

GIBELA

PRASA PROJECT

APPLICABLE FROM TRAINSET 190+ AS PER BASELINE 10.4

## 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

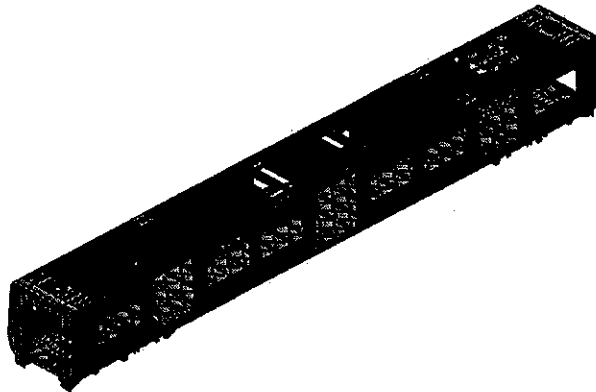
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?		
				TC	M1	M2	M3	M4	TC				
<input type="checkbox"/>	DTR3000152644	AA00001278566	CARBODYSHELL M3,M4 ASSEMBLY	CB2210		X				X		PRA.CB2210.DTR3022S 487/3.V30	YES
<input type="checkbox"/>													
REV	DATE	MODIFICATION CONTENT			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 CB2210			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						
					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						
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING			APPROVER		Mbhombi collins		17/08/2021				
					CHECKER		Mpho Mulaudzi						
					REVISED BY		Mpho Mulaudzi						
25	19/02/2022	New Baseline change 10.3.1			APPROVER		Mbhombi collins		19/02/2022				
					CHECKER		Andani Muthelo						
					REVISED BY		Andani Muthelo						
26	14/04/2023	Addition of welding consumable traceability			APPROVER		Ntuli Vanessa		14/04/2023				
					CHECKER		Mohlampe Amogelang						
					REVISED BY		Mohlampe Amogelang						
30	20/07/2023	New Baseline change 10.4			APPROVER		Ngobeni Tyson		28/07/2023				
					CHECKER		Mohlampe Amogelang						
					REVISED BY		Mohlampe Amogelang						
31	07/11/2023	Added traceability for welding sections			APPROVER		Ngobeni Tyson		07/11/2023				
					CHECKER		Mohlampe Amogelang						
					REVISED BY		Ntokozo Zwane						
TRAINSET	CAR	OPERATOR NAME & ALPS NO		DATE	SELF INSPECTION NUMBER		PAGES						
225	M3	12000 442933		20/04/24	SI.CB2210.254.V30		17						

	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	

Car: M3 & M4	NOR:	Work station: CB2210
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Safety Related



### I - Documentation and Instruments Control

#### I.1 - Documentation Control

Document	Type of car						Revisions	Observation	In	Signature/Date (Manufacturing)	Signature/Date (Quality)
	1	2	3	4	5	6					
DTR30225487/3			X				28		✓	<i>[Signature]</i> 30/04/24	<i>[Signature]</i> 30/04/24

#### I.2 - Instruments Control


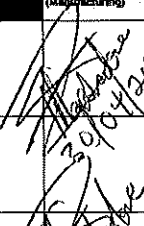
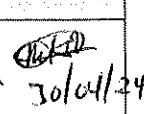
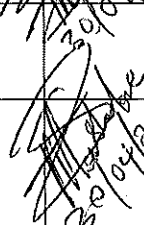
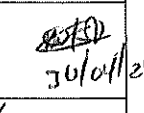
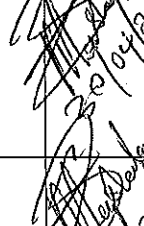
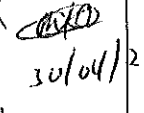

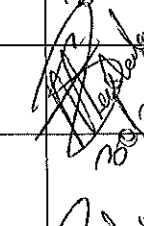
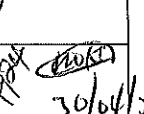
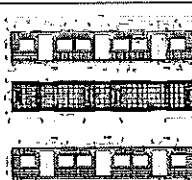

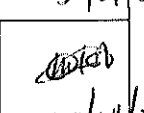

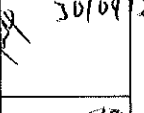
##### Monitoring and Measuring Instrument Control - Used for Special Process


Instrument	Serial number	Calibration or Verification Validation Date	In	Signature/Date (Manufacturing)	Signature/Date (Quality)
Tubular	32823-2	15/08/25	✓	<i>[Signature]</i>	
Laser tape	125423924	08/01/25	✓	<i>[Signature]</i>	<i>[Signature]</i> 30/04/24
3mm tape	GIBTP0102	18/11/24	✓	<i>[Signature]</i>	

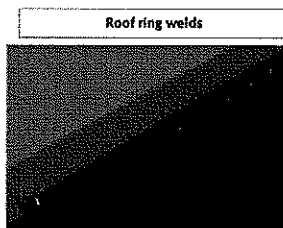
#### I.3 Consumables




##### Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	In	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER308LSi	314018-74097	MIG	✓	<i>[Signature]</i>	
ER308L	299687-70320	TIG	✓	<i>[Signature]</i>	<i>[Signature]</i> 30/04/24




		<b>CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3</b>		Rev. 31 Date 07/11/2023		<b>Project: PRASA</b> <b>SI.CB2210.254.V30</b>	
<b>II - Self Inspection - Items to Check</b>							
<b>II.1 - Items to check</b>							
Item	Picture/Drawing	Description	Acceptance criteria / Record			Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		 30/04/24	 30/04/24
02	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 • DTD0000210675	✓		 30/04/24	 30/04/24
03	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 30/04/24	 30/04/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 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.	✓		 30/04/24	 30/04/24
06	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.	✓		 30/04/24	 30/04/24

	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	
Welding Traceability			

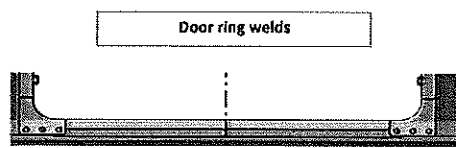


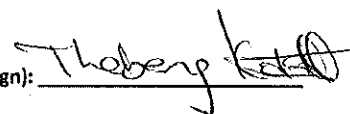
LHS	
Boiler maker (Name & Sign): <u>LUNGA</u> 	Welder (Name & Sign): <u>SIPHOKAZI</u> 
RHS	
Boiler maker (Name & Sign): <u>Sean</u>	Welder (Name & Sign): <u>SIPHOKAZI</u> 

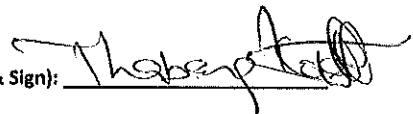
END 1

LHS	
Boiler maker (Name & Sign): <u>LUNGA</u> 	Welder (Name & Sign): <u>SIPHOKAZI</u> 
RHS	
Boiler maker (Name & Sign): <u>Sean</u>	Welder (Name & Sign): <u>SIPHOKAZI</u> 

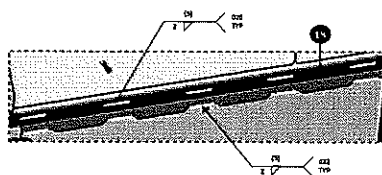
END 2

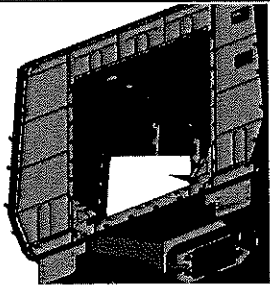


LHS
Boiler maker (Name & Sign): <u>Sean</u>
Welder (Name & Sign): <u>Thobeng</u> 

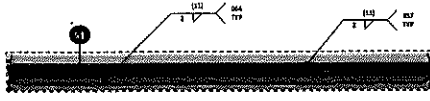
RHS
Boiler maker (Name & Sign): <u>Sean</u>
Welder (Name & Sign): <u>Thobeng</u> 

EUF Reinforcement Plates

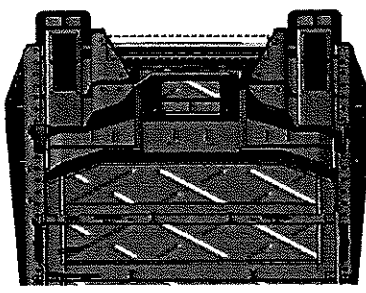




**END 1**  
Boiler maker (Name & Sign): Tumelo  
Welder (Name & Sign): Thabang

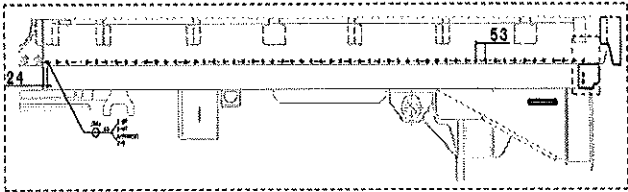


END 2




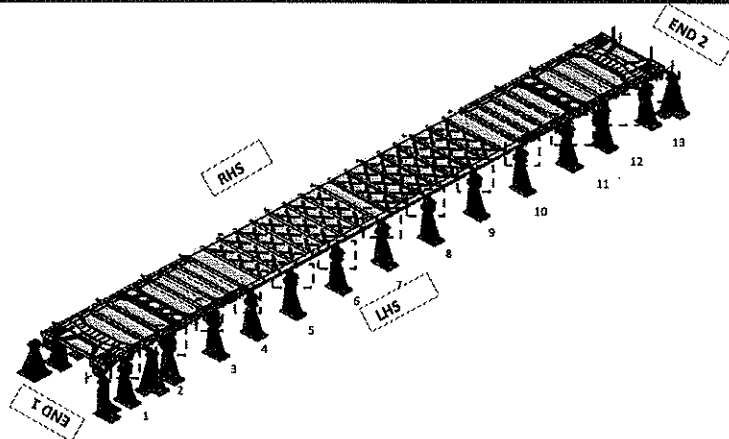
Underneath the CAR

**END 2**  
Boiler maker (Name & Sign): Justice  
Welder (Name & Sign): KEITH K. MAB



**FEDOLI**  
Operator: Lungu

	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	
<b>Specifications of Details for CBS measurement</b>			

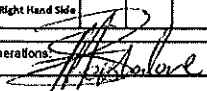


Measure gap between jig pillar / chair and underframe = 0mm. No gap.

After loading and clamping

Fill in the gap found on 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													
Right Hand Side													

Signature Operations:  Date: 20/04/24

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													
Right Hand Side													

Signature Industrial Quality: \_\_\_\_\_ Date: \_\_\_\_\_



CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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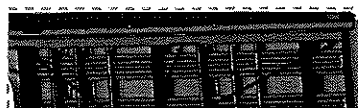
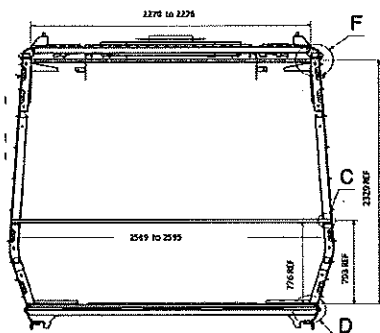
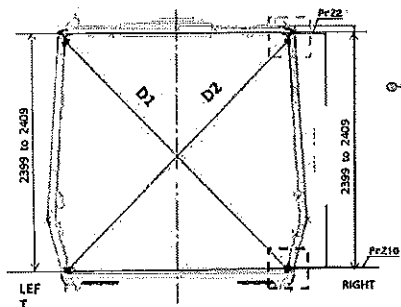
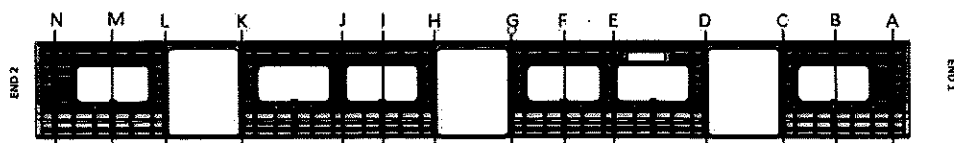
Date

07/11/2023

Project: PRASA

SI.CB2210.254.V30

### Specifications of Details for CBS measurement



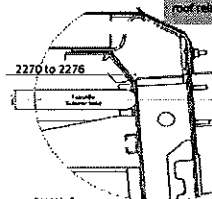
Measurement positions on roof rail and sidewall omega corner



Measurement positions on sidewall and side sill corner



Reinforcement area measurement position on roof reinforcement area



041813 F

2013, 2014, 2015, 2016, 2017, 2018, 2019, 2020, 2021, 2022, 2023



CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

Rev.

31

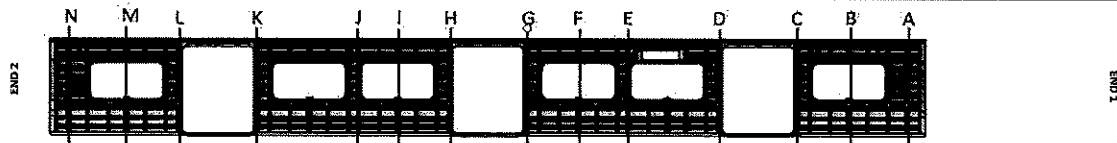
Date

07/11/2023

Project: PRASA

SI.CB2210.254.V30

## Specifications of Details for CBS 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 $\leq 2$
A	3267	3266	1	2406	2403	1
B	3265	3266	1	2404	2406	2
C	3265	3266	1	2406	2405	1
D	3266	3266	0	2405	2405	0
E	3263	3265	2	2406	2404	2
F	3267	3266	1	2404	2404	0
G	3268	3266	2	2406	2405	1
H	3267	3265	2	2405	2404	1
I	3266	3266	0	2405	2406	1
J	3265	3266	1	2406	2404	2
K	3264	3265	1	2405	2406	1
L	3268	3265	3	2407	2406	1
M	3267	3265	2	2407	2407	3
N	3268	3269	1	2408	2407	1



CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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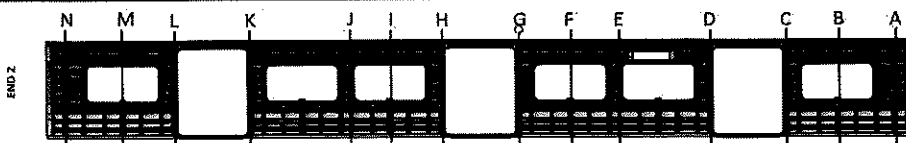
Date

07/11/2023

Project: PRASA


SI.CB2210.254.V30

## Specifications of Details for CBS measurement

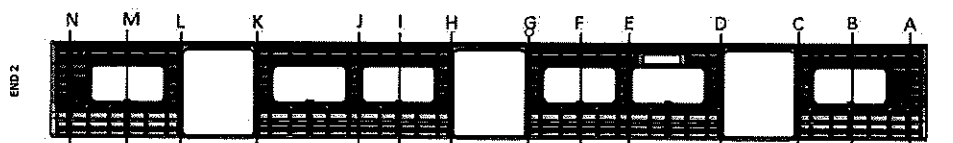
PME Column LHS - RHS should be  
≤ 2MM on each point.

## AFTER WELDING

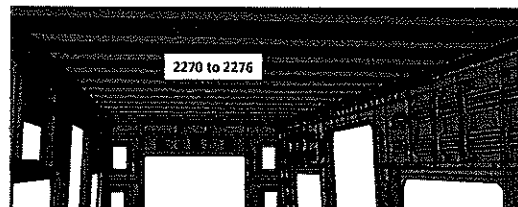
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3297	3298	1	2405	2404	1
B	3265	3262	3	2409	2405	1
C	3296	3295	1	2405	2406	1
D	3296	3297	1	2406	2406	0
E	3266	3265	1	2405	2404	1
F	3265	3267	2	2404	2403	1
G	3295	3295	0	2406	2403	3
H	3296	3297	1	2405	2406	1
I	3264	3265	1	2408	2404	2
J	3266	3265	1	2404	2405	1
K	3296	3295	1	2406	2405	1
L	3295	3296	1	2404	2405	1
M	3264	3266	2	2407	2405	2
N	3298	3297	1	2408	2409	1

	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	
CBS measurement			

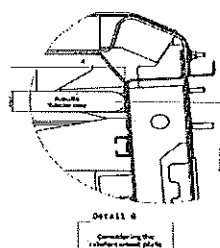
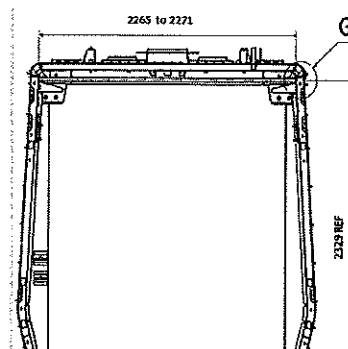
BEFORE WELDING




	2270 to 2276
A	2272
B	2271
C	2274
D	2270
E	2273
F	2271
G	2274
H	2276
I	2278
J	2276
K	2271
L	2271
M	2276
N	2276

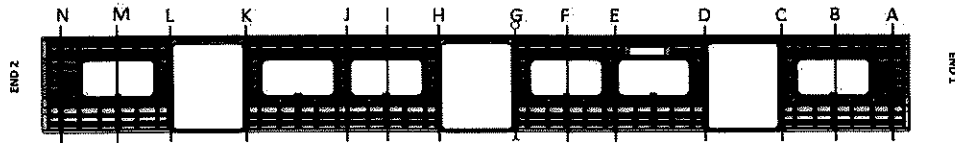


Do not consider reinforcement ( Take measurements top area of zee profile



	CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3	Rev. 31 Date 07/11/2023	Project: PRASA SI.CB2210.254.V30
CBS measurement			

# AFTER WELDING



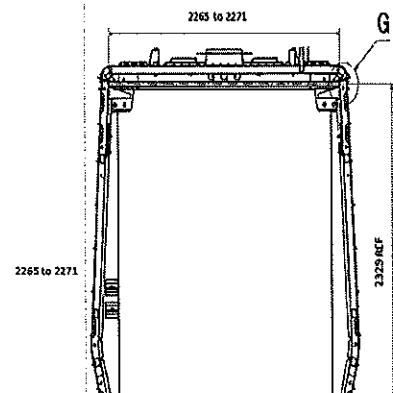
	2265 to 2271	2270 to 2276
A	2270	
B		2274
C	2269	
D	2267	
E		2273
F		2275
G	2269	
H	2271	
I		2273
J		2276
K	2268	
L	2270	
M		2274
N	2269	



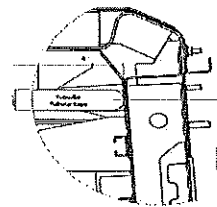
Do not consider reinforcement ( Take measurements top area of zee profile



Take measurement close to radius ( considering reinforcement)

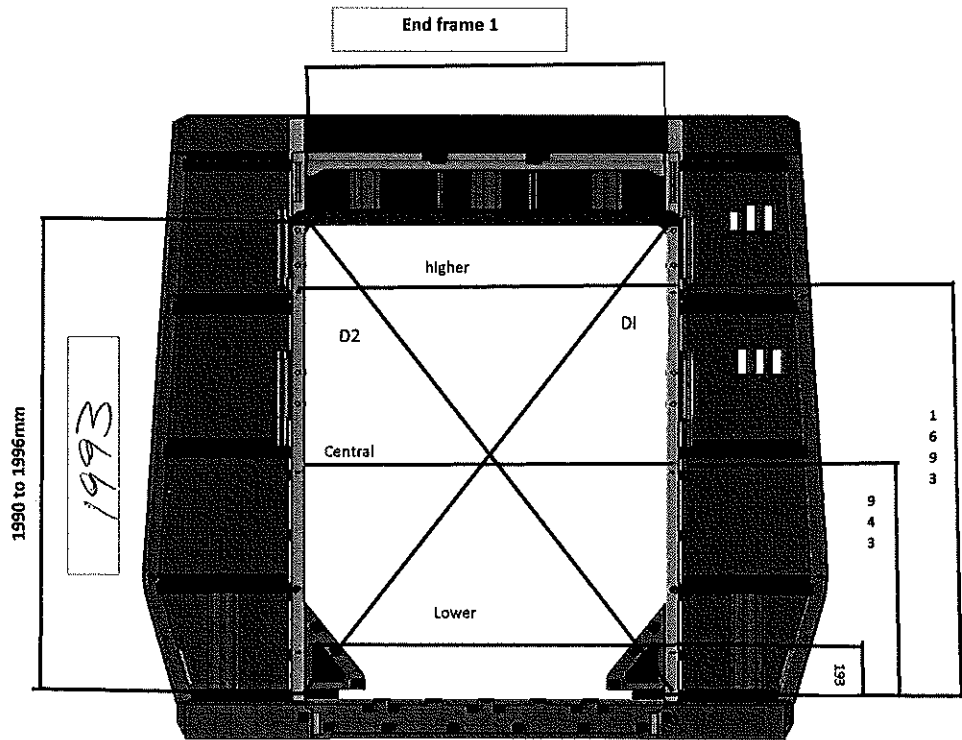


2265 to 2271



Detail d  
Considering the  
radius of the  
profile

**Specifications of Details for CBS measurement**



1380 to 1382 mm

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

Higher Dimension

1381

D1

2416

Central Dimension

1381

D2

2414

Lower Dimension

1381

D1-D2

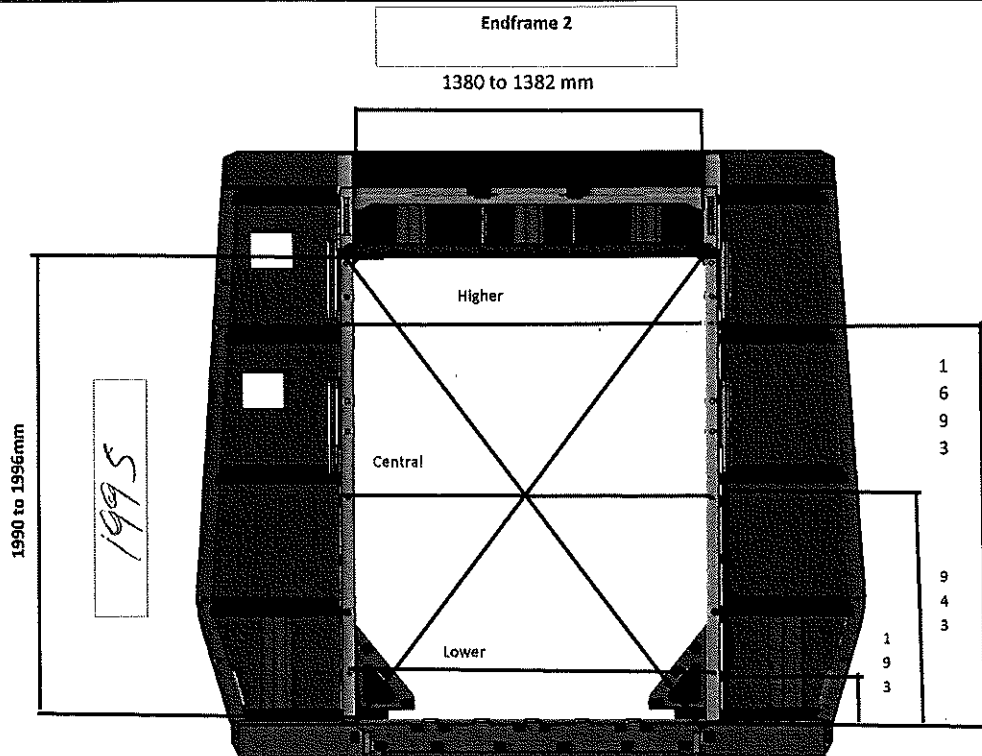
2



CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.  
31  
Date  
07/11/2023Project: PRASA  
SI.CB2210.254.V30

## Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1382

D1

2414

Central Dimension

1381

D2

2413

Lower Dimension

1381

D1-D2

1



CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.

31

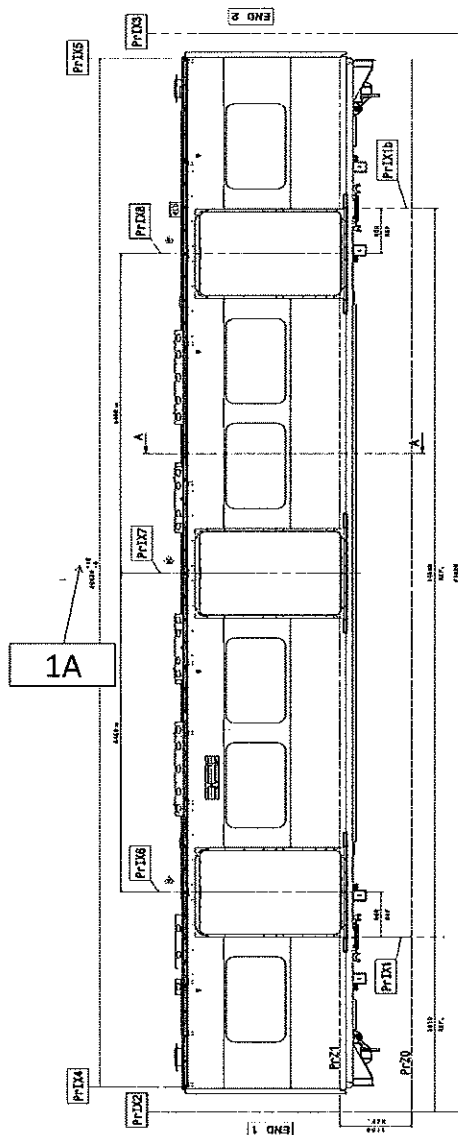
Project: PRASA

SI.CB2210.254.V30

Date

07/11/2023

## Specifications of Details for CBS measurement



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20628


RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20628

## Dye penetrant test

Dye-penetration test to be performed by quality personnel





		CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3		Rev. 3f	Project: PRASA SI.CB2210.254.V30	
				Date 07/11/2023		
<b>Self Inspection - Final Result</b>						
			DATE	NAME	SIGNATURE	
HOLD POINT		(if activities are not complete, the missing activities must not impact the next stage)	30/04/24	Lebogo	[Signature]	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.	30/04/24	Richmond	[Signature]	
		There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)				
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)				
In case of "NO GO", describe blocking problems						
In case of "NO GO", the operations manager must define below action plan to ensure "GO":						
Item	Description		Responsible	Due date	Status	

---

Operations

---

Quality



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

APPLICATION REFERENCE											
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?
				TC1	M4	M1	M2	M3	TC2		
<input type="checkbox"/>	DTR3022548/2	CARBODY SHELL M1,M3,M4 ASSEMBLY	CR3220		X	X		X		PRA.CB2220.DTR3022548/2.V21	YES
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
REV	DATE	MODIFICATION CONTENT		RESPONSIBLE	NAME	DATE					
0	01/02/2018	GIBELA NEW CREATION		APPROVER	Itumeleng Modiba	01/02/2018					
				CHECKER	Nosizo Pindela	01/02/2018					
				COMPILER	Thanyani Mtheghu	01/02/2018					
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager		APPROVER	Itumeleng Modiba	18/05/2018					
				CHECKER	Nosizo Pindela	18/05/2018					
				REVISED BY	Ramokone Motama	18/05/2018					
2	2018/07/05	Certain dimensional checks added and others moved to CB1210		APPROVER	Itumeleng Modiba	2018/07/05					
				CHECKER	Nosizo Pindela	2018/07/05					
				REVISED BY	Ramokone Motama	2018/07/05					
3	2018/06/12	Width tolerance as per D70000336600		APPROVER	Itumeleng Modiba	2018/06/12					
				CHECKER	Nosizo Pindela	2018/06/12					
				REVISED BY	Nosizo Pindela	2018/06/12					
5	24/01/2019	As per Baseline 10.2		APPROVER	Itumeleng Modiba	24/01/2019					
				CHECKER	Nosizo Pindela	24/01/2019					
				REVISED BY	Vanessa Ntuli	24/01/2019					
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements Remove		APPROVER	Itumeleng Modiba	13/03/2019					
				CHECKER	Nosizo Pindela	13/03/2019					
				REVISED BY	Nosizo Pindela	13/03/2019					
10	22/08/2019	New Baseline 10.2.5		APPROVER	Itumeleng Modiba	22/08/2019					
				CHECKER	Nosizo Pindela	22/08/2019					
				REVISED BY	Nosizo Pindela	22/08/2019					
15	06/08/2020	New Baseline 10.2.6		APPROVER	Timothy Maimela	06/08/2020					
				CHECKER	Bongane Masina	06/08/2020					
				REVISED BY	Bongane Masina	06/08/2020					
20	19/04/2021	New Baseline change 10.3		APPROVER	Timothy Maimela	19/04/2021					
				CHECKER	Bongane Masina						
				REVISED BY	Bongane Masina						
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING		APPROVER	Mhombi Collins	17/08/2021					
				CHECKER	Mpho Mulaudzi						
				REVISED BY	Mpho Mulaudzi						
25	20/02/2022	New Baseline change 10.3.1		APPROVER	Collins Mhombhi	19/02/2022					
				CHECKER	Andani Muthelo						
				REVISED BY	Andani Muthelo						
26	14/06/2022	Update minimum temperature requirement for sealant application		APPROVER	Collins Mhombhi	14/06/2022					
				CHECKER	Andani Muthelo						
				REVISED BY	Andani Muthelo						
27	19/10/2022	Addition of traceability for sealant application & welding		APPROVER	Collins Mhombhi	19/10/2022					
				CHECKER	Ntokozo Zwane						
				REVISED BY	Amogelang Mohlampe						
28	14/04/2023	Added sealant batch number & welding consumables traceability		APPROVER	Vanessa Ntuli	14/04/2023					
				CHECKER	Ntokozo Zwane						
				REVISED BY	Amogelang Mohlampe						
29	28/10/2023	Addition of bracket quantity		APPROVER	Ngobeni Tyson	28/10/2023					
				CHECKER	Ntokozo Zwane						
				REVISED BY	Amogelang Mohlampe						
TRAINSET	CAR	OPERATOR NAME & ALPS NO		DATE	SELF INSPECTION NUMBER		PAGES				
225	M03	Tetelo		06/05/24	SI.CB2220.250.V29		13				

	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DTR30226487/2	Rev. 29	<b>Project: PRASA</b>  <b>SI.CB2220.250.V29</b>	
		Date 28/10/2023		
Car: M1,M3&M4	NCR:	Work station:		CB2220

Safety Related

**I - Documentation and Instruments Control**

**I.1 - Documentation Control**

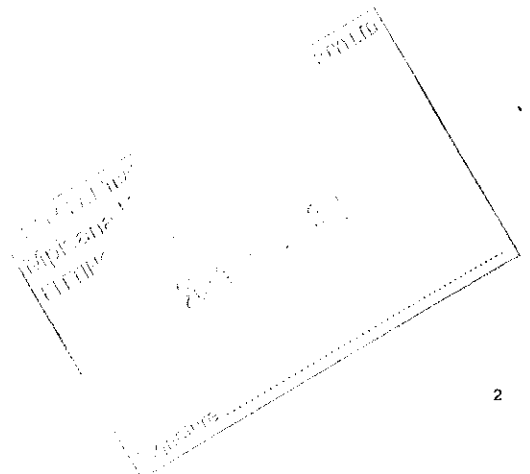
Document	Type of car					Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
	M1	M3	M4	M5	M6						
DTR30226487/2				✓		29	06/05/24	✓		N/A	06/05/24








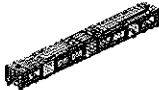


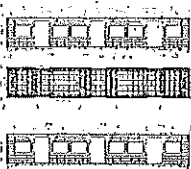












**I.2 - Instruments Control**


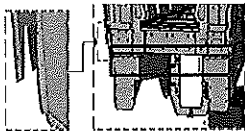

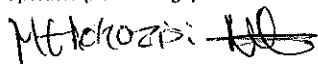
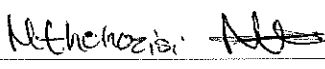
Monitoring and Measuring Instrument Control - Used for Special Process						
Instrument's	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
Turbidimeter	328232	05/03/25	✓		06/05/24	06/05/24
Measuring Tape	GIBELQ	12/04/25	✓		06/05/24	06/05/24

**I.3 Consumables**


Welding Consumable Control - Used for Special Process						
Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
Welding wire	E231067	MIG Welding	✓		06/05/24	06/05/24

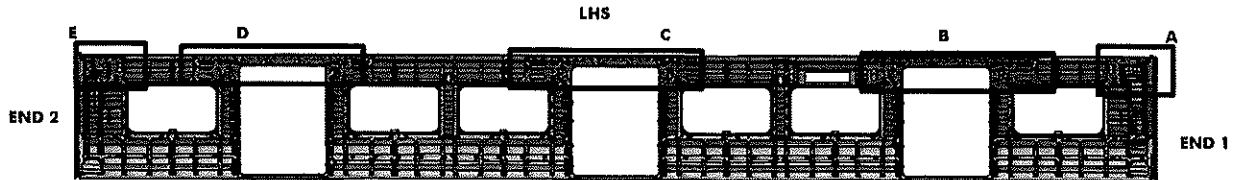
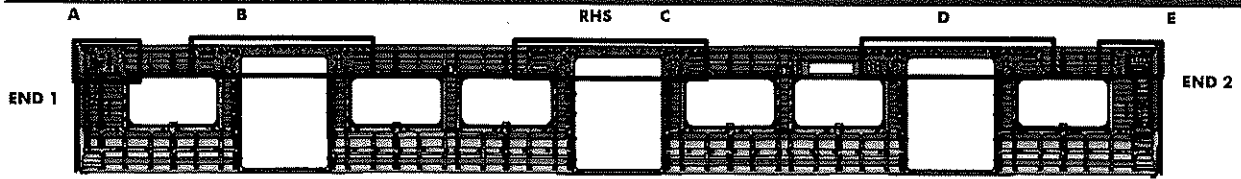


	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DTR30225487/2	Rev. 29	Project: PRASA  SI.CB2220.250.V29			
		Date 28/10/2023				
<b>II - Self Inspection - Items to Check</b>						
<b>II.1 - Items to check</b>						
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB2220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB2220.DTR30225487/2	✓	 06/05/24	 06/05/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	 06/05/24	 06/05/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	 06/05/24	 06/05/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	 06/05/24	 06/05/24
05		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓	 06/05/24	 06/05/24
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.	✓	 06/05/24	 06/05/24
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 (°C) Min-Max 10°C - 35°C Relative humidity Min - Max (%) 25% - 80%	Sealant Batch No: 2009351P Exp Date: 1/05/24 Actuals Temperature: 28 Humidity: 25	✓	 06/05/24	 06/05/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓	 06/05/24	 06/05/24
09		Verification of safety welds	Approved according to DTD000210658 reference and Self inspection	✓	 06/05/24	 06/05/24




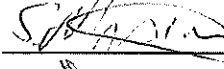


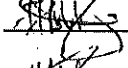
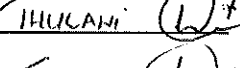

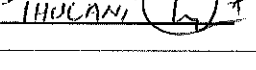
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA  SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	
II - Self Inspection - Items to Check			
<div style="text-align: center;">SEALANT APPLICATION</div> <div style="display: flex; justify-content: space-between; align-items: flex-start;"> <div style="width: 40%;">   </div> <div style="width: 55%; border: 1px solid black; padding: 5px;"> <div style="text-align: center;">AREA 1 &amp; 2 END 1</div> <div>Operator (Name &amp; sign):</div> <div style="margin-top: 5px;">  </div> <div>Operator (Name &amp; sign):</div> <div style="margin-top: 5px;">  </div> </div> </div>			

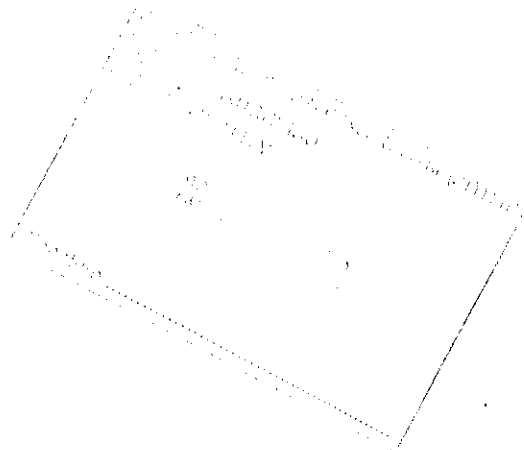
Approved by:   
 Name:   
 Date:

	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			



### REINFORCEMENT WELDING

AREA	LHS	RHS
A	Operator (Name&sign): 	
B	Operator (Name&sign): 	
C	Operator (Name&sign): 	
D	Operator (Name&sign): 	THUCANI (L)* 
E	Operator (Name&sign): 	THUCANI (L)* 



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

**II - Self Inspection - Items to Check**

**BRACKETING**

<b>INSTALLATION</b>	
C-RAILS:	Operator: <u>I. Can</u>
	Operator: _____
DOOR MECHANISMS:	Operator: <u>Ntho</u>
	Operator: _____
TAPPING PADS	Operator: <u>Priscilla</u>
	Operator: _____

<b>INSTALLATION &amp; VERIFICATION</b>	
SEAT & LUGGAGE BRACKETS:	Operator: <u>ASAMIDA</u>
	Operator: <u>Totelo</u>
SEAT BRACKETS VERIFICATION:	Operator: <u>ASAMIDA</u>
	Operator: _____


**WELDING**

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

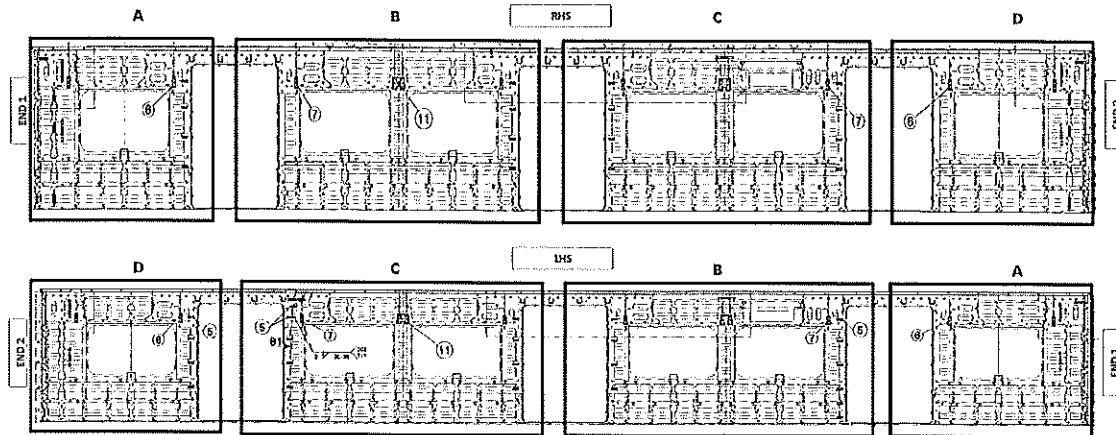
**ENDS**

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

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

	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DTR30226487/2	Rev.	Project: PRASA
		29	
		Date	SI.CB2220.250.V29
		28/10/2023	
<b>II - Self Inspection - Items to Check</b>			

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7	✓	
	B	4	✓	
	C	8	✓	
	D	8	✓	
SEAT BRACKETS	A	13	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	3	✓	
	B	5	✓	
	C	4	✓	
	D	3	✓	
<b>ROOF ENDS:</b> CAILS 2 OFF EACH END EARTH BUSH 6 OFF EACH END VERIFICATION BY: <u>Tebebo</u>				

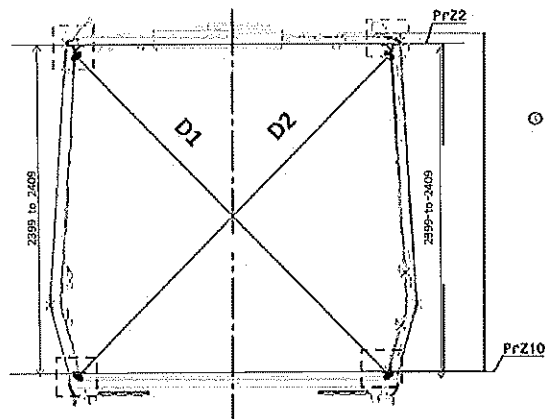
LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2	✓	
	B	8	✓	
	C	11	✓	
	D	8	✓	
SEAT BRACKETS	A	13	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	3	✓	
	B	5	✓	
	C	8	✓	
	D	2	✓	
<b>ROOF ENDS:</b> CAILS 2 OFF EACH END EARTH BUSH 6 OFF EACH END VERIFICATION BY: <u>Tebebo</u>				

QUANTITIES (M1)

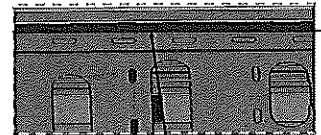
RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7		
	B	8		
	C	8		
	D	8		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	2		
	B	4		
	C	5		
	D	3		
<b>ROOF ENDS:</b> CAILS 2 OFF EACH END EARTH BUSH 6 OFF EACH END VERIFICATION BY: _____				

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	10		
	C	11		
	D	8		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	7		
	C	6		
	D	2		
<b>ROOF ENDS:</b> CAILS 2 OFF EACH END EARTH BUSH 6 OFF EACH END VERIFICATION BY: _____				

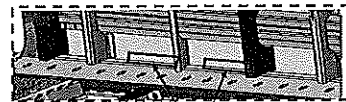
Specifications of Details for CBS measurement



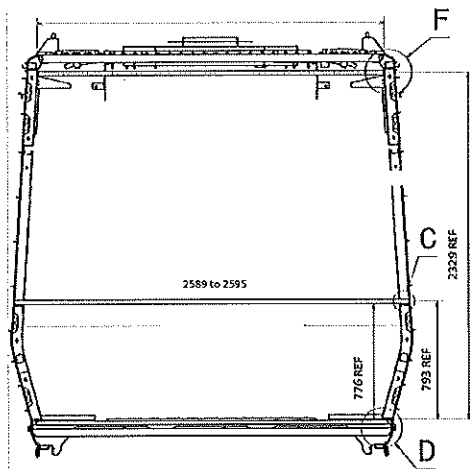
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.

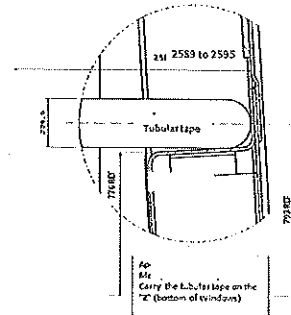
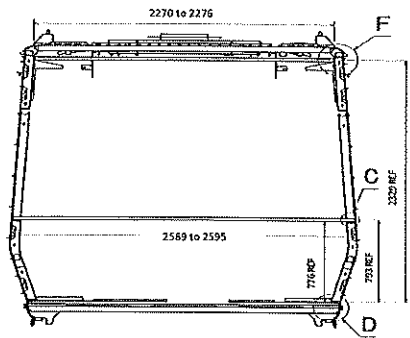


Measurement positions on sidewall and side sill corner.

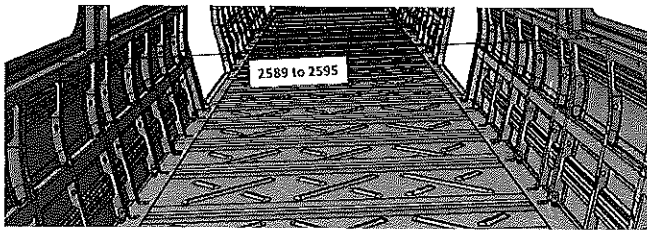


PROJEKTOVANÉ: 2023.10.29  
2023.10.29

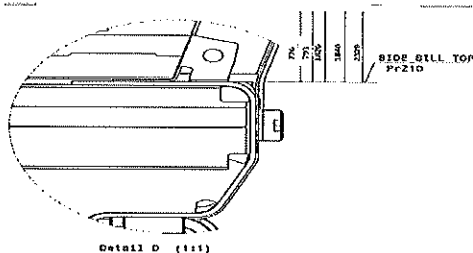
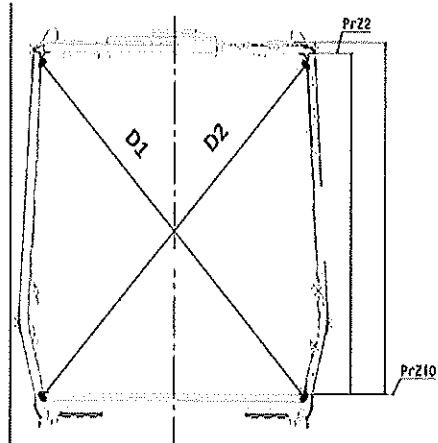
**CBS measurement**




**Detail C**

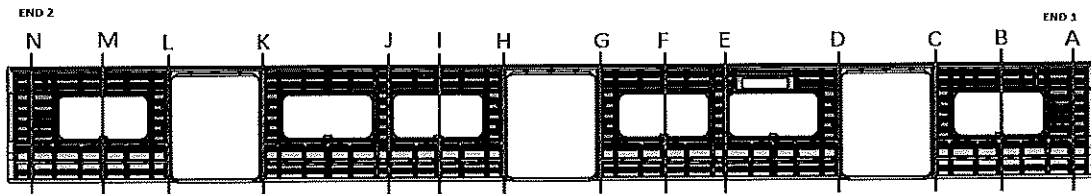


Take measurement close to radius



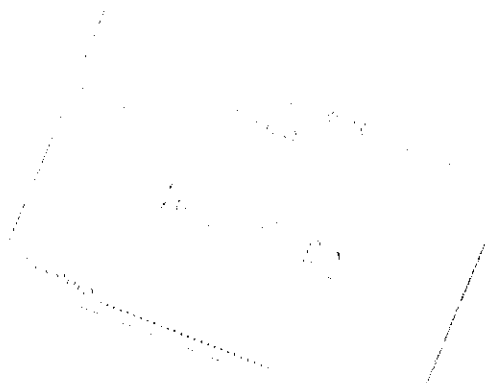
**Detail D (1:1)**


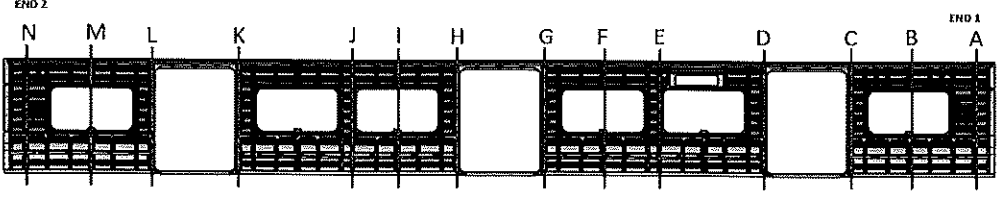
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA  SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	
CBS measurement			



BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3296	4	—
B	3297	3296	1	—
C	3300	3299	1	—
D	3298	3296	2	—
E	3266	3268	2	—
F	3269	3267	2	—
G	3297	3295	2	—
H	3296	3298	2	—
I	3269	3266	3	—
J	3266	3268	2	—
K	3296	3298	2	—
L	3298	3296	2	—
M	3268	3266	2	—
N	3297	3298	1	—

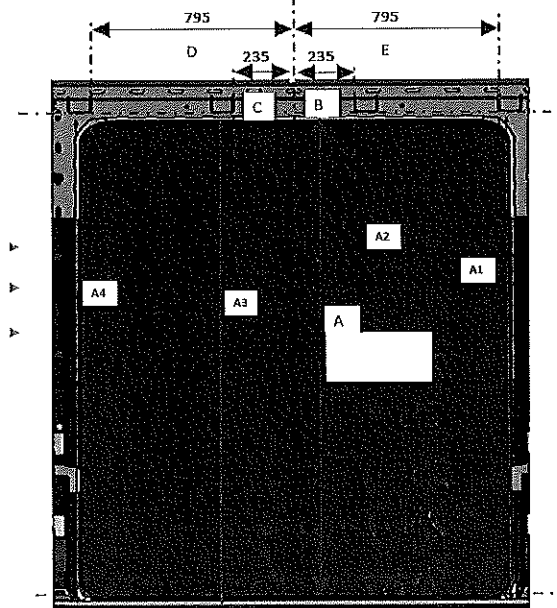


	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRA5A  SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	
CBS measurement			
			

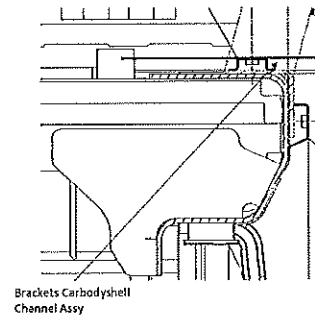
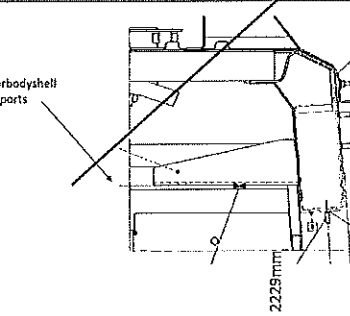
AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3299	3297	2	2589
B	3265	3267	2	2589
C	3300	3298	2	2591
D	3298	3296	2	2592
E	3266	3268	2	2593
F	3268	3266	2	2590
G	3298	3296	2	2591
H	3298	3296	2	2592
I	3268	3267	1	2593
J	3269	3268	1	2594
K	3300	3298	2	2591
L	3300	3297	3	2591
M	3267	3265	2	2592
N	3299	3298	1	2591

Specifications of Details for CBS measurement CB1220



Brackets Carbodyshell  
U Type Supports



Brackets Carbodyshell  
Channel Assy

DOOR 1 - LHS

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

DOOR 2 - LHS

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

DOOR 2 - RHS

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

DOOR 1 - RHS

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

DOOR 2 - RHS

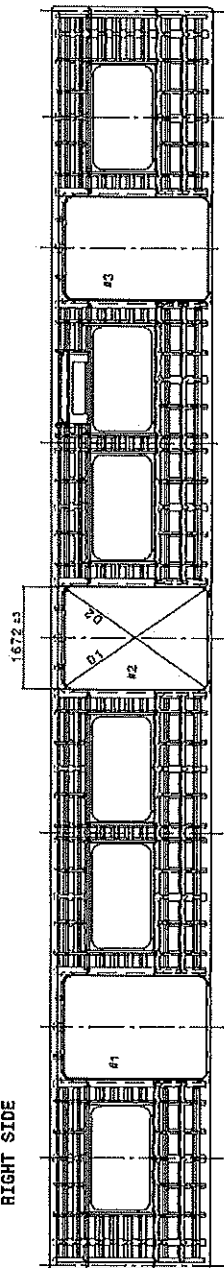
	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2231
A3	2230 to 2232	2230
A4	2230 to 2232	2230
B	234 to 236	235
C	234 to 236	235
D	794 to 796	795
E	794 to 796	796

DOOR 3 - RHS

	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	234
D	794 to 796	794
E	794 to 796	795

Specifications of Details for CBS measurement CB1220

End #2



RIGHT SIDE

End #1

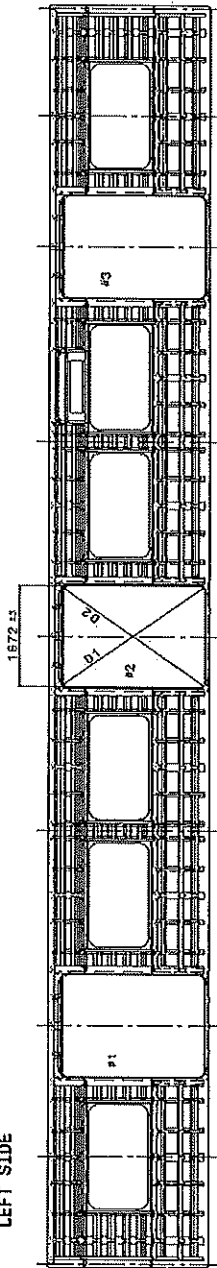
Doors diagonal D1-D2 maximum difference ≤ 4mm

	#1	#2	#3
D1	2750	2751	2752
D2	2748	2749	2750
D1-D2	2	2	2

	#1	#2	#3
HIGHER DIMENSION	1673	1672	1673
CENTRAL DIMENSION	1669	1671	1672
LOWER DIMENSION	1671	1673	1671

Doors Length = 1672 ±3mm

End #1



LEFT SIDE

End #2


Doors diagonal D1-D2 maximum difference ≤ 4mm

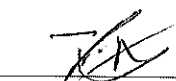

	#1	#2	#3
D1	2749	2751	2752
D2	2751	2750	2751
D1-D2	2	1	1

	#1	#2	#3
HIGHER DIMENSION	1669	1672	1671
CENTRAL DIMENSION	1671	1674	1673
LOWER DIMENSION	1672	1672	1672

Doors Length = 1672 ±3mm

[illegible]

	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DTR30226487/2	Rev.	<b>Project: PRASA</b>  <b>SI.CB2220.250.V29</b>
		29	
		Date	
		28/10/2023	
<b>Self Inspection - Final Result</b>			


Is the car good to advance to the next workstation/process? (Approval of Operations Manager and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	✓	GO	(If activities are not complete, the missing activities must not impact the next stage)	06/05/24	Tetelo Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	06/05/24	Andoni 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

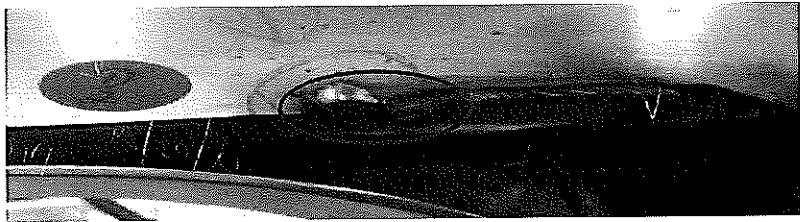
in case of "NO GO", the operations manager must define below action plan to ensure "GO":					
Item	Description		Responsible	Due date	Status

  
Tetelo  
Operations  

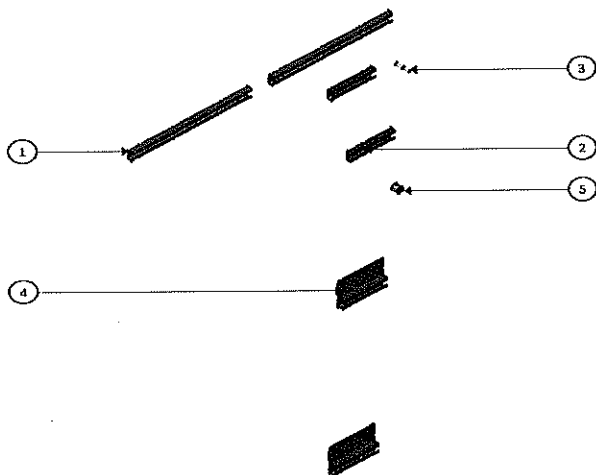

Quality

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA  SI.CB2220.250.V29
		29	
		Date 28/10/2023	

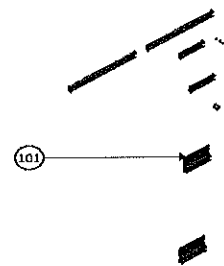
### ANNEXURE A: Arc Welding Quality Acceptance Standard



Station: CB1220-004- U108 & U107



PART NO.	ITEM NO.	QTY	DESCRIPTION	MASS [KG]
DIF0020074042	5	6	EARTH STUD E	0.095
AAC0001201548	4	6	ASSEMBLY SUPPORT	0.271
DIF0000343405	3	12	WELDING STUD ISO13918 PT - M200 - SST	0.007
AAC0001180421	2	12	ASSEMBLY SUPPORT	0.191
AAC0001184418	1	14	ASSEMBLY SUPPORT	0.522
AAC0001161090	101	6	CARBODYSHELL BRACKET CARBODYSHELL HT/PA/M CARCODE [FRAME MODULE END - 099]	12.132




APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1


## SELF INSPECTION SHEET


## CONFIDENTIAL INFORMATION

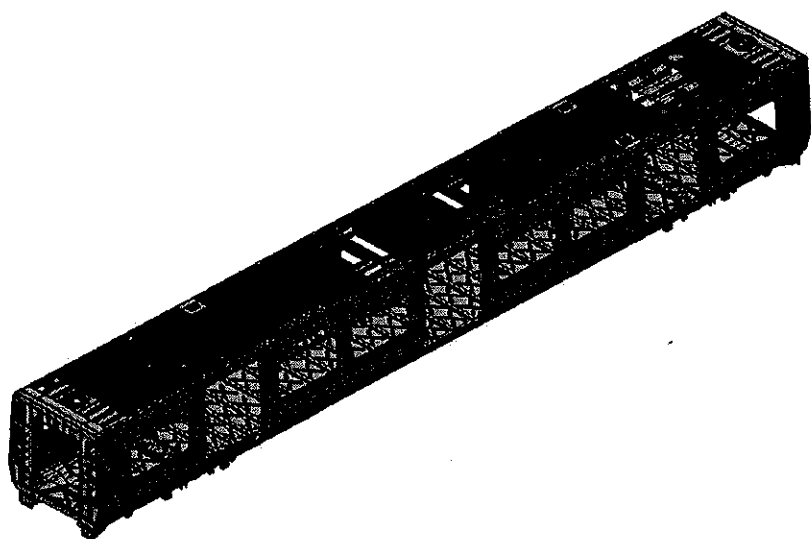
This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

## APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ? 
				TC1	M1	M2	M3	TC2			
<input type="checkbox"/>	DTR3000152669	AAD0001278566	CARBODYSHELL M1,M3,M4 ASSEMBLY	CB1210			X			PRA.CB1230.DT000002 25487.V20	YES
<input type="checkbox"/>	DTR3000152673	AAD0001278566	CARBODYSHELL M1,M3,M4 ASSEMBLY	CB1230		X		(X)		PRA.CB1230.DT000002 25487.V20	YES
<input type="checkbox"/>											
SV	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	19/10/2022	Addition of traceability for sealant application			APPROVER		Collins Mbombhi		19/10/2022		
					CHECKER		Ntokozo Zwane				
					REVISED BY		Amogelang Mohlampe				
28	14/04/2023	Added sealant batch number & welding consumables traceability			APPROVER		Vanessa Ntuli		14/04/2023		
					CHECKER		Ntokozo Zwane				
					REVISED BY		Amogelang Mohlampe				
29	06/11/2023	Added thresholds traceability for boiler makers and welders			APPROVER		Tyson Ngobeni		06/11/2023		
					CHECKER		Andani Muthelo				
					REVISED BY		Ntokozo Zwane				
TRAINSET	CAR	OPERATOR NAME & ALPS NO		DATE	SELF INSPECTION NUMBER		PAGES				
223	M03	KHOSI 417409		07.06.24	SI.CB1230.256.V28		11				

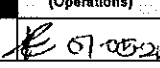
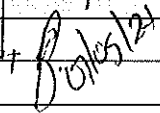
	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DT00000225487	Rev. 29	<b>Project: PRASA</b>  <b>SI.CB1230.256.V28</b>	
		Date 06/11/2023		
		Car: _____	NCR: _____	Work station: <span style="float: right;"><b>CB1230</b></span>


Safety Related



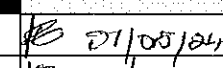
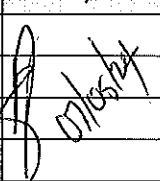
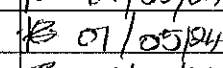
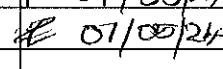
**I - Documentation and Instruments Control**

**I.1 - Documentation Control**

Document	Type of car					Revision	Observation	OK		Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4	TC2						
PRA.CB1230.DT00000225487			X			V29		OK		N/A	 07/05/24  07/05/24

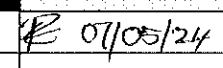
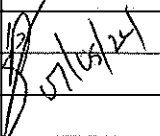
**I.2 - Instruments Control**

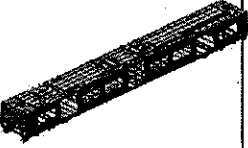
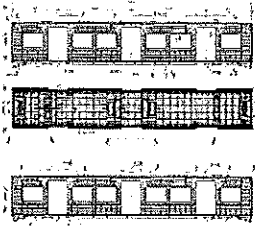
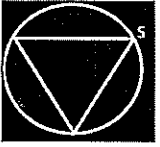
Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Operations)	Signature/Date (Quality)
MEASURING TAPE	G180794	25/04/25	OK		 07/05/24	 07/05/24
COMBINATION SQUARE	G180572	27/07/24	OK		 07/05/24	
TUBULAR	33713	26/06/25	OK		 07/05/24	

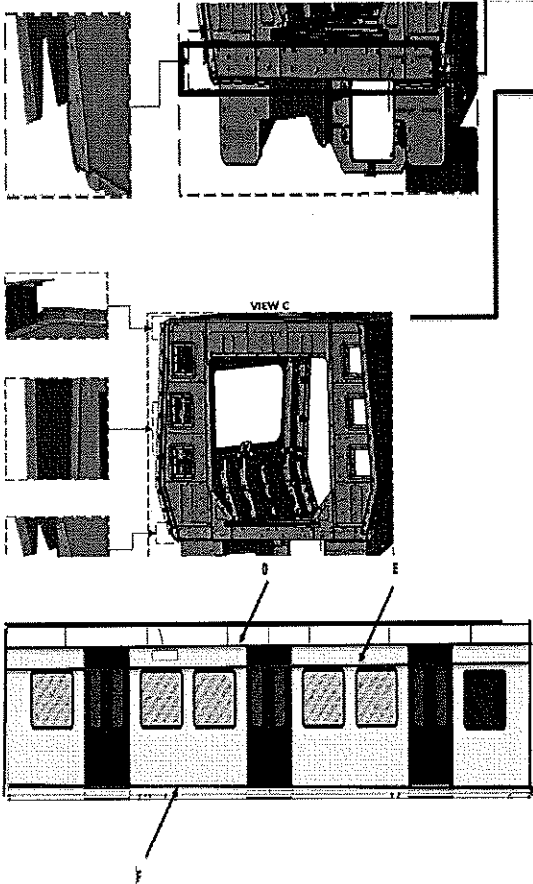
**1.3 Consumables**

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
AUTROD 308 LS1	620180	MIG	OK		 07/05/24	 07/05/24

GIBELQ		CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487		Rev. 29	Project: PRASA								
				Date 06/11/2023	SI.CB1230.256.V28								
<b>II - Self Inspection - Items to Check</b>													
<b>II.1 - Items to check</b>													
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK			Signature/Date (Operations)						
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	OK			07/05/24						
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	OK			07/05/24						
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	OK			07/05/24						
		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	OK			07/05/24						
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	OK			07/05/24						
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	OK			07/05/24						
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: <table border="1"> <tr> <td>Temperature Min - Max (1)</td> <td>Min-Max</td> <td>10°C - 35°C</td> </tr> <tr> <td>Relative humidity Min - Max (1)</td> <td>Min-Max</td> <td>25% - 80%</td> </tr> </table>	Temperature Min - Max (1)	Min-Max	10°C - 35°C	Relative humidity Min - Max (1)	Min-Max	25% - 80%	Sealant Batch No: 15470-08 Exp Date: 06/24 Actuals Temperature: 21,9°C Humidity: 31%	OK			07/05/24
Temperature Min - Max (1)	Min-Max	10°C - 35°C											
Relative humidity Min - Max (1)	Min-Max	25% - 80%											
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.	OK			07/05/24						

AREA 1



END 2 SEALANT

OPERATOR  
(Name & sign):

LERDY

*[Signature]*

OPERATOR  
(Name & sign):

LERDY

*[Signature]*

OPERATOR  
(Name & sign):

LERDY

*[Signature]*

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

Operator (Name & sign):

(E) LERDY  
*[Signature]*

(E) LERDY  
*[Signature]*

Operator (Name & sign):

Sihle  
*[Signature]*

Sihle  
*[Signature]*

Operator (Name & sign):

Tshenolo

Tshenolo

Operator (Name & sign):

*[Signature]*

*[Signature]*

Operator (Name & sign):

(FGHI)

(FGHI)

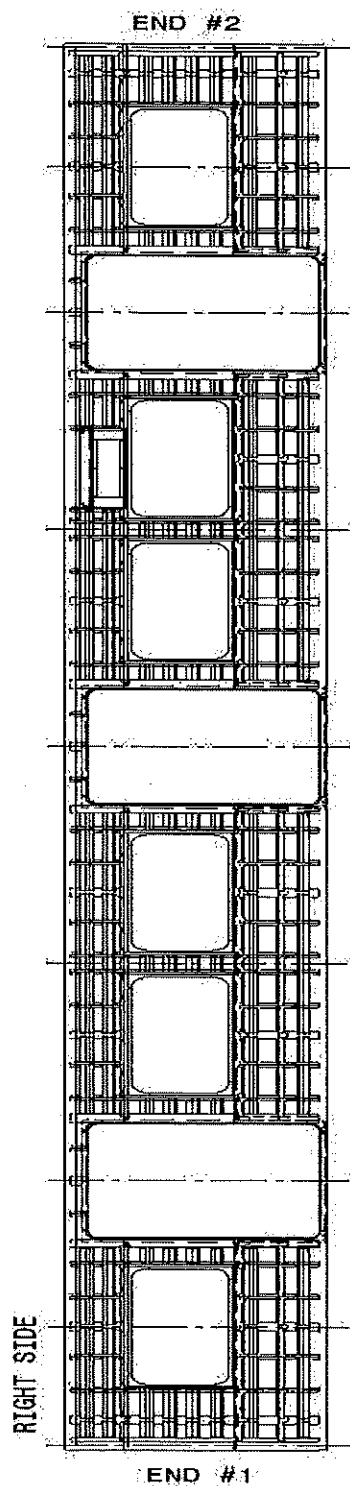
Operator (Name & sign):

*[Signature]*  
LERATO

*[Signature]*  
LERATO

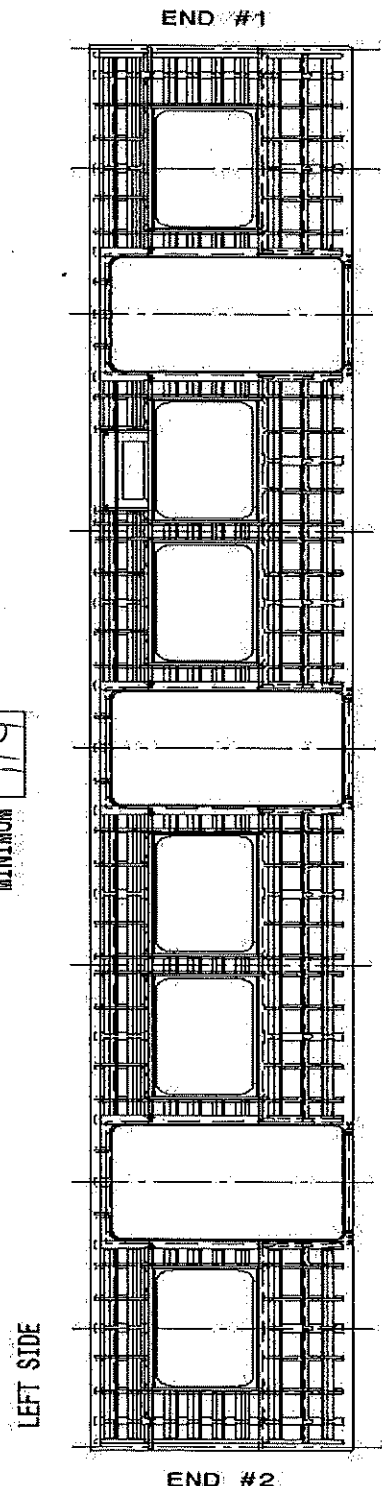
Specifications of Details for CBS measurement CB1230

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.



MAXIMUM 1.6

MINIMUM 1.4

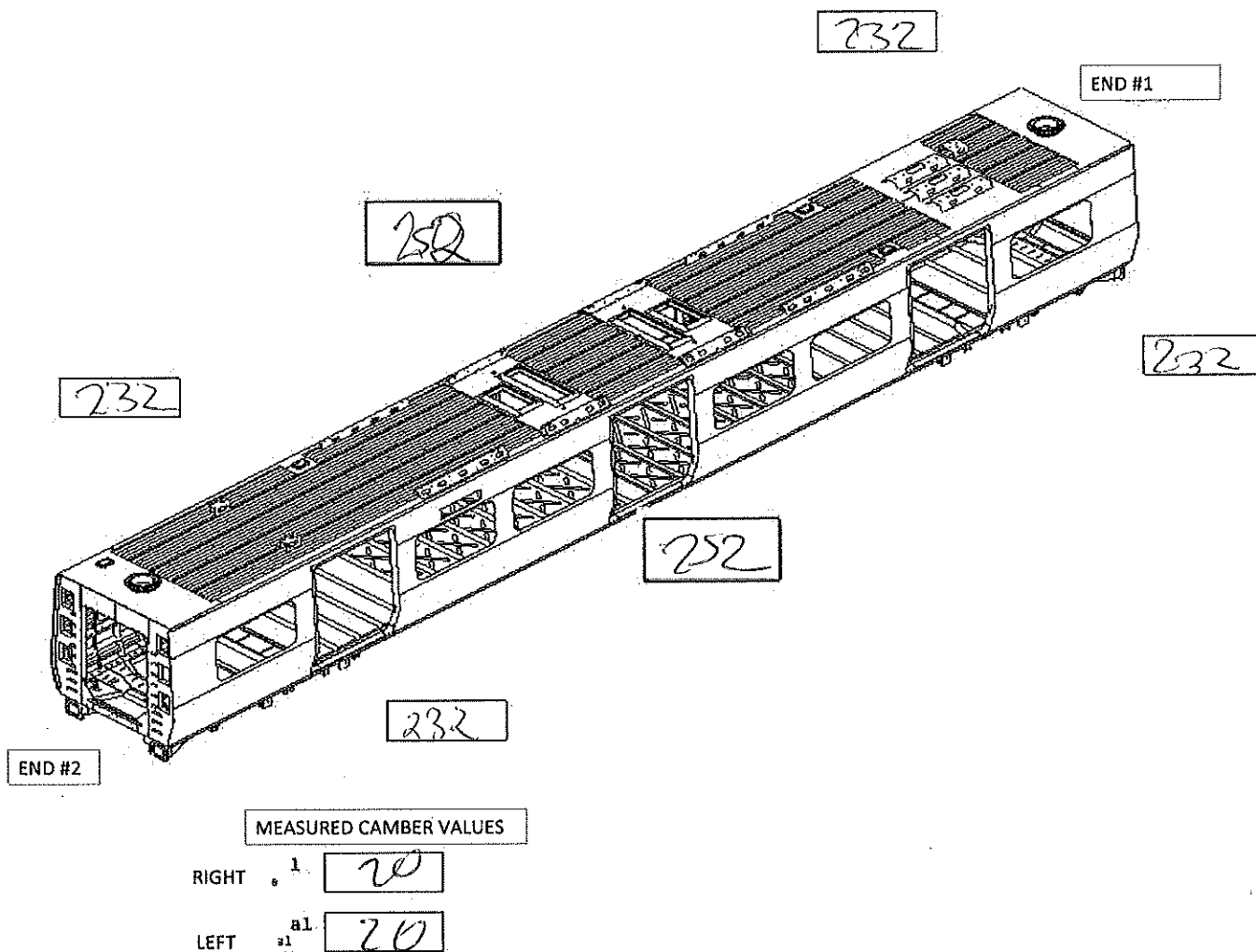


MAXIMUM 1.8

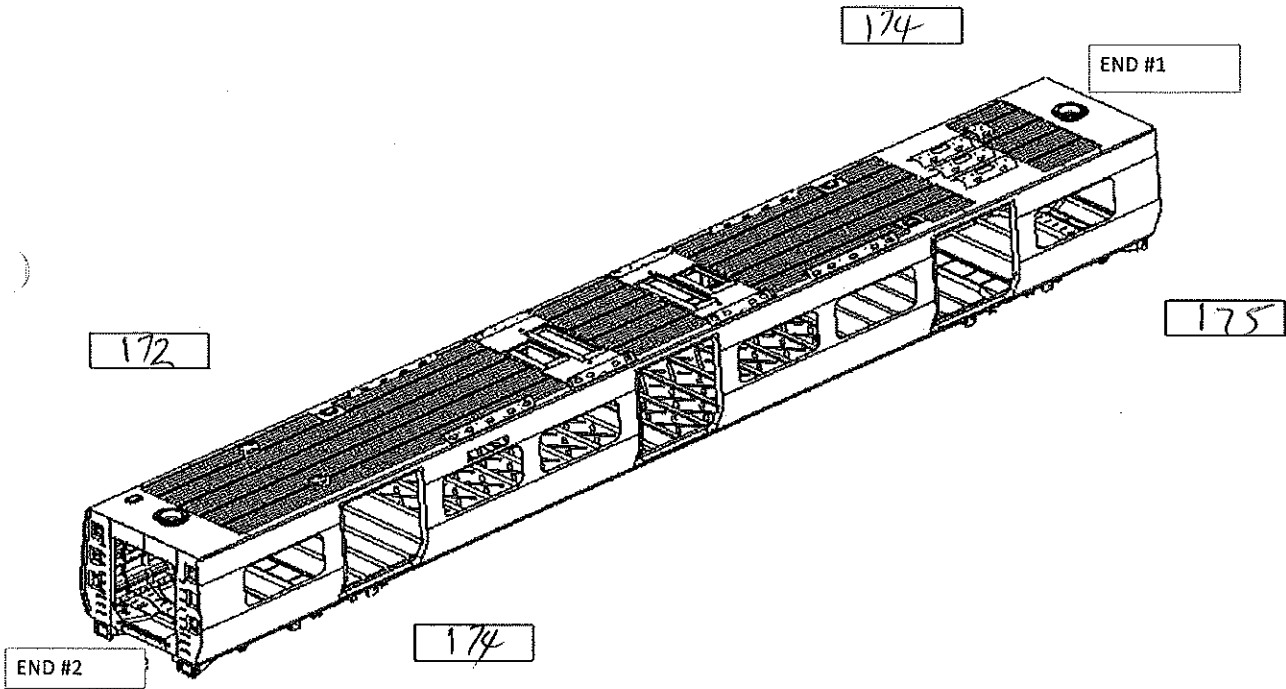
MINIMUM 1.5

Specifications of Details for CBS measurement CB1230

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

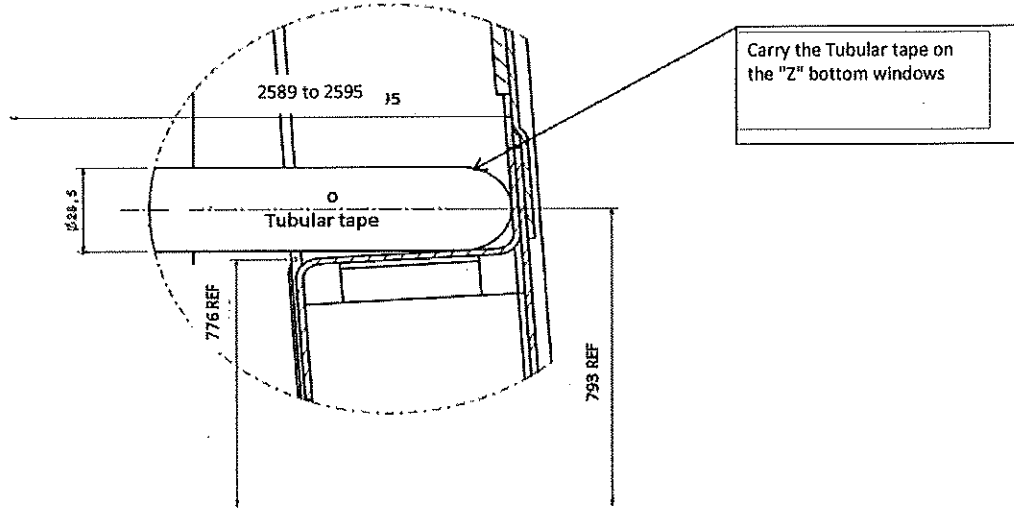


Twist measured in transversal and longitudinal = Maximum 3mm. Measure twist on air spring plates (LHS and RHS), both End 1 and End 2 following twist measurement document.

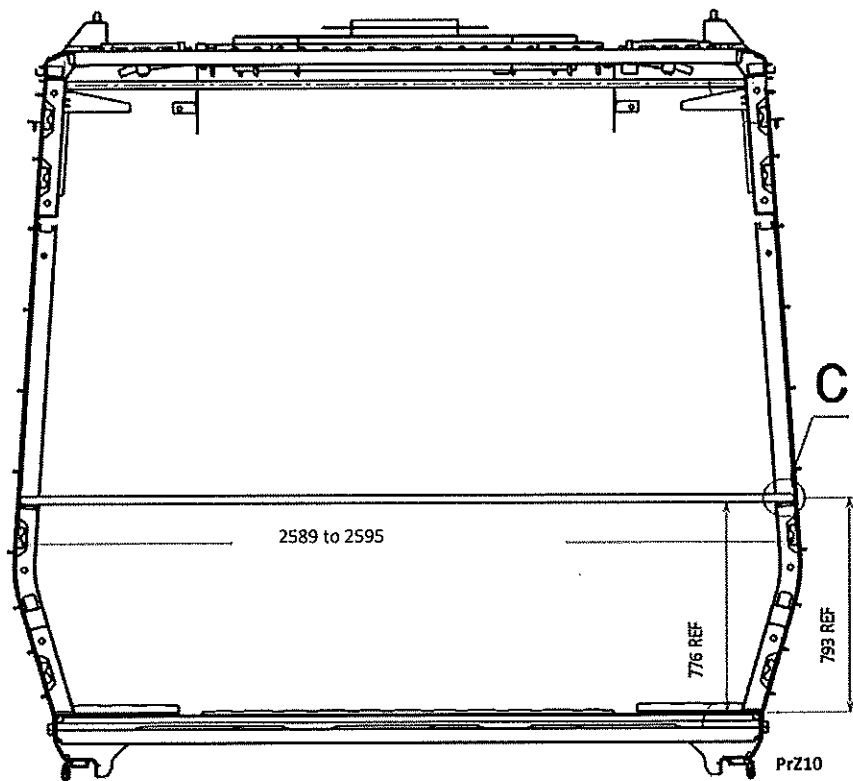


TWIST FOUND ON END 1		TWIST FOUND ON END 2	
TRANVERS	2	TRANVERSE	1
LONGITUDIN	2	LONGITUDINAL	1

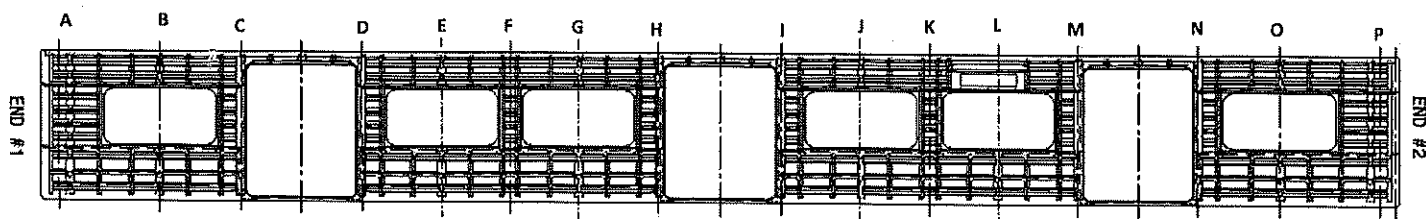
Specifications of Details for CBS measurement CB1230



Detail C

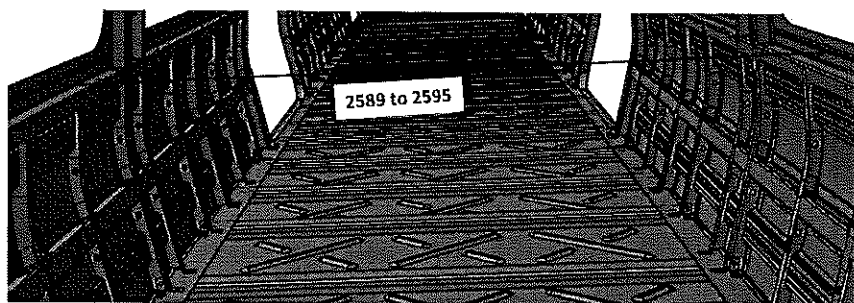


Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	2597
B	2595
C	2592
D	2591
E	2593
F	2594
G	2591
H	2592
I	2590
J	2593
K	2595
L	2596
M	2596
N	2592
O	2590
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: *mmitkapev* *Alucida*  
Welding: *Erasmus*

	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DT00000225487	Rev. 29	<b>Project: PRASA</b>  <b>SI.CB1230.256.V28</b>
		Date	
		06/11/2023	

## Dye penetrant test

Dye-penetration test to be performed by quality personnel




### Specifications of Details for CBS measurement

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



#### II.2 - Check List REX

#### Check List Items

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

	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DT00000225487	Rev. 29	<b>Project: PRASA</b>  <b>SI.CB1230.256.V28</b>
		Date 06/11/2023	

**Self Inspection - Final Result**

Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)			DATE	NAME	SIGNATURE	
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage!)	05/05/24	Khosy Operations		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	07/05/24	Ntokoze 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

