

PRASA PROJECT

APPLICABLE FROM TRAINSET 100+ AS PER BASELINE 10.3.1

SELF INSPECTION SHEET


CONFIDENTIAL INFORMATION

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

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?
				TC1	M1	M2	M3	M4	TC2		
<input checked="" type="checkbox"/> DTR30225497/3	AAD0003278566	CARBODYSHELL M1 ASSEMBLY	CB1210			<input checked="" type="checkbox"/>				PRA.CB1210.DTR30225487/3.V25	YES
<input type="checkbox"/>											
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE						
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018						
			CHECKER	Nosizo Pindela	10/01/2018						
			COMPILER	Thanyani Mathegu	10/01/2018						
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18						
			CHECKER	Nosizo Pindela	2018/05/18						
			REVISED BY	Ramokone Motama	2018/05/18						
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230	APPROVER	Itumeleng Modiba	2018/07/04						
			CHECKER	Nosizo Pindela	2018/07/04						
			REVISED BY	Ramokone Motama	2018/07/04						
3	2018/12/12	Added dimensional check points to CB1210	APPROVER	Itumeleng Modiba	2018/12/12						
			CHECKER	Nosizo Pindela	2018/12/12						
			REVISED BY	Ramokone Motama	2018/12/12						
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	22/01/2019						
			CHECKER	Nosizo Pindela	22/01/2019						
			REVISED BY	Vanessa Ntuli	22/01/2019						
6	13/03/2019	Added D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	13/03/2019						
			CHECKER	Nosizo Pindela	13/03/2019						
			REVISED BY	Nosizo Pindela	13/03/2019						
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	21/08/2019						
			CHECKER	Nosizo Pindela	21/08/2019						
			REVISED BY	Nosizo Pindela	21/08/2019						
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020						
			CHECKER	Bongane Masina	06/08/2020						
			REVISED BY	Bongane Masina	06/08/2020						
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021						
			CHECKER	Bongane Masina	19/04/2021						
			REVISED BY	Bongane Masina	19/04/2021						
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021						
			CHECKER	Mpho Mulaudzi	17/08/2021						
			REVISED BY	Mpho Mulaudzi	17/08/2021						
25	19/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	19/02/2022						
			CHECKER	Andani Muthelo	19/02/2022						
			REVISED BY	Andani Muthelo	19/02/2022						
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023						
			CHECKER	Mohlampe Amogelang	14/04/2023						
			REVISED BY	Mohlampe Amogelang	14/04/2023						
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023						
			CHECKER	Zwane Ntokozo	27/07/2023						
			REVISED BY	Mohlampe Amogelang	27/07/2023						
28	07/11/2023	Addition of welding traceability	APPROVER	Ngobeni Tyson	07/11/2023						
			CHECKER	Andani Muthelo	07/11/2023						
			REVISED BY	Ntokozo Zwane	07/11/2023						
TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES						
225	MU	WUGA 471497	26/04/24	SI.CB1210.254.V28	17						

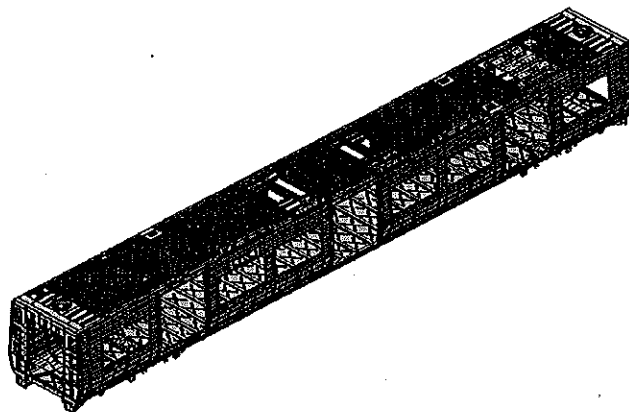
24
QUALITY
LINE

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

Car: M1	NCR:	Work station: CB1210
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Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
	D	M	S	S	M	D						
DTR30225487/3	X								✓			

I.2 - Instruments Control

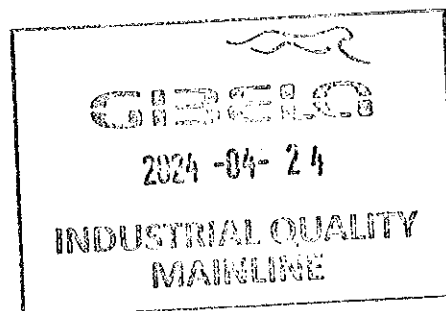
Monitoring and Measuring Instrument Control - Used for Special Process



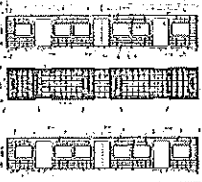
Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULAR	32823-2	15/03/24	✓		26/04/24	26/04/24
30 M TAPE	6187P0084	14/03/24	✓		26/04/24	26/04/24
CASER TAPE	125425924	08/01/24	✓		26/04/24	26/04/24

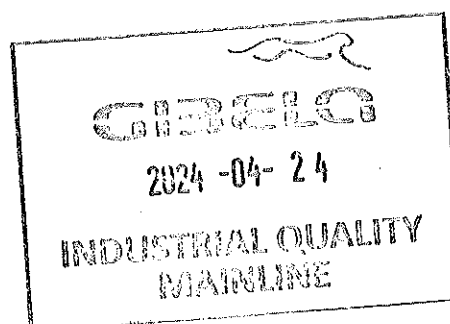
1.3 Consumables


Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
AUTROD 308 CSI	G2218P0	MIG	✓		26/04/24	26/04/24
ER 309 CSI	318344	MIG	✓		26/04/24	26/04/24

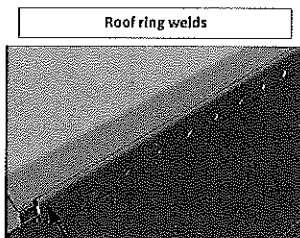


		Rev. 28		Project: PRASA SI.CB1210.254.V28		
		Date 07/11/2023				
CARBODYSHELL M1 ASSEMBLY DTR30226487/3						
II - Self Inspection - Items to Check						
II.1 - Items to check						
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls, Endframes, Roof and Underframe)	DT00000311225	✓	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 to procedure	IND-SAL-WMS-016 e DTD00000210675	✓	26/04/24	26/04/24
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to 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		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	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.	✓	26/04/24	26/04/24



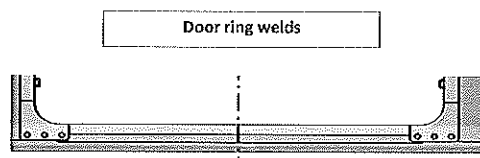
	CARBODYSHELL M1 ASSEMBLY DTR30226487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

Welder Traceability



<div style="text-align: right; margin-bottom: 5px;"><u>LHS</u></div> Boiler maker (Name & Sign): <u>SEAN [Signature]</u>	<div style="text-align: right; margin-bottom: 5px;"><u>Welder (Name & Sign):</u> <u>MITHOKOZISI [Signature]</u></div>
END 1	
<div style="text-align: right; margin-bottom: 5px;"><u>RHS</u></div> Boiler maker (Name & Sign): <u>SEAN [Signature]</u>	<div style="text-align: right; margin-bottom: 5px;"><u>Welder (Name & Sign):</u> <u>MITHOKOZISI [Signature]</u></div>

<div style="text-align: right; margin-bottom: 5px;"><u>LHS</u></div> Boiler maker (Name & Sign): <u>SEAN [Signature]</u>	<div style="text-align: right; margin-bottom: 5px;"><u>Welder (Name & Sign):</u> <u>MITHOKOZISI [Signature]</u></div>
END 2	
<div style="text-align: right; margin-bottom: 5px;"><u>RHS</u></div> Boiler maker (Name & Sign): <u>SEAN [Signature]</u>	<div style="text-align: right; margin-bottom: 5px;"><u>Welder (Name & Sign):</u> <u>MITHOKOZISI [Signature]</u></div>



LHS

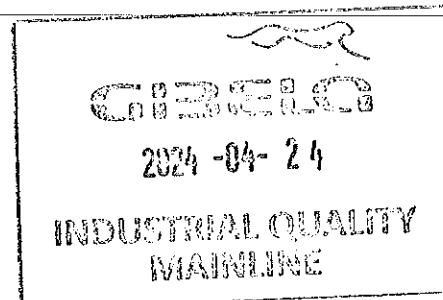
Boiler maker (Name & Sign): LUNGA [Signature]


Welder (Name & Sign): TNABING [Signature]

RHS

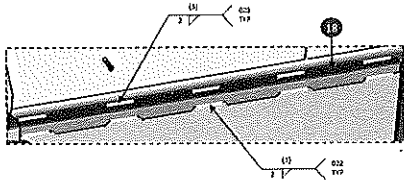
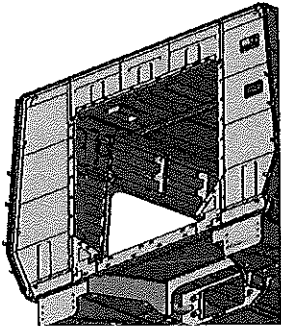
Boiler maker (Name & Sign): TIMOTHY [Signature]

Welder (Name & Sign): KERTU [Signature]



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

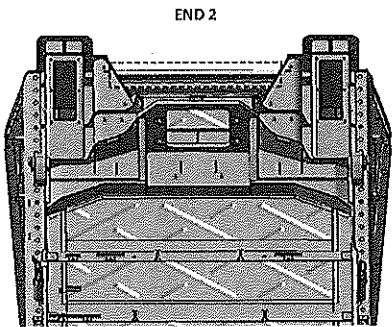
EUF Reinforcement Plates



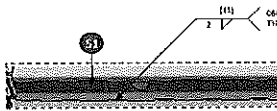
END 1

Boiler maker (Name & Sign):
PONTISO

Welder (Name & Sign):
KBTU K.




Underneath the CAR



END 2

Boiler maker (Name & Sign):
JUSTICE

Welder (Name & Sign):
THABANG



2024-04-24


INDUSTRIAL QUALITY

MAINLINE

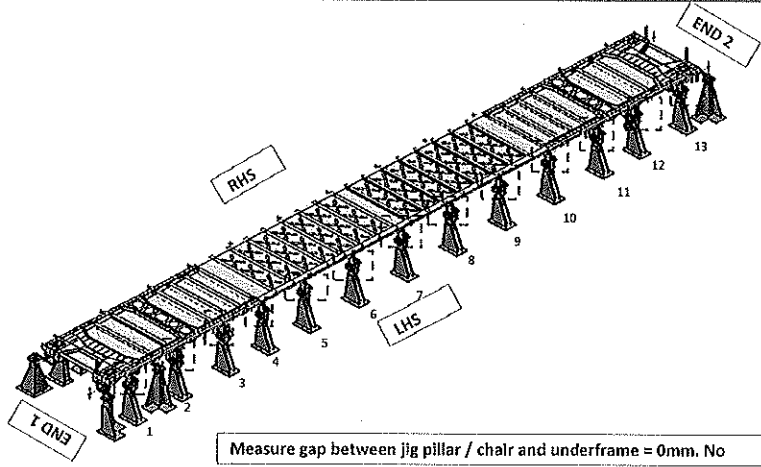


FE00LI

OPERATOR:
TEBOLIO

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


Specifications of Details for CBS measurement



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


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

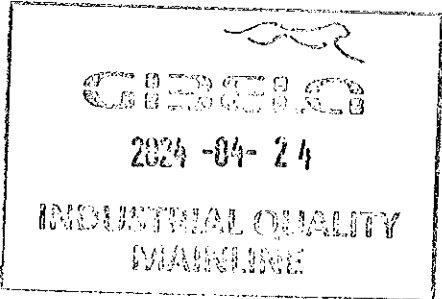
	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Right Hand Side	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

Signature Operations:  Date: 26/09/24

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

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Right Hand Side	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

Signature Industrial Quality:  Date: 26/09/24





CARBODYSHELL M1 ASSEMBLY DTR30226487/3

Rev.

28

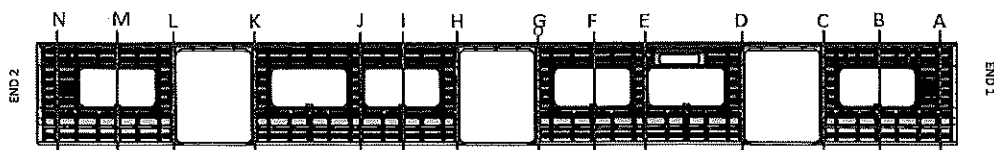
Date

07/11/2023

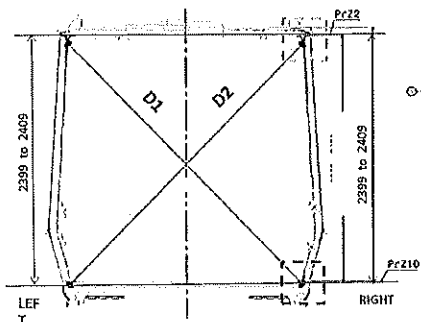
Project: PRASA

SI.CB1210.254.V28

Specifications of Details for CBS measurement



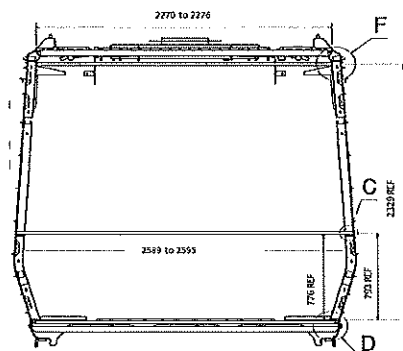
9



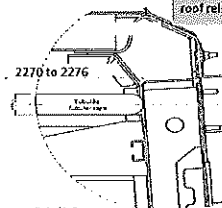
Measurement positions on roof rail and sidewall omega corner.



Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.



Detail F

Don't considering the reinforcement



2024-04-24

INDUSTRIAL QUALITY
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CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev.

28

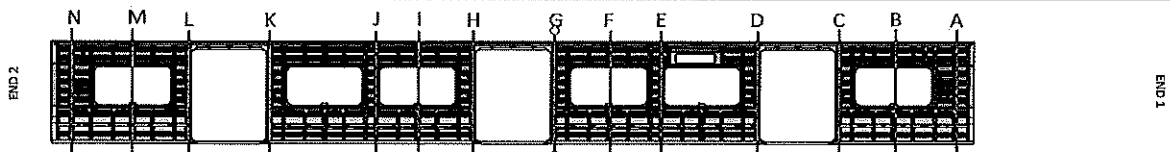
Date

07/11/2023

Project: PRASA

SI.CB1210.254.V28

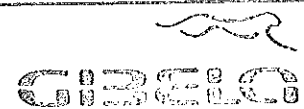
Specifications of Details for GBS measurement

PME Column LHS - RHS should be $\leq 2\text{MM}$ on each point.

BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3269	3269	0	2407	2408	1
B	3268	3265	3	2406	2406	0
C	3268	3268	0	2407	2406	1
D	3269	3267	2	2406	2405	1
E	3266	3266	0	2407	2406	1
F	3265	3264	1	2404	2405	1
G	3268	3269	1	2405	2407	2
H	3269	3267	2	2406	2404	2
I	3264	3266	2	2405	2406	1
J	3266	3266	0	2406	2406	0
K	3270	3268	2	2407	2405	2
L	3268	3268	0	2405	2406	1
M	3269	3268	4	2406	2407	1
N	3268	3269	1	2408	2409	1

2604/24



2024-04-24

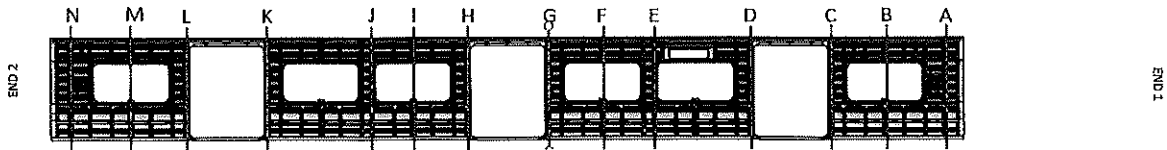
INDUSTRIAL QUALITY
MAINLINE



CARBODYSHELL M1 ASSEMBLY DTR30226487/3

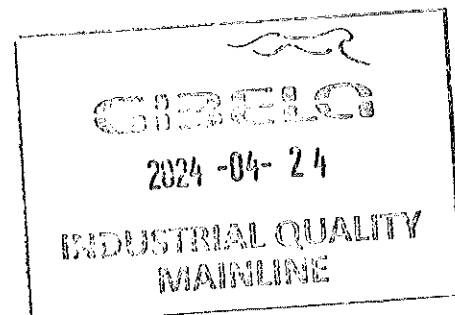
Rev.
28
Date
07/11/2023Project: PRASA
SI.CB1210.254.V28


Specifications of Details for CBS measurement

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

AFTER WELDING

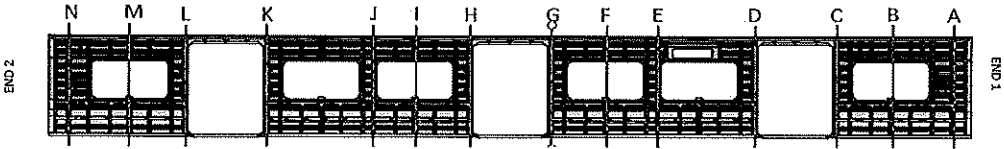
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3295	3294	1	2408	2409	1
B	3268	3266	2	2406	2405	1
C	3295	3294	1	2405	2407	2
D	3293	3295	2	2406	2405	1
E	3265	3265	0	2406	2406	0
F	3266	3265	1	2405	2408	1
G	3295	3295	0	2405	2407	2
H	3295	3295	0	2406	2405	1
I	3264	3265	1	2405	2405	0
J	3266	3266	0	2406	2404	2
K	3296	3294	2	2405	2405	0
L	3295	3295	0	2404	2406	2
M	3268	3265	3	2406	2405	1
N	3295	3294	1	2408	2408	0

26/04/24

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

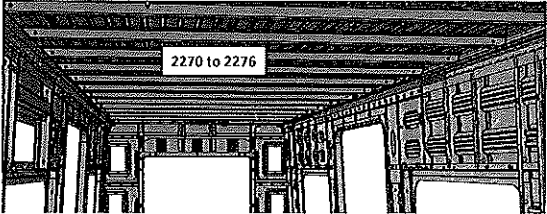
CBS measurement

BEFORE WELDING

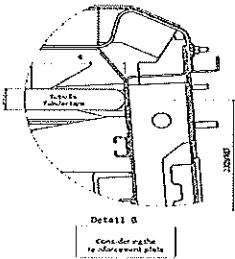
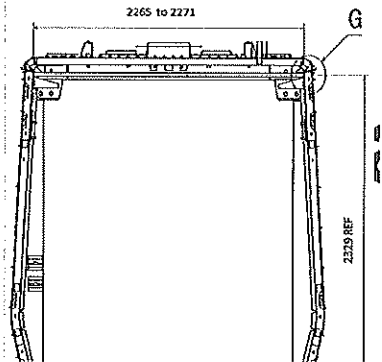


	2270 to 2276
A	2271
B	2273
C	2272
D	2274
E	2277
F	2274
G	2271
H	2274
I	2276
J	2277
K	2270
L	2272
M	2274
N	2271


1990 to




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

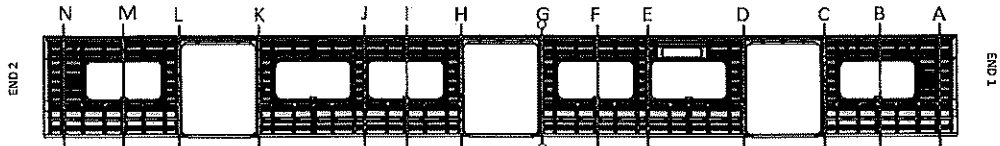


26/ap/24

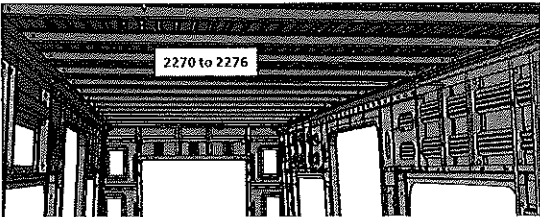

2024 -04- 24
INDUSTRIAL QUALITY MAINLINE

	CARBODYSHELL M1 ASSEMBLY DTR30226487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	
		CBS measurement	

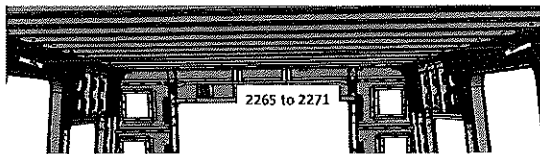
AFTER WELDING



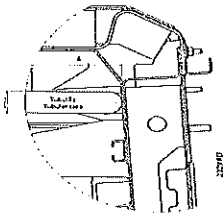
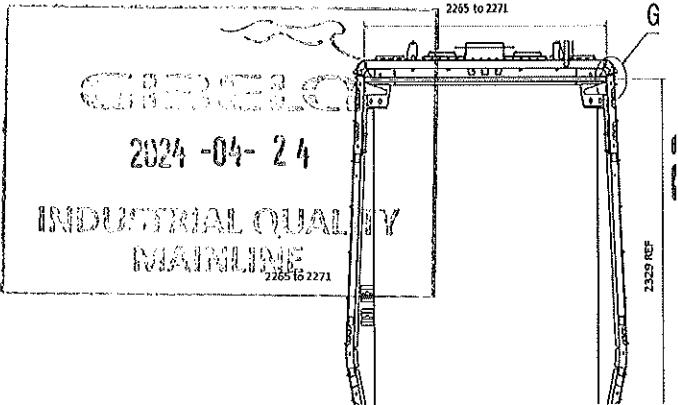
	2265 to 2271	2270 to 2276
A	2268	NA
B	NA	2273
C	2265	NA
D	2269	NA
E	NA	2276
F	NA	2274
G	2270	NA
H	2266	NA
I	NA	2276
J	NA	2276
K	2268	NA
L	2265	NA
M	NA	2274
N	2266	NA



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



Take measurement close to radius (considering reinforcement)



Detail G
Cons. Reinforcing reinforcement plate

26/04/24



CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev.

28

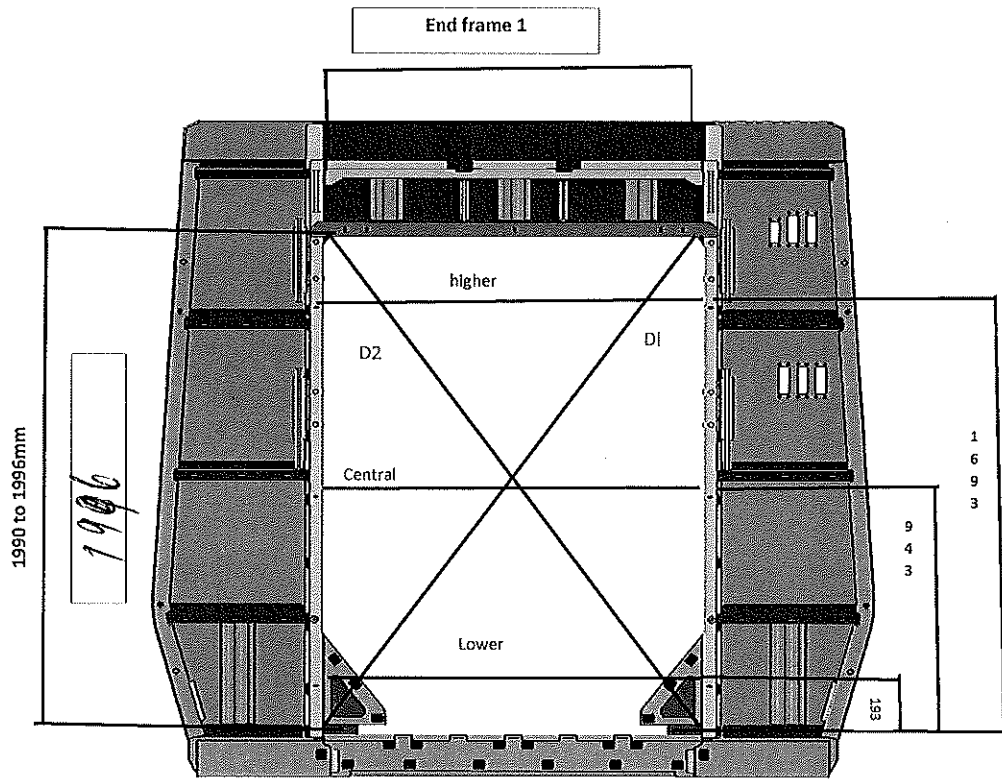
Date

07/11/2023

Project: PRASA

SI.CB1210.254.V28

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3mm$

Higher Dimension

1382

D1

2414

Central Dimension

1381

D2

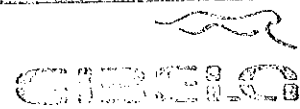
2413

Lower Dimension

1381

D1-D2

1



2024-04-24

INDUSTRIAL QUALITY
MANLINE

26/04/24

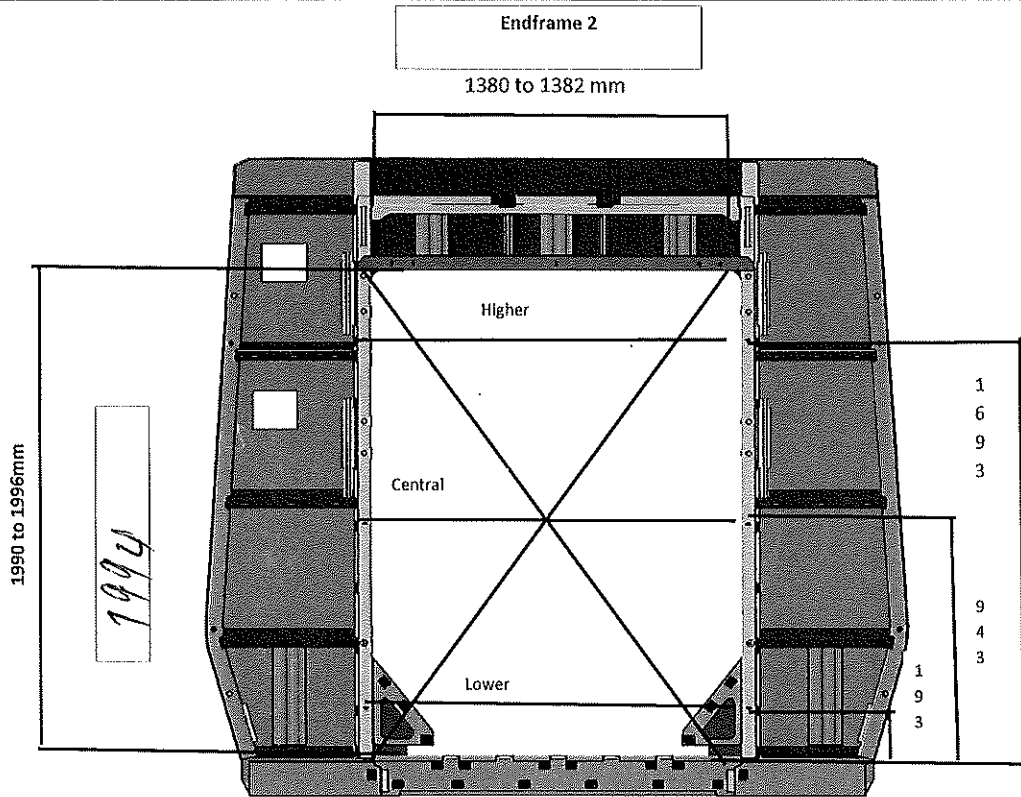


CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev.
28
Date
07/11/2023

Project: PRASA
SI.CB1210.254.V28

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3mm$

Higher Dimension

1381

D1

2413

Central Dimension

1381

D2

2415

Lower Dimension

1380

D1-D2

2

GIBELQ

2024-04-24

INDUSTRIAL QUALITY
MAINLINE

26/04/24



CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev.

28

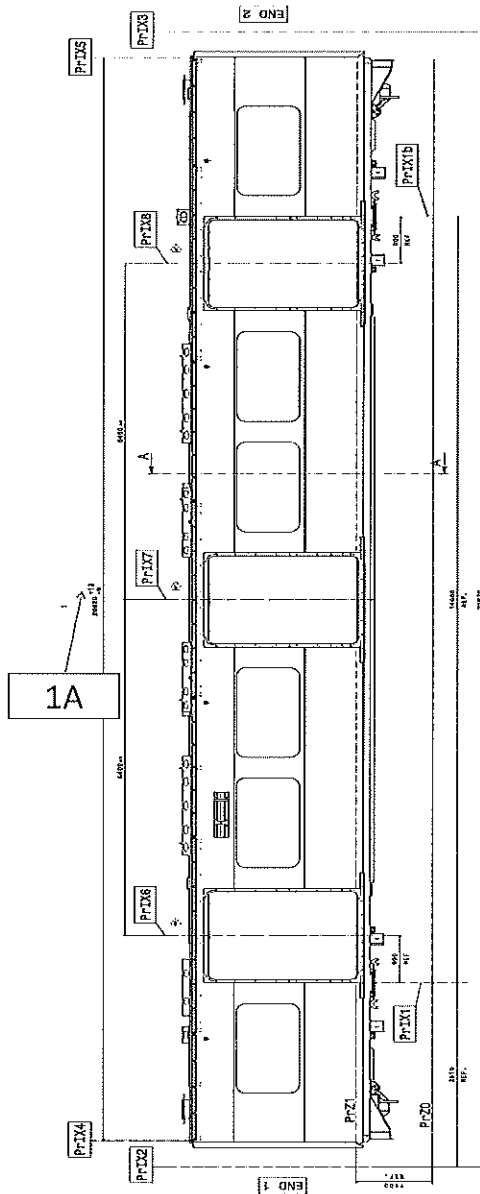
Date

07/11/2023

Project: PRASA

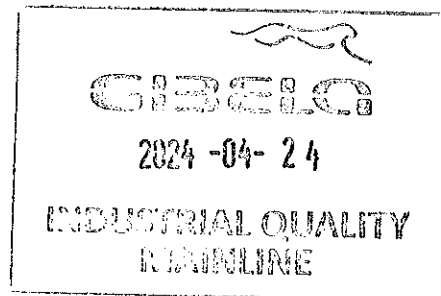
SI.CB1210.254.V28

Specifications of Details for CBS measurement



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


RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20616

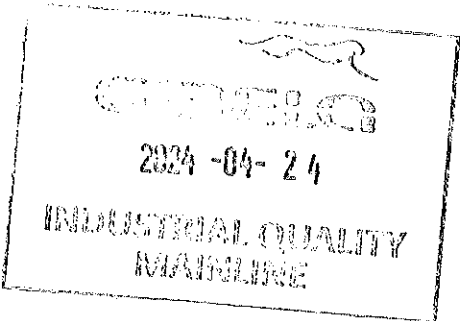



Dye penetrant test

Dye-penetration test to be performed by quality personnel





		CARBODYSHELL M1 ASSEMBLY DTR30225487/3		Rev. 28	Project: PRA5A		
				Date 07/11/2023	SI.CB1210.254.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				



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

Self Inspection - Final Result

				DATE	NAME	SIGNATURE
HOLD POINT		GO	(If activities are not complete, the missing activities must not impact the next stage)	26/04/24	hewga Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	26/04/24	Andri Industrial Quality	
		NO	There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)		Operations	
			There are non-conformities impact the quality of the product and there is no corrective action defined yet)		Industrial Quality	

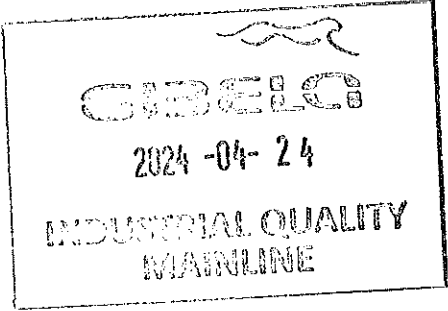
In case of "NO GO", describe blocking problems

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

Item	Description		Responsible	Due date	Status

Operations

Quality






SELF INSPECTION SHEET

CONFIDENTIAL INFORMATION


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

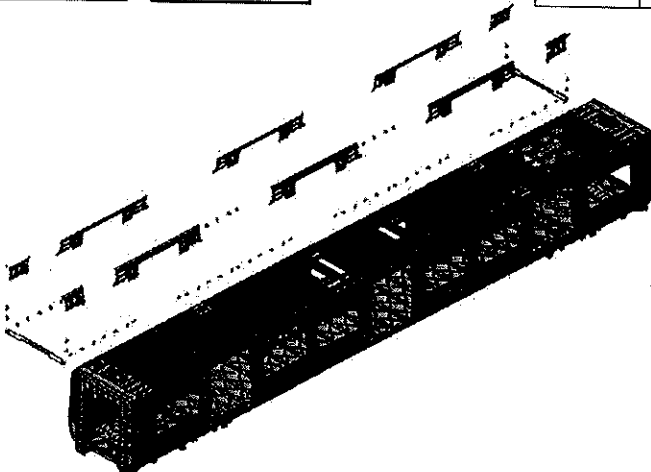
[illegible]

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

Car: M1,M3&M4	NCR:	Work station:	CB1220
---------------	------	---------------	--------




Safety Related





I - Documentation and Instruments Control



I.1 - Documentation Control

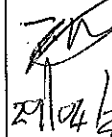
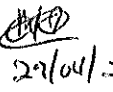
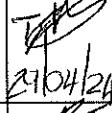
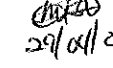
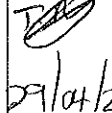


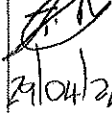

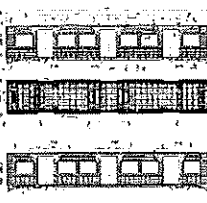
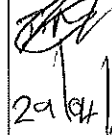
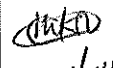
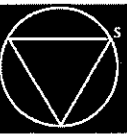
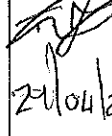

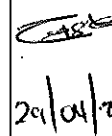
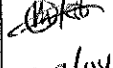
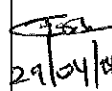
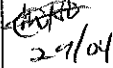

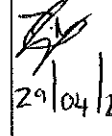

Document	Type of car					Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
	TGT	M1	M3	M4	TCS						
DTR30225487/2	✓					29	29/10/24	✓		N/A	 29/09/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process						
Instrument	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
Measuring tape	GIBEL001	22/09/24	✓		 29/04/24	 29/04/24
Turbulal	32823-3	15/08/25	✓			

I.3 Consumables

Welding Consumable Control - Used for Special Process						
Filler Material	Roll Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
Welding wire	E23067	MIG Welding	✓		 29/08/05	 29/04/24

GIBELQ		CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2		Rev. 29 Date 28/10/2023	Project: PRA5A SI.CB1220.250.V29		
II - Self Inspection - Items to Check							
II.1 - Items to check							
Item	Picture/Drawing	Description	Acceptance criteria / Record	✓		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB1220.DTR30225487/2	✓		 29/04/24	 29/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		 29/04/24	 29/04/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 29/04/24	 29/04/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 29/04/24	 29/04/24
05		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		 29/04/24	 29/04/24
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓		 29/04/24	 29/04/24
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: Temperature Min - Max (I) Min-Max Relative humidity Min - Max (I) 10°C - 35°C 25% - 60%	Sealant Batch No: <u>108 70-B</u> Exp Date: <u>09 / 06 / 24</u> Actuals Temperature: <u>20°C</u> Humidity: <u>35%</u>	✓		 29/04/24	 29/04/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓		 29/04/24	 29/04/24
09		Verification of safety welds	Approved according to DTD000210658 reference and Self inspection	✓		 29/04/24	 29/04/24



CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

Rev.
29
Date
28/10/2023

Project: PRASA

SI.CB1220.250.V29

II - Self Inspection - Items to Check

SEALANT APPLICATION




AREA 1 & 2 END 1

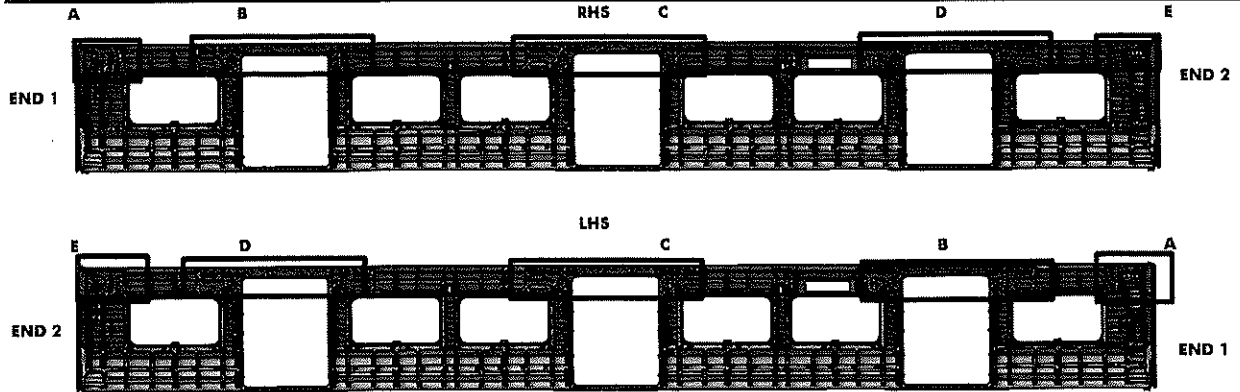
Operator (Name & sign):

M. H. Kozs

Operator (Name & sign):

P. Scilla

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB1220.250.V29
		29	
		Date	
		28/10/2023	
II - Self Inspection - Items to Check			



REINFORCEMENT WELDING

AREA	LHS	RHS
A	Operator (Name&sign): <u><i>[Signature]</i></u>	<u><i>[Signature]</i></u>
B	Operator (Name&sign): <u><i>[Signature]</i></u>	<u><i>[Signature]</i></u>
C	Operator (Name&sign): <u>MATSUOKA Maki</u>	<u>MATSUOKA Maki</u>
D	Operator (Name&sign): <u><i>[Signature]</i></u>	<u><i>[Signature]</i></u>
E	Operator (Name&sign): <u><i>[Signature]</i></u>	<u><i>[Signature]</i></u>

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

II - Self Inspection - Items to Check

BRACKETING

INSTALLATION

C-RAILS:

DOOR MECHANISMS:

TAPPING PADS

Operator: *[Signature]*

Operator: *[Signature]*

Operator: *[Signature]*

Operator: *[Signature]*

Operator: *[Signature]*

Operator: *[Signature]*

INSTALLATION & VERIFICATION

SEAT & LUGGAGE BRACKETS:

SEAT BRACKETS VERIFICATION:

Operator: *[Signature]*

Operator: *[Signature]*

Operator: *[Signature]*

Operator: *[Signature]*

WELDING

AREA

LHS

RHS

A (Seat brackets)
(C-rails, Luggage and earth bushes)

Operator (Name&sign): *[Signature]*
Operator (Name&sign): *[Signature]*

Operator (Name&sign): *[Signature]*
Operator (Name&sign): *[Signature]*

B (Seat brackets)
(C-rails, Luggage and earth bushes)

Operator (Name&sign): *[Signature]*
Operator (Name&sign): *[Signature]*

Operator (Name&sign): *[Signature]*
Operator (Name&sign): *[Signature]*

C (Seat brackets)
(C-rails, Luggage and earth bushes)

Operator (Name&sign): *[Signature]*
Operator (Name&sign): *[Signature]*

Operator (Name&sign): *[Signature]*
Operator (Name&sign): *[Signature]*

D (Seat brackets)
(C-rails, Luggage and earth bushes)

Operator (Name&sign): *[Signature]*
Operator (Name&sign): *[Signature]*

Operator (Name&sign): *[Signature]*
Operator (Name&sign): *[Signature]*

ENDS

END 1 TAPPING PADS WELDING: Operator (Name&sign): *[Signature]*

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

6



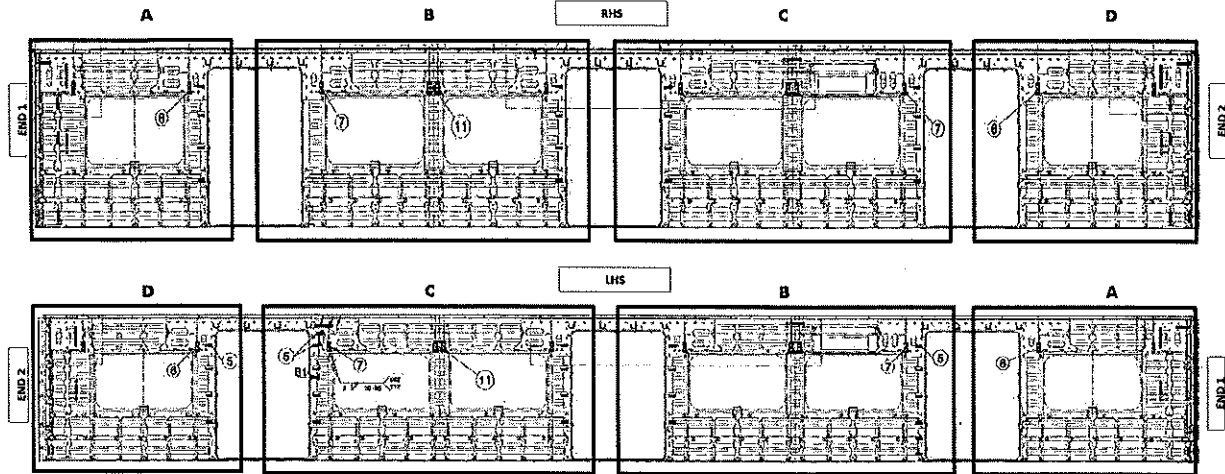
CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30226487/2

Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB1220.250.V29

II - Self Inspection - Items to Check

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

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

ROOF ENDS:
CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: _____

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

ROOF ENDS:
CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: _____

QUANTITIES (M1)

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

ROOF ENDS:
CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

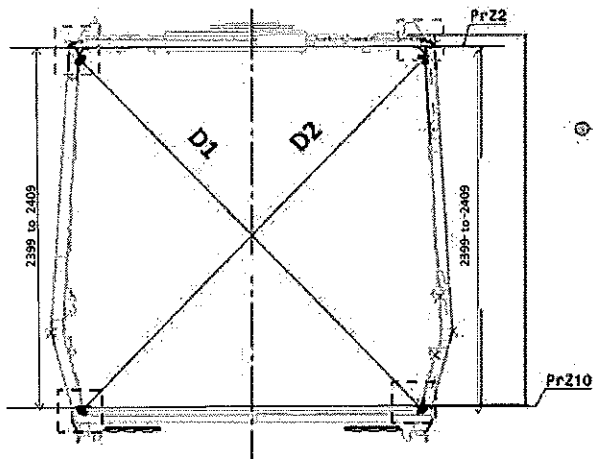
VERIFICATION BY: Tetelo

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

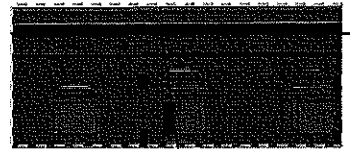
ROOF ENDS:
CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: Tetelo

Specifications of Details for CBS measurement



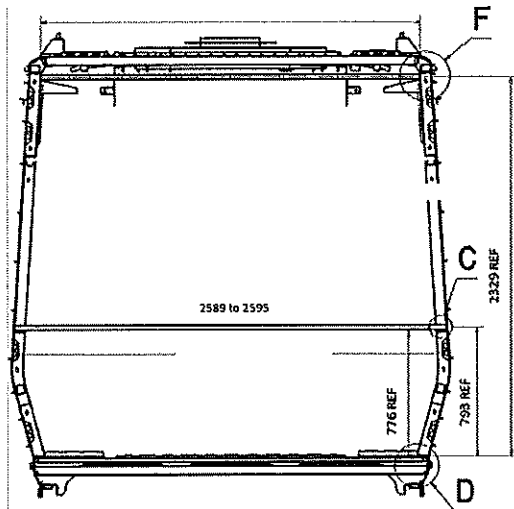
Measurement positions on roof rail and sidewall omega corner.



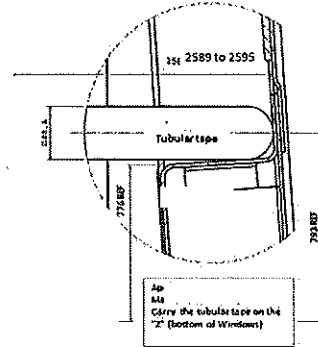
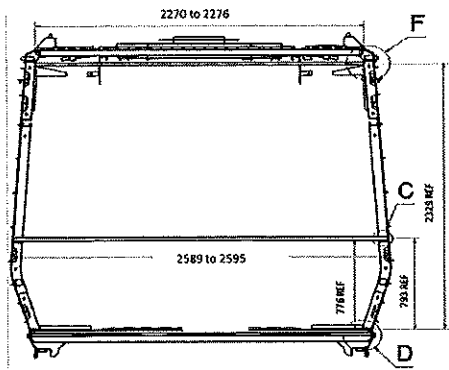
Reinforcement area measurement positions on roof reinforcement area.



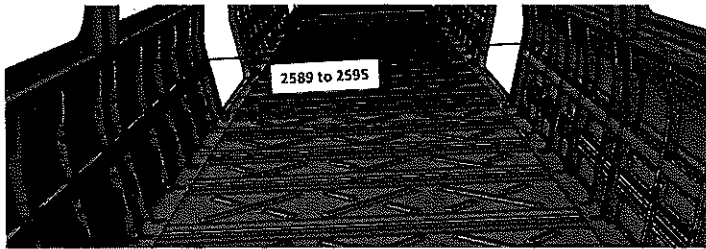
Measurement positions on skewed and side sill corner.



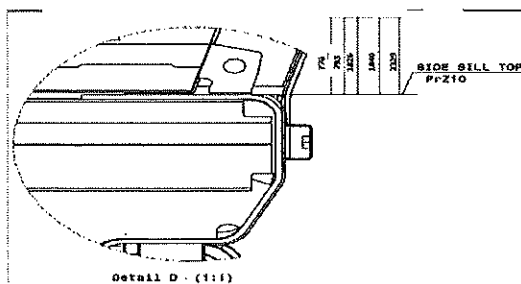
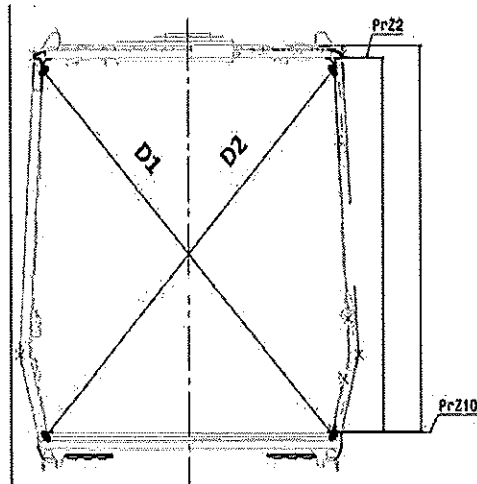
CBS measurement




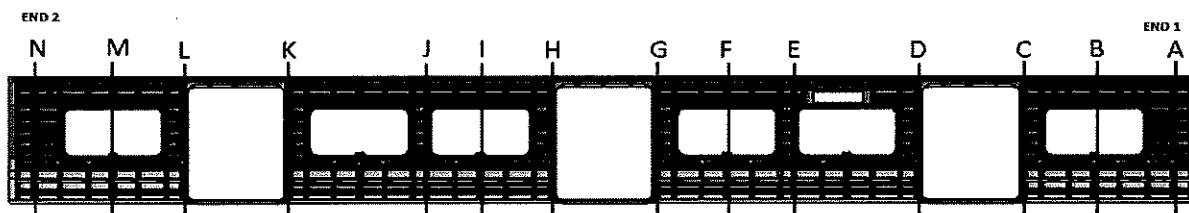
Detail C



Take measurement close to radius



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

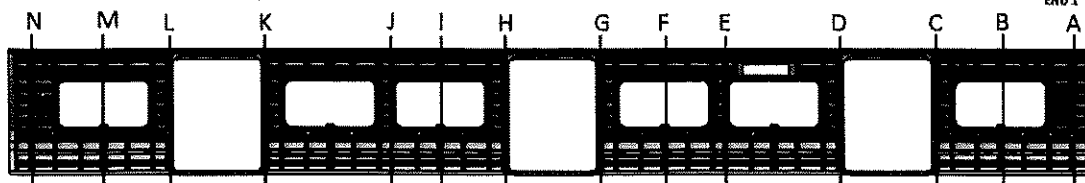


BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3297	3	
B	3265	3263	2	
C	3299	3297	2	
D	3300	3298	2	
E	3265	3267	2	
F	3267	3269	2	
G	3298	3296	2	
H	3300	3297	3	
I	3265	3266	1	
J	3267	3265	2	
K	3296	3297	1	
L	3297	3298	1	
M	3268	3266	2	
N	3299	3297	2	

CBS measurement

END 2

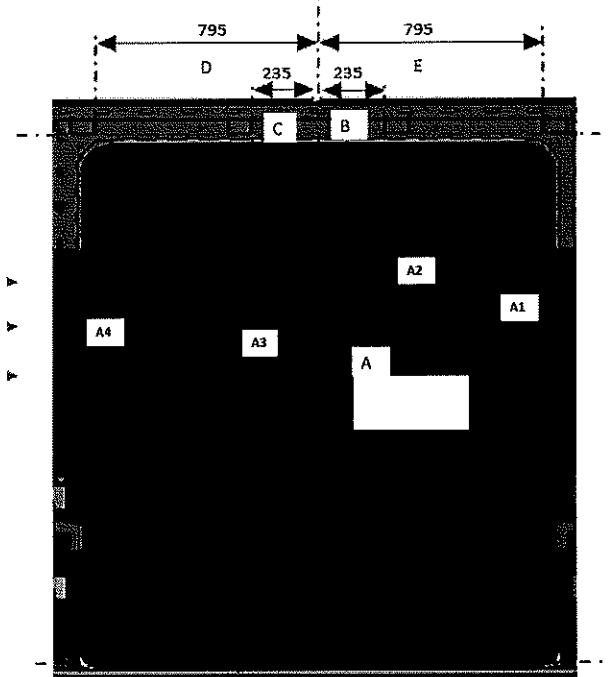


END 1

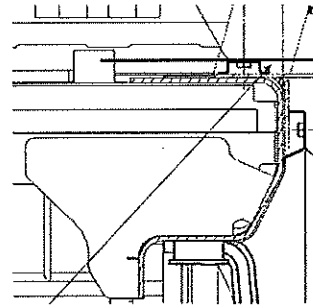
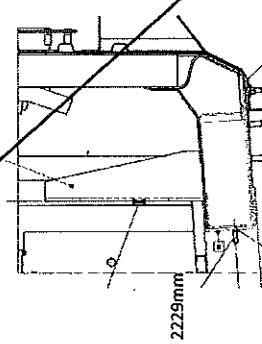
AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3297	3	2589
B	3265	3267	2	2590
C	3297	3299	2	2591
D	3300	3297	3	2592
E	3265	3267	2	2593
F	3266	3267	1	2590
G	3297	3298	1	2591
H	3299	3297	2	2592
I	3297	3295	2	2591
J	3296	3297	1	2591
K	3297	3295	2	2591
L	3296	3297	1	2590
M	3265	3267	2	2591
N	3300	3297	3	2592

Specifications of Details for CBS measurement CB1220



Brackets Carbodysshell
U Type Supports



Brackets Carbodysshell
Channel Assy

DOOR 1 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
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	796

DOOR 2 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
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

DOOR 2 - RHS

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

DOOR 1 - RHS

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

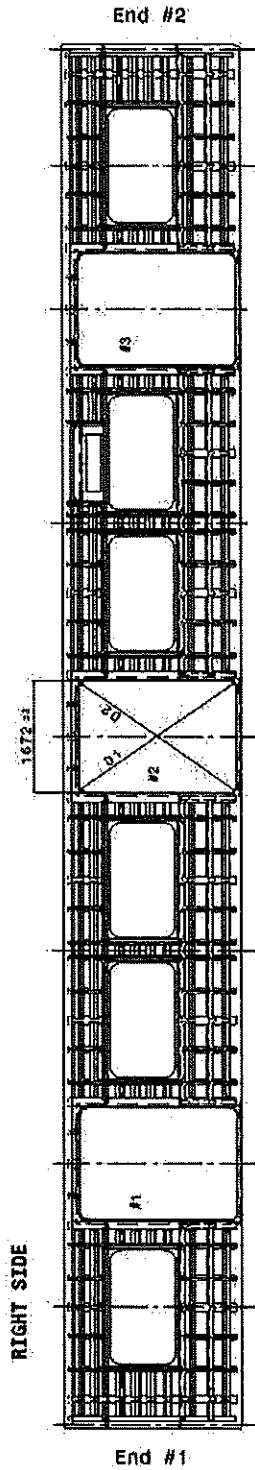
DOOR 2 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2231
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	794

DOOR 3 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
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	794
E	794 to 796	795

Specifications of Details for CBS measurement CB1220



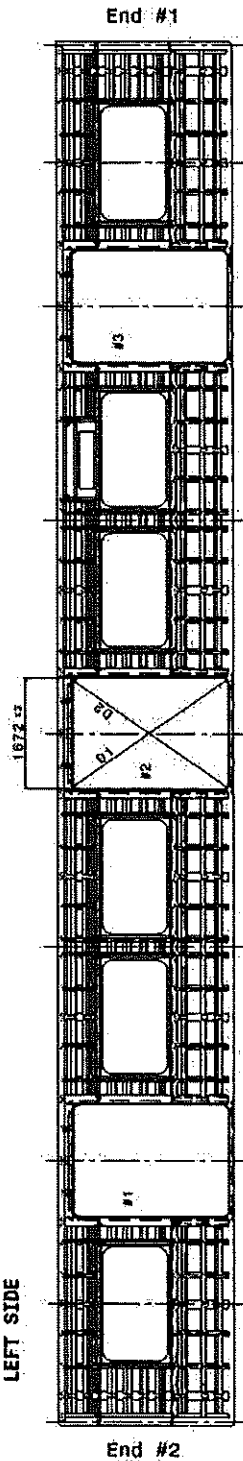
Doors diagonal D1-D2 maximum difference ≤ 4mm

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

Doors length - 1672 mm

#1	#2	#3
HIGHER DIMENSION 1671	1672	1671
CENTRAL DIMENSION 1672	1671	1670
LOWER DIMENSION 1670	1672	1670

LEFT SIDE








Doors diagonal D1-D2 maximum difference ≤ 4mm


#1	#2	#3
D1 2751	2751	2751
D2 2750	2751	2750
D1-D2 0	2	1

Doors length - 1672 mm

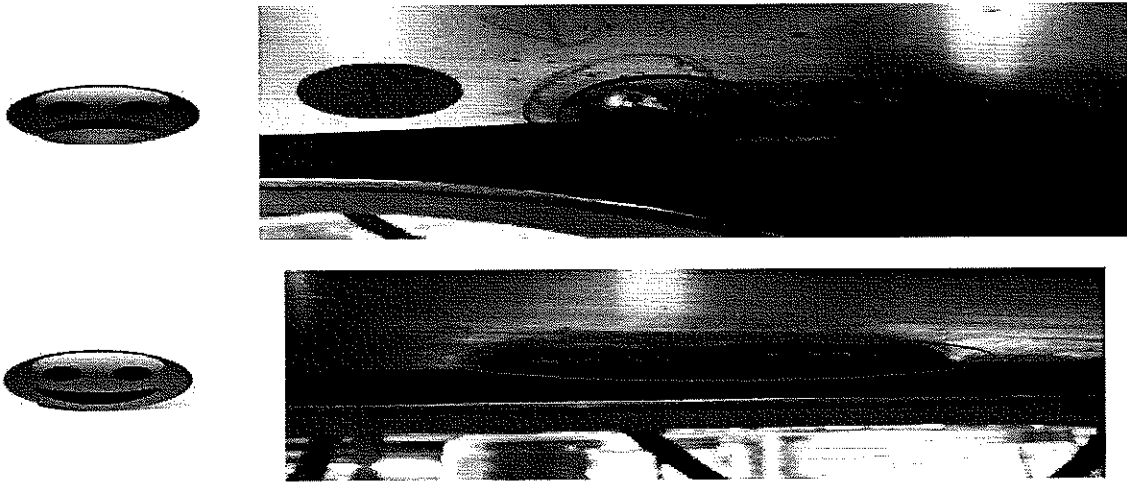
#1	#2	#3
HIGHER DIMENSION 1670	1672	1670
CENTRAL DIMENSION 1670	1672	1670
LOWER DIMENSION 1671	1671	1671

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB1220.250.V29				
		29					
		Date					
		28/10/2023					
CBS measurement (Manufacturing)							
Dye penetrant test							
Dye-penetration test to be performed by quality personnel							
							
Item	Description of the issue					Signature/Date (Manufacturing)	Signature/Date (Quality)
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				

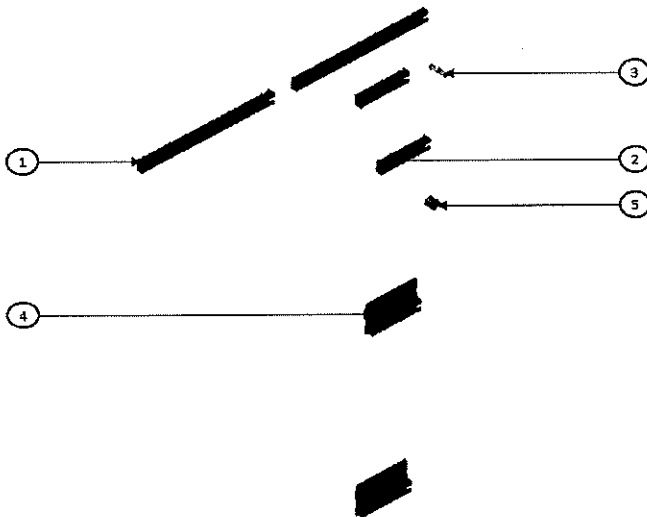
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB1220.250.V29		
		29			
		Date			
		28/10/2023			
Self Inspection - Final Result					
Is the car good to advance to the next workstation/process? (Approval of Operations Manager and Industrial Quality)		DATE	NAME	SIGNATURE	
HOLD POINT	✓	(If activities are not complete, the missing activities must not impact the next stage)	29/04/24	Tebedo Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	29/04/24	Kelebone Industrial Quality	
	There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			Operations	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)			Industrial Quality
In case of "NO GO", describe blocking problems					
In case of "NO GO", the operations manager must define below action plan to ensure "GO":					
Item	Description		Responsible	Due date	Status
Operations		Quality			

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB1220.250.V29
		29	
		Date	
		28/10/2023	

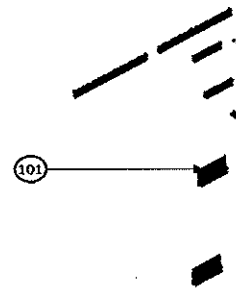
ANNEXURE A: Arc Welding Quality Acceptance Standard



Station: CB1220-004- U108 & U107



PART NO.	ITEM NO.	QTY	DESCRIPTION	MASS [kg]
DTR000074038	5	6	EARTH STUD 6	0.036
AA00001201848	4	6	ASSEMBLY SUPPORT	0.271
DTR0000348305	3	12	WELDING STUD ISO13918 PT -- M8X20 - SST	0.007
AA00001180424	2	12	ASSEMBLY SUPPORT	0.193
AA00001186418	1	14	ASSEMBLY SUPPORT	0.522
AA00001161080	101	6	CARBODYSHELL BRACKETS CARBODYSHELL M1/M3/M4 CARSIDE FRAME ANCHORE END - QPP	12.132




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.

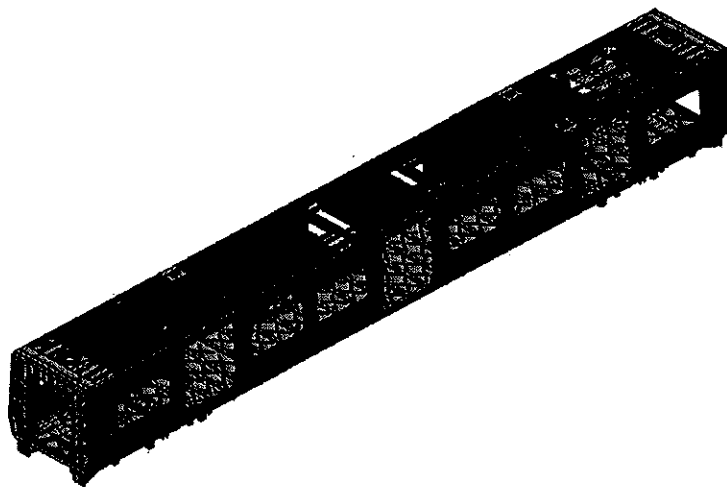
APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ? 	
				TCS	M4	M1	M2	M3	TCS			
<input type="checkbox"/>	DTR3000152669	AAD0001278568	CARBOYSHELL M1,M3,M4 ASSEMBLY	CB2230			X				PRA.CB2230.DT000002 25487.V20	YES
<input type="checkbox"/>	DTR3000152673	AAD0001278568	CARBOYSHELL M1,M3,M4 ASSEMBLY	CB2230		X			X		PRA.CB2230.DT000002 25487.V20	YES
<input type="checkbox"/>												
REV	DATE	MODIFICATION CONTENT			RESPONSIBLE		NAME		DATE			
0	2018/08/02	GIBELA NEW CREATION			APPROVER		Philippe Marques		2018/08/02			
					CHECKER		Nosizo Pindela		2018/08/02			
					COMPILER		Nosizo Pindela		2018/08/02			
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager			APPROVER		Itumeleng Modiba		30/5/2018			
					CHECKER		Nosizo Pindela		30/5/2018			
					REVISED BY		Nosizo Pindela		30/5/2018			
2	2018/05/07	Certain dimensional checks moved to CB1220			APPROVER		Itumeleng Modiba		2018/05/07			
					CHECKER		Nosizo Pindela		2018/05/07			
					REVISED BY		Ramokone Motama		2018/05/07			
5	24/01/2019	As per Baseline 10.2			APPROVER		Itumeleng Modiba		24/01/2019			
					CHECKER		Nosizo Pindela		24/01/2019			
					REVISED BY		Vanessa Ntuli		24/01/2019			
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements			APPROVER		Itumeleng Modiba		13/03/2019			
					CHECKER		Nosizo Pindela		13/03/2019			
					REVISED BY		Nosizo Pindela		13/03/2019			
10	23/08/2019	New Baseline 10.2.5			APPROVER		Itumeleng Modiba		23/08/2019			
					CHECKER		Nosizo Pindela		23/08/2019			
					REVISED BY		Nosizo Pindela		23/08/2019			
15	06/08/2020	New Baseline 10.2.6			APPROVER		Timothy Maimela		06/08/2020			
					CHECKER		Bongane Masina					
					REVISED BY		Bongane Masina					
20	19/04/2021	New Baseline change 10.3			APPROVER		Timothy Maimela		19/04/2021			
					CHECKER		Bongane Masina					
					REVISED BY		Bongane Masina					
25	20/02/2022	New Baseline change 10.3.1			APPROVER		Collins Mbombhi		20/02/2022			
					CHECKER		Andani Muthelo					
					REVISED BY		Andani Muthelo					
26	14/06/2022	Update minimum temperature requirement for sealant application			APPROVER		Collins Mbombhi		14/06/2022			
					CHECKER		Andani Muthelo					
					REVISED BY		Andani Muthelo					
27	26/07/2022	Threshold measurements addition			APPROVER		Collins Mbombhi		26/07/2022			
					CHECKER		Andani Muthelo					
					REVISED BY		Andani Muthelo					
28	17/10/2022	Added traceability of sealant application			APPROVER		Collins Mbombhi		17/10/2022			
					CHECKER		Ntokozo Zwane					
					REVISED BY		Amogelang Mohlampe					
29	14/04/2023	Added sealant batch number & welding consumables traceability			APPROVER		Vanessa Ntuli		14/04/2023			
					CHECKER		Ntokozo Zwane					
					REVISED BY		Amogelang Mohlampe					
30	06/11/2023	Added threshold traceability for boiler makers and welders			APPROVER		Ngobeni Tyson		06/11/2023			
					CHECKER		Andani Muthelo					
					REVISED BY		Ntokozo Zwane					
TRAINSET	CAR	OPERATOR NAME & ALPS NO		DATE	SELF INSPECTION NUMBER		PAGES					
225	M1	TAKSI 4171409		30.04.24	SI.CB2230.256.V29		12					

	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30	Project: PRASA SI.CB2230.256.V29
		Date 08/11/2023	
Car:	NCR:	Work station: CB2230	



Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car					Revision	Observation		Signature/Date (Operations)	Signature/Date (Quality)
	M1	M3	M4	M5	T01					
PRA.CB2230.DT00000225487	X					V30		OK	N/A	30/04/24

I.2 - Instruments Control

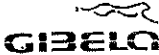

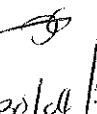
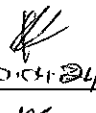
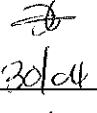
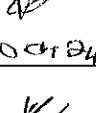
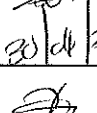

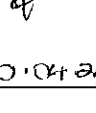
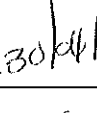
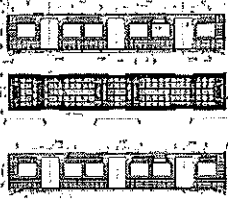


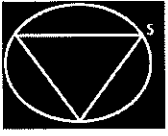
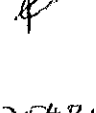
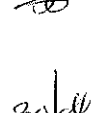


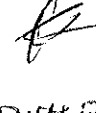
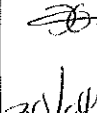
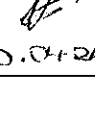
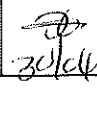
Monitoring and Measuring Instrument Control - Used for Special Process


Instruments	Serial number	Calibration or Verification Validation Date			Signature/Date (Operations)	Signature/Date (Quality)
TUBULAR	027113	20/06/24	OK		30/04/24	30/04/24
MEASURING C. TAP	318074	25/04/25	OK		30/04/24	30/04/24
COMBINATION SQUARE	C18052	27/07/24	OK		30/04/24	30/04/24

1.3 Consumables

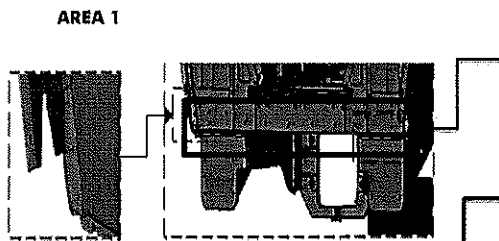
Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process			Signature/Date (Manufacturing)	Signature/Date (Quality)
AUTROD 308 LG	E221880	MIG	OK		30/04/24	30/04/24


		CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487		Rev. 30 Date 08/11/2023	Project: PRASA SI.CB2230.256.V29							
II - Self Inspection - Items to Check												
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 n° PRA.CB1230.DT00000225487 Verification of fillet for all brackets.	PRA.CB1230.DT00000225487	<input checked="" type="checkbox"/>		 30/04/24  30/04/24						
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	<input checked="" type="checkbox"/>		 30/04/24  30/04/24						
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	<input checked="" type="checkbox"/>		 30/04/24  30/04/24						
		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	<input checked="" type="checkbox"/>		 30/04/24  30/04/24						
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	<input checked="" type="checkbox"/>		 30/04/24  30/04/24						
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	<input checked="" type="checkbox"/>		 30/04/24  30/04/24						
07	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" style="width: 100%;"> <tr> <td>Temperature Min - Max (1)</td> <td>Min-Max</td> <td>10°C - 35°C</td> </tr> <tr> <td>Relative humidity Min - Max (1)</td> <td>Min-Max</td> <td>25% - 80%</td> </tr> </table>	Temperature Min - Max (1)	Min-Max	10°C - 35°C	Relative humidity Min - Max (1)	Min-Max	25% - 80%	<p>Sealant Batch No: <u>152108</u></p> <p>Exp Date: <u>06/24</u></p> <p>Actuals</p> <p>Temperature: <u>20°C</u></p> <p>Humidity: <u>60%</u></p>	<input checked="" type="checkbox"/>		 30/04/24  30/04/24
Temperature Min - Max (1)	Min-Max	10°C - 35°C										
Relative humidity Min - Max (1)	Min-Max	25% - 80%										
08	N/A	Verification of sealant application on the roof and sidewall finishers.	<p>Sealant must be:</p> <ul style="list-style-type: none"> -Applied straight and even -Free of gaps,cracks,damage and debris (flashes, dirt, dust) <p>Refer to Annexure B</p>	<input checked="" type="checkbox"/>		 30/04/24  30/04/24						
09	N/A	Verification of sealant application in certain regions in the drawing.	AAD0001278566	<input checked="" type="checkbox"/>		 30/04/24  30/04/24						

	CARBODYSHELL M1,M3,M4 ASSEMBLY¹ DT00000225487	Rev. 30	Project: PRASA SI.CB2230.256.V29
		Date 08/11/2023	
		II - Self Inspection - Items to Check	

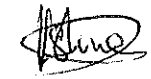
END 2 SEALANT




OPERATOR
(Name & sign):

Levey 

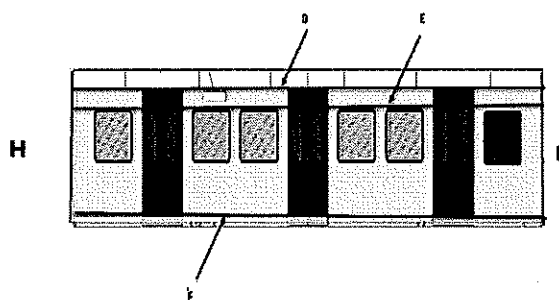
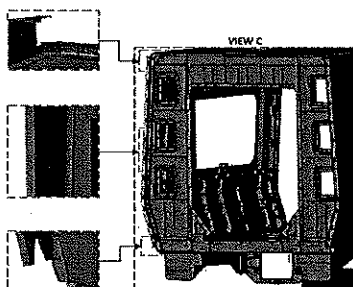
OPERATOR
(Name & sign):

Levey 

OPERATOR
(Name & sign):

Levey 

AREA 2 (VIEW C)



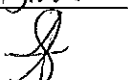
Area D,E,F,G,H,I

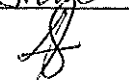
Operator (Name & sign) :

LHS
D,E,G,H,I top

RHS
D,E,G,H,I top

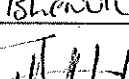
Operator (Name & sign) :

Sihle


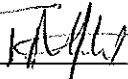
Sihle


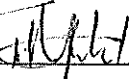
Operator (Name & sign) :

Tshenolo


Tshenolo


Operator (Name & sign) :

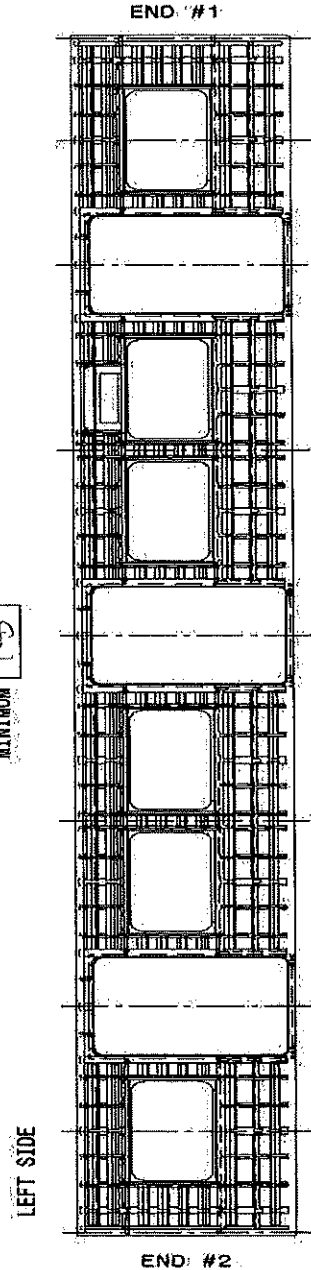
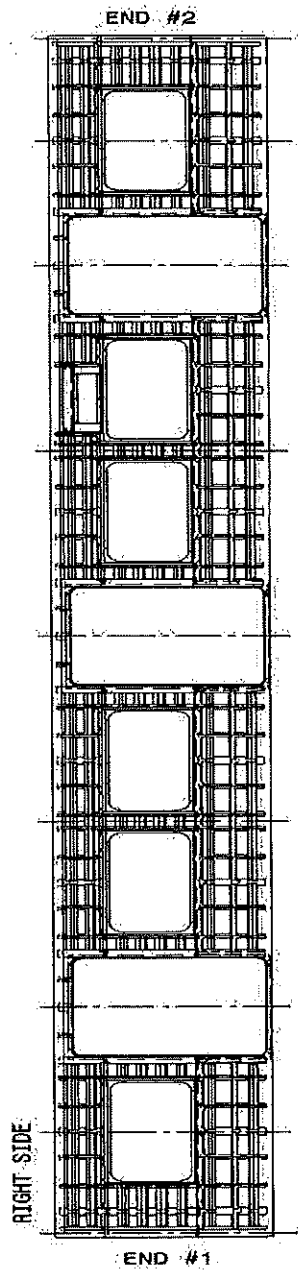




Operator (Name & sign) :

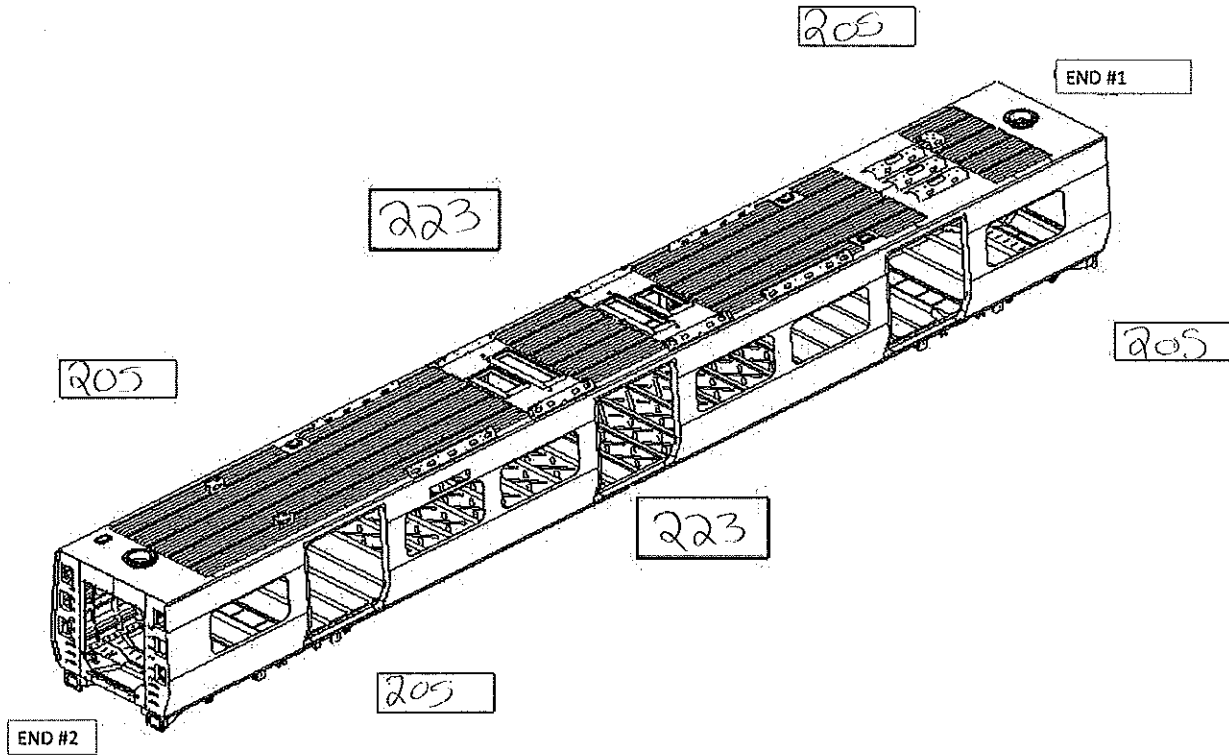
Specifications of Details for CBS measurement CB1230

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



Specifications of Details for CBS measurement CB1230

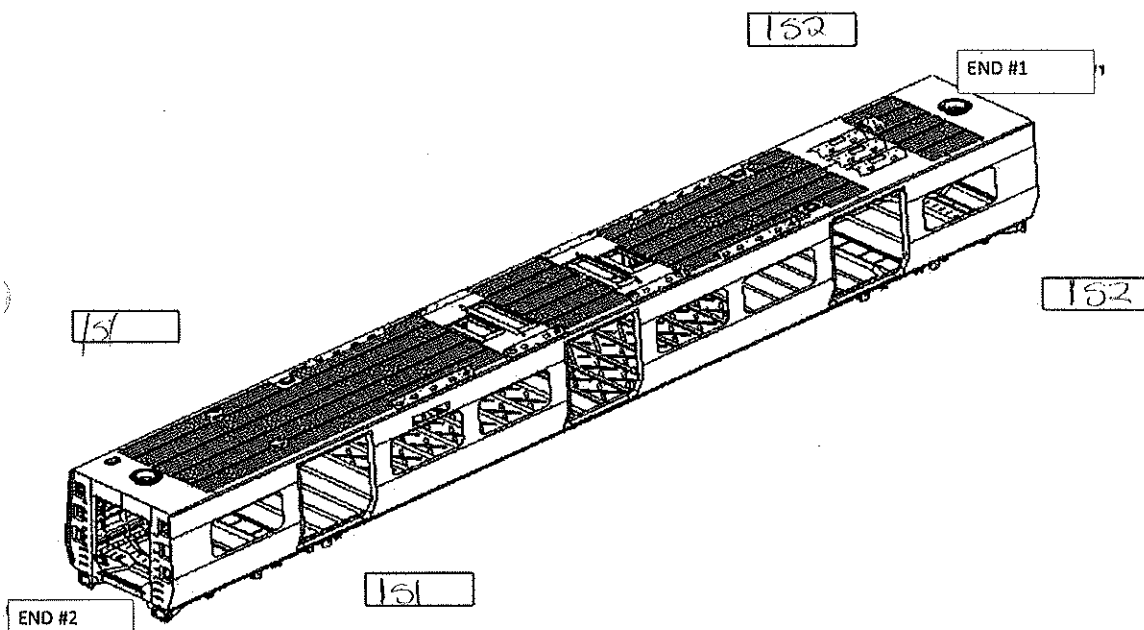
Specified Camber for car out of jig is 18mm(-0mm + 2mm)



MEASURED CAMBER VALUES	
RIGHT	i1. 19
LEFT	s1. 19

Specifications of Details for CBS measurement CB1230

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



TWIST FOUND ON END 1

TRANVERSE

0

LONGITUDINAL

1

TWIST FOUND ON END 2

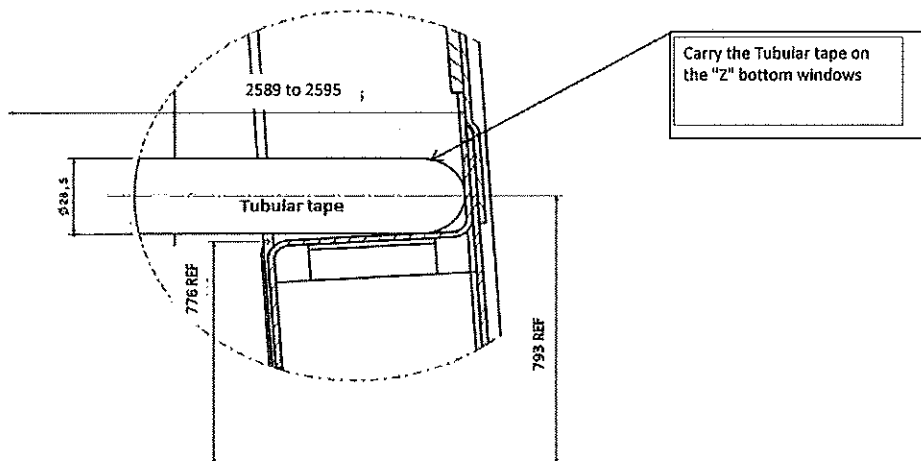
TRANVERSE

0

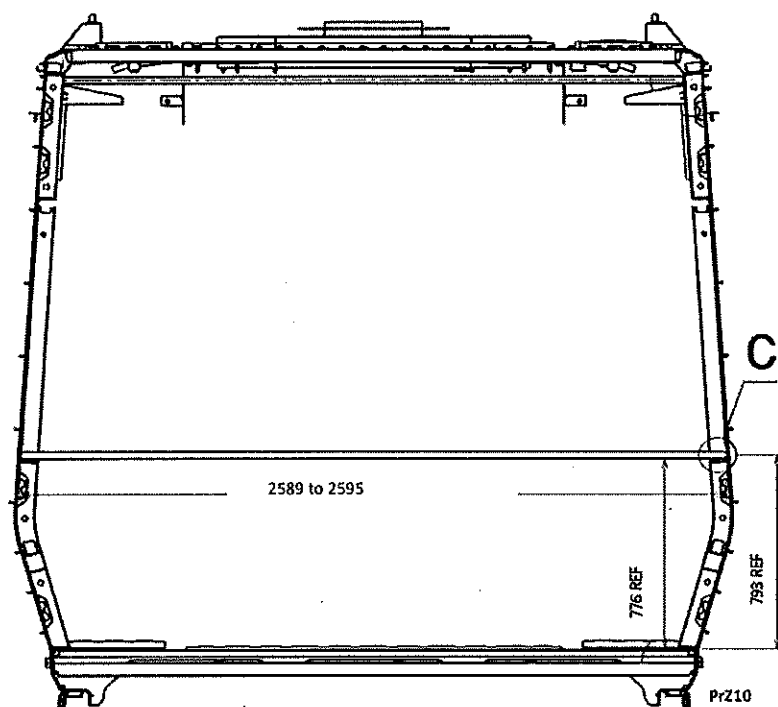
LONGITUDINAL

1

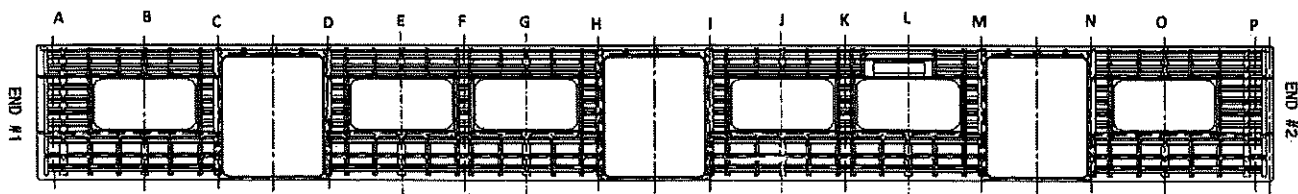
Specifications of Details for CBS measurement CB1230



Detail C

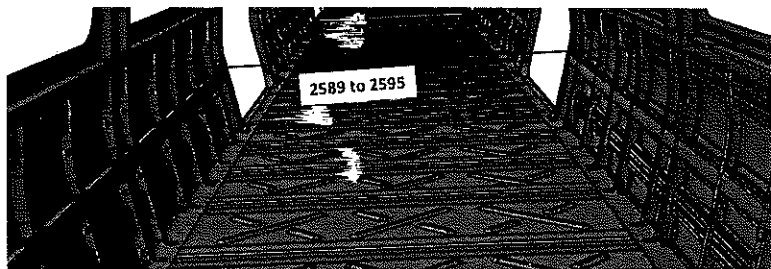


Specifications of Details for CBS measurement CB1230



2589 to 2595mm

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




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: Mr. Mathapelo Wick
WELDER: _____

Dye penetrant test


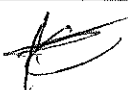

Dye-penetration test to be performed by quality personnel



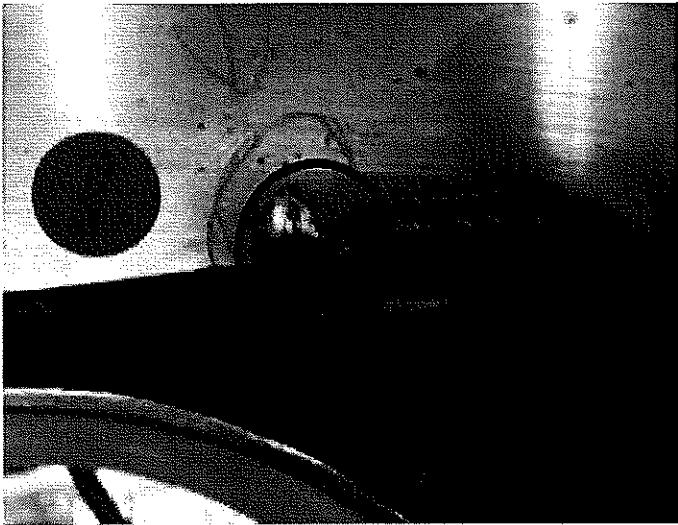
	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev.	Project: PRASA SI.CB2230.256.V29
		30	
		Date	
		08/11/2023	


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

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

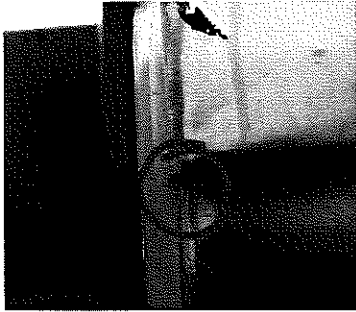
	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000226487	Rev. 30	Project: PRASA SI.CB2230.256.V29		
		Date 08/11/2023			
Self Inspection - Final Result					
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)		DATE	NAME	SIGNATURE	
HOLD POINT	(If activities are not complete, the missing activities must not impact the next stage)	30.04.24	KHOSI Operations		
		30/04/24	Andani Industrial Quality		
	There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			Operations	
	There are non-conformities impact the quality of the product and there is no corrective action defined yet)			Industrial Quality	
In case of "NO GO", describe blocking problems					
In case of "NO GO", the operations manager must define below action plan to ensure "GO":					
Item	Description	Responsible	Due date	Status	
Operations		Quality			

ANNEXURE A: Arc Welding Quality Acceptance Standard



	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30	Project: PRASA SI.CB2230.256.V29
		Date 08/11/2023	

ANNEXURE B: Sealant



100