
PRASA PROJECT

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET


CONFIDENTIAL INFORMATION

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

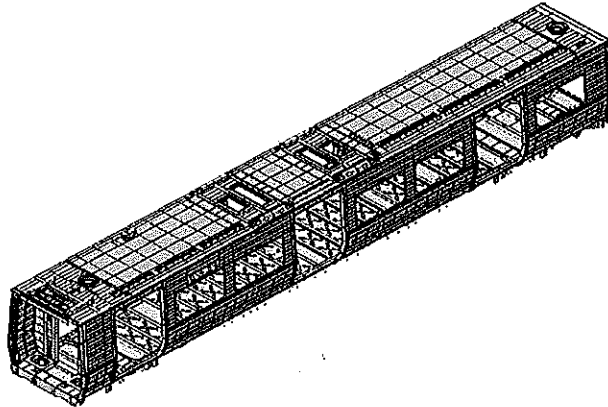
APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?
				TC1	M4	M1	M2	M3	TC2		
DTR30223319/3	AAD0001241033	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 final signature from PME Manager to Quality manager Change	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	2018/06/18
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	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
20	19/04/2020	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi Collins	17/08/2021
			CHECKER	Mpho Mulaudzi	
			REVISED BY	Mpho Mulaudzi	
25	21/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi Collins	21/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlame Amogelang	
			REVISED BY	Mohlame Amogelang	
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023
			CHECKER	Mathapo Kelebone	
			REVISED BY	Mohlame Amogelang	
28	07/11/2023	Addition of welding traceability	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Andani Muthelo	
			REVISED BY	Ntokozi Zwane	
TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
225	TC1	168050 482833	24/04/24	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
----------------	------	----------------------



I - Documentation and Instruments

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
	TC1	TC2	TC3	TC4	TC5	TC6						
DTR30223319/3	X								✓		N/A	

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	3282.3-2	15/03/28	✓			
Laser tape	125425924	08/01/28				
30m tape	CIBTP 0102	18/11/24				




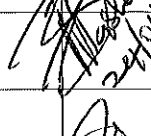
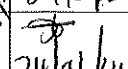
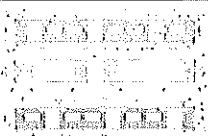

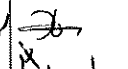

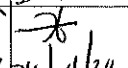
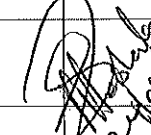
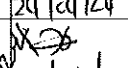
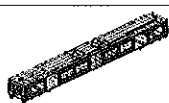

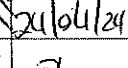
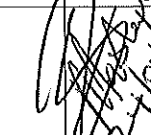
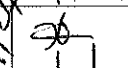
1.3 Consumables


Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
ER308LSI	314018-74097	Mig	✓			
ER308L	299687-70322	Mig	✓			

Signature

07/11/2023

		DTR30223319/3 Carshell Assembly TC		Rev. V28 Date- 07/11/2023	Project: PRASA 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	✓		 24/04/24	 24/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓		 24/04/24	 24/04/24
03		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		 24/04/24	 24/04/24
04	REFER TO ANNEXURE A	Spot Welding inspected and approved according procedure	IND-SAL-WMS-016 e DTD0000210675	✓		 24/04/24	 24/04/24
05	REFER TO ANNEXURE B	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 24/04/24	 24/04/24
06		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 24/04/24	 24/04/24
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	✓		 24/04/24	 24/04/24

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

Welder traceability

Roof ring welds

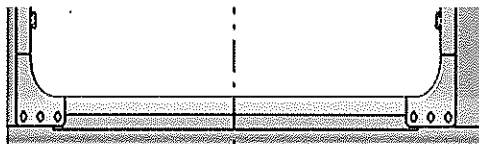


<p style="text-align: center;"><u>LHS</u></p> Boiler maker (Name & Sign): <u>Mthembu [Signature]</u>	<p style="text-align: center;"><u>LHS</u></p> Welder (Name & Sign): <u>ROBERT [Signature]</u>
<p style="text-align: center;"><u>RHS</u></p> Boiler maker (Name & Sign): <u>Justice [Signature]</u>	<p style="text-align: center;"><u>RHS</u></p> Welder (Name & Sign): <u>ROBERT [Signature]</u>

END 1

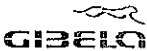
<p style="text-align: center;"><u>LHS</u></p> Boiler maker (Name & Sign): <u>Mthembu [Signature]</u>	<p style="text-align: center;"><u>LHS</u></p> Welder (Name & Sign): <u>ROBERT [Signature]</u>
<p style="text-align: center;"><u>RHS</u></p> Boiler maker (Name & Sign): <u>Justice [Signature]</u>	<p style="text-align: center;"><u>RHS</u></p> Welder (Name & Sign): <u>ROBERT [Signature]</u>

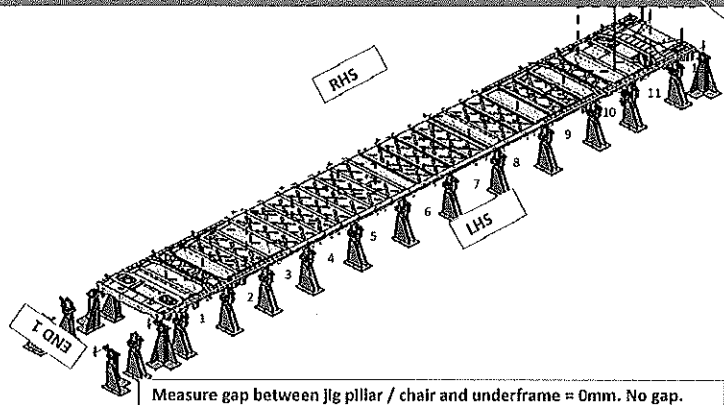
END 2



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

<p style="text-align: center;"><u>RHS</u></p> Boiler maker (Name & Sign): <u>Wing [Signature]</u>	<p style="text-align: center;"><u>RHS</u></p> Welder (Name & Sign): <u>MTHAKOZISI [Signature]</u>
---	---

	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA SI.CB1210.322.V28
		Date- 07/11/2023	
Specifications of Details for CBS measurement			

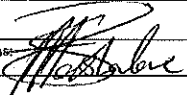


Measure gap between jig pillar / chair and underframe = 0mm. No gap.

Fill in the gap foundon 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: 24/04/24

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: 24/04/24



DTR30223319/3 Carshell Assembly TC

Rev.

V28

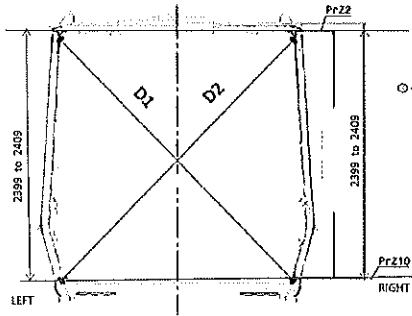
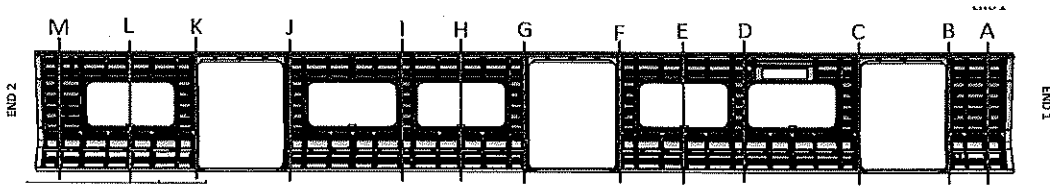
Date-

07/11/2023

Project: PRASA

SI.CB1210.322.V28

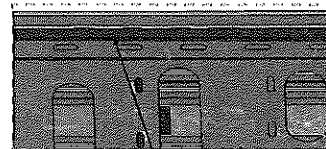
Specifications of Details for CBS measurement




Measurement positions on roof rail and sidewall omega corner.



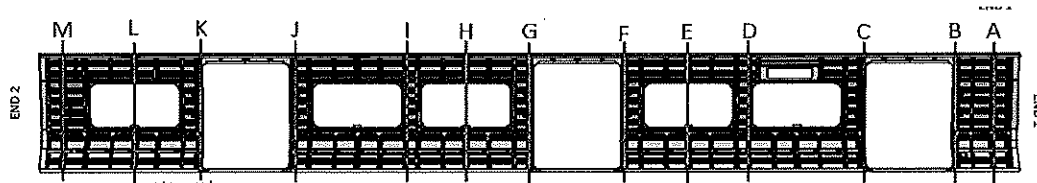
Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.


	DTR30223319/3 Carshell Assembly TC	Rev. V28 Date- 07/11/2023	Project: PRASA SI.CB1210.322.V28
Specifications of Details for CBS measurement			

BEFORE WELDING

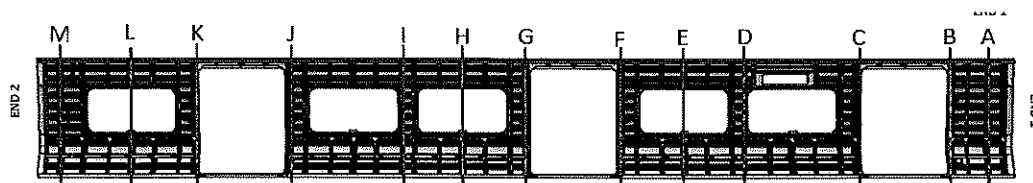


PME: The difference in Height values measured on the LHS and RHS should be $\leq 2\text{MM}$ on each point.

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


	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA SI.CB1210.322.V28
		Date- 07/11/2023	
Specifications of Details for CBS measurement			

AFTER WELDING



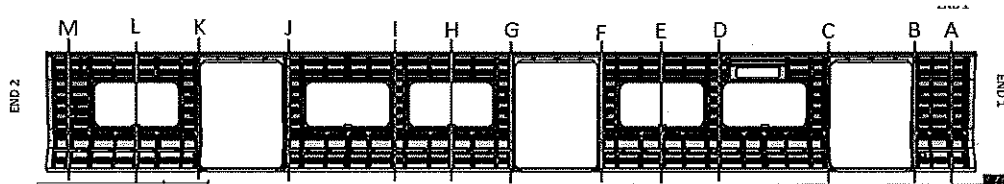
PME: The difference in Height values measured on the LHS and RHS should be $\leq 2\text{MM}$ on each point.

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3263	3265	2	2405	2404	1
B	3294	3293	1	2405	2406	1
C	3295	3295	0	2405	2404	1
D	3266	3265	1	2404	2404	0
E	3264	3266	2	2403	2405	2
F	3296	3293	1	2405	2404	1
G	3295	3297	2	2404	2403	1
H	3265	3265	0	2405	2405	0
I	3266	3267	1	2405	2406	1
J	3295	3295	0	2404	2403	1
K	3296	3297	1	2405	2406	1
L	3265	3266	1	2406	2404	2
M	3296	3298	2	2406	2407	1

	DTR30223319/3 Carshell 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 2271

B 2273

C 2269

D 2270

E 2274

F 2273

G 2270

H 2272

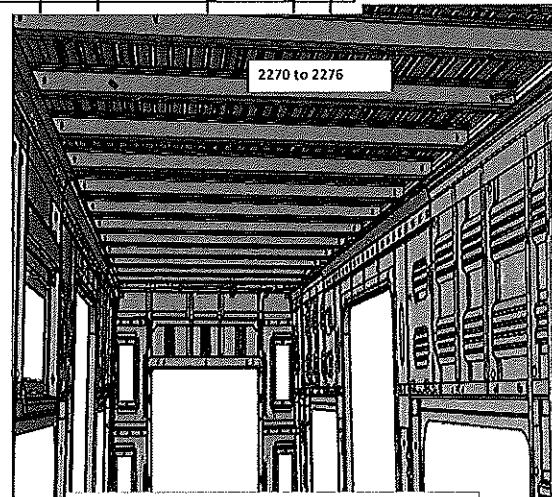
I 2268

J 2271

K 2270

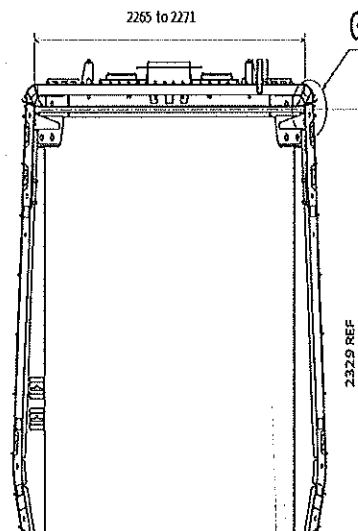
L 2273

M 2271

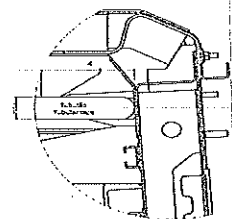


Do not consider reinforcement (Take measurements top area of zee profile

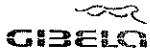
2265 to 2271



2265 to 2271



Detail 0
Consider the reinforcement plate

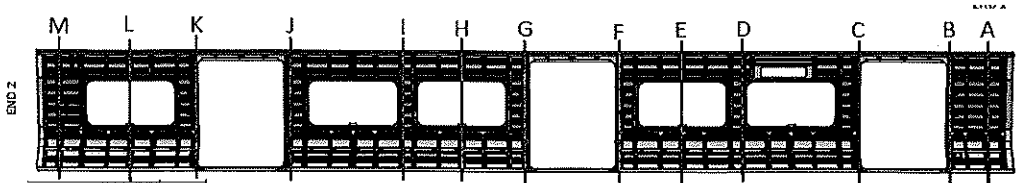


DTR30223319/3 Carshell Assembly TC

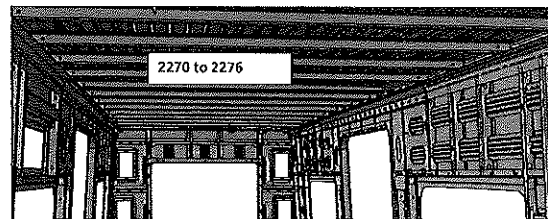
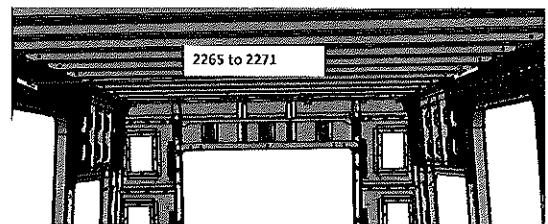
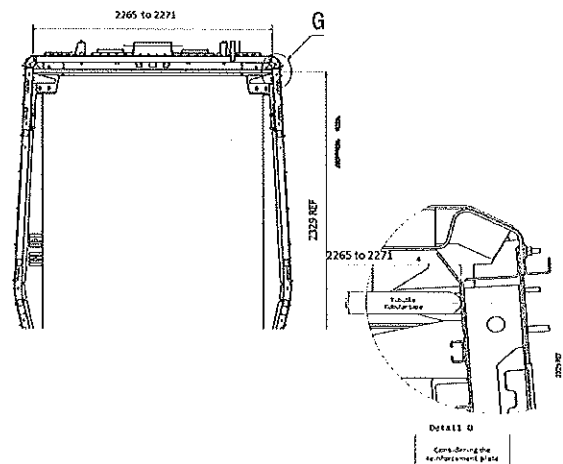
Rev.
V28
Date-
07/11/2023Project: PRASA
SI.CB1210.322.V28

Specifications of Details for CBS measurement

AFTER WELDING

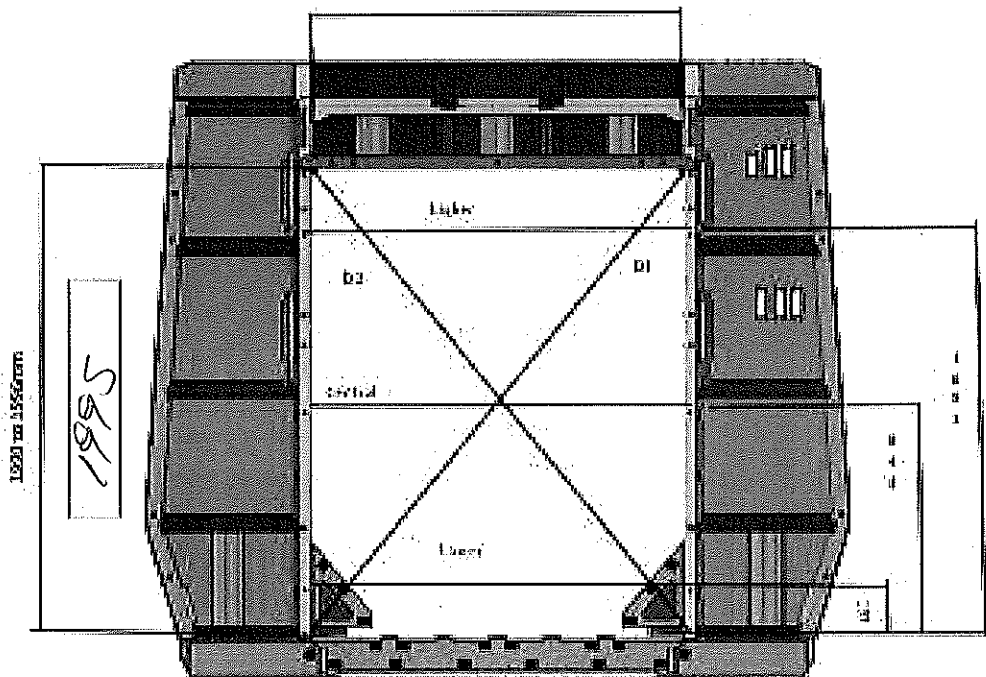


	2265 to 2271	2270 to 2276
A	N/A	2274
B	2269	N/A
C	2271	N/A
D	N/A	2274
E	N/A	2276
F	2269	N/A
G	2270	N/A
H	N/A	2275
I	N/A	2271
J	2267	N/A
K	2269	N/A
L	N/A	2273
M	2268	N/A

Do not consider reinforcement (Take
measurements top area of zee profileTake measurement close to radius (considering
reinforcement)

Specifications of Details for CBS measurement

Endframe 2



1180±3 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3mm$

Upper Dimension

1381

D1

2414

Central Dimension

1380

D2

2415

Lower Dimension

1380

D1-D2

1

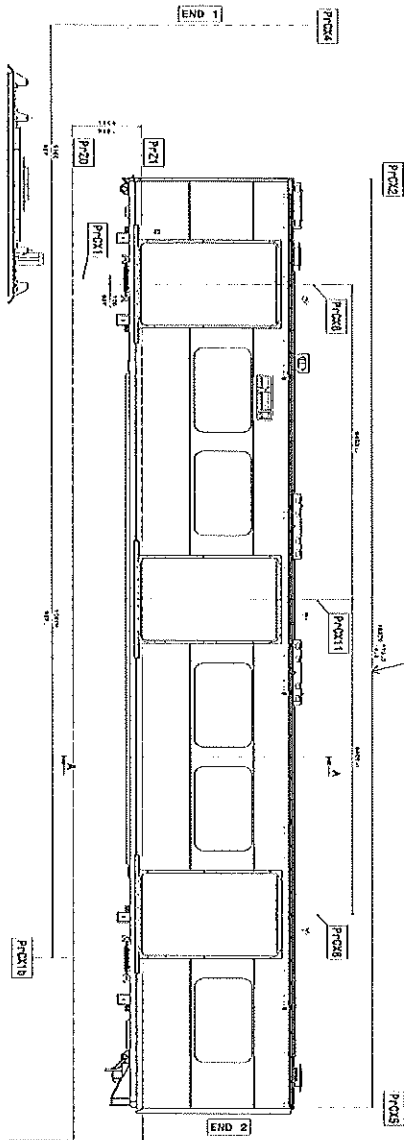


DTR30223319/3 Carshell Assembly TC

Rev.
V28
Date-
07/11/2023

Project: PRASA
SI.CB1210.322.V28

Specifications of Details for CBS measurement



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	18870 $\begin{matrix} +10.5 \\ -4.5 \end{matrix}$	18868


RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	18870 $\begin{matrix} +10.5 \\ -4.5 \end{matrix}$	18869


1A

Dye penetrant test

Dye-penetration test to be performed by quality personnel




		DTR30223319/3 Carshell Assembly TC		Rev. V28		Project: PRA5A			
				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						

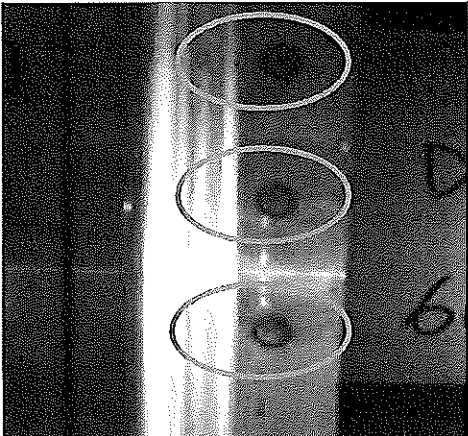
		DTR30223319/3 Carshell Assembly TC		Rev. V28 Date- 07/11/2023	Project: PRASA SI.CB1210.322.V28	
Self Inspection - Final Result						
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	GO	If activities are not complete, the missing activities must not impact the next stage!	24/04/23	Operations	[Signature]	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.	24/04/23	Andani	[Signature]	
	NO GO	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!		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	Action	Responsible	Due date	Status	

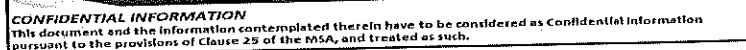
Operations

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

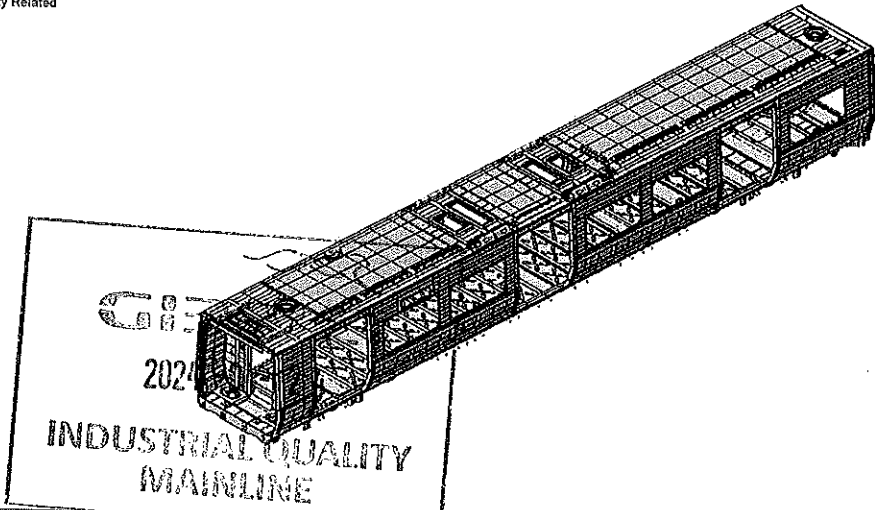


[illegible]

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 Mathagu	06/04/2018
1	23/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	23/05/2018
			CHECKER	Nosizo Pindela	23/05/2018
			REVISED BY	Ramagone Motama	23/05/2018
2	05/07/2018	Certain dimensional checks added and others moved to CB1210 and CB1230	APPROVER	Itumeleng Modiba	05/07/2018
			CHECKER	Nosizo Pindela	05/07/2018
			COMPILER	Ramagone Motama	05/07/2018
3	2018/06/12	Certain dimensional checks added and others moved to CB1210 and CB1230	APPROVER	Itumeleng Modiba	2018/06/12
			CHECKER	Nosizo Pindela	2018/06/12
			COMPILER	Ramagone Motama	2018/06/12
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			COMPILER	Vanessa Nhuli	24/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			COMPILER	Nosizo Pindela	13/03/2019
7	20/05/2019	Removed roof width	APPROVER	Itumeleng Modiba	20/05/2019
			CHECKER	Nosizo Pindela	20/05/2019
			REVISED BY	Nosizo Pindela	20/05/2019
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 10.2.6	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	Mthombi Collins	17/08/2021
			CHECKER	Mulaudzi Mpho	17/08/2021
			REVISED BY	Mulaudzi Mpho	17/08/2021
25	20/02/2022	New Baseline 10.2.6	APPROVER	Mthombi 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	Mthombi Collins	14/06/2022
			CHECKER	Andani Muthelo	14/06/2022
			REVISED BY	Andani Muthelo	14/06/2022
27	17/10/2022	Addition of traceability for sealant application and welding.	APPROVER	Mthombi Collins	17/10/2022
			CHECKER	Ntokoza Zwane	17/10/2022
			REVISED BY	Amogelang Moshlampe	17/10/2022
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Nhuli	14/04/2023
			CHECKER	Ntokoza Zwane	14/04/2023
			REVISED BY	Amogelang Moshlampe	14/04/2023
29	28/10/2023	Addition of bracket quantity	APPROVER	Ngobeni Tyson	28/10/2023
			CHECKER	Mathapo Kefone	28/10/2023
			REVISED BY	Amogelang Moshlampe	28/10/2023
TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
225	Tel	Leni 483003	24/01/24	SI.CB1220.323.V29	17

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

Carro Car:	TC1, TC2	NCR:	Work station:	CB1220
---------------	----------	------	---------------	--------



I - Documentation and Instruments

1.1 - Documentation Control

Document	Type of car						Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
	TC1	TC2	TC3	TC4	TC5	TC6						
DTR30223319/2							29	28/10/2023	X	N/A	26/04/24	26/04/24

1.2 - Instruments Control










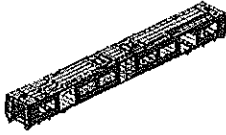









Monitoring and Measuring Instrument Control - Used for Special Process

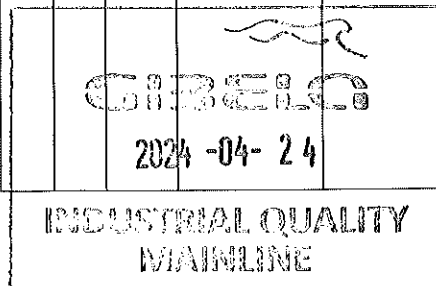
Instruments	Validation	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
Tubular	32823-2	15/03/2024-15/03/2025	X		26/04/24	26/04/24
Measuring Tape	9187A001	22/01/2023-22/01/2024	X		26/04/24	26/04/24

1.3 Consumables






Welding Consumable Control - Used for Special Process

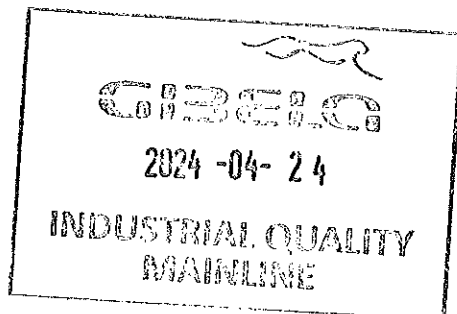
Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
MIG welding 308LSi	B221880	Mig	X		26/04/24	26/04/24

		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		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	✓		26/04/24 	26/04/24 								
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓		26/04/24 	26/04/24 								
03	REFER TO ANNEXURE A	Spot Welding inspected and approved according procedure	IND-SAL-WMS-016 e DTD0000210675	✓		26/04/24 	26/04/24 								
04	REFER TO ANNEXURE B	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		26/04/24 	26/04/24 								
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		26/04/24 	26/04/24 								
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.	✓		26/04/24 	26/04/24 								
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	✓		26/04/24 	26/04/24 								
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</p> <p>Specified:</p> <table border="1"> <tr> <td>Temperature Min - Max (I)</td> <td>Min-Max</td> </tr> <tr> <td>10°C -</td> <td>35°C</td> </tr> <tr> <td>Relative humidity Min -</td> <td>25% -</td> </tr> <tr> <td>Max (I)</td> <td>60%</td> </tr> </table>	Temperature Min - Max (I)	Min-Max	10°C -	35°C	Relative humidity Min -	25% -	Max (I)	60%	<p>Sealant Batch No: 132-7003</p> <p>Exp Date: 09/06/24</p> <p>Actuals</p> <p>Temperature: 20°C</p> <p>Humidity: 35%</p>	✓		26/04/24 	26/04/24 
Temperature Min - Max (I)	Min-Max														
10°C -	35°C														
Relative humidity Min -	25% -														
Max (I)	60%														



INDUSTRIAL QUALITY
MAINLINE

		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	✓			26/04/24 	 26/04/24
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	✓			26/04/24 	 26/04/24





DTR30223319/2 Carshell Assembly TC

Rev.

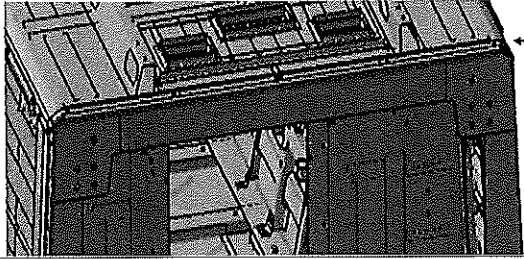
29

Project: PRASA

Date-

28/10/2023

SI.CB1220.323.V29



END 1
SEALANT

OPERATOR
(Name & sign):

Prasanna Galla

OPERATOR
(Name & sign):


11

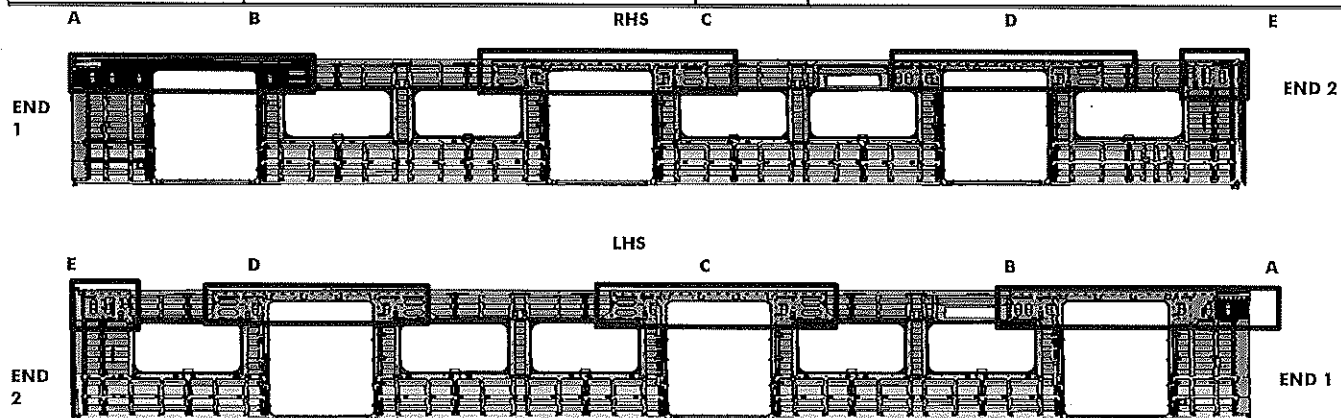


GIBEL

2024-04-24

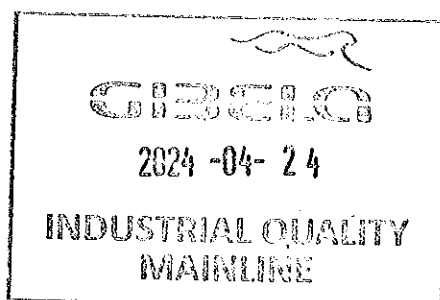
INDUSTRIAL QUALITY
MAINLINE


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

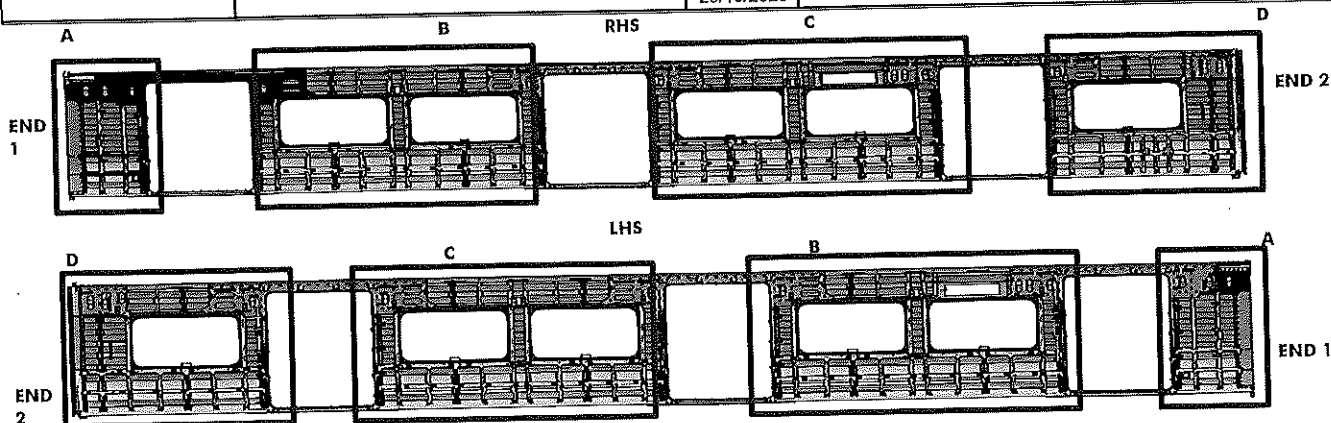


REINFORCEMENT WELDING

AREA	LHS	RHS
A	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>
B	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>
C	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>
D	Operator (Name&sign): <u>THULANI D</u>	<u>MMAKHEKO Mma</u>
E	Operator (Name&sign): <u>THULANI L</u>	<u>MMAKHEKO Mma</u>



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



BRACKETING

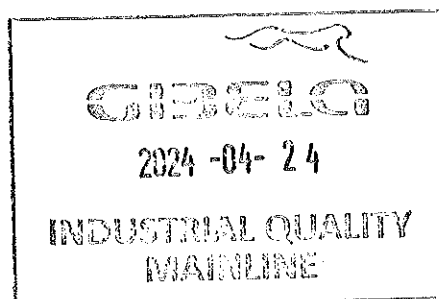
C-RAILS: Operator: INSTALLATION: Mthokozisi

DOOR MECHANISMS: Operator: ASANDI

TAPPING PADS: Operator: Mthokozisi

SEAT & LUGGAGE BRACKETS: Operator: Priscilla

SEAT BRACKETS VERIFICATION: Operator: Mthokozisi



WELDING

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

Operator (Name&sign): Mthokozisi

Operator (Name&sign): Sibiga

Operator (Name&sign): Mthokozisi


Operator (Name&sign): Sibiga

Operator (Name&sign): Mthokozisi

Operator (Name&sign): Sibiga


Operator (Name&sign): Mthokozisi

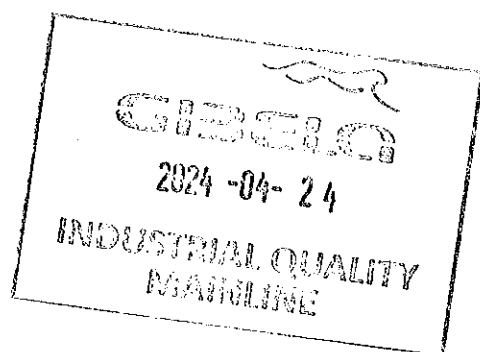
Operator (Name&sign): Sibiga

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

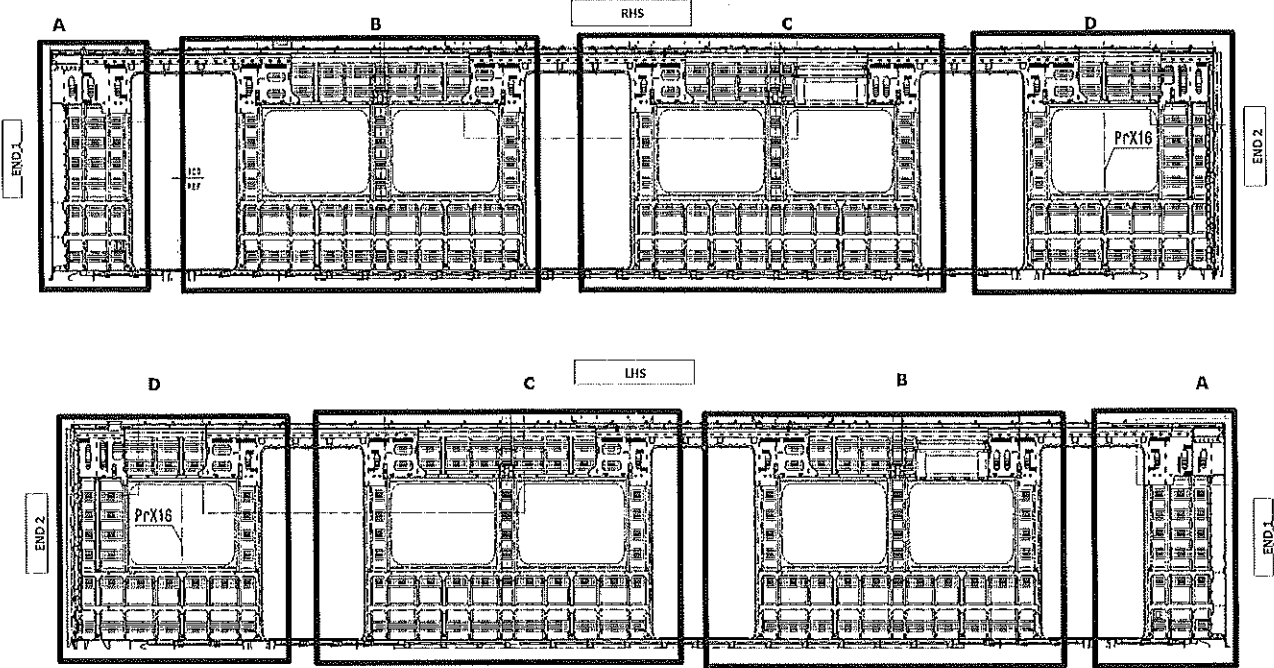
ENDS

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

THULAK 




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	✓	

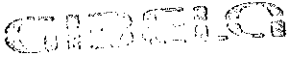
ROOF ENDS:
 C-RAILS 2 OFF END 2
 EARTH BUSH 4 OFF END 2

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:
 C-RAILS 2 OFF END 2
 EARTH BUSH 4 OFF END 2

VERIFICATION BY: 



2024-04-24

INDUSTRIAL QUALITY
MAINLINE



DTR30223319/2 Carshell Assembly TC

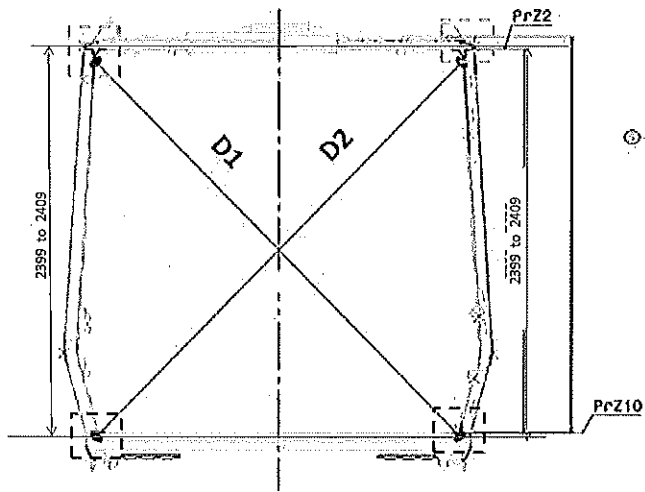
Rev.
29

Project: PRASA

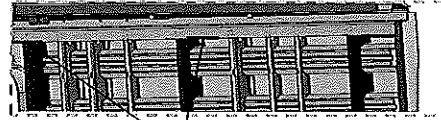
Date-

SI.CB1220.323.V29

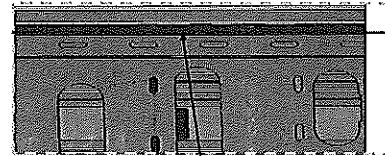
28/10/2023



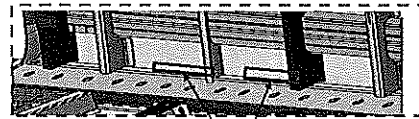
Take measurement close to radius



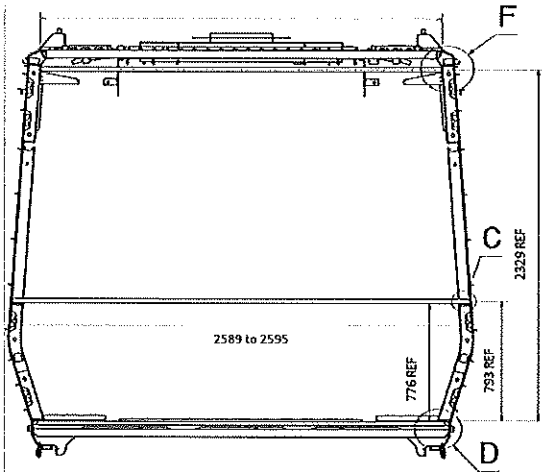
Measurement positions on roof rail and sidewall omega corner.



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

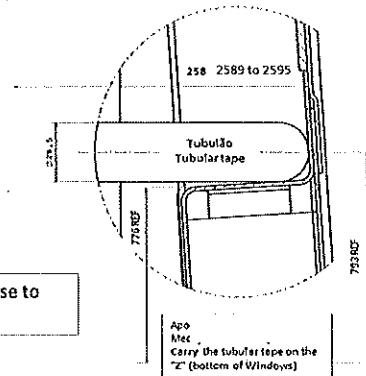
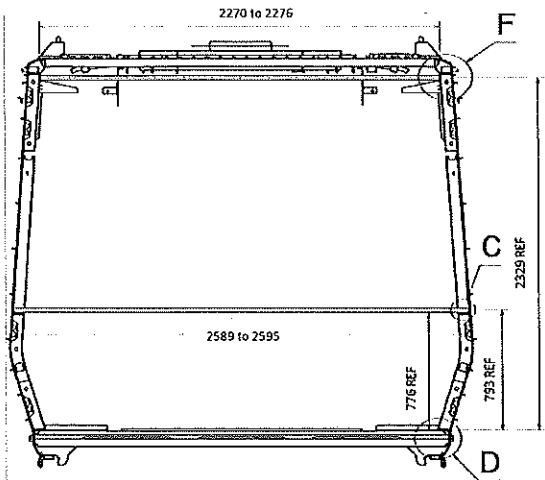
Rev.
28

Project: PRASA

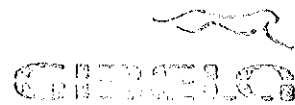
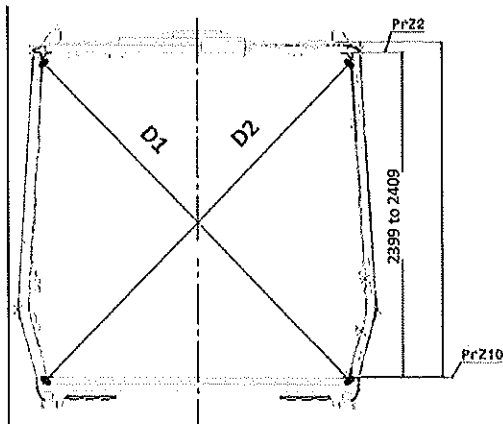
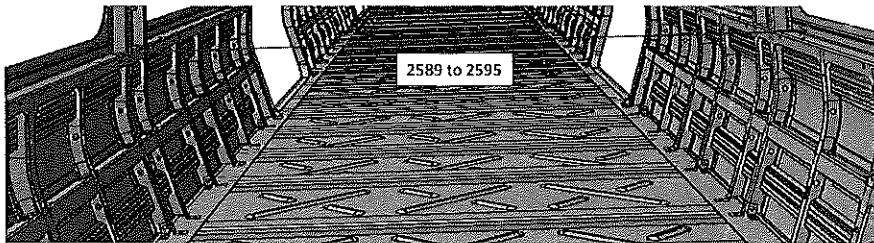
Date-

SI.CB1220.323.V29

28/10/2023

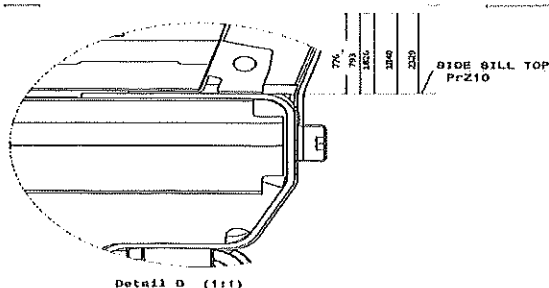


Detail C



2024-04-24

INDUSTRIAL QUALITY
WAXLINE



Detail D (1/1)



DTR30223319/2 Carshell Assembly TC

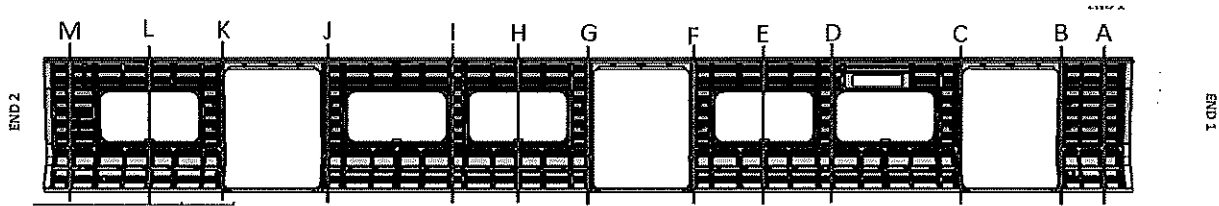
Rev.
29

Project: PRASA

Date-

SI.CB1220.323.V29

28/10/2023

**BEFORE WELDING**

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3297	3292	5	—
B	3296	3292	4	—
C	3294	3295	1	—
D	3264	3263	1	—
E	3262	3263	1	—
F	3295	3297	2	—
G	3296	3295	1	—
H	3265	3264	1	—
I	3265	3268	3	—
J	3299	3295	4	—
K	3295	3297	2	—
L	3266	3267	1	—
M	3297	3299	2	—

2024-04-24

INDUSTRIAL QUALITY
MAINLINE



DTR30223319/2 Carshell Assembly TC

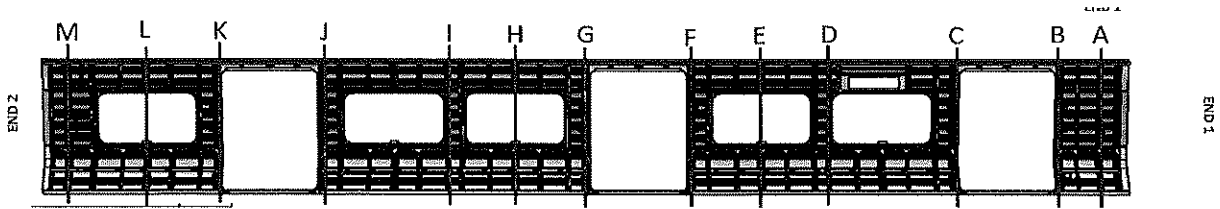
Rev.
29

Project: PRASA

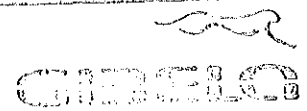
Date:

SI.CB1220.323.V29

28/10/2023


AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3290	3291	1	2590
B	3293	3295	2	2593
C	3294	3293	1	2593
D	3265	3264	1	2594
E	3263	3264	1	2592
F	3295	3293	2	2595
G	3293	3294	1	2595
H	3262	3263	1	2593
I	3264	3265	1	2593
J	3292	3295	3	2589
K	3295	3295	0	2589
L	3265	3265	0	2590
M	3297	3299	2	2595

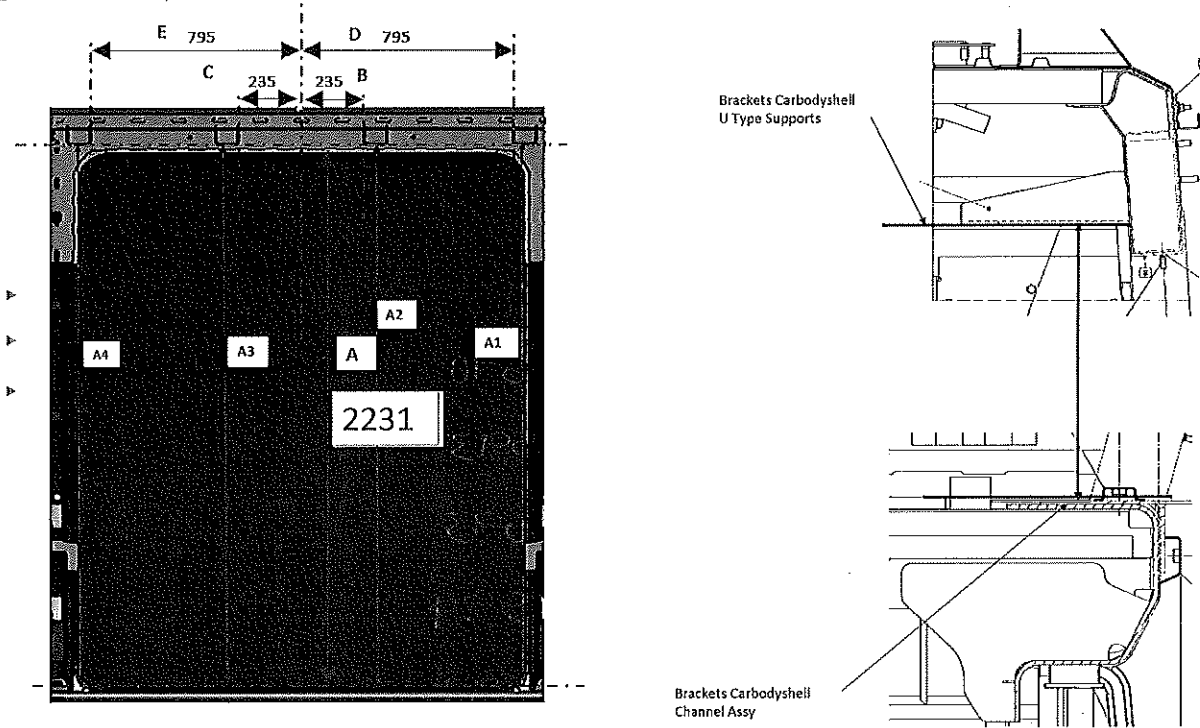


2024-04-24

INDUSTRIAL QUALITY
MANUFA

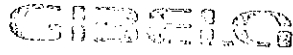
	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA SI.CB1220.323.V29
		Date-	
		28/10/2023	

Specifications of Details for CBS measurement



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

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



2024-04-24

INDUSTRIAL QUALITY

MAINLINE



DTR30223319/2 Carshell Assembly TC

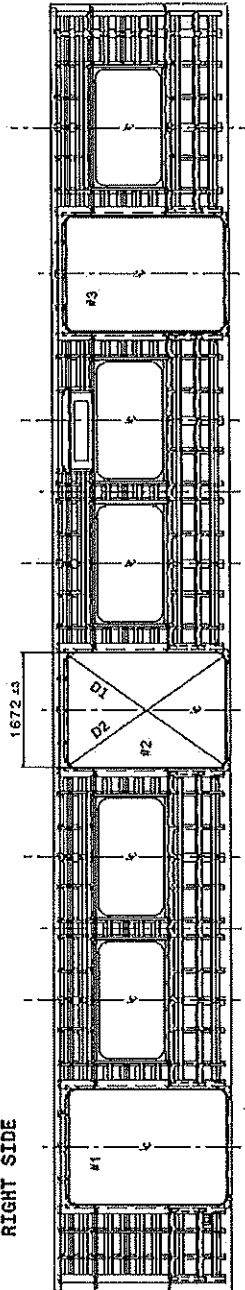
Rev.
29
Date-
28/10/2023

Project: PRASA

SI.CB1220.323.V29

Specifications of Details for CBS measurement

End #2



End #1

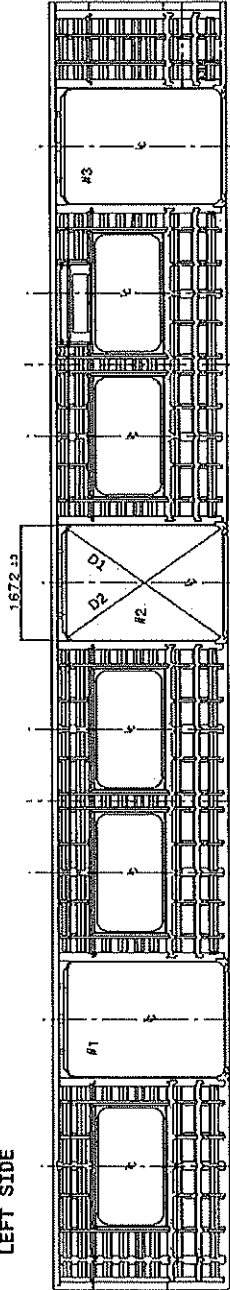
Doors diagonal D1-D2 maximum difference ≤ 4 mm

	#1	#2	#3
D1	2149	2148	2149
D2	2149	2149	2147
D1-D2	2	1	2

Doors length - 1672 ± 3 mm

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

End #1



LEFT SIDE

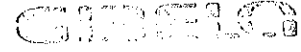
End #2

Diagonal da porta - diferença D1-D2 ≤ 4 mm

	#1	#2	#3
D1	2149	2148	2147
D2	2148	2149	2149
D1-D2	1	2	2



Vão de Portas - 1672 ± 3 mm

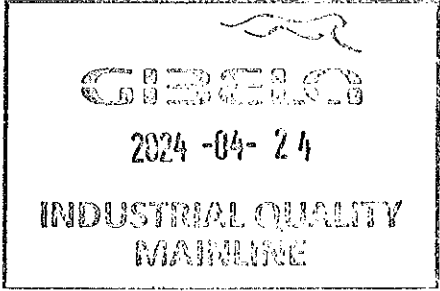
	#1	#2	#3
HIGHER DIMENSION	1671	1671	1671
CENTRAL DIMENSION	1672	1672	1672
LOWER DIMENSION	1672	1672	1671






2024-04-24

INDUSTRIAL QUALITY
FRAMELINE

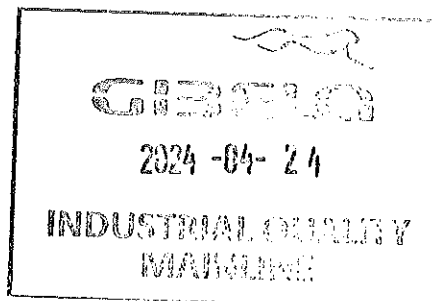
	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA SI.CB1220.323.V29				
		Date-					
		28/10/2023					
Specifications of Details for CBS measurement							
Dye penetrant test							
<div>Dye-penetration test to be performed by quality personnel</div> <div></div>							
Item	Description of the issue			OK	Signature/Date (Manufacturing)	Signature/Date (Quality)	
II.2 - Check List REX							
Check List Items							
Item	Picture/Drawing	Description	Criteria /Record	OK		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 SI.CB1220.323.V29	
				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!	26/04/24 Lemi	Lemi		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	26/04/24	Andani		
		There are activities pending 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	

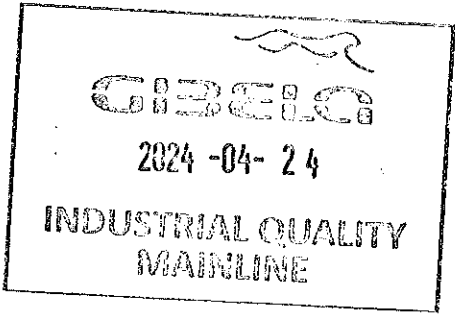
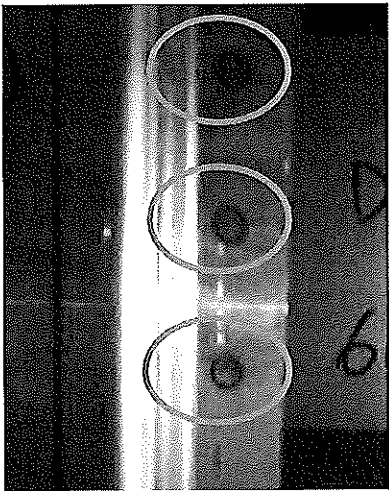
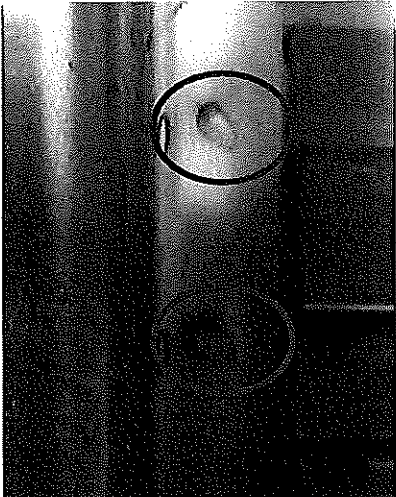
Operations

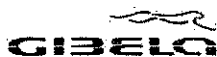
Quality



	DTR30223319/2 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

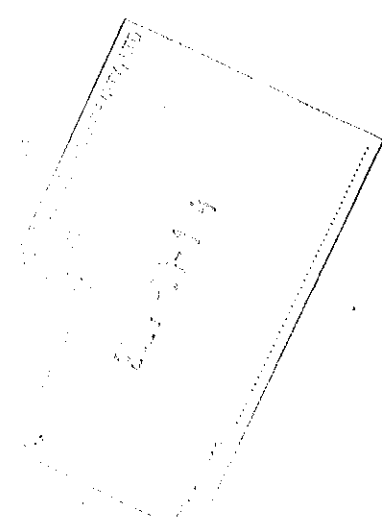
SELF INSPECTION SHEET


CONFIDENTIAL INFORMATION

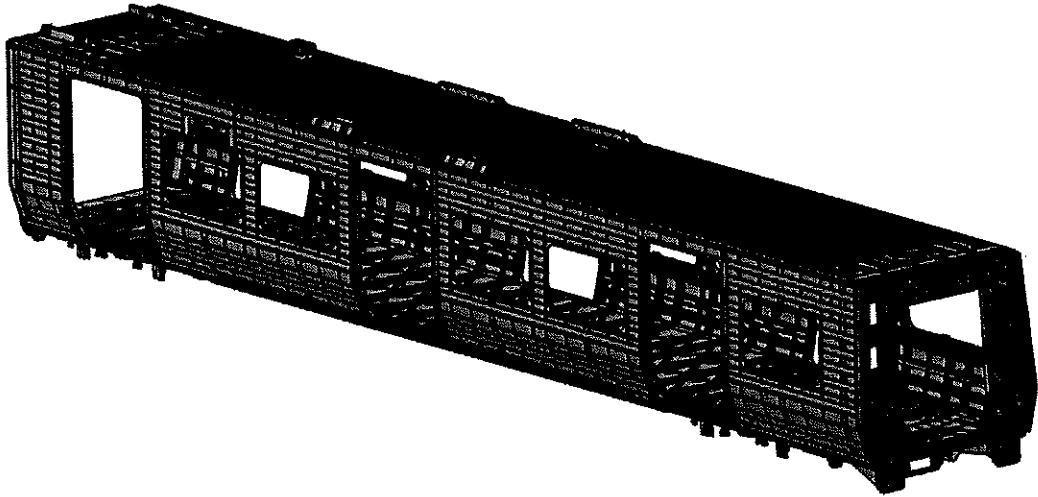
This document and the information contemplated therein have to be considered as Confidential information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?	
				TCL	PA	MS	ME	MA	TCL			
<input type="checkbox"/>	OTR3000152695	AAD0001238963	OT0000022319 Carbell Assembly TC	CB1120	X					X	PRA.CB1230.OT0000012 23319.V2D	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 Mathegu	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 Motama	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	Collins Mbombhhi	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	Collins Mbombhhi	14/06/2022							
			CHECKER	Andani Muthelo	14/06/2022							
			COMPILER	Andani Muthelo	14/06/2022							
27	26/07/2022	Threshold measurements addition	APPROVER	Collins Mbombhhi	26/07/2022							
			CHECKER	Andani Muthelo	26/07/2022							
			COMPILER	Andani Muthelo	26/07/2022							
28	17/10/2022	Addition of traceability for sealant application	APPROVER	Collins Mbombhhi	17/10/2022							
			CHECKER	Ntokozo Zwane	17/10/2022							
			COMPILER	Amogelang Mhlangeni	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							
			COMPILER	Amogelang Mhlangeni	14/04/2023							
30	06/11/2023	Added traceability for thresholds for boiler makers and welders	APPROVER	Tyson Ngobeni	06/11/2023							
			CHECKER	Andani Muthelo	06/11/2023							
			COMPILER	Ntokozo Zwane	06/11/2023							
TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES							
T60015	R1	CHOST 417409	26.04.24	SI.CB1230.324.V28	14							




	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA SI.CB1230.324.V29
		Date- 06/11/2023	
Carro Car:	NCR:	Work station: CB1230	




I - Documentation and Instruments

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK		Signature/Date (Operations)	Signature/Date (Quality)
	TC1	M1	M2	M3	M4	TC2						
DT00000223319	X						V30		OK		N/A - E 26.04.24	 26/04/24


I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Validation	Calibration or Verification Validation Date	OK		Signature/Date (Operations)	Signature/Date (Quality)
MEASURING TAPE	G180714	25/04/25	OK		E 26.04.24	
COMBINATION SQUARE	G180712	27/07/24	OK		E 26.04.24	 26/04/24
TUBULAR	22713	26/06/25	OK		E 26.04.24	

1.3 Consumables

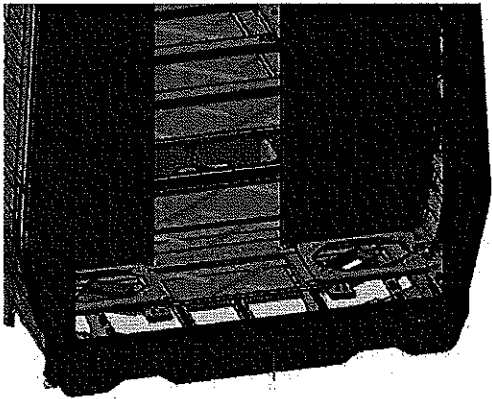
Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
AUTIGEN 308LSI	E221886	MIG	OK		E 26.04.24	 26/04/24
ER 308L	1,4316	TIG	OK		E 26.04.24	

II - Control Activities of Production


II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering nº DT00000223319	DT00000223319	OK	26.04.24	26/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	OK	26.04.24	26/04/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 DTD0000210675	OK	26.04.24	26/04/24
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	26.04.24	26/04/24
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	26.04.24	26/04/24
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: <div> <div>Temperature Min - Max (1)</div> <div>Min-Max</div> <div>10°C - 35°C</div> </div> <div> <div>Relative humidity Min - Max (1)</div> <div>Min-Max</div> <div>25% - 80%</div> </div>	Sealant Batch No: <u>KR 10-03</u> Exp Date: <u>1/05/24</u> Actuals Temperature: <u>15,4°C</u> Humidity: <u>50%</u>	OK	26.04.24	26/04/24
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	26.04.24	26/04/24

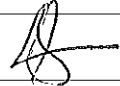


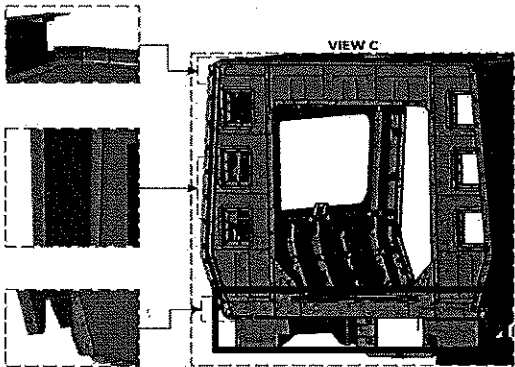
END 1
SEALANT

OPERATOR
(Name & sign):

Silvie 

OPERATOR
(Name & sign):

Silvie 



OPERATOR
(Name&sign):

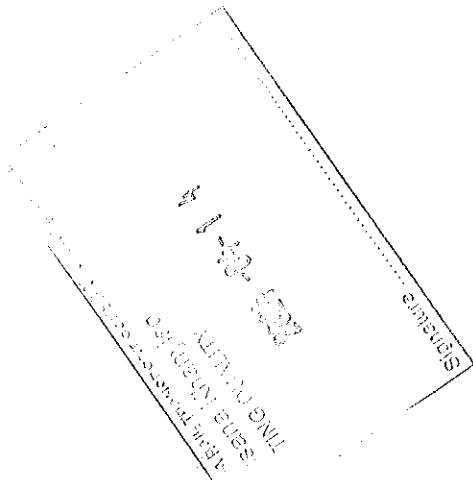
LEROY 

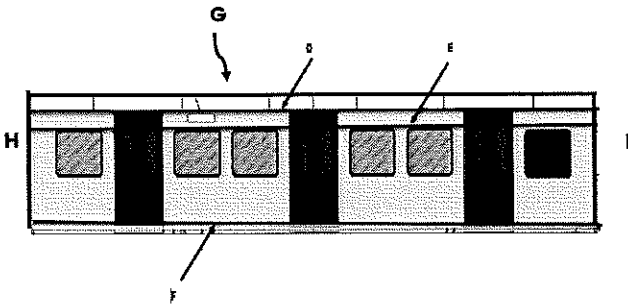
OPERATOR
(Name&sign):

LEROY 

OPERATOR
(Name&sign):

LEROY 





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

LHS

RHS

Operator (Name & sign): DEI GUTT

Operator (Name & sign): DEI GUTT

Operator (Name & sign): ISherola

Operator (Name & sign): ISherola

Operator (Name & sign): IAH

Operator (Name & sign): IAH

Operator (Name & sign): Sihle

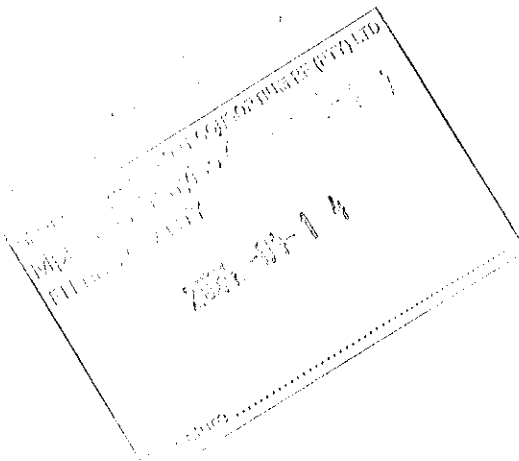
Operator (Name & sign): Sihle

Operator (Name & sign): [Signature]

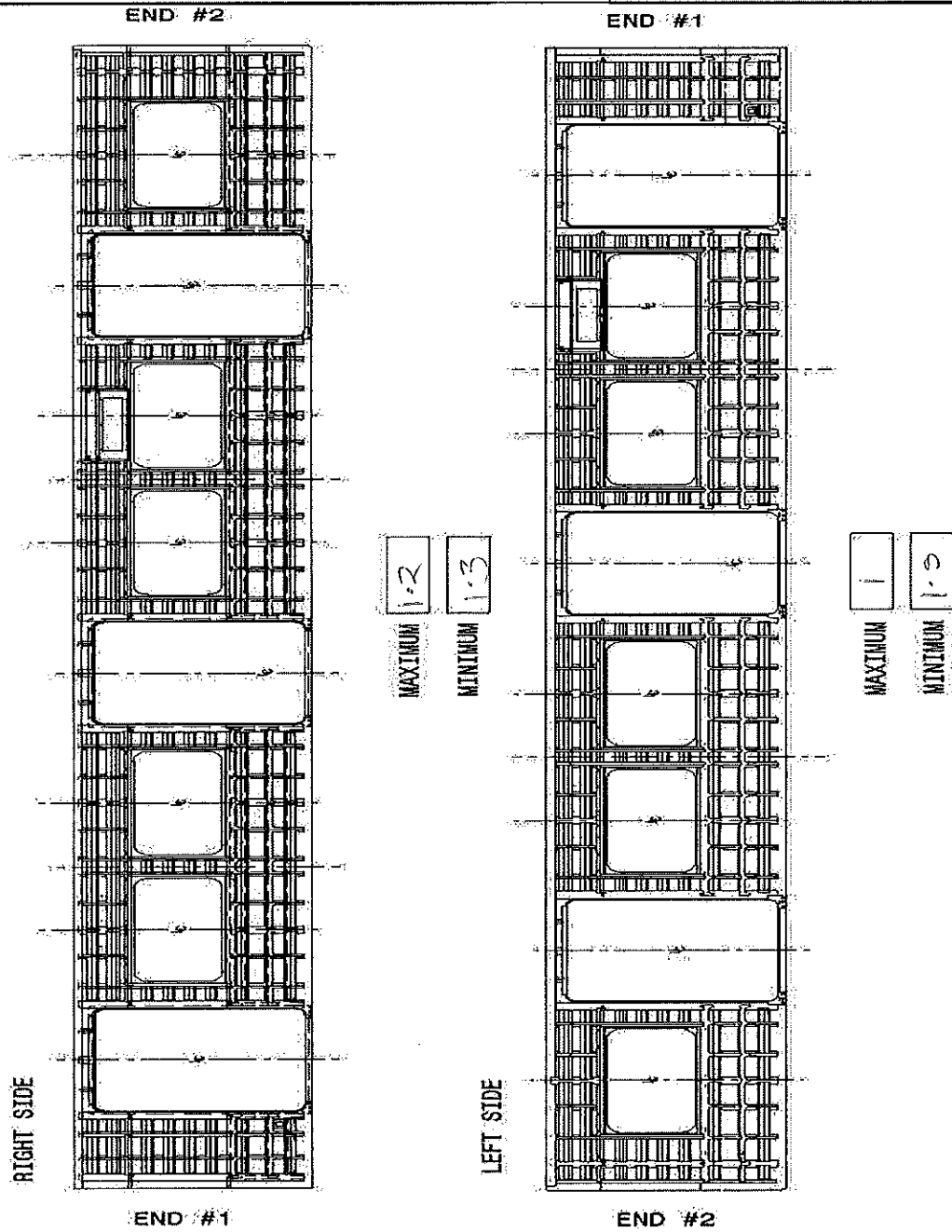
Operator (Name & sign): [Signature]

Operator (Name & sign): F Buhle

Operator (Name & sign): F Buhle



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



2023-06-13

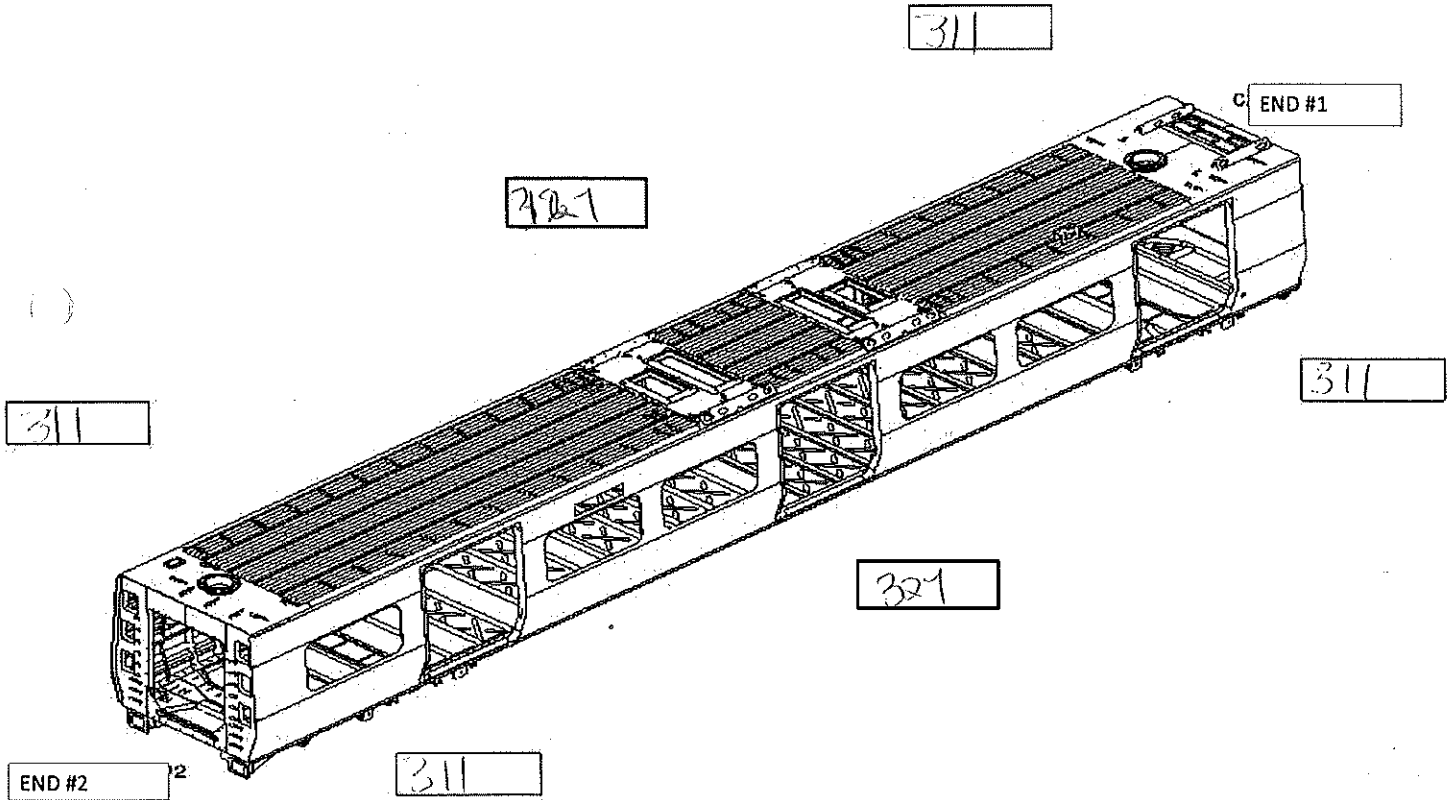
FOR ELABORATION OF THE PROJECT

DATE: 2023-06-13

SIGNATURE: _____

Specifications of Details for CBS measurement CB1230

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



MEASURED CAMBER VALUES

RIGHT

16

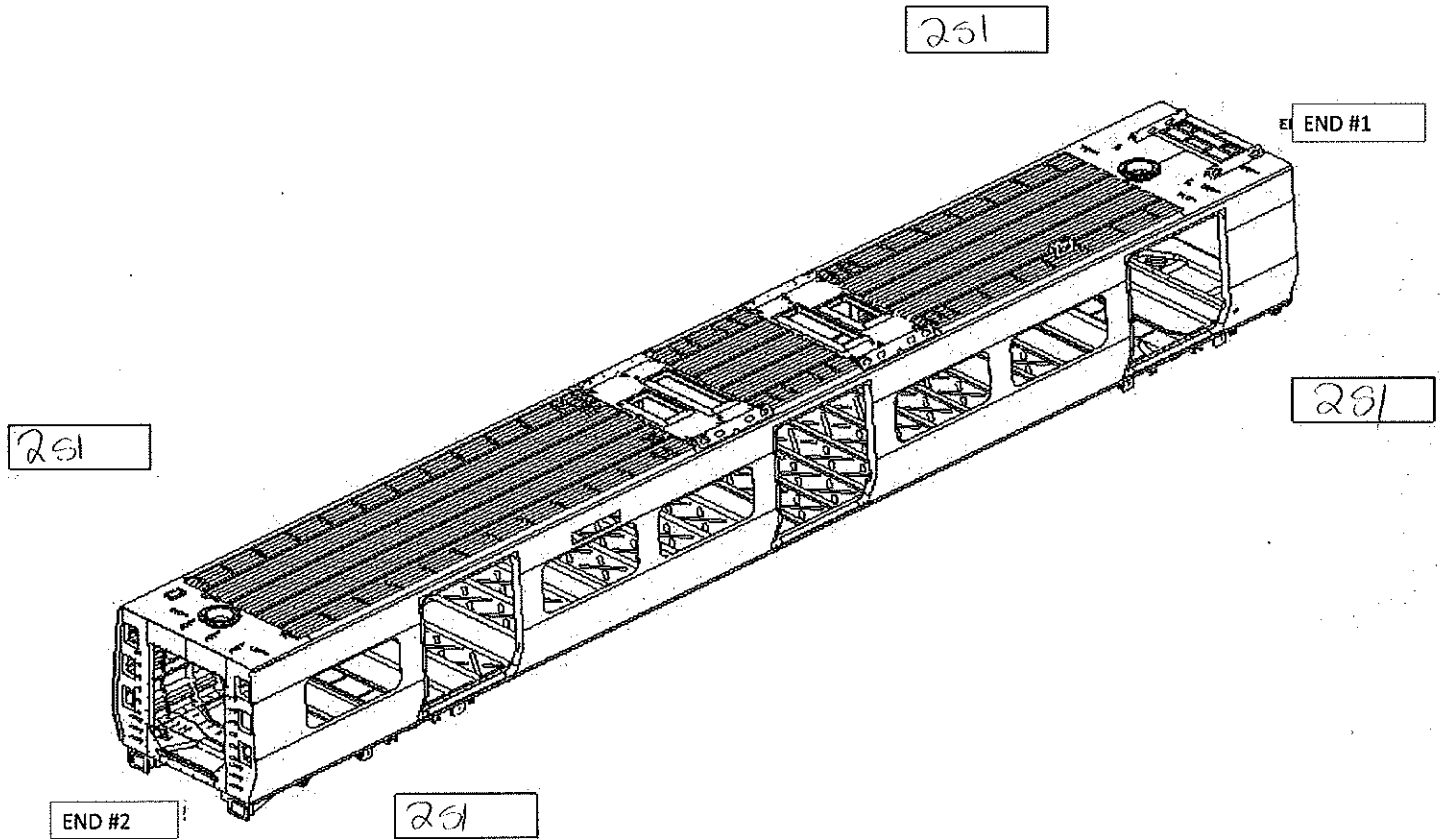
LEFT

16

D1

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

0

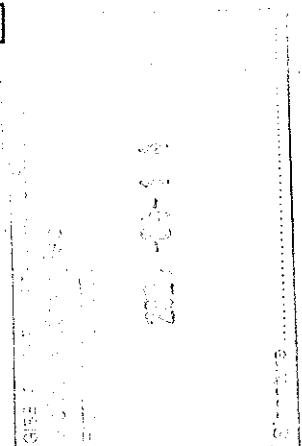
MEASURED TWIST VALUES END 2

LATERAL

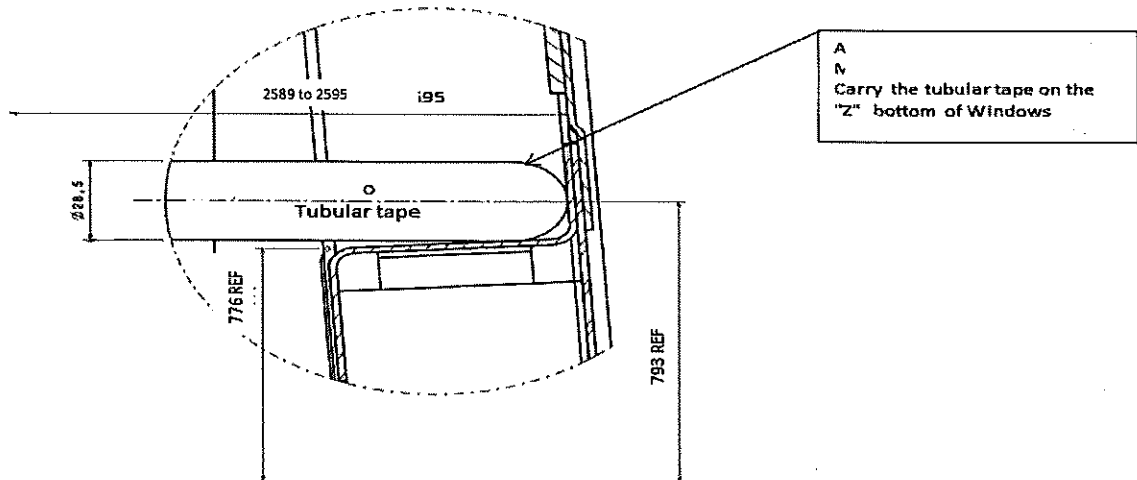
0

LONGITUDINAL

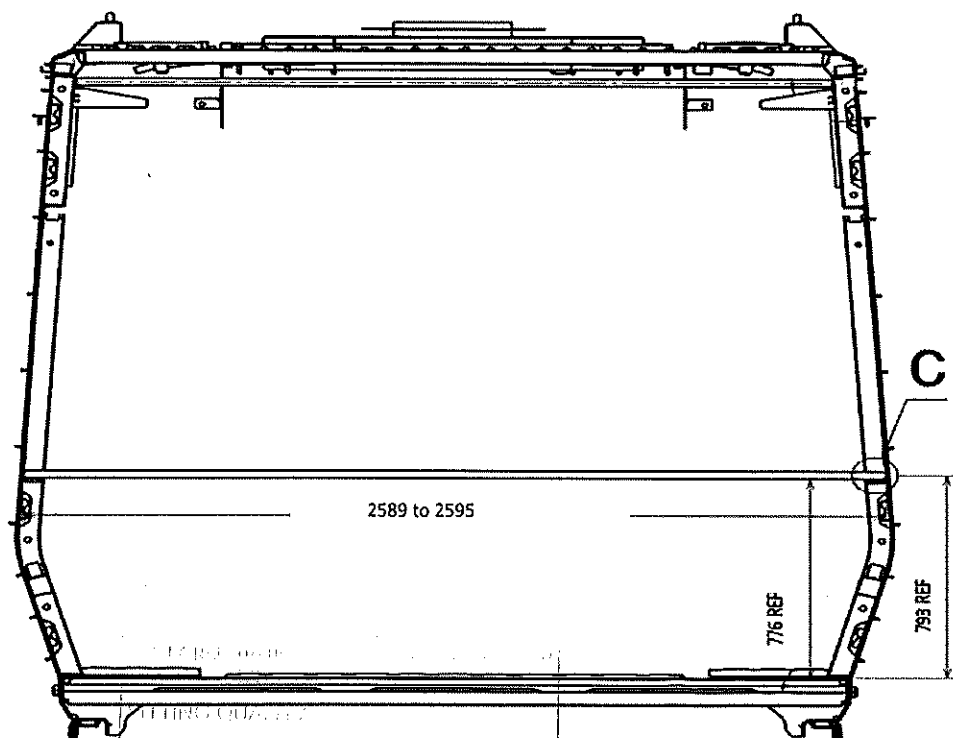
0



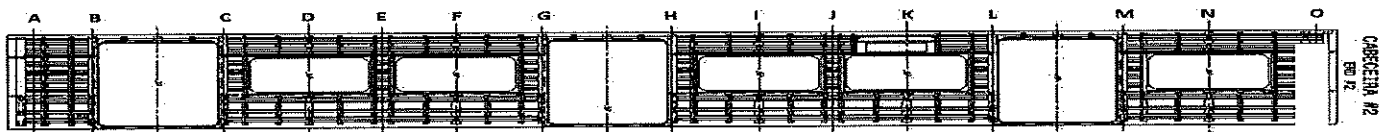
Details for measuring on the CB1230 stage, after completion of activities



Detail C



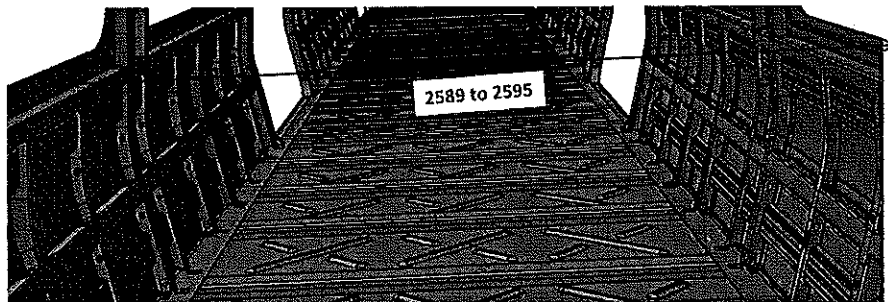
Specifications of Details for CBS measurement



LATERAL DIREITA
Right side

2589 to 2595mm

A	2595
B	2595
C	2593
D	2594
E	2594
F	2593
G	2595
H	2595
I	2593
J	2593
K	2590
L	2589
M	2589
N	2596
O	2596



2589 to 2595

Threshold verification

Nominal value 38

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

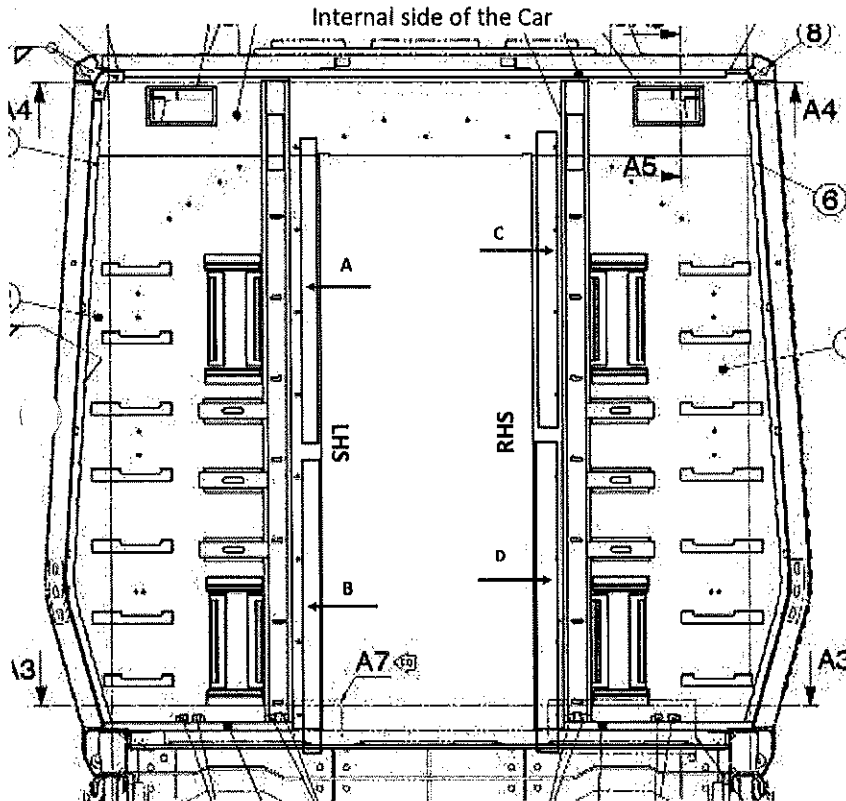
BOILER MAKER: MITCHELL

WELDER: MITCHELL

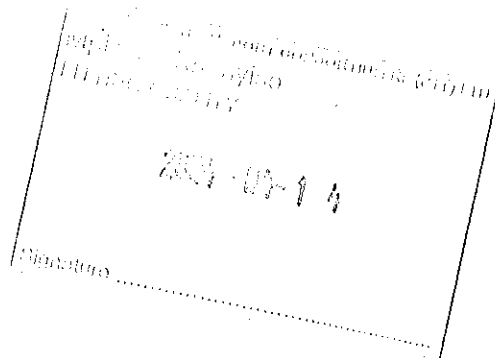
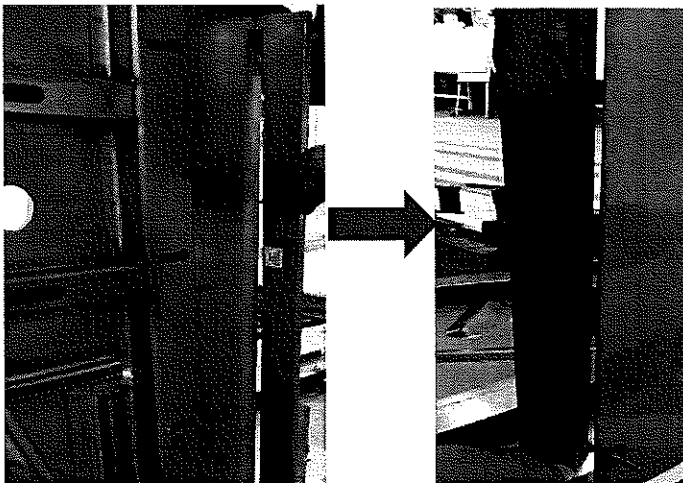
Specifications of Details for CBS measurement


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	8.0	9.9	1.9
B	9.2	10.3	1.2
C	11.1	11.6	0.5
D	12.0	12.0	0



	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA SI.CB1230.324.V29
		Date-	
		06/11/2023	

Dye penetrant test

Dye-penetration test to be performed by quality personnel

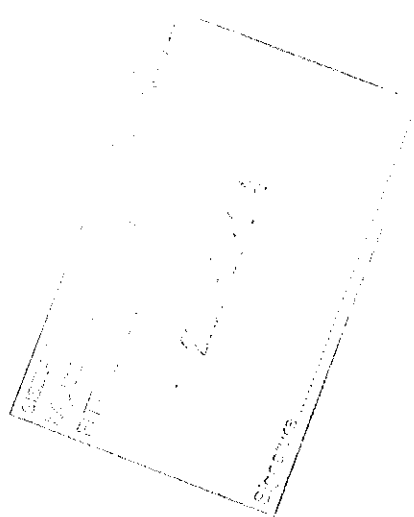


Item	Description of the Issue	CR	Signature/Date (Operations)	Signature/Date (Quality)

II.2 - Check List REX

Check List Items

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







DT00000223319 Carshell Assembly TC

Rev.
30Date-
06/11/2023

Project: PRASA

SI.CB1230.324.V29

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	YES	If activities are not complete, the missing activities must not impact the next stage	06.04.24	KHOSI	
				Operations	
	NO	Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	26/04/24	Keleboro	
				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	

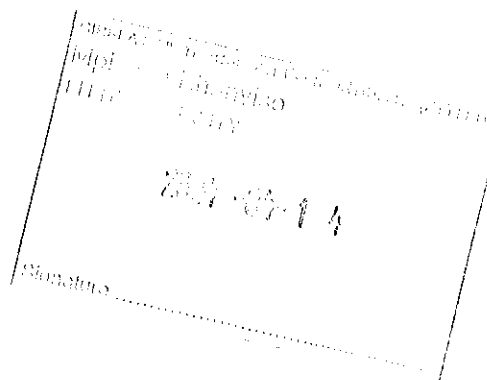
In case of "NO GO", describe blocking problems

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

Item	Description	Action	Responsible	Due date	Status

Operations

Quality



ANNEXURE A: Arc Welding Quality Acceptance Standard

