

## CABIN STRUCTURE QUALITY CARD

CAB No.: CAB443  

WEIGHT: 1495 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	LP 49402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	14/02/24	178820 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	28/02/24	178488 104640 01	P300091	
RCS 355	20 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegasus	12/02/24			
RCS 355	30 mm					

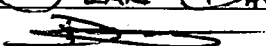
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	08/02/24	178489 104640 01	VHC 35578	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

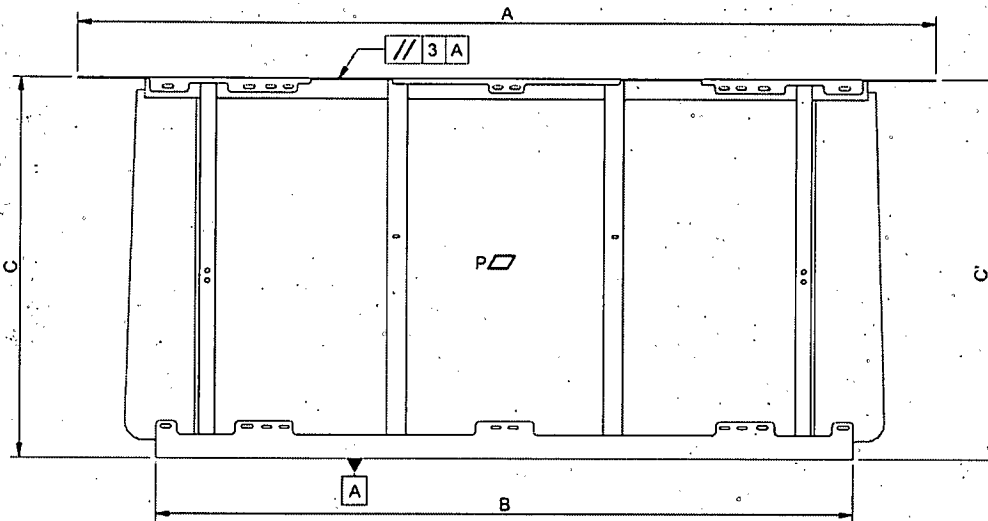
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	14/02/24	178815 104640 01	F207905 VHC 28402	
RCS 450	6 mm					
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	22/11/23	175569 102206 01	F207906 VHS 58432	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					




## Cabin Roof Assembly: GN002839


Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	DYLAN DAVIDS	Assembly Date:	2024/02/08	
Sign:		Wire Batch No.:	107238201	




### Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	LEON	Sign:		Date: 2024/02/08

### Dimensional Control

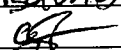
Rep	Toler.	Dimension measured		Measuring Equipment	Observations	
A	2216	+5/-0	2216	Tape Measure	Acceptable Superior	
B	1800	±4	1800			
C	976	+2/-3	977			
QC Inspector:		LEON		Sign:		Date: 2024/02/08

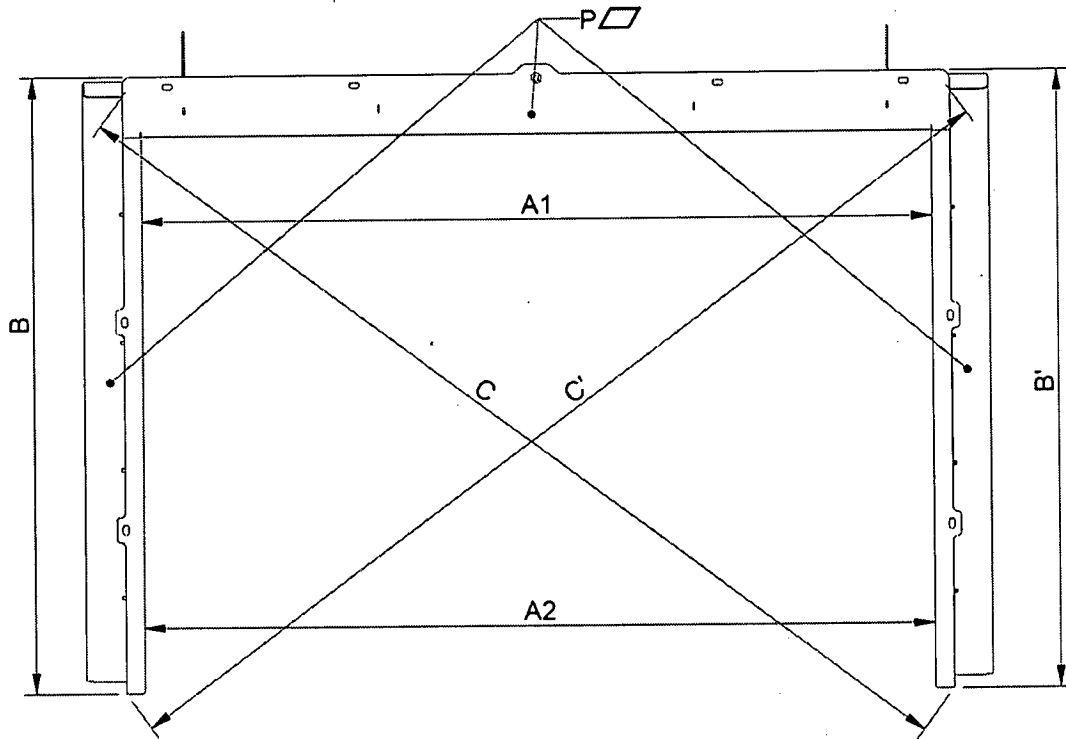
### Geometrical Control

Nature of Checks		Dimension Measured	Measuring Equipment	Observations		
Planeity P	6 mm	Pass	Ruler	Acceptable Superior		
//	3	A	Set Square			
QC Inspector:		LEON		Sign:		Date: 2024/02/08




## Cabin Front Frame Assembly: GN002840


Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<u>Rambelo Gcinan</u>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>08</u>			
Sign:		Wire Batch No.:	<u>2202152</u>			




### 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:	<u>Leon</u>	Sign:		Date:	20 <u>24</u> / <u>02</u> / <u>08</u>	

### Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	1910	± 2	1912		Tape Measure	Acceptable
A2	1910		1910			Acceptable
B	1475	± 1	1475	1475		Acceptable
C	Diagonals  C - C'  ≤ 3		2478	2476		Acceptable
QC Inspector:		<u>Leon</u>		Sign:		Date: 20 <u>24</u> / <u>02</u> / <u>08</u>

### Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P : Planicity	4 mm	<u>Pass</u>	Ruler	Acceptable
QC Inspector:		<u>Leon</u>		Sign:  Date: 20 <u>24</u> / <u>02</u> / <u>08</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	
Operator:	<i>Xander</i>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>08</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	
Operator:	<i>Glenn</i>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>07</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	
Operator:	<i>Glenn</i>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>07</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

☒

No

Operator:

Glenn

Assembly Date:

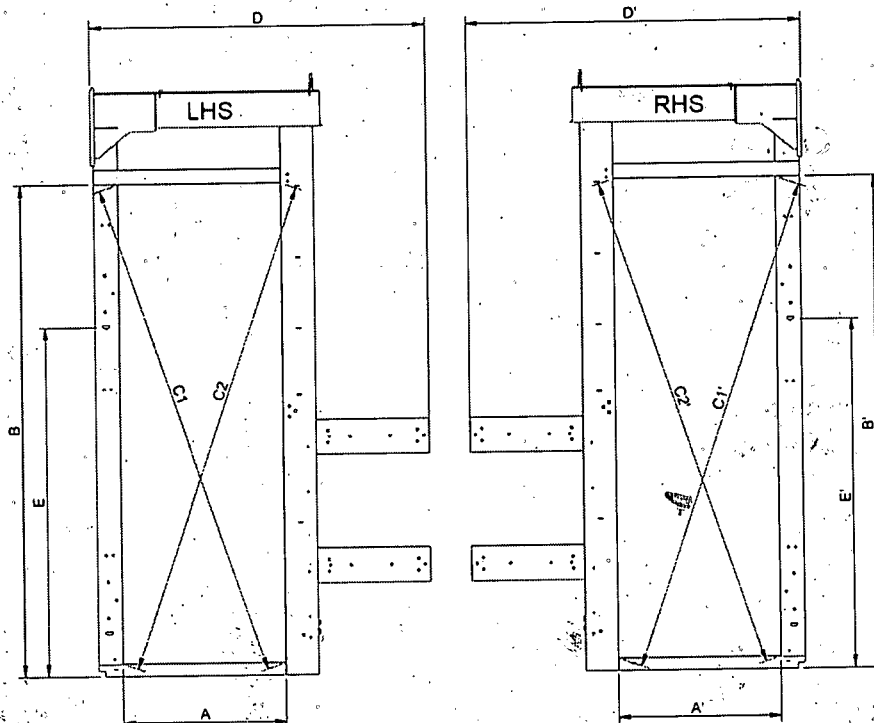
2024/02/12

Sign:

*Glenn*

Wire Batch No.:

2202152



## Welding Control

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

Confirmed

Yes

☒

No

QC Inspector:

*Leon*

Sign:

*AS*

Date:

2024/02/12

## Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	696	Tape Measure	<i>Acceptable</i>
B	2086	+1/-3	2086	2084		<i>Acceptable</i>
C1 / C2	Difference of diagonals $ C1 - C2  \leq 3$		2152	2152		<i>Acceptable</i>
C1 - C2			2152	2150		<i>Acceptable</i>
D	1438	+2/-3	1437	1436		<i>Acceptable</i>
E			1483	1483		<i>Acceptable</i>
QC Inspector:		<i>Leon</i>	Sign:		<i>AS</i>	Date: 2024/02/12

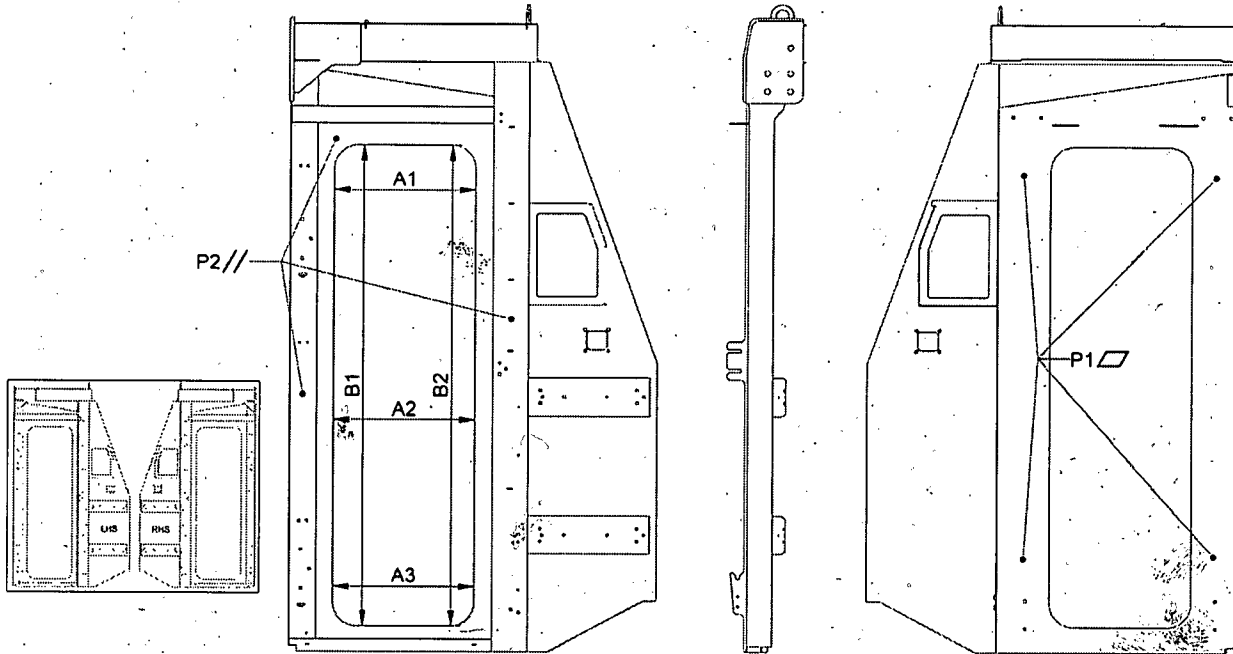
## Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	<i>Pass</i>	<i>Acceptable</i>
QC Inspector:		<i>Leon</i>	Date: 2024/02/12



## Cabin LHS/RHS Side Assembly: GN002838/GN002837

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	/	No
Operator:	<i>Xande</i>	Assembly Date:	2024/02/12		
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152		



### Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	✓	No
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	20_24/02/17

### Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	558	559	Tape Measure	<i>Accepted</i>
A2			559	560		<i>Accepted</i>
A3			559	559		<i>Accepted</i>
B1	1900	± 2	1898	1898		<i>Accepted</i>
B2			1898	1898		<i>Accepted</i>

QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	20_24/02/17
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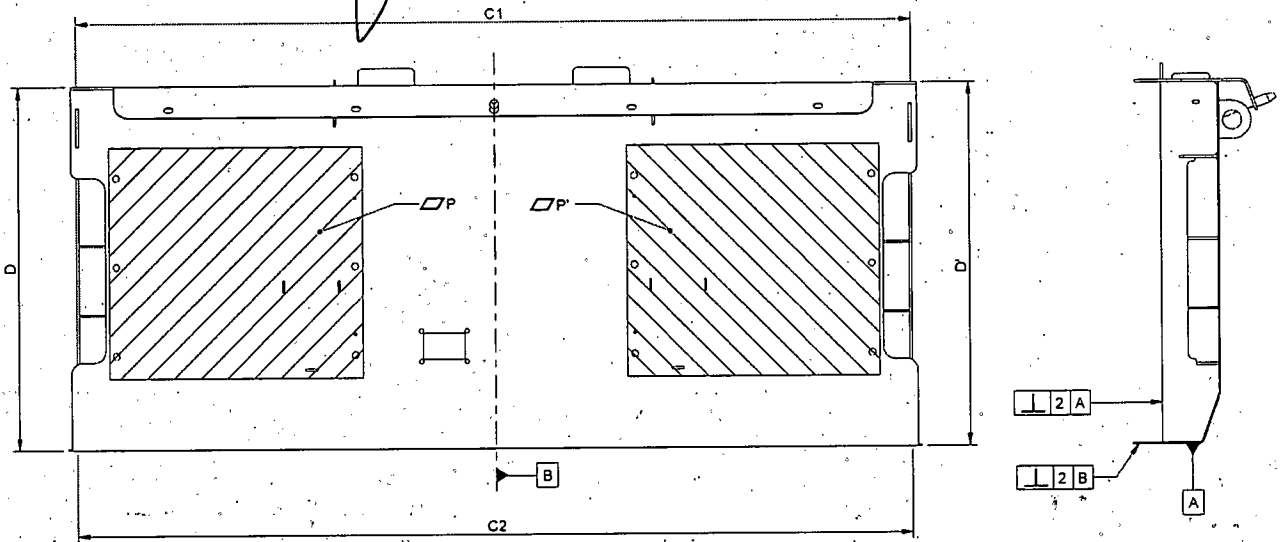
### Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Ruler	<i>Accepted</i>
P2 : Planeity	2 mm	Ruler	<i>Accepted</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>
Date:	2024/02/17		



## Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>DEVAN DAVENHILL</i>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>08</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202156			



### Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>02</u> / <u>08</u>	

### Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	<i>2214</i>	<i>2214</i>	Tape Measure	<i>Acceptable</i>
D' / D	956	± 2	<i>955</i>	<i>955</i>		<i>Acceptable</i>
QC Inspector:	<i>Leon</i>		Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>02</u> / <u>08</u>

### Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Perpendicularity	Planarity P / P'	2 mm	<i>Passes</i>		Ruler	<i>Acceptable</i>
		2	A	<i>Passes</i>	Set Square	<i>Acceptable</i>
		2	B	<i>Passes</i>	Set Square	<i>Acceptable</i>
QC Inspector:	<i>Leon</i>		Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>02</u> / <u>08</u>



# Cabin Front Headstock Assembly: GN002841

Assembly Completed as per WI/SOS MD\_0019

Confirmed

Yes

No

Operator:

TK BOOLE

Assembly Date:

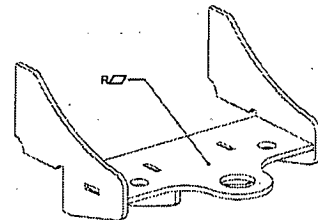
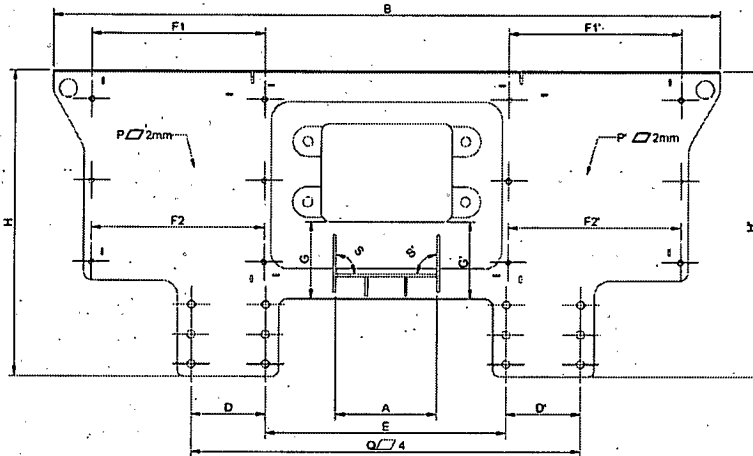
2024 / 1 /

Sign:

[Signature]

Wire Batch No.:

2202152



## Welding Control

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

Confirmed

Yes

No

QC Inspector:

LEON


Sign:

[Signature]



Date:

2024 / 02 / 14

## Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	± 1	340		Tape Measure	Accepted
B	2240	± 4	2244			Accepted
D / D'	250	± 1	250.5	250.5		Accepted
E	808	± 2	801			Accepted
F1 / F1'	580	± 1	581	581		Accepted
F2 / F2'			581	581		Accepted
G / G'	258	± 1	259	257		Accepted
H / H'	1019	± 2	1020	1020		Accepted
QC Inspector:		Leon		Sign:		Date: 2024/04/14

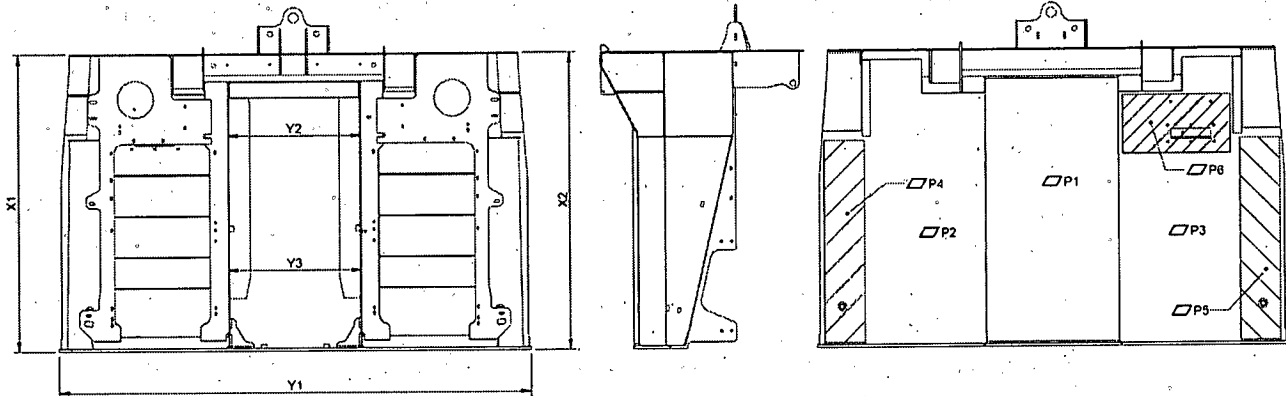
## Geometrical Control

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: 		Sign: 	Date: 20__/01/14	



## Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Richard Wood</i>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>15</u>	
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: 20 <u>24</u> / <u>02</u> / <u>15</u>

### Dimensional Control


Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1486	1486	Tape Measure	<i>Acceptable</i>
Y1	2354	± 3	2351			<i>Acceptable</i>
Y2 / Y3	666	± 1	666	668		<i>Acceptable</i>
QC Inspector:		<i>LEON</i>	Sign:		<i>[Signature]</i>	Date: 20 <u>24</u> / <u>02</u> / <u>15</u>

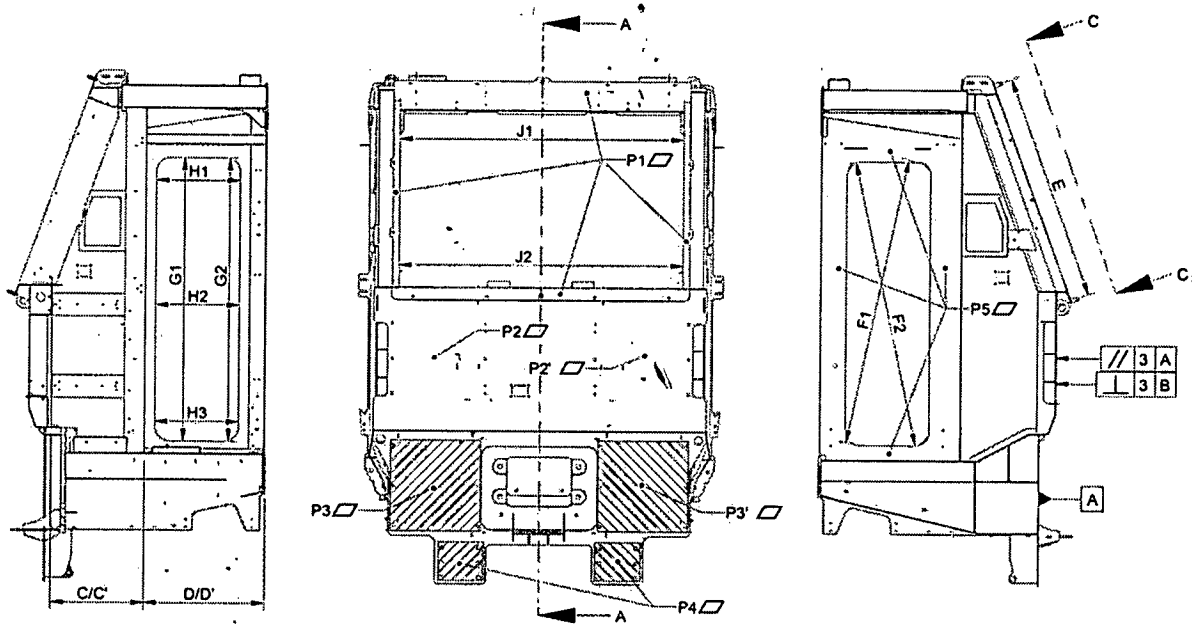
### Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	<i>Pass</i>	<i>Acceptable</i>
P2 / P3 : Planeity	4 mm	<i>Pass</i>	<i>Acceptable</i>
P4 / P5 : Planeity	2 mm	<i>Pass</i>	<i>Acceptable</i>
P6 : Planeity	2 mm	<i>Pass</i>	<i>Acceptable</i>
QC Inspector:		<i>LEON</i>	Date: 20 <u>24</u> / <u>02</u> / <u>15</u>



Cabin Structure Assembly: GN002834

Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLOOM	Assembly Date:	20 24/02/15			
Sign:		Wire Batch No.:	220252			



SECTION A-A

SECTION B-B

AUX VIEW: C



Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed		Yes		No
QC Inspector:		Bridley			Sign:		[Signature]		Date: 2024/02/21
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	625	624	Acceptable				
D / D'	813	± 2,5	814	813	Acceptable				
E	1531.5	± 3	1530		Acceptable				
G1 / G'1	Height	+1	1900	1900	Acceptable				
G2 / G'2	1900	-3	1899	1898	Acceptable				
H1 / H'1	Width	+1 -3	558	558	Acceptable				
H2 / H'2			558	558	Acceptable				
H3 / H'3			559	558	Acceptable				
F1 / F'1	Diagonals		1932	1933	Acceptable				
F2 / F'2			1934	1936	Acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	2	3	Acceptable				
J	Gap of Doors	± 1,5	1		Acceptable				
K1 / K2	1515	± 3	1514	1516	Acceptable				
L1 / L2	1996	± 3	1997	1996	Acceptable				
M1 / M'1	2306	± 3	2474	2475	Acceptable				
M2 / M'2			2464	2468	Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2130	2130	Acceptable				
T2 / T'2	2230 Top/Bottom		2230	2230	Acceptable				
Difference	U - U' (3522)	≤ 4mm	3519	3517	Acceptable				
QC Inspector:		Bridley			Sign:		[Signature]		Date: 2024/02/21
Geometrical Control									
Nature of checks				Toler.	LHS / Dimension Measured / RHS		Observations		
P1 / P'1	Planeity			2 mm	Passed		Acceptable		
P2 / P'2	Planeity			2 mm	Passed		Acceptable		
P3 / P'3	Planeity			4 mm	Passed		Acceptable		
P4 / P'4	Planeity			4 mm	Passed		Acceptable		
P5 / P'5	Planeity			4 mm	Passed		Acceptable		
P6 Roof	Planeity			6 With 2m Ruler	Passed		Acceptable		
Shield	//	3	A	3	Passed		Acceptable		
Shield	⊥	3	A	3	Passed		Acceptable		
Door Post	⊥	3	A	Front	Passed		Acceptable		
				Back	Passed		Acceptable		
QC Inspector:		Bridley			Sign:		[Signature]		Date: 2024/02/21



### Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091	Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator: <i>Daniel</i>	Assembly Date:	2024/02/21		
Sign: <i>[Signature]</i>	Wire Batch No.:	2202152		


### Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092	Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator: <i>SEWYN</i>	Assembly Date:	2024/02/21		
Sign: <i>[Signature]</i>	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			
Date: 20 24/03/15					
Record of Shot Blasting					
Operator: DAVID		Date: 20 24/03/15			
Start Time:		End Time: 09 H00			
Temperature ( $\geq 15^\circ$ ): 22-01 $^\circ\text{C}$		Humidity ( $\leq 75\%$ ): 64-09 %			
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			
Date: 20 24/03/15					
Shot Blasting Cleaning					
Cabin free of all sand		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator: DAVID		Sign: TD			
Date: 20 24/03/15					
Shot Blasting Control					
Temperature $\geq 15^\circ$ : 20-07 $^\circ\text{C}$		Humidity $\leq 75\%$ : 60-05 %			
Internal Roughness $3.2 \leq \text{Ra} \leq 12.5$ : 8.756		External Roughness $3.2 \leq \text{Ra} \leq 12.5$ : 7.269			
QC Inspector: L. G. W.		Sign: A			
Date: 13/03/24					




Record of Priming							
Start Time:		21:00		End Time:		23:30	
Temperature $\geq 15^{\circ}$ :		25 $^{\circ}$ C		Humidity $\leq 75\%$ :		49%	
Paint Batch No.:		7878267		Paint Expiry Date:		06/25	
Hardener Batch No.:		733119		Hardener Expiry Date:		01/11/24	
Desolvation Start Time:		23:30		Desolvation End Time:		23:45	
Stoving Start Time:		123:45		Stoving End Time:		00:45	
Stoving Temp:		60 $^{\circ}$ C					
Operator:		Ntuthuko		Sign:		NTUTHUKO.	
Date:		2024/03/15					
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 47.3	5: 65.8	1: 61.7	5: 48.3	1: 74.6	5: 68.3	1: 79.2	5: 65.7
2: 51.9	6: 68.0	2: 82.3	6: 51.9	2: 80.7	6: 60.5	2: 65.9	6: 38.3
3: 73.8	7: 70.1	3: 64.8	7: 57.7	3: 65.9	7: 71.0	3: 73.7	7: 47.6
4: 72.4	8: 44.2	4: 44.7	8: 62.8	4: 54.4	8: 73.8	4: 52.0	8: 43.8
Min:	44.2	Min:	44.7	Min:	54.4	Min:	38.3
Max:	73.8	Max:	82.3	Max:	80.7	Max:	79.2
Average:	74.1	Average:	59.2	Average:	68.6	Average:	62.2
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 41.8	5: 65.2	1: 71.4	5: 63.8	1: 50.0	5: 61.9	1: 43.2	5: 72.3
2: 52.0	6: 49.3	2: 81.1	6: 60.3	2: 52.4	6: 74.8	2: 74.0	6: 61.5
3: 42.7	7: 69.8	3: 61.1	7: 51.2	3: 57.7	7: 68.7	3: 81.9	7: 63.8
4: 62.8	8: 63.7	4: 68.2	8: 51.3	4: 46.2	8: 82.5	4: 65.3	8: 61.1
Min:	41.8	Min:	61.1	Min:	46.2	Min:	43.2
Max:	69.8	Max:	81.1	Max:	74.8	Max:	81.9
Average:	55.9	Average:	63.5	Average:	68.6	Average:	65.3
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 49.1	5: 52.8	1: 83.0	5: 41.9	1: 62.0	5: 78.9	1: 71.8	5: 56.5
2: 81.4	6: 69.4	2: 74.9	6: 44.7	2: 71.6	6: 54.3	2: 65.4	6: 64.1
3: 65.4	7: 73.5	3: 69.5	7: 48.1	3: 59.6	7: 63.7	3: 58.9	7: 80.2
4: 74.2	8: 62.4	4: 74.4	8: 45.2	4: 57.3	8: 54.2	4: 61.5	8: 55.8
Min:	49.1	Min:	41.9	Min:	54.3	Min:	55.8
Max:	81.4	Max:	83.0	Max:	79.6	Max:	80.2
Average:	66.0	Average:	59.8	Average:	63.7	Average:	64.0
Primer has been inspected and is free of defects				Confirmed		Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>	
QC Inspector:		Zothile		Sign:			
Date:		16 Mar 2024					



### Record of Painting NCSS3010 R90B

Start Time:	22:00	End Time:	22:30
Temperature $\geq 15^{\circ}$ :	27°C	Humidity $\leq 75\%$ :	42%
Paint Batch No.:	8156903	Paint Expiry Date:	23/01/2025
Hardener Batch No.:	7502416121	Hardener Expiry Date:	12/14
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:	Ntuthuku	Sign:	Ntuthuku
Date:	2024/03/16		

### Painting NCSS3010 R90B Control

DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)			
1: 121	5: 127	1: 116	5: 125				
2: 153	6: 138	2: 107	6: 128				
3: 146	7: 140	3: 123	7: 137				
4: 144	8: 102	4: 103	8: 129				
Min: 102		Min: 103					
Max: 153		Max: 137					
Average: 127		Average: 120					
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	99.6		
QC Inspector:	Zothile			Sign:			
Date:	17 Mar 2024						



Record of Painting Blue NCSS1565 B			
Start Time:	10:06	End Time:	10:30
Temperature $\geq 15^{\circ}$ :	29 $^{\circ}$ C	Humidity $\leq 75\%$ :	34%
Paint Batch No.:	8120318	Paint Expiry Date:	62/02/2025
Hardener Batch No.:	7502115121	Hardener Expiry Date:	12/24
Desolvation Start Time:	10:30	Desolvation End Time:	10:45
Stoving Start Time:	10:45	Stoving End Time:	11:45
Stoving Temp:	60 $^{\circ}$ C		
Operator:	MUSA	Sign:	MUSA
Date:	2024/03/17		
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: 117	5: 126	1: 94.7	5: 100
2: 124	6: 104	2: 136	6: 111
3: 138	7: 118	3: 122	7: 104
4: 109	8: 122	4: 146	8: 125
Min: 104		Min: 94.7	
Max: 138		Max: 146	
Average: 121		Average: 120	
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	94.1
QC Inspector:	Zotwile	Sign:	
Date:	17 Mar 2024		



Record of RAL 7012								
Start Time:		03:00		End Time:		05:00		
Temperature $\geq 15^{\circ}$ :		31 $^{\circ}$ C		Humidity $\leq 75\%$ :		34%		
Paint Batch No.:		815 6853		Paint Expiry Date:		06/02/2025		
Hardener Batch No.:		7502 113/21		Hardener Expiry Date:		12/24		
Desolvation Start Time:		05:00		Desolvation End Time:		05:15		
Stoving Start Time:		05:15		Stoving End Time:		06:15		
Stoving Temp:		60 $^{\circ}$ C						
Operator:		NTUT HUKO		Sign:		NTUT HUKO		
Date:		2024/03/16						
RAL 7012 Control								
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front		
1: 118	5: 94.8	1: 131	5: 100	1: 139	5: 97	1: 150	5: 145	
2: 124	6: 106	2: 111	6: 95.9	2: 86.6	6: 105	2: 130	6: 91.3	
3: 103	7: 121	3: 135	7: 124	3: 141	7: 123	3: 156	7: 109	
4: 117	8: 138	4: 118	8: 151	4: 110	8: 136	4: 116	8: 137	
Min:	94.8	Min:	95.9	Min:	86.6	Min:	91.3	
Max:	138	Max:	151	Max:	141	Max:	156	
Average:	116	Average:	123	Average:	113.0	Average:	113	
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside		
1: 132	5: 121	1: 125	5: 114	1: 118	5: 163	1: 92.1	5: 114	
2: 140	6: 102	2: 129	6: 155	2: 89.2	6: 106	2: 98.8	6: 154	
3: 107	7: 143	3: 103	7: 134	3: 93.5	7: 157	3: 138	7: 90.4	
4: 158	8: 99.3	4: 119	8: 122	4: 160	8: 117	4: 141	8: 112	
Min:	99.3	Min:	103	Min:	89.2	Min:	90.4	
Max:	158	Max:	155	Max:	163	Max:	154	
Average:	124	Average:	129	Average:	126	Average:	122	
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test				
1: 128	5: 88	1: 126	5: 120					
2: 133	6: 96.7	2: 153	6: 101					
3: 108	7: 152	3: 94.0	7: 127					
4: 109	8: 142	4: 113	8: 87					
Min:	88	Min:	87.94.0					
Max:	159	Max:	153					
Average:	123	Average:	120					
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	45.5			
QC Inspector:		Zotnile		Sign:				
Date:		17 Mar 2024						
SEALING OF CABIN								
All areas where there is no welding has been sealed with SIKA						Confirmed	YES <input checked="" type="checkbox"/>	NO <input type="checkbox"/>
All sealants have been neatly applied along joints						Confirmed	YES <input checked="" type="checkbox"/>	NO <input type="checkbox"/>
SIGN OFF								
CLOCK No:	2400		OPERATOR SIGN:	Apmle		DATE:		

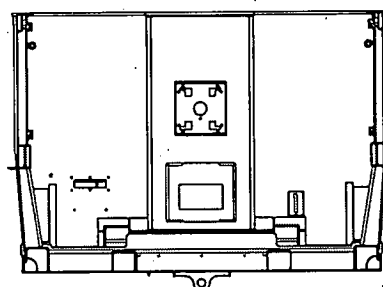
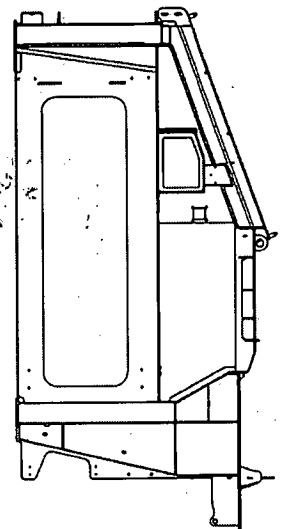
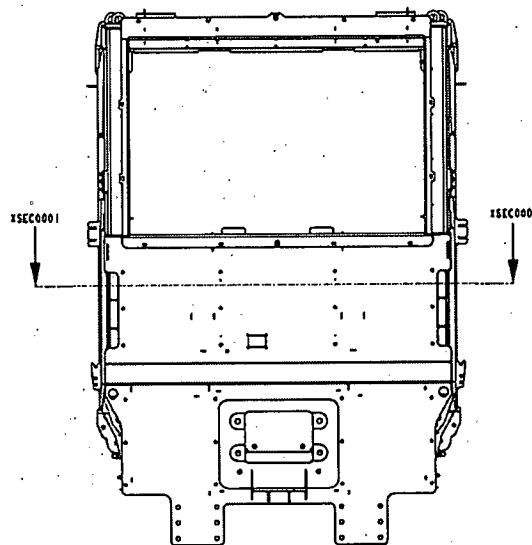
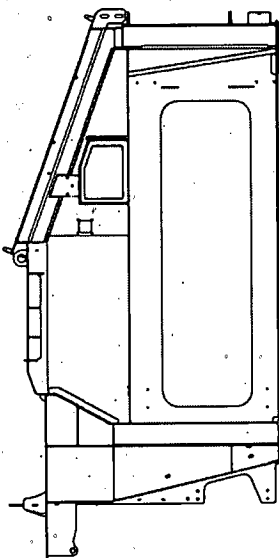
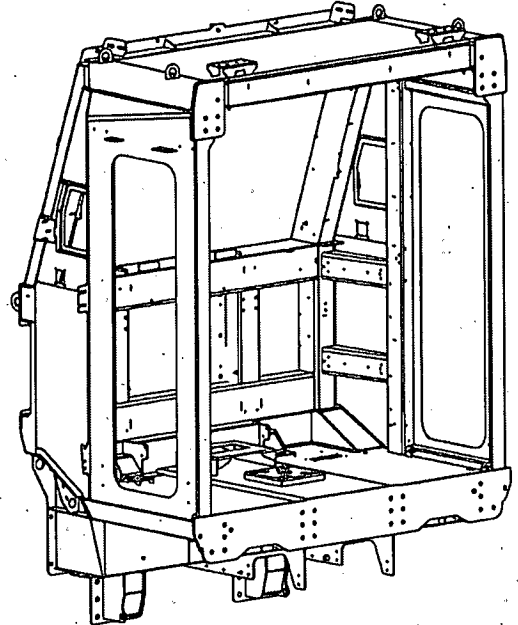
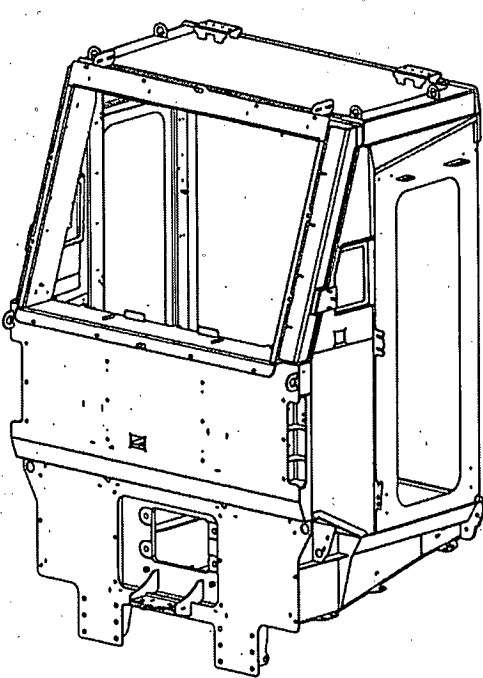






## REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)





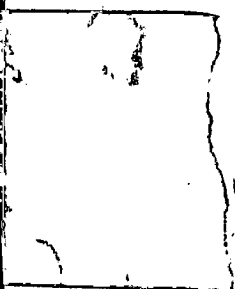
## FAULT TRACKING

[illegible]

<div style="text-align: center;"> <b>REMINDERS / COMMENTS</b> </div>	
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[illegible]









## CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	0443	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	17 Mar 2024