

## CABIN STRUCTURE QUALITY CARD

CAB No.: CAB \_ 4 5 1 \_

WEIGHT: \_ 1 4 8 1 \_ Kg

# RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	05/02/24	178247 104825 01	CP49402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	19.02.24	178826 104640 01	F205272	
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegasus	23.02.2024	178488 104640 01	P300091	
RCS 355	20 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegasus	12.02.2024			
RCS 355	30 mm					

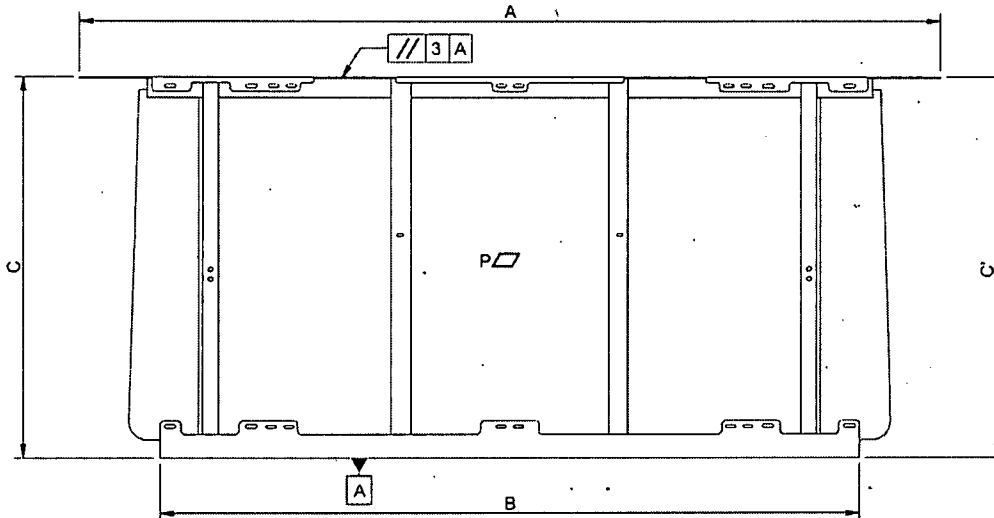
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	08.02.2024	178489 104640 01	VHC35578	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					


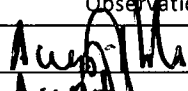
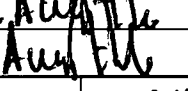
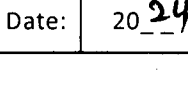

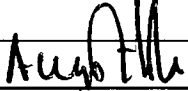
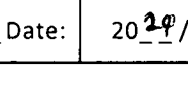

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	14.02.2024	178815 104640 01	F207908 VHC 28402	
RCS 450	6 mm					
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	22.11.23	175569 102206 01	F207906 VHS58432	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

## Cabin Roof Assembly: GN002839

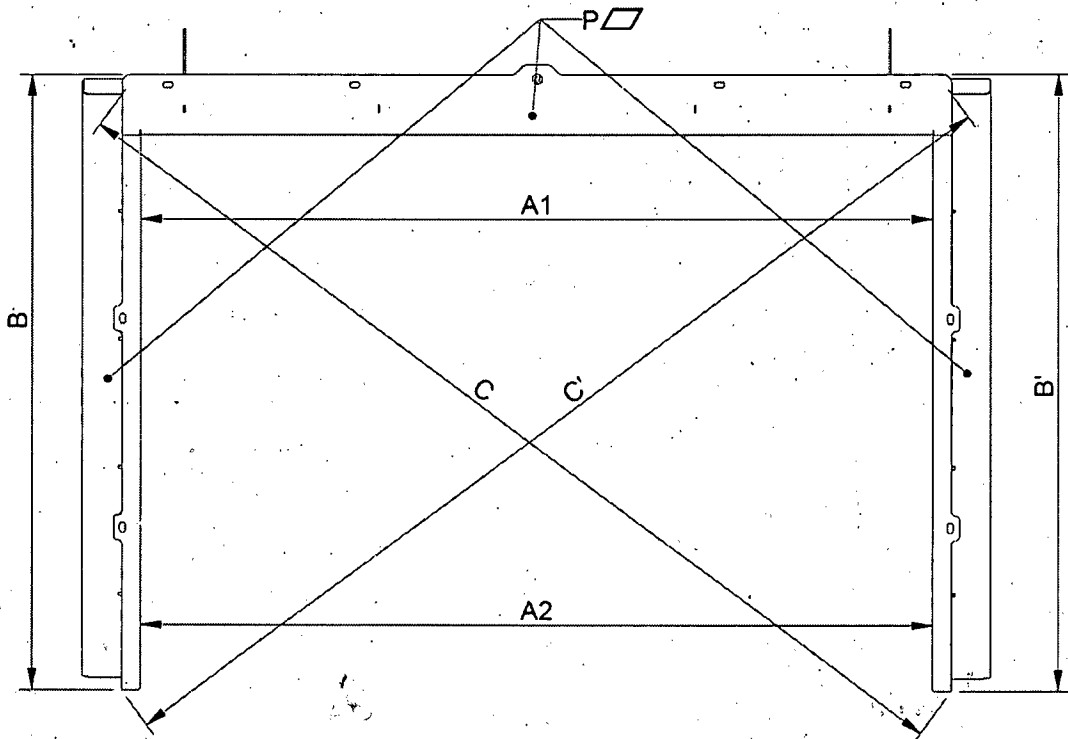
Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<b>DYLAN DAVIDS</b>	Assembly Date:	20 <u>24</u> / <u>03</u> / <u>06</u>			
Sign:		Wire Batch No.:	101238201			



Welding Control						
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042			Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<b>Leon</b>	Sign:		Date:	20 <u>24</u> / <u>03</u> / <u>06</u>	
Dimensional Control						
Rep		Toler.	Dimension measured	Measuring Equipment	Observations	
A	2216	+5/-0	<b>2216</b>	Tape Measure		
B	1800	± 4	<b>1800</b>			
C	976	+2/-3	<b>976</b>			
QC Inspector:	<b>Leon</b>	Sign:		Date:	20 <u>24</u> / <u>03</u> / <u>06</u>	
Geometrical Control						
Nature of Checks		Dimension Measured		Measuring Equipment	Observations	
Planeity P		6 mm		Ruler		
//	3	<b>Passed</b>		Set Square		
QC Inspector:	<b>Leon</b>	Sign:		Date:	20 <u>24</u> / <u>03</u> / <u>06</u>	

## Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	<i>Raimbela Gcinani</i>	Assembly Date:	20 <u>24</u> / <u>03</u> / <u>06</u>		
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152		



Welding Control						
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042			Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>03</u> / <u>06</u>	
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	1910	± 2	<i>1912</i>		Tape Measure	<i>Acceptable</i>
A2	1910		<i>1911</i>			<i>Acceptable</i>
B	1475	± 1	<i>1474</i>	<i>1474</i>		<i>Acceptable</i>
C	Diagonals  C - C'  ≤ 3		<i>2478</i>	<i>2475</i>		<i>Acceptable</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>03</u> / <u>06</u>	
Geometrical Control						
Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P: Planarity		<i>4 mm</i>	<i>Passed</i>	Ruler	<i>Acceptable</i>	
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>03</u> / <u>06</u>	

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

Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Xander</i>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>20</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

### Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

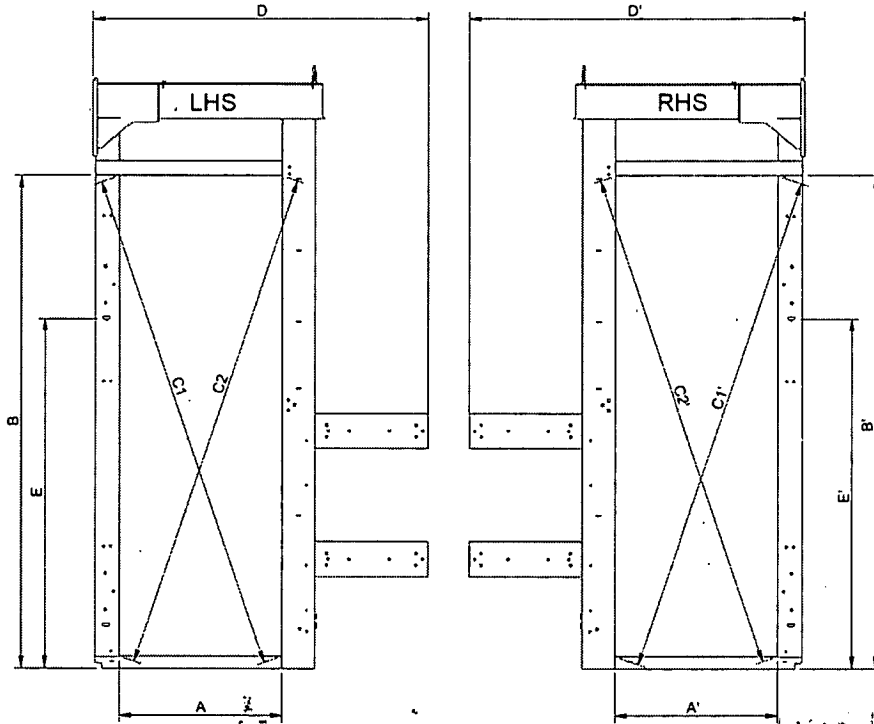
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Glenn</i>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>23</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

### Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Glenn</i>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>23</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

## Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	Glenn	Assembly Date:	2024/02/26		
Sign:	<i>Glenn</i>	Wire Batch No.:	2202152		



### Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	Leon	Sign:	<i>Leon</i>	Date:	2024/08/26

### Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	696	Tape Measure	Acceptable
B	2086	+1/-3	2085	2086		Acceptable
C1 / C2	Difference of diagonals $ C1 - C2  \leq 3$		2132	2132		Acceptable
C1 - C2			2150	2150		Acceptable
D	1438	+2/-3	1439	1440		Acceptable
E				1485		

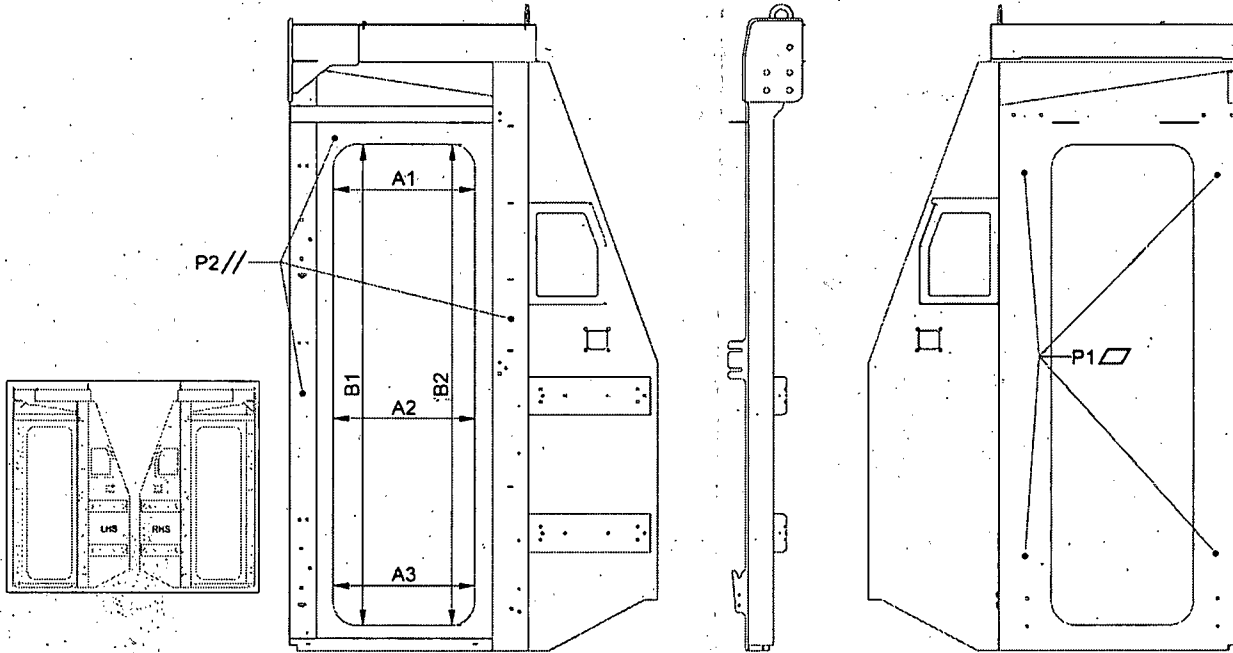
QC Inspector:	Leon	Sign:	<i>Leon</i>	Date:	2024/08/26
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### Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1: planeity of 2 edges	4 mm	Pass	Ruler	Acceptable
QC Inspector:	Leon	Sign:	<i>Leon</i>	Date: 2024/08/26

# Cabin LHS/RHS Side Assembly: GN002838/GN002837

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	<i>Ximle</i>	Assembly Date:	2024/03/01		
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152		




## Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/03/01

## Dimensional Control

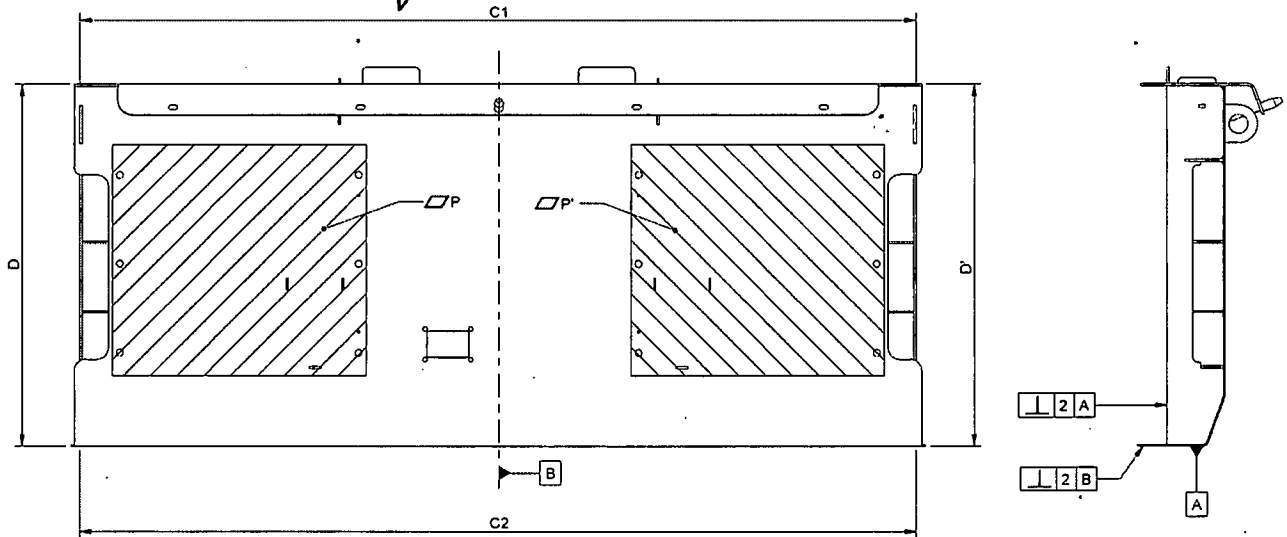
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	560	± 2	559	559	Tape Measure	Acceptable	
A2			559	559		Acceptable	
A3			560	560		Acceptable	
B1	1900	± 2	1898	1898		Acceptable	
B2			1898	1898		Acceptable	
QC Inspector:		Leon		Sign:	A	Date:	2024-02-06

## Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Passo Passo	Ruler	Acceptable Acceptable
P2 : Planeity	2 mm		Ruler	
QC Inspector:	Leon	Sign:		Date: 2024/03/06

## Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>DOVAN DAVENHILL</i>	Assembly Date:	20 <u>24</u> / <u>03</u> / <u>06</u>	
Sign:	<i>[Signature]</i>	Wire Batch No.:	552083	



### Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input type="checkbox"/> No
QC Inspector:		Sign:		Date: 20__ / __ / __

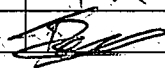
### Dimensional Control

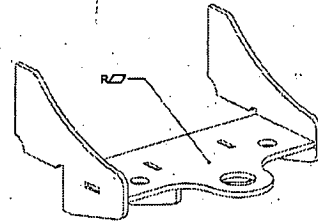
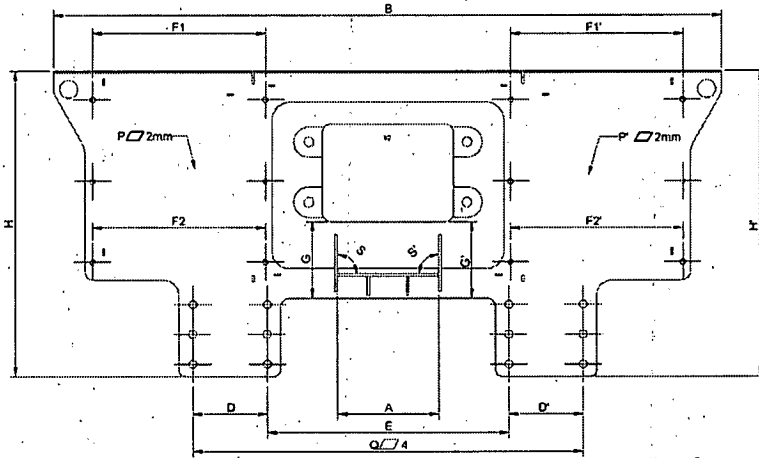
Rep	Theoretical Dim	Toler.	Dimension measured	Measuring Equipment	Observations
C1 / C2	2210	± 4		Tape Measure	
D / D'	956	± 2			
QC Inspector:			Sign:		Date: 20__ / __ / __

### Geometrical Control


Nature of Checks		Dimension Measured		Measuring Equipment	Observations
Planeity P / P'		2 mm		Ruler	
Perpendicularity	2	A		Set Square	
	2	B		Set Square	
QC Inspector:			Sign:		Date: 20__ / __ / __

# Cabin Front Headstock Assembly: GN002841


Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	TK Boot	Assembly Date:	2024/02/29			
Sign:		Wire Batch No.:	2202152			



## Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Leo	Sign:		Date:	2024/02/29	

## Dimensional Control

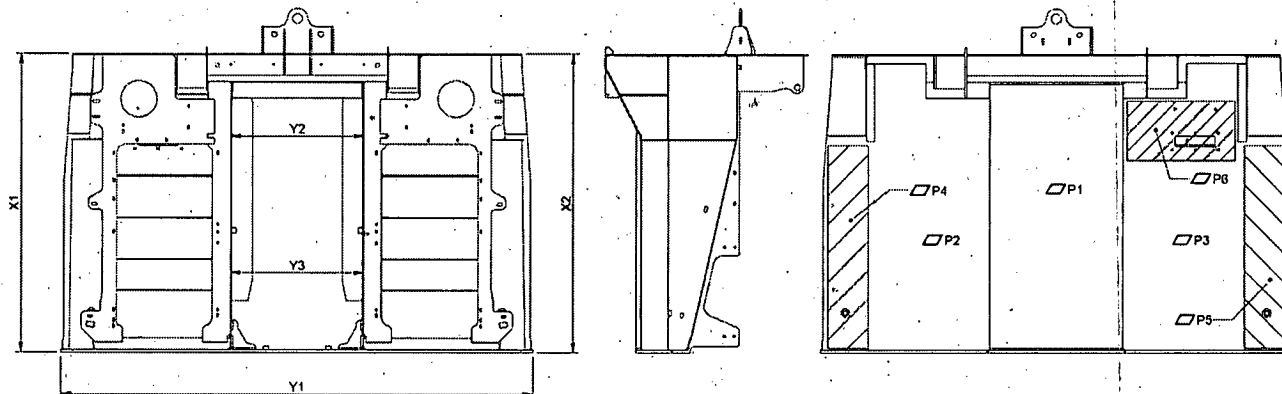
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	340	± 1	339		Tape Measure	Acceptable	
B	2240	± 4	2244			Acceptable	
D / D'	250	± 1	250.5	250.5		Acceptable	
E	808	± 2	808			Acceptable	
F1 / F1'	580	± 1	581	581		Acceptable	
F2 / F2'			581	581		Acceptable	
G / G'	258	± 1	258	257.5		Acceptable	
H / H'	1019	± 2	1020	1020		Acceptable	
QC Inspector:		Leo		Sign:		Date:	2024/02/29

## Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations	
O: Planeity of global assembly	4 mm	Pass	Ruler	Acceptable	
P / P': Planeity	2 mm	Pass	Ruler	Acceptable	
Q: Planeity Surface of Supports	4 mm	Pass	Ruler	Acceptable	
R: Planeity Coupler Support	2 mm	Pass	Ruler	Acceptable	
S: Perpendicularity coupler	1mm	Pass	Square	Acceptable	
QC Inspector:	Leo	Sign:	A	Date:	2024/02/29

## Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	2024/03/06	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152	



### Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date: 2024/03/06


### Dimensional Control

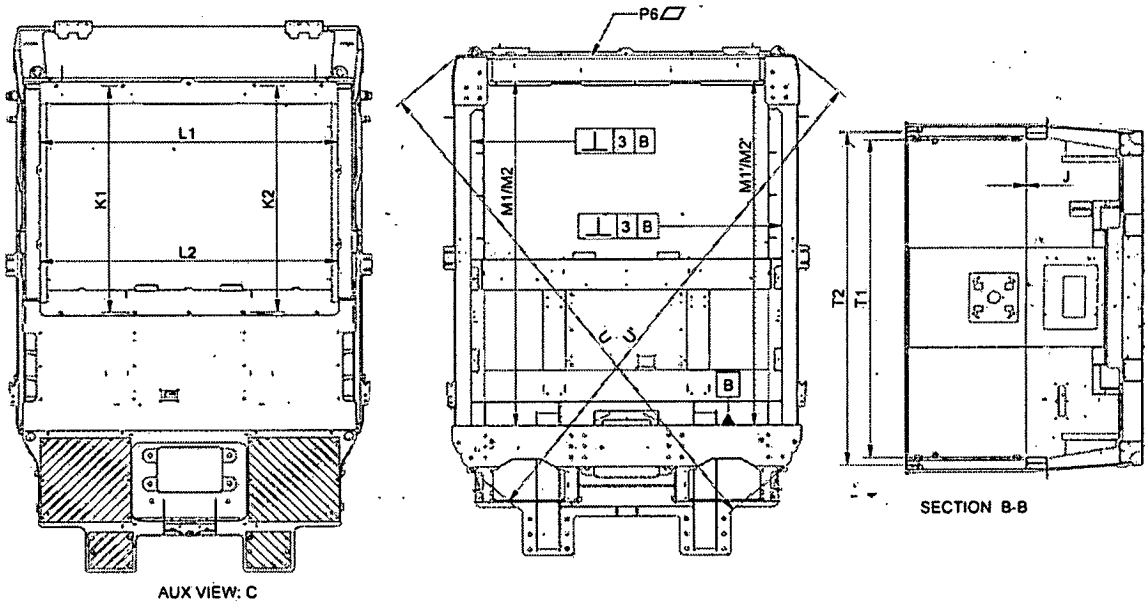
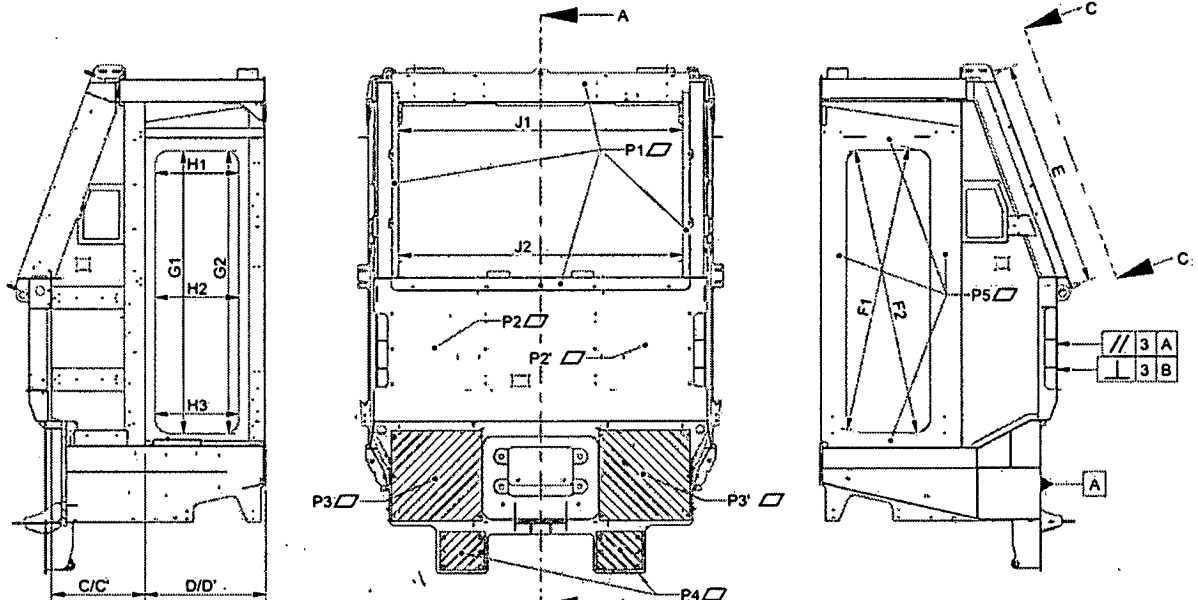
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1486	1486	Tape Measure	<i>[Signature]</i>
Y1	2354	± 3				
Y2 / Y3	666	± 1	667	667		<i>[Signature]</i>
QC Inspector:		<i>Leon</i>	Sign:		<i>[Signature]</i>	Date: 2024/03/06

### Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Ruler	
P2 / P3 : Planeity	4 mm	Ruler	
P4 / P5 : Planeity	2 mm	Ruler	
P6 : Planeity	2 mm	Ruler	
QC Inspector:		Sign:	Date: 20__/__/__

# Cabin Structure Assembly: GN002834

Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BROWN	Assembly Date:	20 24/03/06			
Sign:		Wire Batch No.:	2202152			



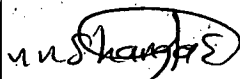

<b>Welding Control</b>									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed		Yes		No
QC Inspector:					Sign:				Date: 20__/__/__
<b>Dimensional Control</b>									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	625	624					
D / D'	813	± 2,5	813	812					
E	1531.5	± 3	1531						
G1 / G'1	Height 1900	+1	1897	1897					
G2 / G'2		-3	1898	1898					
H1 / H'1	Width 560	+1	557	557					
H2 / H'2		-3	558	558					
H3 / H'3			559	559					
F1 / F'1	Diagonals 1939		1936	1936					
F2 / F'2			1986	1936					
Difference	F1-F2 / F'1-F'2	≤ 4	0	0					
J	Gap of Doors	± 1,5	1						
K1 / K2	1515	± 3	1513	1513					
L1 / L2	1996	± 3	1995	1994					
M1 / M'1	2306	± 3	2470	2470					
M2 / M'2			2479	2478					
T1 / T'1	2130 Top/Bottom	± 3	2127	2127					
T2 / T'2	2230 Top/Bottom		2231	2230					
Difference	U - U' (3522)	≤ 4mm	3523	3520					
QC Inspector:					Sign:				Date: 20__/__/__
<b>Geometrical Control</b>									
Nature of checks				Toler.	LHS / Dimension Measured / RHS				
P1 / P'1	Planeity			2 mm	Passed				
P2 / P'2	Planeity			2 mm	Passed				
P3 / P'3	Planeity			4 mm	Passed				
P4 / P'4	Planeity			4 mm	Passed				
P5 / P'5	Planeity			4 mm	Passed				
P6 Roof	Planeity			6 With 2m Ruler	Passed				
Shield	//	3	A	3	Passed				
Shield	⊥	3	A	3	Passed				
Door Post	⊥	3	A	Front	Passed				
				Back	Passed				
QC Inspector:					Sign:				Date: 20__/__/__

Cabin Bracket Assembly: GN002833				
Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>Damico</i>	Assembly Date:	20 <i>24</i> / <i>03</i> / <i>10</i>	
Sign:	<i>[Signature]</i>	Wire Batch No.:	<i>2202152</i>	


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

Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Fasteners positioned in all Rivnuts and Bosses	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Masked as per GMS-SOS-GIBELA-CABIN-001	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID	Sign:		TD [Signature]	
Date:	20 24/03/28				
Record of Shot Blasting					
Operator:		Date:	2024/02/28		
Start Time:	07 H04	End Time:	10 H01		
Temperature ( $\geq 15^{\circ}$ ):	19-08 °C	Humidity ( $\leq 75\%$ ):	67-02 %		
Shot Blasting Self-Inspection					
Interior of Cabin: Sa 1 - Light Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID	Sign:		TD [Signature]	
Date:	2024/03/28				
Shot Blasting Cleaning					
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID	Sign:		TD [Signature]	
Date:	2024/03/28				
Shot Blasting Control					
Temperature $\geq 15^{\circ}$ :	20-02 °C	Humidity $\leq 75\%$ :	69-04 %		
Internal Roughness $3.2 \leq Ra \leq 12.5$		External Roughness $3.2 \leq Ra \leq 12.5$			
QC Inspector:		Sign:			
Date:					

Record of Priming									
Start Time:		22:00		End Time:		23:58			
Temperature $\geq 15^{\circ}$ :		26 $^{\circ}$ C		Humidity $\leq 75\%$ :		48%			
Paint Batch No.:		7978267		Paint Expiry Date:		06/25			
Hardener Batch No.:		7331119		Hardener Expiry Date:		01-11-24			
Desolvation Start Time:		23:58		Desolvation End Time:		00:15			
Stoving Start Time:		00:15		Stoving End Time:		01:15			
Stoving Temp:		60 $^{\circ}$ C							
Operator:		N. Luthuk		Sign:		M. S. Khan			
Date:		2024 03/28							
Priming Control									
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front			
1: 52.6	5: 59.2	1: 46.0	5: 49.7	1: 45.9	5: 82.6	1: 42.2	5: 54.1		
2: 48.5	6: 43.9	2: 65.3	6: 54.0	2: 64.4	6: 87.8	2: 71.4	6: 76.7		
3: 60.8	7: 72.1	3: 76.7	7: 59.9	3: 47.2	7: 60.6	3: 84.8	7: 43.3		
4: 48.3	8: 41.4	4: 44.6	8: 43.3	4: 65.8	8: 76.1	4: 48.0	8: 50.5		
Min:	41.4	Min:	43.3	Min:	45.9	Min:	42.2		
Max:	72.1	Max:	76.7	Max:	87.8	Max:	84.8		
Average:	53.3	Average:	54.9	Average:	66.3	Average:	58.8		
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside			
1: 65.6	5: 53.1	1: 69.0	5: 61.3	1: 48.0	5: 78.2	1: 61.8	5: 51.3		
2: 89.8	6: 41.2	2: 43.9	6: 51.1	2: 60.8	6: 62.6	2: 45.7	6: 63.5		
3: 78.4	7: 65.3	3: 62.8	7: 41.9	3: 62.3	7: 78.3	3: 62.7	7: 71.3		
4: 57.7	8: 42.0	4: 51.9	8: 43.6	4: 43.5	8: 62.9	4: 73.4	8: 59.2		
Min:	41.2	Min:	43.6	Min:	43.5	Min:	45.7		
Max:	89.8	Max:	69.0	Max:	82.6	Max:	73.4		
Average:	56.3	Average:	53.9	Average:	64.5	Average:	53.1		
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS			
1: 32.6	5: 51.9	1: 66.7	5: 79.1	1: 78.4	5: 51.7	1: 81.4	5: 63.3		
2: 58.4	6: 49.6	2: 78.8	6: 69.4	2: 64.3	6: 62.5	2: 72.4	6: 71.9		
3: 52.8	7: 44.7	3: 63.7	7: 54.2	3: 75.8	7: 77.0	3: 63.1	7: 68.4		
4: 60.0	8: 49.7	4: 61.4	8: 58.3	4: 43.3	8: 62.1	4: 55.7	8: 49.6		
Min:	32.6	Min:	54.2	Min:	43.3	Min:	49.6		
Max:	60.0	Max:	79.1	Max:	78.4	Max:	81.4		
Average:	43.7	Average:	65.7	Average:	64.3	Average:	65.7		
Primer has been inspected and is free of defects				Confirmed		Yes		No	
QC Inspector:		Zothile		Sign:		M. S. Khan			
Date:		02 Apr 2024							

Record of Painting NCSS3010 R90B			
Start Time:	20:00	End Time:	20:30
Temperature $\geq 15^{\circ}$ :	29°C	Humidity $\leq 75\%$ :	41%
Paint Batch No.:	8156903	Paint Expiry Date:	23-01-25
Hardener Batch No.:	75202115121	Hardener Expiry Date:	12-24
Desolvation Start Time:	20:30	Desolvation End Time:	20:45
Stoving Start Time:	20:45	Stoving End Time:	21:45
Stoving Temp:	60°C		
Operator:	Ntuthuko	Sign:	
Date:	2024/04/02		
Painting NCSS3010 R90B Control			
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS	
1: 121	5: 105	1: 110	5: 128
2: 114	6: 117	2: 144	6: 122
3: 120	7: 153	3: 157	7: 119
4: 132	8: 129	4: 113	8: 142
Min:	105	Min:	110
Max:	153	Max:	157
Average:	123	Average:	129
Painting NCSS3010 R90B has been inspected and is free of defects		Confirmed	Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	38.2
QC Inspector:	Zotwile	04 Apr 2024	Sign: 
Date:			

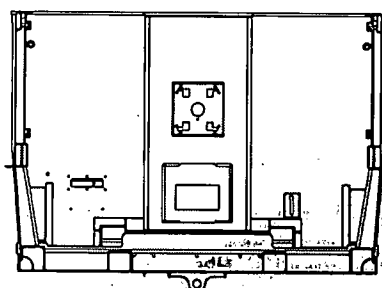
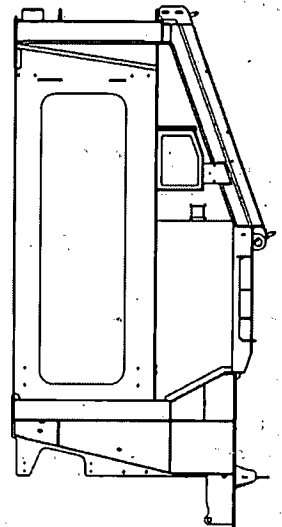
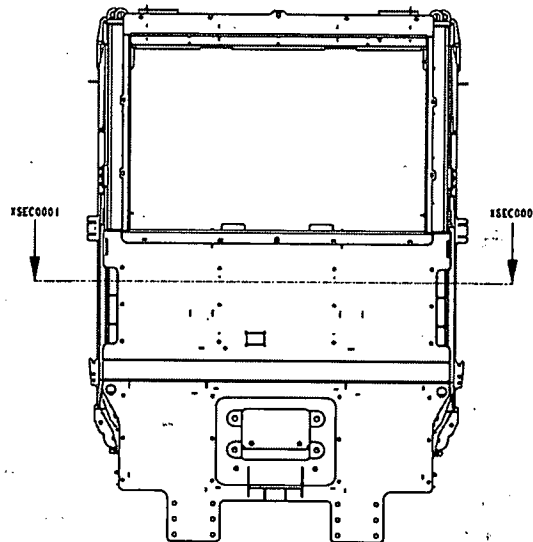
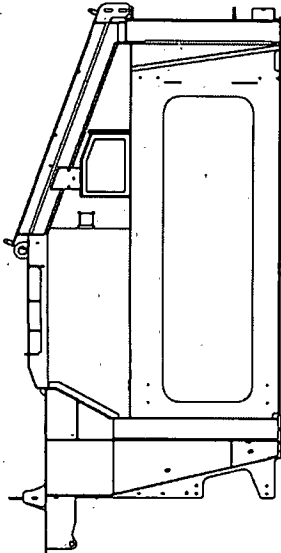
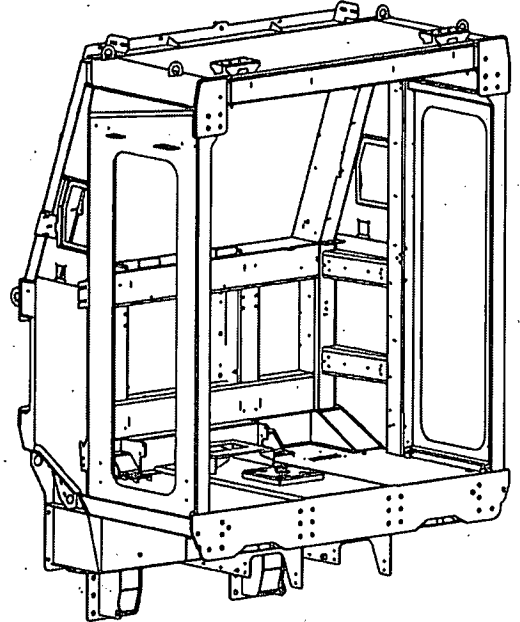
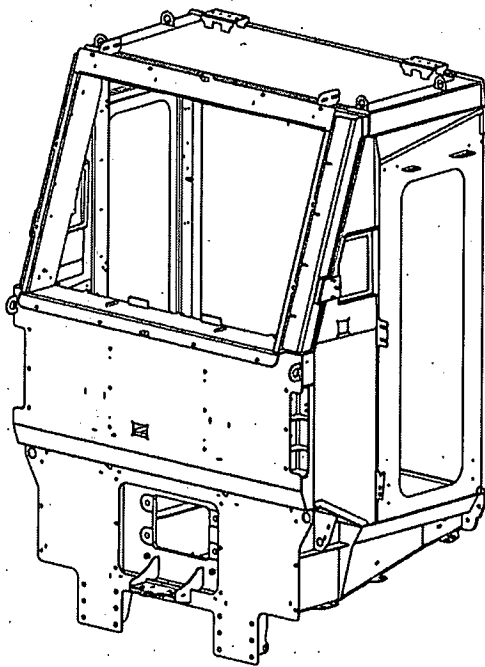
Record of Painting Blue NCSS1565-B				
Start Time:	22:00		End Time:	22:30
Temperature $\geq 15^{\circ}$ :	31°C		Humidity $\leq 75\%$ :	44%
Paint Batch No.:	81763138		Paint Expiry Date:	02-01-25
Hardener Batch No.:	7502115121		Hardener Expiry Date:	12/24
Desolvation Start Time:	22:30		Desolvation End Time:	22:45
Stoving Start Time:	22:45		Stoving End Time:	23:45
Stoving Temp:	60°C			
Operator:	Ntuthuko		Sign:	[Signature]
Date:	20 <del>29</del> / 04 / 02			
Painting Blue NCSS1565-B Control				
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)
1: 107	5: 154	1: 107	5: 137	
2: 143	6: 116	2: 119	6: 122	
3: 155	7: 121	3: 152	7: 115	
4: 112	8: 117	4: 127	8: 118	
Min: 107		Min: 107		
Max: 155		Max: 152		
Average: 128		Average: 128		
Painting NCSS3010 R90B has been inspected and is free of defects				
				Yes <input checked="" type="checkbox"/>
				No <input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test				Value
				92.2
QC Inspector:	Zothule			Sign:
Date:	04 Apr 2024			
				[Signature]

Record of RAL 7012							
Start Time:		02:00		End Time:		04:30	
Temperature $\geq 15^{\circ}$ :		26 $^{\circ}$ C		Humidity $\leq 75\%$ :		47%	
Paint Batch No.:		8156853		Paint Expiry Date:		06-02-25	
Hardener Batch No.:		75021121		Hardener Expiry Date:		12/20	
Desolvation Start Time:		04:30		Desolvation End Time:		04:45	
Stoving Start Time:		04:45		Stoving End Time:		05:45	
Stoving Temp:		600C					
Operator:		Ntuthu/10		Sign:		nshango	
Date:		20/04/2024					
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 84.4	5: 93.0	1: 89.0	5: 136	1: 110	5: 83.4	1: 116	5: 89.5
2: 88.9	6: 150	2: 128	6: 117	2: 115	6: 145	2: 84.9	6: 98.9
3: 73.9	7: 96.6	3: 153	7: 144	3: 129	7: 75.4	3: 105	7: 119
4: 95.1	8: 109	4: 83.4	8: 72.4	4: 143	8: 166	4: 83.9	8: 128
Min:	73.9	Min:	72.4	Min:	75.4	Min:	83.9
Max:	150	Max:	153	Max:	166	Max:	119
Average:	98.8	Average:	115	Average:	120	Average:	103
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 89.4	5: 79.3	1: 118	5: 131	1: 152	5: 160	1: 98.7	5: 114
2: 116	6: 93.7	2: 122	6: 95.6	2: 143	6: 108	2: 117	6: 99.2
3: 121	7: 85.4	3: 145	7: 89.0	3: 149	7: 146	3: 144	7: 136
4: 81.5	8: 82.1	4: 147	8: 79.4	4: 138	8: 135	4: 84.9	8: 157
Min:	79.3	Min:	79.4	Min:	108	Min:	84.9
Max:	121	Max:	147	Max:	160	Max:	144
Average:	93.55	Average:	115	Average:	141	Average:	118
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 111	5: 127	1: 101	5: 108				
2: 139	6: 132	2: 145	6: 133				
3: 108	7: 148	3: 131	7: 123				
4: 81.4	8: 112	4: 162	8: 125				
Min:	81.4	Min:	101				
Max:	148	Max:	162				
Average:	119	Average:	128				
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No
GMS-SOS-GIBELA-PS-002 Gloss Test				Value			
QC Inspector:		Zothile		Sign:			
Date:		04 Apr 2024					
SEALING OF CABIN							
All areas where there is no welding has been sealed with SIKA						Confirmed	YES
All sealants have been neatly applied along joints						Confirmed	YES
SIGN OFF							
CLOCK No:	OPERATOR SIGN:		DATE:				



## REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)



## FAULT TRACKING

[illegible]

REMINDERS / COMMENTS

[illegible]

2000



## CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	0451	Checks Updated:	2022/08/26

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

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

Quality approval for release Signature	CO. NO:	DATE
	2285	09 Apr 2024