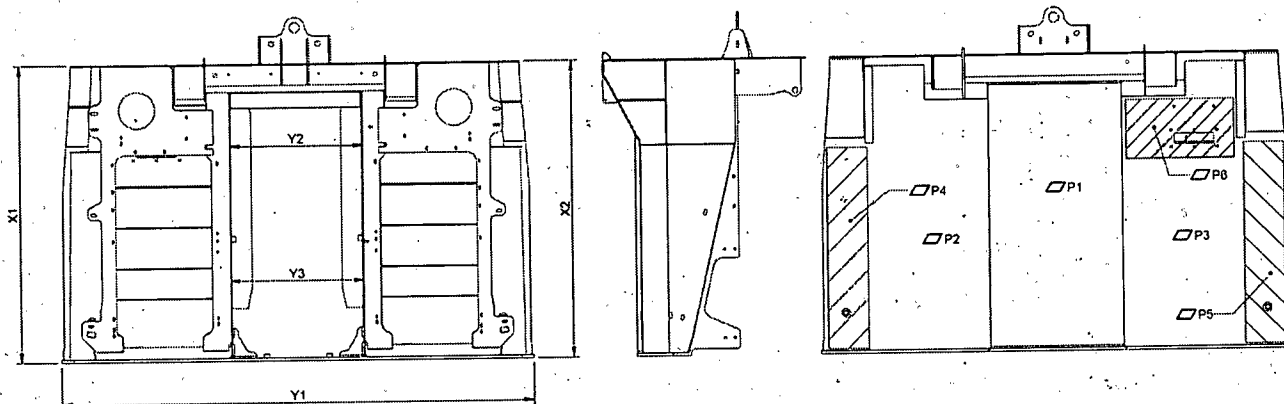
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	± 1	340		Tape Measure	Acceptable
B	2240	± 4	2244			Acceptable
D / D'	250	± 1	251	251		Acceptable
E	808	± 2	808			Acceptable
F1 / F1'	580	± 1	581	581		Acceptable
F2 / F2'			581	581		Acceptable
G / G'	258	± 1	259	259		Acceptable
H / H'	1019	± 2	1020	1020		Acceptable
QC Inspector:		Leon	Sign:			Date: 2024 / 02 / 22

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
O: Planeity of global assembly	4 mm	Ruler	Acceptable
P / P': Planeity	2 mm	Ruler	Acceptable
Q: Planeity Surface of Supports	4 mm	Ruler	Acceptable
R: Planeity Coupler Support	2 mm	Ruler	Acceptable
S: Perpendicularity coupler	1mm	Square	Acceptable
QC Inspector:	LEON	Sign:	<i>[Signature]</i>
Date:	2024/02/22		

Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator: <i>Michael Wood</i>	Assembly Date:		20 <u>24</u> / <u>02</u> / <u>26</u>	
Sign: <i>[Signature]</i>	Wire Batch No.:		22 02152	



Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector: <i>Leon</i>	Sign: <i>[Signature]</i>	Date:	20 <u>24</u> / <u>02</u> / <u>26</u>	

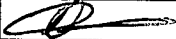
Dimensional Control

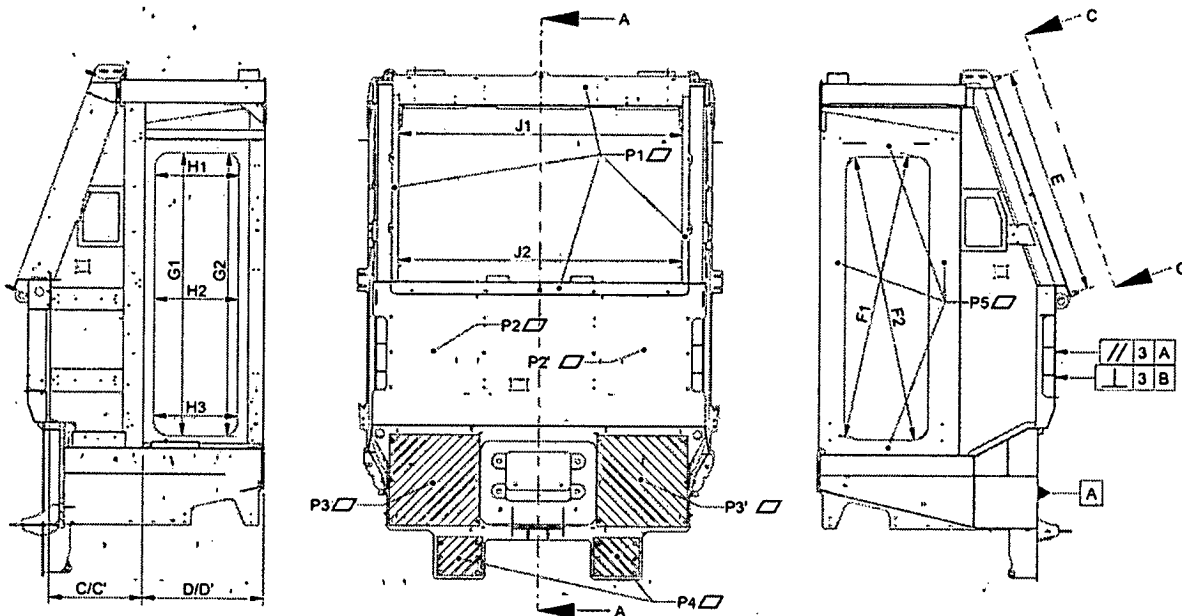
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1486	1486	Tape Measure.	<i>Acceptable</i>
Y1	2354	± 3	2384			<i>Acceptable</i>
Y2 / Y3	666	± 1	668	668		<i>Acceptable</i>
QC Inspector: <i>Leon</i>		Sign: <i>[Signature]</i>	Date:		20 <u>24</u> / <u>02</u> / <u>26</u>	

Geometrical Control


Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Ruler	<i>Acceptable</i>
P2 / P3 : Planeity	4 mm	Ruler	<i>Acceptable</i>
P4 / P5 : Planeity	2 mm	Ruler	<i>Acceptable</i>
P6 : Planeity	2 mm	Ruler	<i>Acceptable</i>
QC Inspector: <i>Leon</i>	Sign: <i>[Signature]</i>	Date:	20 <u>24</u> / <u>02</u> / <u>26</u>

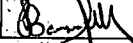
Cabin Structure Assembly: GN002834

Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLOEM	Assembly Date:	20 24 / 02 / 21			
Sign:		Wire Batch No.:	220252			



Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed		Yes		✓ No
QC Inspector:		Leon		Sign:		A		Date: 20 ²⁴ / 03 / 01	
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	624	624	Acceptable				
D / D'	813	± 2,5	812	812	Acceptable				
E	1531.5	± 3	1530		Acceptable				
G1 / G'1	Height 1900	+1	1897	1897	Acceptable				
G2 / G'2		-3	1898	1899	Acceptable				
H1 / H'1	Width 560	+1	557	557	Acceptable				
H2 / H'2		-3	558	559	Acceptable				
H3 / H'3			560	559	Acceptable				
F1 / F'1	Diagonals 1939		1935	1935	Acceptable				
F2 / F'2			1936	1933	Acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	↓	2	Acceptable				
J	Gap of Doors	± 1,5	0		Acceptable				
K1 / K2	1515	± 3	1516	1514	Acceptable				
L1 / L2	1996	± 3	1996	1994	Acceptable				
M1 / M'1	2306	± 3	2467	2467	Acceptable				
M2 / M'2			2476	2476	Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2127	2127	Acceptable				
T2 / T'2	2230 Top/Bottom		2230	2231	Acceptable				
Difference	U - U' (3522)	≤ 4mm	3520	3520	Acceptable				
QC Inspector:		Leon		Sign:		A		Date: 20 ²⁴ / 03 / 01	
Geometrical Control									
Nature of checks				Toler.	LHS / Dimension Measured / RHS				
P1 / P'1	Planeity			2 mm	PASSED		Acceptable		
P2 / P'2	Planeity			2 mm	PASSED		Acceptable		
P3 / P'3	Planeity			4 mm	PASSED		Acceptable		
P4 / P'4	Planeity			4 mm	PASSED		Acceptable		
P5 / P'5	Planeity			4 mm.	PASSED		Acceptable		
P6 Roof	Planeity			6 With 2m Ruler	PASSED		Acceptable		
Shield	//	3	A	3	PASSED		Acceptable		
Shield	⊥	3	A	3	PASSED		Acceptable		
Door Post	⊥	3	A	Front	PASSED		Acceptable		
				Back	PASSED		Acceptable		
QC Inspector:		Leon		Sign:		A		Date: 20 ²⁴ / 02 / 09	


Cabin Bracket Assembly: GN002833					
Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	CHARL BLOEM	Assembly Date:	20 24 / 02 / 28		
Sign:		Wire Batch No.:	220252		

Cabin Rivnut Assembly: GN002832					
Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input type="checkbox"/>	No
Operator:	Seamus	Assembly Date:	20 __ / __ / __		
Sign:		Wire Batch No.:			

Shot Blasting				
Shot Blasting Pre-Inspection				
All external threads masked	Confirmed	Yes	<input checked="" type="checkbox"/> No	
Fasteners positioned in all Rivnuts and Bosses	Confirmed	Yes	<input checked="" type="checkbox"/> No	
Masked as per GMS-SOS-GIBELA-CABIN-001	Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:	DAVID	Sign:		
Date:	2024/03/26			
Record of Shot Blasting				
Operator:		Date:	2024/03/26	
Start Time:	08 H02	End Time:	16 H50	
Temperature ($\geq 15^\circ$):	19-05 °C	Humidity ($\leq 75\%$):	67-08%	
Shot Blasting Self-Inspection				
Interior of Cabin: Sa 1 - Light Stripping	Confirmed	Yes	<input checked="" type="checkbox"/> No	
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.	Confirmed	Yes	<input checked="" type="checkbox"/> No	
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping	Confirmed	Yes	<input checked="" type="checkbox"/> No	
	Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:	DAVID	Sign:		
Date:	2024/03/26			
Shot Blasting Cleaning				
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:		Sign:		
Date:	2024/03/26			
Shot Blasting Control				
Temperature $\geq 15^\circ$:	20-02 °C	Humidity $\leq 75\%$:	69-09%	
Internal Roughness $3.2 \leq Ra \leq 12.5$	8.441	External Roughness $3.2 \leq Ra \leq 12.5$	7.942	
QC Inspector:	LEON	Sign:		
Date:	26/03/24			

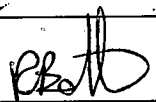
RA 6.183 - RZ 37.535
 RA 4.639 - RZ 29.062
 RA 5.368 - RZ 32.917
 RA 6.119 - RZ 36.313
 RA 6.658 - RZ 37.260
 RA 7.465 - RZ 45.234
 RA 7.282 - RZ 41.518
 RA 7.371 - RZ 42.761
 RA 6.047 - RZ 38.984
 RA 8.441 - RZ 44.246

RA 5.324 - RZ 32.173
 RA 4.819 - RZ 28.372
 RA 5.658 - RZ 32.400
 RA 6.982 - RZ 38.321
 RA 7.942 - RZ 49.946
 RA 7.789 - RZ 40.045
 RA 7.590 - RZ 36.685
 RA 5.531 - RZ 32.932
 RA 6.184 - RZ 33.806
 RA 5.292 - RZ 39.992

Record of Priming									
Start Time:		19:00		End Time:		21:00			
Temperature $\geq 15^{\circ}$:		20°C		Humidity $\leq 75\%$:		70%			
Paint Batch No.:		7978267		Paint Expiry Date:		06/25			
Hardener Batch No.:		7331119		Hardener Expiry Date:		01-11-24			
Desolvation Start Time:		21:00		Desolvation End Time:		21:15			
Stoving Start Time:		21:15		Stoving End Time:		22:15			
Stoving Temp:		60°C							
Operator:		Ntuthuko		Sign:		Ntuthuko			
Date:		20/03/26							
Priming Control									
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front			
1: 88.0	5: 54.2	1: 62.9	5: 47.7	1: 43.7	5: 91.3	1: 73.7	5: 56.3		
2: 79.4	6: 53.8	2: 71.1	6: 40.2	2: 81.2	6: 78.8	2: 46.2	6: 41.9		
3: 65.8	7: 50.1	3: 41.8	7: 79.3	3: 61.9	7: 61.8	3: 59.8	7: 76.4		
4: 75.1	8: 59.7	4: 43.9	8: 63.2	4: 52.7	8: 55.2	4: 64.4	8: 51.2		
Min:	53.8	Min:	40.2	Min:	43.7	Min:	41.9		
Max:	88.0	Max:	79.3	Max:	91.3	Max:	76.4		
Average:	65.8	Average:	56.3	Average:	65.2	Average:	58.0		
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside			
1: 69.8	5: 63.2	1: 86.1	5: 67.9	1: 81.6	5: 77.9	1: 70.4	5: 57.2		
2: 65.0	6: 72.7	2: 70.4	6: 44.1	2: 64.0	6: 64.3	2: 86.0	6: 59.7		
3: 54.2	7: 79.1	3: 78.2	7: 64.5	3: 79.9	7: 46.1	3: 58.7	7: 55.3		
4: 49.3	8: 55.6	4: 78.3	8: 54.1	4: 47.2	8: 87.3	4: 60.9	8: 44.1		
Min:	49.3	Min:	44.1	Min:	47.2	Min:	55.3		
Max:	79.1	Max:	86.1	Max:	81.6	Max:	88.0		
Average:	63.6	Average:	68.0	Average:	62.3	Average:	64.0		
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS			
1: 68.0	5: 47.2	1: 64.1	5: 72.4	1: 86.4	5: 79.2	1: 67.6	5: 63.8		
2: 51.8	6: 71.4	2: 63.8	6: 85.9	2: 77.0	6: 65.1	2: 81.4	6: 71.9		
3: 81.7	7: 67.3	3: 55.3	7: 63.3	3: 79.8	7: 81.6	3: 72.9	7: 64.3		
4: 65.2	8: 60.6	4: 64.9	8: 62.6	4: 78.1	8: 76.9	4: 65.7	8: 80.2		
Min:	47.2	Min:	55.3	Min:	65.1	Min:	63.8		
Max:	81.7	Max:	85.9	Max:	86.4	Max:	80.2		
Average:	64.2	Average:	66.5	Average:	78.0	Average:	71.0		
Primer has been inspected and is free of defects				Confirmed		Yes <input checked="" type="checkbox"/>		No <input type="checkbox"/>	
QC Inspector:		Zethile		Sign:					
Date:		27 Mar 2024							

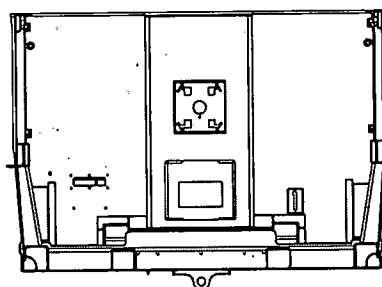
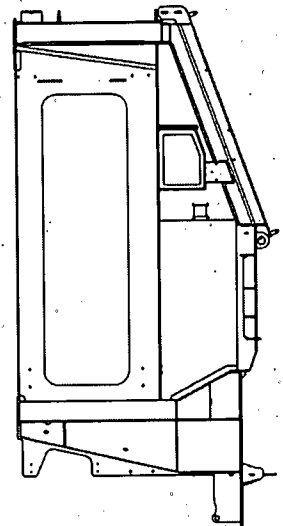
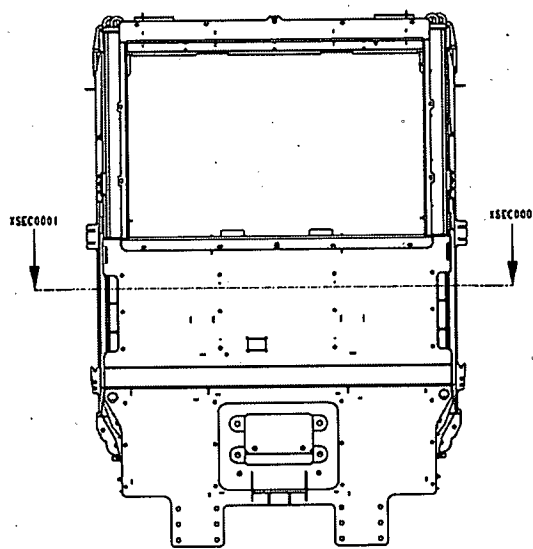
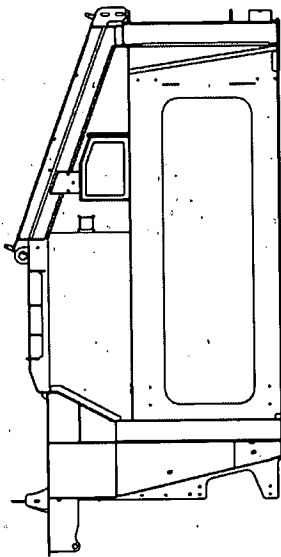
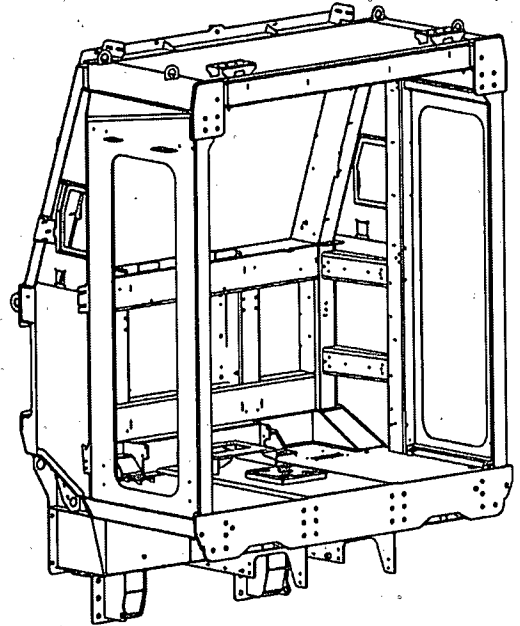
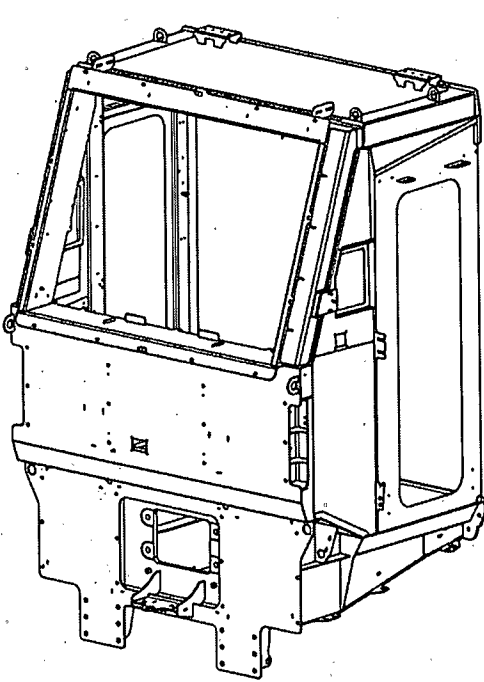
Record of Painting NCSS3010 R90B					
Start Time:		09:00		End Time:	
Temperature $\geq 15^{\circ}$:		27°C		Humidity $\leq 75\%$:	
Paint Batch No.:		8156403		Paint Expiry Date:	
Hardener Batch No.:		7502115121		Hardener Expiry Date:	
Desolvation Start Time:		10:00		Desolvation End Time:	
Stoving Start Time:		10:15		Stoving End Time:	
Stoving Temp:		60°C			
Operator:		musa		Sign:	
Date:		20 24/03/21			
Painting NCSS3010 R90B Control					
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)	
1: 139	5: 124	1: 113.6	5: 159.6		
2: 113.6	6: 88	2: 107.7	6: 141.8		
3: 108.2	7: 138.2	3: 83.8	7: 149.6		
4: 80	8: 124.9	4: 144.3	8: 154.3		
Min:	80	Min:	83.8		
Max:	139	Max:	154.3		
Average:	111.73	Average:	131.8		
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed	Yes
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	39.6
QC Inspector:		Reece		Sign:	
Date:		27/04/24			

Record of Painting Blue NCSS1565 B			
Start Time:	12:00	End Time:	13:00
Temperature $\geq 15^{\circ}$:	30 $^{\circ}$ C	Humidity $\leq 75\%$:	37%
Paint Batch No.:	8176318	Paint Expiry Date:	02/02/25
Hardener Batch No.:	7502115 121	Hardener Expiry Date:	12/24
Desolvation Start Time:	13:00	Desolvation End Time:	13:15
Stoving Start Time:	13:15	Stoving End Time:	14:15
Stoving Temp:	60 $^{\circ}$ C		
Operator:	muso.	Sign:	muso.
Date:	20 24/03/21		
Painting Blue NCSS1565 B Control			
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS	
1: 124.6	5: 161.8	1: 101.3	5: 126.9
2: 106.9	6: 118.2	2: 120.7	6: 117.8
3: 131.8	7: 107.9	3: 136.9	7: 166.9
4: 108.6	8: 101.3	4: 140.9	8: 105.2
Min:	101.3	Min:	108.2
Max:	161.8	Max:	166.9
Average:	120.1	Average:	127.4
Painting NCSS3010 R90B has been inspected and is free of defects		Confirmed	Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	89.3
QC Inspector:	Reece	Sign:	Reece
Date:	27/04/24		

Record of RAL 7012								
Start Time:		20:00		End Time:		22:00		
Temperature $\geq 15^{\circ}$:		29°C		Humidity $\leq 75\%$:		42%		
Paint Batch No.:		8156853		Paint Expiry Date:		06-02-25		
Hardener Batch No.:		7502115121		Hardener Expiry Date:		12/24		
Desolvation Start Time:		22:00		Desolvation End Time:		22:15		
Stoving Start Time:		22:15		Stoving End Time:		23:15		
Stoving Temp:		60°C						
Operator:		Ntuthuko		Sign:		Ntuthuko		
Date:		20/03/24						
RAL 7012 Control								
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front		
1: 101.3	5: 177.7	1: 99.8	5: 149.8	1: 126.9	5: 186.1	1: 176.9	5: 139.8	
2: 124.6	6: 113.8	2: 108.6	6: 116.8	2: 118.8	6: 107.8	2: 100.7	6: 104.6	
3: 131.8	7: 120.6	3: 124.8	7: 118.6	3: 141.3	7: 163.8	3: 98.6	7: 133.8	
4: 160.9	8: 118.8	4: 140.8	8: 120.6	4: 118.2	8: 116.8	4: 107.9	8: 89.7	
Min:	101.3	Min:	103.6	Min:	107.8	Min:	89.7	
Max:	177.7	Max:	149.8	Max:	186.1	Max:	176.9	
Average:	131.1	Average:	121.8	Average:	134.9	Average:	119	
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside		
1: 118	5: 98.2	1: 155.9	5: 102.6	1: 102.6	5: 124.6	1: 130.8	5: 101.3	
2: 149.8	6: 108.9	2: 104.3	6: 120.8	2: 183.8	6: 112.8	2: 120.8	6: 129.8	
3: 150.3	7: 131.7	3: 186.9	7: 131.9	3: 84.3	7: 170.8	3: 124.6	7: 136.8	
4: 107.6	8: 116.8	4: 196.9	8: 101.3	4: 113.8	8: 102.4	4: 117.8	8: 121.8	
Min:	98.2	Min:	102.6	Min:	102.4	Min:	101.3	
Max:	150.3	Max:	196.9	Max:	183.8	Max:	136.8	
Average:	122.6	Average:	137.5	Average:	124.5	Average:	122.9	
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test				
1: 79.8	5: 131.8	1: 111.3	5: 102.6					
2: 86.9	6: 103.6	2: 113.8	6: 129.8					
3: 120.7	7: 104.9	3: 156.9	7: 109.6					
4: 177.6	8: 109.3	4: 114.9	8: 108.2					
Min:	66.9	Min:	102.6					
Max:	177.6	Max:	156.9					
Average:	111.8	Average:	122.1					
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No	
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	482			
QC Inspector:		Reece		Sign:				
Date:		28/03/24						
SEALING OF CABIN								
All areas where there is no welding has been sealed with SIKA						Confirmed	YES <input checked="" type="checkbox"/>	NO <input type="checkbox"/>
All sealants have been neatly applied along joints						Confirmed	YES <input checked="" type="checkbox"/>	NO <input type="checkbox"/>
SIGN OFF								
CLOCK NO	2400		OPERATOR SIGN	APRILE		DATE	30/02/2024	

REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)

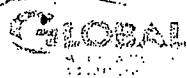


FAULT TRACKING

[illegible]

REMINDERS / COMMENTS

[illegible]



CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	446	Checks Updated:	2021/07/07

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

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

Quality approval for release Signature	CO. NO:	DATE
RECE	2291	28/03/24