

# CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:	L	Updated By:	Jonathan Chetty
Frame No.:	439	Checks Updated:	2021/07/07

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
PRB	2291	09/03/24



## FAULT TRACKING

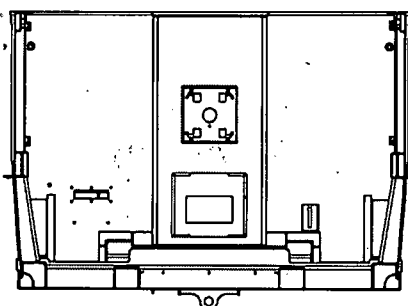
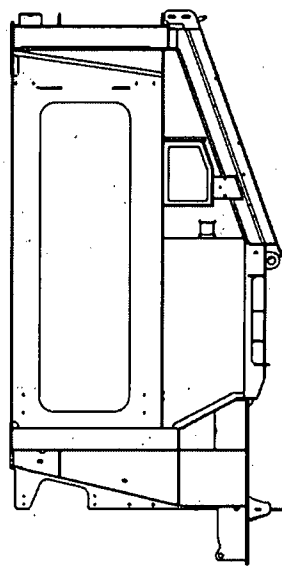
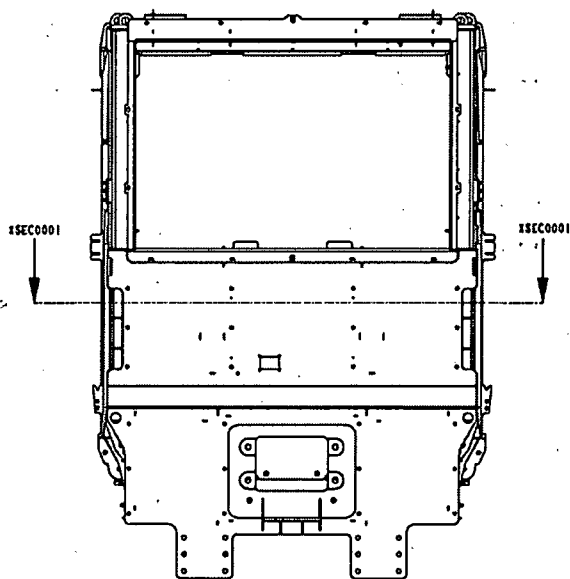
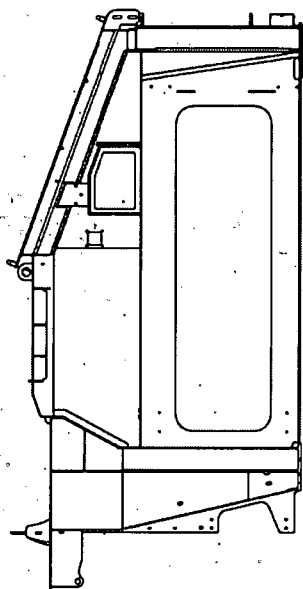
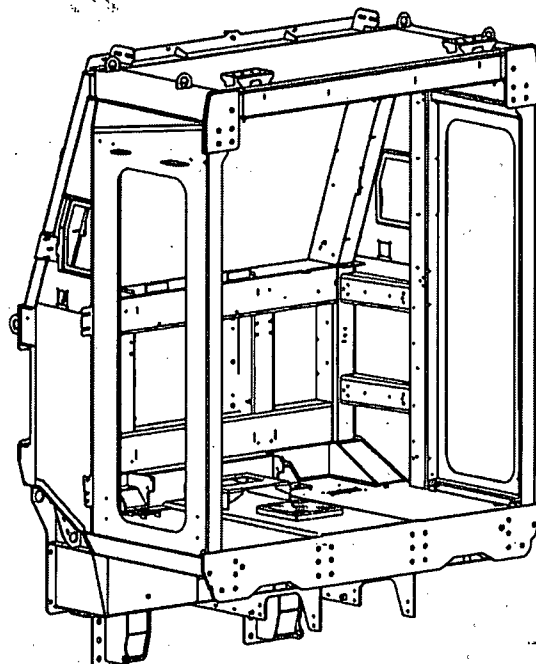
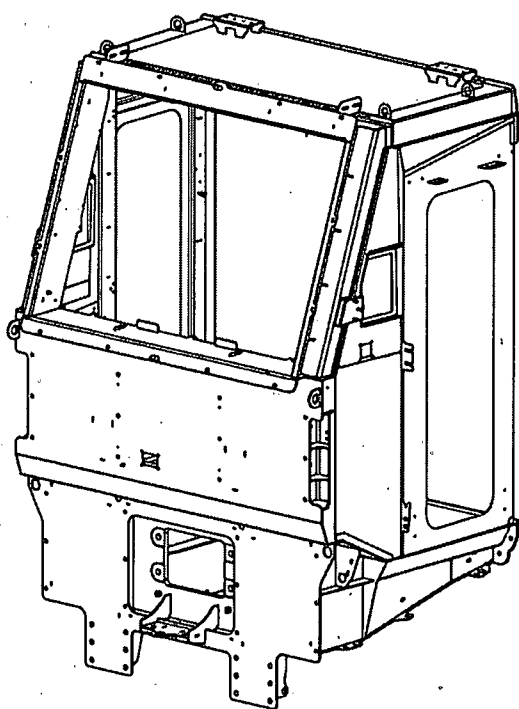
[illegible]

REMINDERS / COMMENTS

[illegible]

## REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)



CABIN WAXING									
CABIN IS WAXED							Confirmed	YES	NO
SIGN OFF									
CLOCK No		OPERATOR SIGN		DATE					

**Confirmed**

**YES**

NO

## SIGN OFF

CLOCK No.

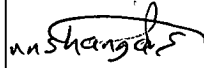
OPERATOR SIGN

DATE \_\_\_\_\_

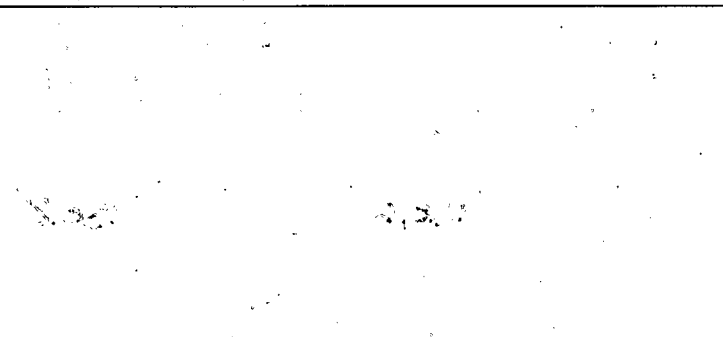

[illegible]

Record of RAL 7012							
Start Time:		03:00		End Time:		05:00	
Temperature $\geq 15^{\circ}$ :		29°C		Humidity $\leq 75\%$ :		32%	
Paint Batch No.:		8156853		Paint Expiry Date:		06.02.2025	
Hardener Batch No.:		7502112121		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:		160°C					
Operator:		Mfuthuko		Sign:			
Date:		2024/03/08					
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 129	5: 142	1: 119	5: 124	1: 960	5: 126	1: 869	5: 914
2: 145	6: 132	2: 120	6: 146	2: 117	6: 104	2: 101	6: 942
3: 139	7: 138	3: 125	7: 133	3: 125	7: 113	3: 89.6	7: 122
4: 146	8: 154	4: 138	8: 141	4: 131	8: 128	4: 127	8: 100
Min:	129	Min:	120	Min:	960	Min:	86.9
Max:	154	Max:	146	Max:	131	Max:	127
Average:	140.6	Average:	130.8	Average:	117.5	Average:	101.5
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 138	5: 98.2	1: 143	5: 153	1: 122	5: 127	1: 145	5: 105
2: 100	6: 115	2: 120	6: 118	2: 131	6: 148	2: 129	6: 138
3: 104	7: 109	3: 131	7: 122	3: 140	7: 128	3: 121	7: 126
4: 126	8: 127	4: 116	8: 142	4: 126	8: 119	4: 118	8: 135
Min:	98.2	Min:	118	Min:	119	Min:	105
Max:	138	Max:	153	Max:	148	Max:	138
Average:	114.7	Average:	130.6	Average:	130	Average:	133.4
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test  			
1: 157	5: 153	1: 99.3	5: 87.0				
2: 143	6: 141	2: 102	6: 99.4				
3: 150	7: 137	3: 94.2	7: 110				
4: 148	8: 151	4: 113	8: 115				
Min:	137	Min:	87.0				
Max:	153	Max:	115				
Average:	147.5	Average:	102.5				
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		38.4	
QC Inspector:		Zatule		Sign:			
Date:		08 Mar					
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				

### Record of Painting Blue NCSS1565 B

Start Time:	23:00	End Time:	23:30
Temperature $\geq 15^{\circ}$ :	26 $^{\circ}$ C	Humidity $\leq 75\%$ :	46%
Paint Batch No.:	8126318	Paint Expiry Date:	02.02.2025
Hardener Batch No.:	7302115121	Hardener Expiry Date:	12/24
Desolvation Start Time:	23:30	Desolvation End Time:	23:45
Stoving Start Time:	23:45	Stoving End Time:	00:45
Stoving Temp:	60 $^{\circ}$ C		
Operator:	Ntuthu ko	Sign:	
Date:	20 24/03/2024		

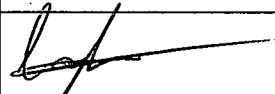
### Painting Blue NCSS1565 B Control

DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)			
1: 129	5: 111	1: 127	5: 141				
2: 128	6: 132	2: 104	6: 138				
3: 110	7: 136	3: 97.4	7: 126				
4: 108	8: 151	4: 121	8: 100				
Min: 104		Min: 100					
Max: 142		Max: 137					
Average: 124.6		Average: 118.1					
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	90.4		
QC Inspector:		Zothile		Sign:			
Date:		08 Mar 2024					




Record of Painting NCSS3010 R90B			
Start Time:	20:00	End Time:	20:30
Temperature $\geq 15^{\circ}$ :	29°C	Humidity $\leq 75\%$ :	43%
Paint Batch.No.:	8156903	Paint Expiry Date:	23.01.2025
Hardener Batch No.:	7502115121	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:	NEUTUKO	Sign:	[Signature]
Date:	2024/03/06		
Painting NCSS3010 R90B Control			
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS	
1: 122	5: 112	1: 137	5: 116
2: 135	6: 128	2: 129	6: 114
3: 119	7: 135	3: 121	7: 108
4: 104	8: 142	4: 120	8: 100
Min: 106		Min: 97.4	
Max: 151		Max: 141	
Average: 127.6		Average: 118.6	
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	358
QC Inspector:	[Signature]	Sign:	[Signature]
Date:	08 Mar 2024		

# Record of Priming


Start Time:	4:40	End Time:	6:05
Temperature $\geq 15^{\circ}$ :	25 $^{\circ}$	Humidity $\leq 75\%$ :	49%
Paint Batch No.:	7878267	Paint Expiry Date:	06/25
Hardener Batch No.:	2331119	Hardener Expiry Date:	01/11/24
Desolvation Start Time:	6:05	Desolvation End Time:	6:20
Stoving Start Time:	6:20	Stoving End Time:	6:20
Stoving Temp:	60 $^{\circ}$		
Operator:	2333	Sign:	
Date:	2024/03/06		

# Priming Control

DFT Interior RHS *		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 65.3	5: 59.5	1: 62.0	5: 42.7	1: 61.6	5: 68.5	1: 43.3	5: 69.5
2: 71.1	6: 64.2	2: 73.8	6: 52.8	2: 46.2	6: 59.2	2: 68	6: 56.8
3: 42.7	7: 61.4	3: 63.7	7: 6.7	3: 103	7: 89	3: 47.6	7: 58.6
4: 53.0	8: 63.8	4: 94.2	8: 82.9	4: 107	8: 62.4	4: 43.8	8: 77.9
Min:	15.3	Min:	42.7	Min:	46.2	Min:	43.3
Max:	76.1	Max:	94.2	Max:	107	Max:	77.9
Average:	58.9	Average:	66.7	Average:	60	Average:	59.2
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 103	5: 101	1: 69.5	5: 69.9	1: 55.5	5: 124	1: 52.1	5: 73.8
2: 75.9	6: 66.5	2: 61.6	6: 84.4	2: 67	6: 94.1	2: 74.7	6: 58.6
3: 79.9	7: 81.9	3: 58.2	7: 46.6	3: 32.5	7: 85.4	3: 69.9	7: 51.0
4: 62.6	8: 61.1	4: 110	8: 106	4: 51.4	8: 53.4	4: 63.0	8: 59
Min:	61.1	Min:	46.6	Min:	32.5	Min:	51.0
Max:	103	Max:	110	Max:	124	Max:	74.7
Average:	82.3	Average:	75.8	Average:	70.4	Average:	62.8
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 74.3	5: 70.4	1: 112	5: 61.1	1: 81.9	5: 72.5	1: 41.6	5: 63.4
2: 72.7	6: 69.5	2: 69.5	6: 85.4	2: 75.8	6: 69	2: 72.3	6: 67.7
3: 64.8	7: 72.2	3: 90	7: 69.5	3: 65.3	7: 73.4	3: 55.2	7: 82.5
4: 78.5	8: 81.1	4: 46.2	8: 47.6	4: 72.1	8: 44.2	4: 61.6	8: 58.5
Min:	31.1	Min:	46.2	Min:	44.2	Min:	41.6
Max:	78.5	Max:	112	Max:	81.9	Max:	82.5
Average:	66.7	Average:	72.7	Average:	69.3	Average:	62.9
Primer has been inspected and is free of defects				Confirmed	Yes	No	
QC Inspector:	Zetile	Sign:					
Date:	08 Mar 2024						

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: 2024/03/06					
Record of Shot Blasting					
Operator:		Date:		2024/03/06	
Start Time: 08 H 15		End Time:		15 H 00	
Temperature ( $\geq 15^\circ$ ): 21-03 $^\circ\text{C}$		Humidity ( $\leq 75\%$ ):		68-07%	
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: 2024/03/06					
Shot Blasting Cleaning					
Cabin free of all sand		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator: DAVID		Sign: TD			
Date: 2024/03/06					
Shot Blasting Control					
Temperature $\geq 15^\circ$ : 19-03 $^\circ\text{C}$		Humidity $\leq 75\%$ :		69-04%	
Internal Roughness $3.2 \leq \text{Ra} \leq 12.5$ : 10.684		External Roughness $3.2 \leq \text{Ra} \leq 12.5$ :		07.695	
QC Inspector: LEON		Sign: A			
Date: 06/03/24					

### Cabin Bracket Assembly: GN002833


Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHUCK BLOOM	Assembly Date:	20 24/02/18			
Sign:		Wire Batch No.:	220252			

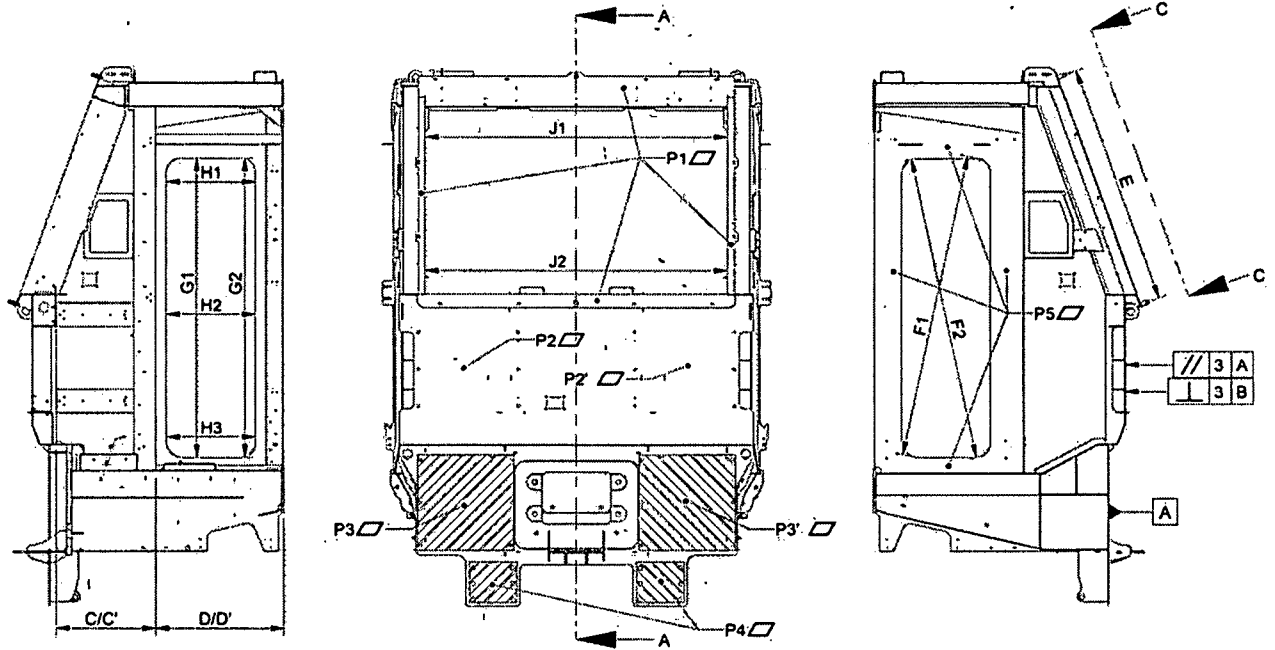
### Cabin Rivnut Assembly: GN002832

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

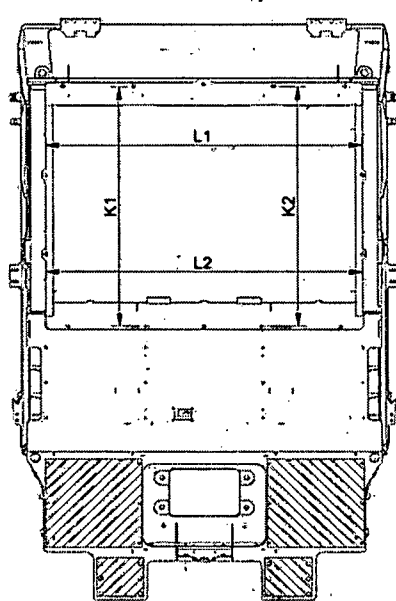
Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed		Yes	<input checked="" type="checkbox"/>	No
QC Inspector: <u>Leon</u>			Sign: <u>A</u>		Date: <u>2024/02/13</u>				
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	<u>625</u>	<u>625</u>	Accepted				
D / D'	813	± 2,5	<u>812</u>	<u>812</u>	Accepted				
E	1531.5	± 3	<u>1530</u>		Accepted				
G1 / G'1	Height 1900	+1	<u>1897</u>	<u>1897</u>	Accepted				
G2 / G'2		-3	<u>1898</u>	<u>1898</u>	Accepted				
H1 / H'1	Width 560	+1	<u>559</u>	<u>560</u>	Accepted				
H2 / H'2		-3	<u>559</u>	<u>560</u>	Accepted				
H3 / H'3			<u>559</u>	<u>560</u>	Accepted				
F1 / F'1	Diagonals 1939		<u>1936</u>	<u>1936</u>	Accepted				
F2 / F'2			<u>1935</u>	<u>1934</u>	Accepted				
Difference	F1-F2 / F'1-F'2	≤ 4	<u>1</u>	<u>2</u>	Accepted				
J	Gap of Doors	± 1,5	<u>1</u>		Accepted				
K1 / K2	1515	± 3	<u>1513</u>	<u>1514</u>	Accepted				
L1 / L2	1996	± 3	<u>1997</u>	<u>1997</u>	Accepted				
M1 / M'1	2306	± 3	<u>2467</u>	<u>2467</u>	Accepted				
M2 / M'2			<u>2478</u>	<u>2477</u>	Accepted				
T1 / T'1	2130 Top/Bottom	± 3	<u>2127</u>	<u>2127</u>	Accepted				
T2 / T'2	2230 Top/Bottom		<u>2231</u>	<u>2231</u>	Accepted				
Difference	U - U' (3522)	≤ 4mm	<u>3521</u>	<u>3521</u>	Accepted				
QC Inspector: <u>Leon</u>		Sign: <u>A</u>		Date: <u>2024/02/13</u>					
Geometrical Control									
Nature of checks				Toler.	LHS / Dimension Measured / RHS				
P1 / P'1	Planeity			2 mm	<u>Passed</u>		Accepted		
P2 / P'2	Planeity			2 mm	<u>Passed</u>		Accepted		
P3 / P'3	Planeity			4 mm	<u>Passed</u>		Accepted		
P4 / P'4	Planeity			4 mm	<u>Passed</u>		Accepted		
P5 / P'5	Planeity			4 mm	<u>Passed</u>		Accepted		
P6 Roof	Planeity			6 With 2m Ruler	<u>Passed</u>		Accepted		
Shield	//	3	A	3	<u>Passed</u>		Accepted		
Shield	⊥	3	A	3	<u>Passed</u>		Accepted		
Door Post	⊥	3	A	Front	<u>Passed</u>		Accepted		
				Back	<u>Passed</u>		Accepted		
QC Inspector: <u>Leon</u>		Sign: <u>A</u>		Date: <u>20 24 02/13</u>					

# Cabin Structure Assembly: GN002834

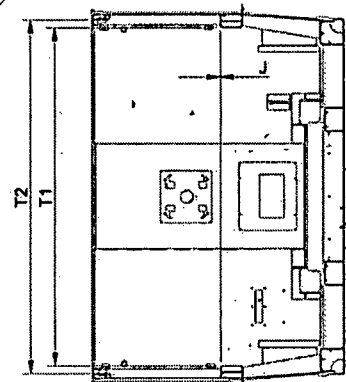
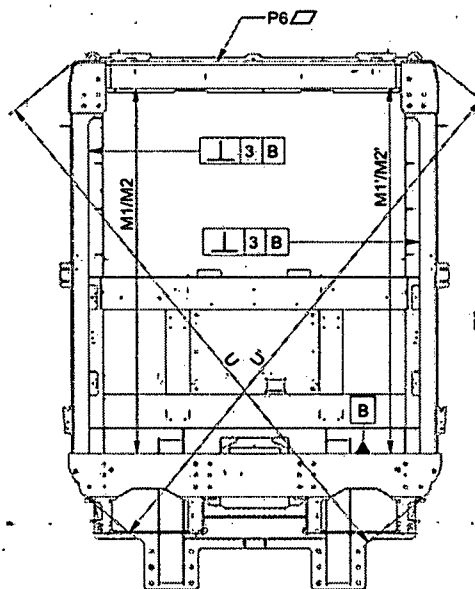
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:	CHALL BLOOM	Assembly Date:	20 24/02/09		
Sign:		Wire Batch No.:	220252		



SECTION A-A



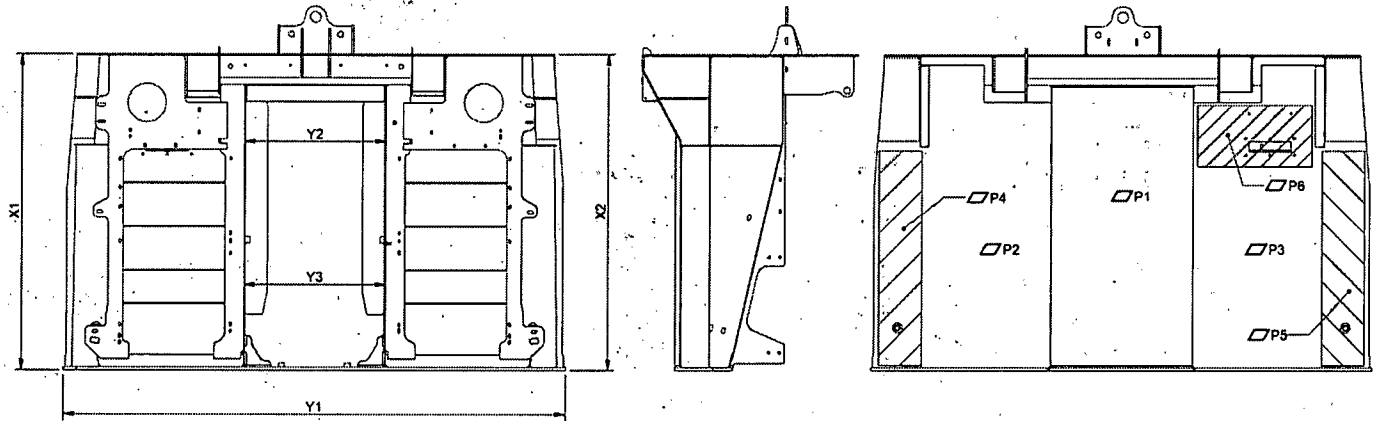
AUX VIEW: C



SECTION B-B

# Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>09</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>09</u>

## Dimensional Control

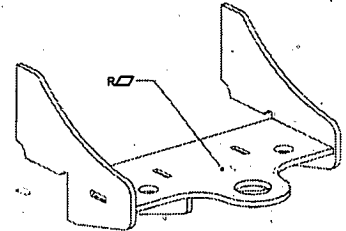
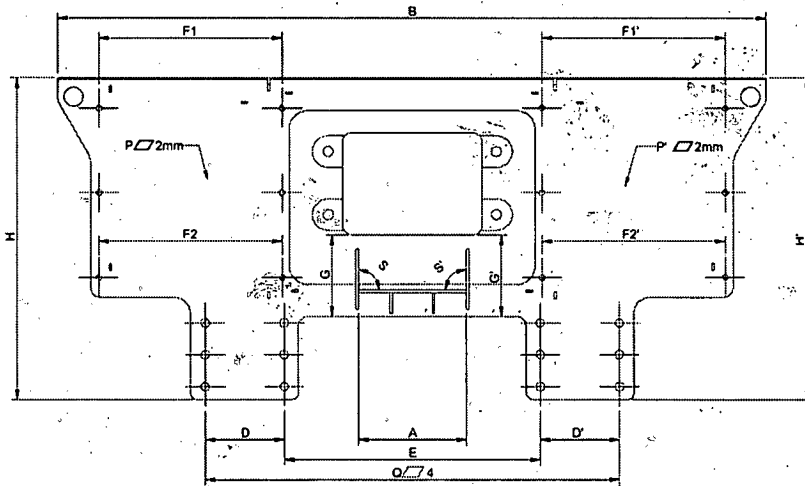
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	<i>1486</i>	<i>1485</i>	Tape Measure	<i>Accepted</i>
Y1	2354	± 3	<i>2352</i>			<i>Accepted</i>
Y2 / Y3	666	± 1	<i>664</i>	<i>668</i>		<i>Accepted</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>		Date:	20 <u>24</u> / <u>02</u> / <u>09</u>

## Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	<i>PASSED</i>	Ruler	<i>Accepted</i>
P2 / P3 : Planeity	4 mm	<i>PASSED</i>	Ruler	<i>Accepted</i>
P4 / P5 : Planeity	2 mm	<i>PASSED</i>	Ruler	<i>Accepted</i>
P6 : Planeity	2 mm	<i>PASSED</i>	Ruler	<i>Accepted</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date: 20 <u>24</u> / <u>02</u> / <u>09</u>

# Cabin Front Headstock Assembly: GN002841

Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	TJK 30004	Assembly Date:	2024/02/06		
Sign:		Wire Batch No.:	2207165		



## 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:	2024/02/06

## Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	± 1	340		Tape Measure	Acceptable
B	2240	± 4	2243,5			Acceptable
D / D'	250	± 1	250,5	250,5		Acceptable
E	808	± 2	807			Acceptable
F1 / F1'	580	± 1	581	581		Acceptable
F2 / F2'			581	581		Acceptable
G / G'	258	± 1	259	258		Acceptable
H / H'	1019	± 2	1020	1020		Acceptable
QC Inspector:	LEON	Sign:		Date:	2024/02/06	

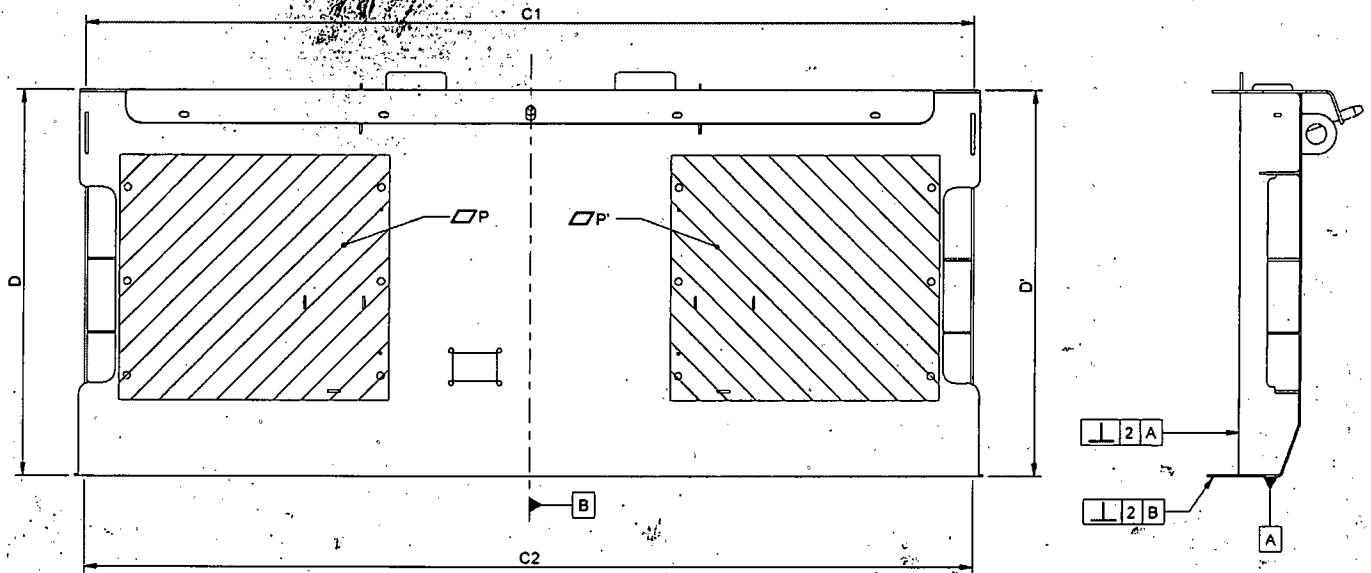
## Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
O: Planeity of global assembly	4 mm	Passed	Ruler	Acceptable
P / P': Planeity	2 mm	Passed	Ruler	Acceptable
Q: Planeity Surface of Supports	4 mm	Passed	Ruler	Acceptable
R: Planeity Coupler Support	2 mm	Passed	Ruler	Acceptable
S: Perpendicularity coupler	1mm	Passed	Square	Acceptable
QC Inspector:	LEON	Sign:		Date: 2024/02/06



# Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	BEVAN	DAVENHILL	Assembly Date:	2024/02/06	
Sign:			Wire Batch No.:	2202152	



## Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	LEON	Sign:		Date:	2024/02/09

## Dimensional Control

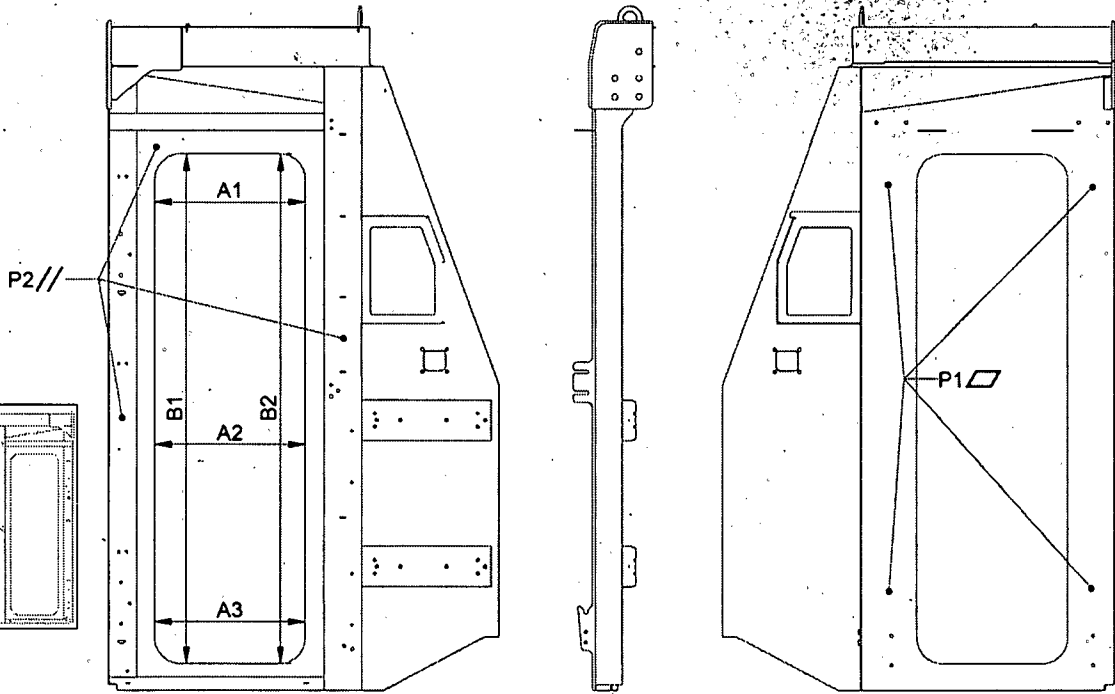
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2214	2212	Tape Measure	Acceptable
D / D'	956	± 2	955	955		Acceptable
QC Inspector:	LEON	Sign:		Date:	2024/02/09	

## Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planarity, P / P'			2 mm	Passes	Ruler	Acceptable
Perpendicularity	2	A	Passes	Passes	Set Square	Acceptable
	2	B	Passes	Passes	Set Square	Acceptable
QC Inspector:	LEON	Sign:		Date:	2024/02/09	

# 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>Xander</i>	Assembly Date:	2024/02/02		
Sign:	<i>[Signature]</i>	Wire Batch No.	2202165		



## 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:	2024/02/10

## Dimensional Control

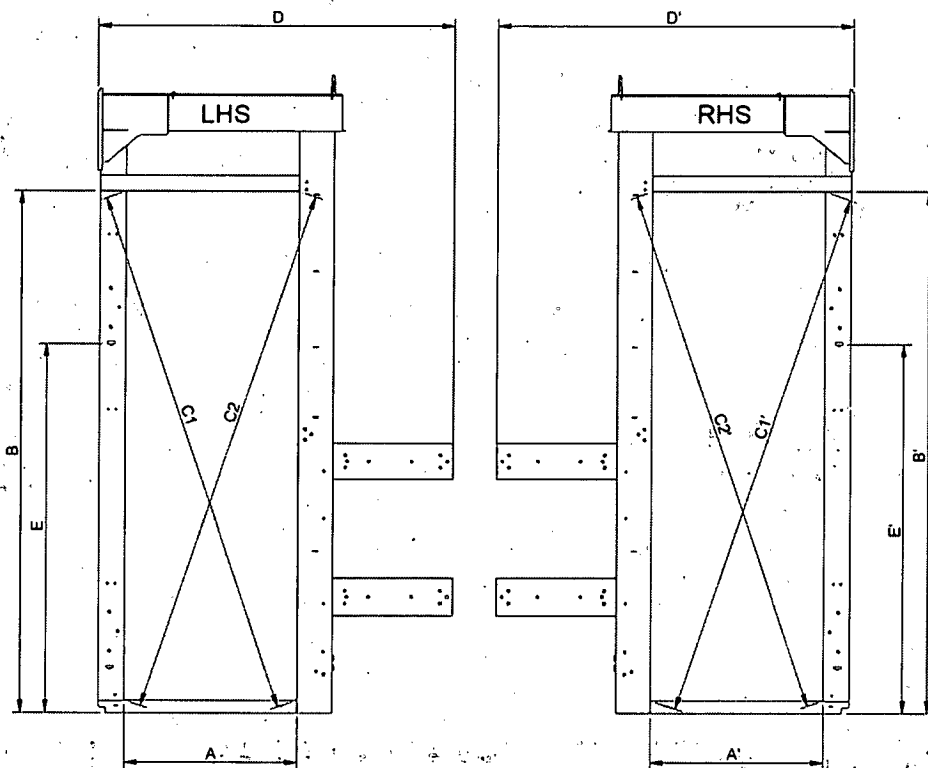
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	558	558	Tape Measure	<i>Acceptable</i>
A2			559	559		<i>Acceptable</i>
A3			559	559		<i>Acceptable</i>
B1	1900	± 2	1898	1898		<i>Acceptable</i>
B2			1898	1898		<i>Acceptable</i>
QC Inspector:		<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/10

## Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	<i>Pass</i>	Ruler	<i>Acceptable</i>
P2 : Planeity	2 mm	<i>Pass</i>	Ruler	<i>Acceptable</i>
QC Inspector:		<i>Leon</i>	Sign:	<i>[Signature]</i>
			Date:	2024/02/10

# Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	No
Operator:	Glenn	Assembly Date:	20 24/01/30	
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	No
QC Inspector:	Law	Sign:	<i>Law</i>	Date: 20 24/02/06

## Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	695	696	Tape Measure	Acceptable
B	2086	+1/-3	2086	2086		Acceptable
C1 / C2	Difference of diagonals $ C1 - C2  \leq 3$		2152	2152		Acceptable
C1 - C2			2151	2152		Acceptable
D	1438	+2/-3	1439	1439		Acceptable
E			1484	1483		Acceptable
QC Inspector:		Law	Sign:		<i>Law</i>	Date: 20 24/02/06

## Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations	
P1 : planeity of 2 edges	4 mm	Pass	Ruler	Acceptable	
QC Inspector:	Law	Sign:	B	Date:	20 24/02/06

**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:	2024/01/31			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202165			

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

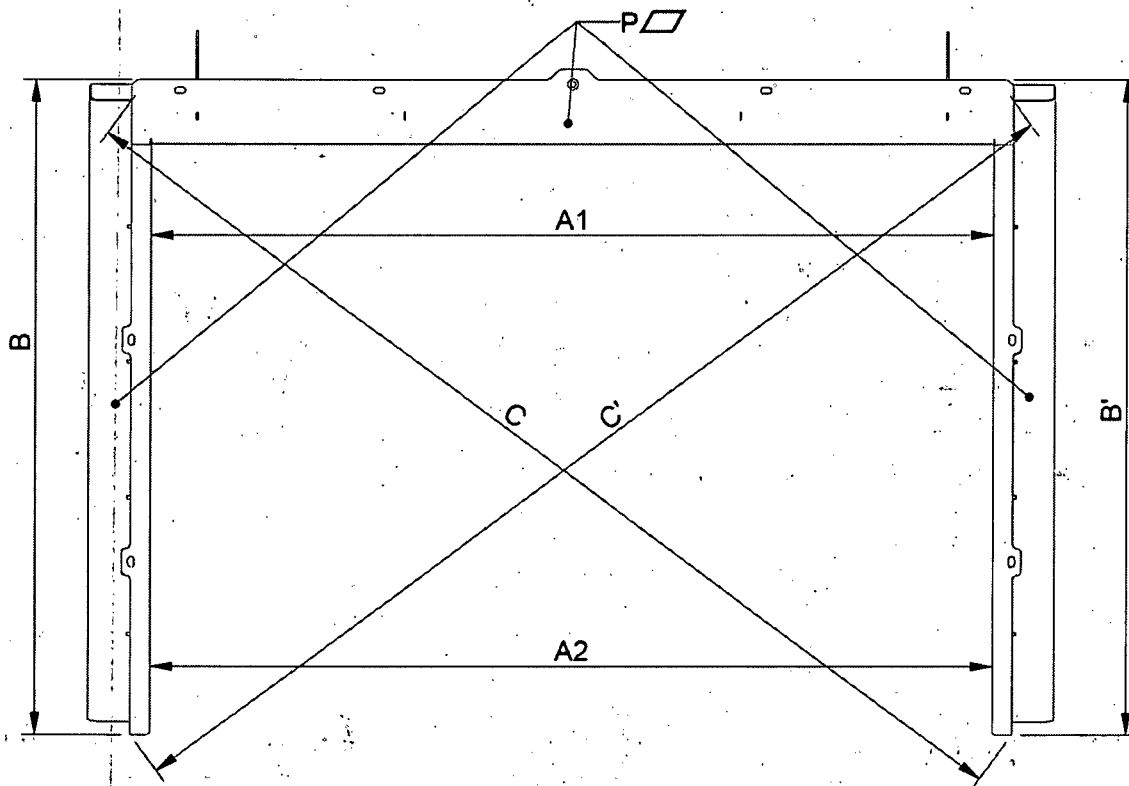
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>Glenn</i>	Assembly Date:	2024/01/29			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

**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:	2024/01/29			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

# Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Ramelo Galian</i>	Assembly Date:	2024/02/02			
Sign:	<i>RG</i>	Wire Batch No.:	220210S2			



## 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:	<i>Rudley</i>	Sign:	<i>RG</i>	Date:	2024/02/02	

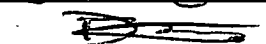
## Dimensional Control

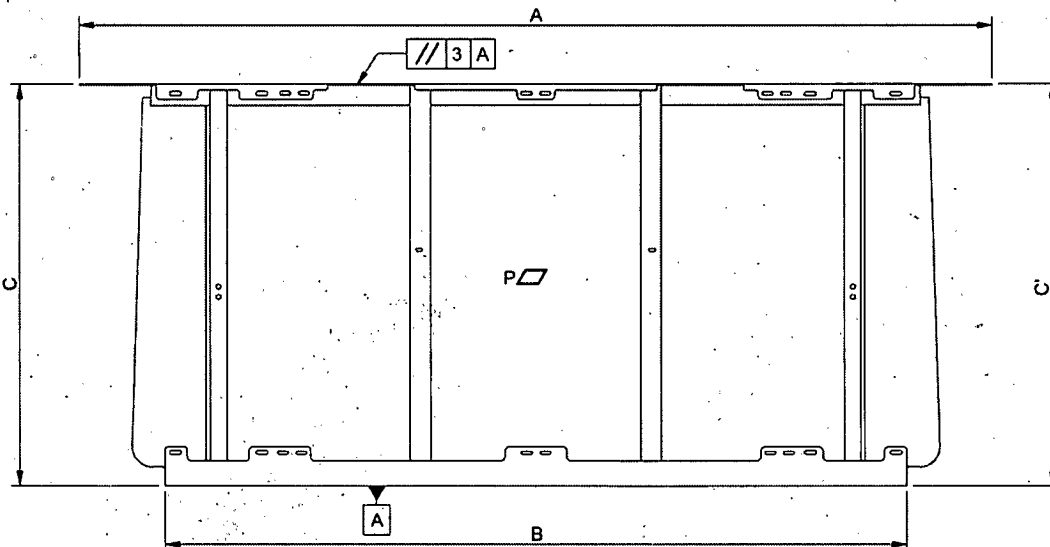
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	1910	± 2	1912		Tape Measure		
A2	1910		1911				
B	1475	± 1	1475	1475		Acceptable	
C	Diagonals  C - C'  ≤ 3		2479	2478		Acceptable	
QC Inspector:				Sign:		Date:	20__/__/__

## Geometrical Control


Nature of checks		Dimension Measured	Measuring Equipment	Observations
P : Planeity	4 mm	<i>Passed</i>	Ruler	<i>Acceptable</i>
QC Inspector:	<i>Rudley</i>	Sign:	<i>RG</i>	Date: 2024/02/02

# Cabin Roof Assembly: GN002839

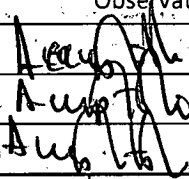

Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	DYLAN DAVIDS	Assembly Date:	20 24 / 02 / 10			
Sign:		Wire Batch No.:	107238201			



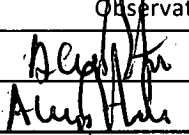

## Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Leon	Sign:		Date:	20 24 / 02 / 10	

## Dimensional Control

Rep	Toler.	Dimension measured	Measuring Equipment	Observations		
A	+5/-0	2216	Tape Measure	 Accepted 20 24 / 02 / 10		
B	± 4	1800				
C	+2/-3	976      975				
QC Inspector:	Leon	Sign:		Date:	20 24 / 02 / 10	

## Geometrical Control

Nature of Checks	Dimension Measured	Measuring Equipment	Observations			
Planeity P	6 mm	Ruler	 Accepted 20 24 / 02 / 10			
//      3	A	Set Square				
QC Inspector:	Leon	Sign:		Date:	20 24 / 02 / 10	

## RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm					
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm					
RCS 355	3 mm					
RCS 355	3 mm					

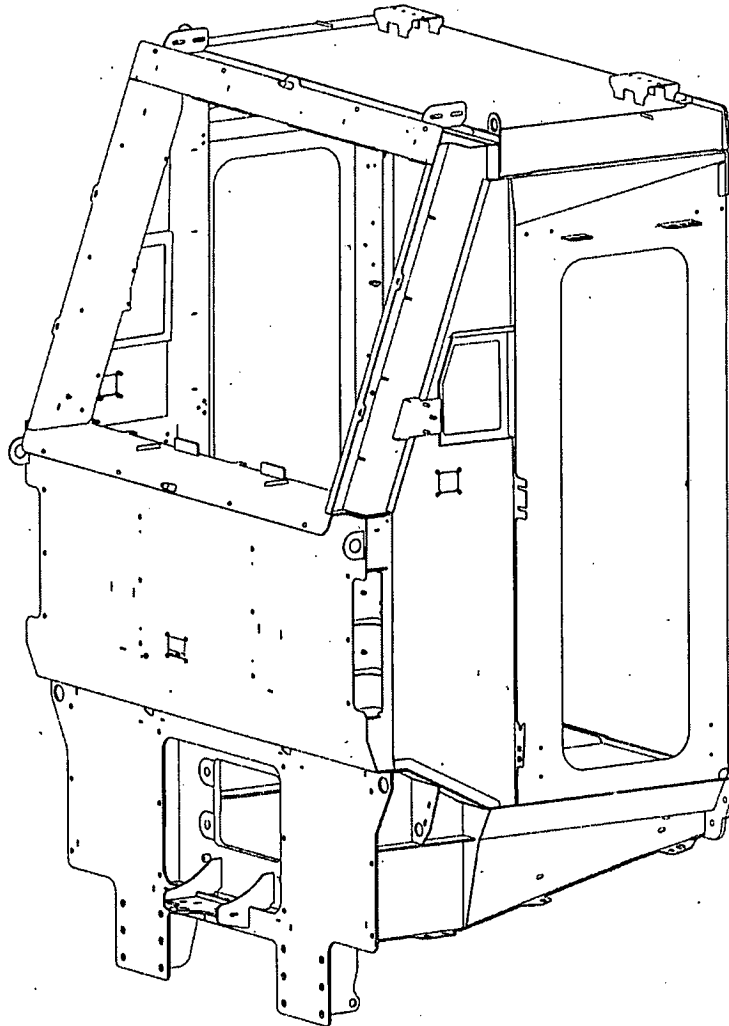
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm					
RCS 355	20 mm					

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

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm					
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					
RCS 450	6 mm					
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					



## CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 4 3 9 \_

WEIGHT: 1 4 8 8 Kg