

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	MA	M1	M2	M3	TC2			
<input type="checkbox"/>	DTR30225487/3	CRABOOT/SHELL M1 ASSEMBLY	CB1210				<input checked="" type="checkbox"/>			PRA.CB1210.DTR30225 487/3.V25	YES	
<input type="checkbox"/>												
REV	DATE	MODIFICATION CONTENT								RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION								APPROVER	Iturneleng Modiba	10/01/2018
										CHECKER	Nosizo Pindela	10/01/2018
										COMPLIER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from P.M. Manager to Quality Manager								APPROVER	Iturneleng Modiba	2018/05/18
										CHECKER	Nosizo Pindela	2018/05/18
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230								REVISD BY	Ramokone Motama	2018/05/18
										APPROVER	Iturneleng Modiba	2018/07/04
										CHECKER	Nosizo Pindela	2018/07/04
										REVISD BY	Ramokone Motama	2018/07/04
3	2018/12/12	Added dimensional check points to CB1210								APPROVER	Iturneleng Modiba	2018/12/12
										CHECKER	Nosizo Pindela	2018/12/12
										REVISD BY	Ramokone Motama	2018/12/12
5	22/01/2019	As per Baseline 10.2								APPROVER	Iturneleng Modiba	22/01/2019
										CHECKER	Nosizo Pindela	22/01/2019
										REVISD BY	Vanessa Ntuli	21/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection								APPROVER	Iturneleng Modiba	13/03/2019
										CHECKER	Nosizo Pindela	13/03/2019
										REVISD BY	Nosizo Pindela	13/03/2019
10	21/08/2019	New Baseline 10.2.5								APPROVER	Iturneleng Modiba	21/08/2019
										CHECKER	Nosizo Pindela	21/08/2019
										REVISD BY	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6								APPROVER	Timothy Maimela	06/08/2020
										CHECKER	Bongane Masina	06/08/2020
										REVISD BY	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3								APPROVER	Timothy Maimela	19/04/2021
										CHECKER	Bongane Masina	19/04/2021
										REVISD BY	Bongane Masina	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING								APPROVER	Mpho Mulaudzi	17/08/2021
										CHECKER	Mpho Mulaudzi	17/08/2021
										REVISD BY	Mpho Mulaudzi	17/08/2021
25	19/02/2022	New Baseline change 10.3.1								APPROVER	Mpho Mulaudzi	19/02/2022
										CHECKER	Andani Muthelo	19/02/2022
										REVISD BY	Andani Muthelo	19/02/2022
26	14/04/2023	Addition of welding consumable traceability								APPROVER	Ntuli Vanessa	14/04/2023
										CHECKER	Mohlamepe Amogelang	14/04/2023
										REVISD BY	Mohlamepe Amogelang	14/04/2023
27	27/07/2023	Added verification of loaded parts								APPROVER	Ngobeni Tyson	27/07/2023
										CHECKER	Zwane Ntokoza	27/07/2023
										REVISD BY	Zwane Ntokoza	27/07/2023
28	07/11/2023	Addition of welding traceability								APPROVER	Ngobeni Tyson	07/11/2023
										CHECKER	Andani Muthelo	07/11/2023
										REVISD BY	Ntokoza Zwane	07/11/2023
TRAINSET	CAR	OPERATOR NAME& ALPS NO		DATE		SELF INSPECTION NUMBER				PAGES		
219	N1	WINGA 471497		18/03/24		SI.CB1210.254.V28				17		

GIBELA  
2024 -03- 19  
INDUSTRIAL QUALITY  
MAINLINE



CARBODYSHELL M1 ASSEMBLY DTR30225487/3

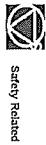
Rev. 28  
Date 07/11/2023  
Project: PRASA  
SI.CB1210.254.V28

Car: M1

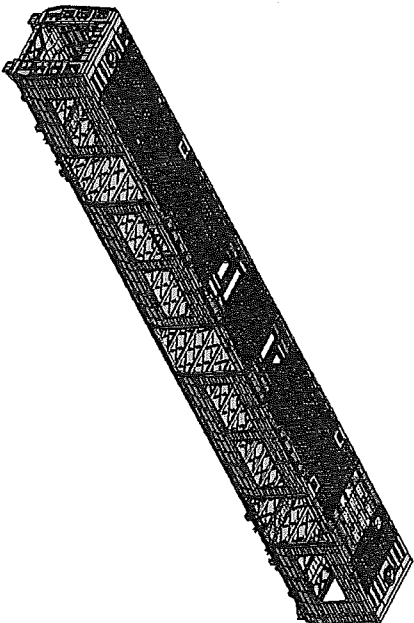
NCR:

Work station:

CB1210





Safety Related






### I - Documentation and Instruments Control





#### I.1 - Documentation Control

Document	Type of car					Revision	Operation	OK	NOK	Rework?	Signature/Date (Manufacturing)	Signature/Date (Quality)
	TC1	M1	M2	M3	M4	TC2						
DTR30225487/3		X						✓			 18/03/24	 18/03/24

#### I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process									
Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Manufacturing)		Signature/Date (Quality)		
TURVARE	32823-7	15/03/24	✓		M	18/03/24		18	
30 M TAPE	6187P 0084	14/03/24	✓		M	18/03/24		18	
LASER TAPE	123423924	08/01/24	✓		M	18/03/24		18	


#### 1.3 Consumables

Welding Consumable Control - Used for Special Process												
Filler Material	Heat Number		Welding Process		OK	NOK	Signature/Date (Manufacturing)		Signature/Date (Quality)			
AUTON 308LSI	E22880		M19		✓		 18/03/24		 18/03/24			
ER 308LSI	318394		M19		✓		 18/03/24		 18/03/24			

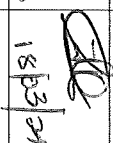
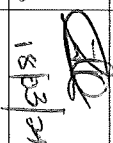









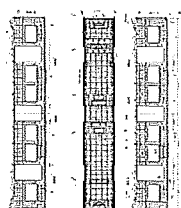
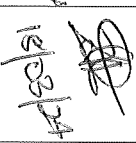
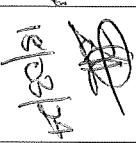
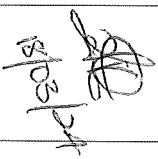
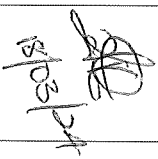



2024 -03- 19

INDUSTRIAL QUALITY  
MAINLINE

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

**II - Self Inspection - Items to check**

II.1 - Items to check									
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	N/A	Remarks	Signature/Date (Manufacturing)	Signature/Date (Quality)	
01	N/A	Verification of correct parts loaded (Sidewalls, Endframes, Roof and Underframe)	DTD00000311225	✓			18/03/24 	18/03/24 	
02	N/A	Corshell free of significant flaws which compromise the appearance or functionality	DTD00000210675	✓			18/03/24 	18/03/24 	
03	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD00000210675	✓			18/03/24 	18/03/24 	
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓			18/03/24 	18/03/24 	
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓			18/03/24 	18/03/24 	
06		Functional's dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓			18/03/24 	18/03/24 	
07	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD00000210658.	As the welding procedure IND-SAL-WMS-018 and DTD00000210658.	✓			18/03/24 	18/03/24 	

  
 2024 -03- 19  
**INDUSTRIAL QUALITY**  
**MAINLINE**

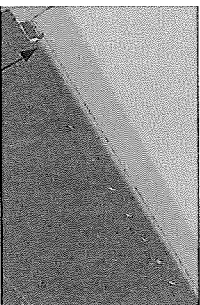


CARBODYSHELL M1 ASSEMBLY DTR30225487/3

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

Welder Traceability

Roof ring welds



LHS

Boiler maker (Name & Sign): Tim Leder

Welder (Name & Sign): Robert Budd

RHS

Boiler maker (Name & Sign): Wanda Wile

Welder (Name & Sign): Robert Budd

END 1

LHS

Boiler maker (Name & Sign): Tim Leder

Welder (Name & Sign): Robert Budd

RHS

Boiler maker (Name & Sign): Wanda Wile

Welder (Name & Sign): Robert Budd

END 2

Door ring welds



LHS

Boiler maker (Name & Sign): Wanda Wile

Welder (Name & Sign): Witbokozisi Gwa

RHS

Boiler maker (Name & Sign): Wanda Wile

Welder (Name & Sign): Witbokozisi Gwa

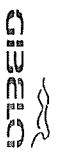


2024-03-19

INDUSTRIAL QUALITY  
MAINLINE



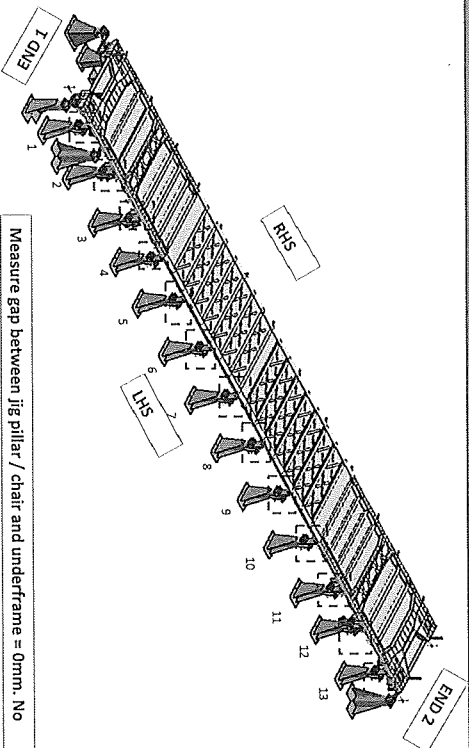




CARBODYSHELL M1 ASSEMBLY DTR30225467/3

Rev. 28  
Date 07/11/2023  
Project: PR5A  
SI.CB1210.254.V28

Specifications of Details for GBs measurement



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

After loading and clamping

Fill in the gap foundon 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	0	0	0	0	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0

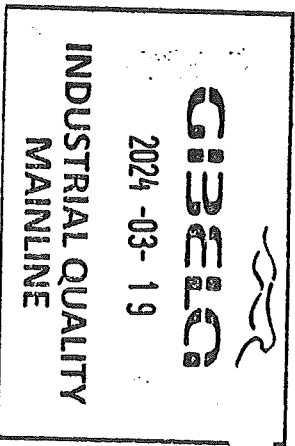
Signature Operations:  Date: 18/05/24

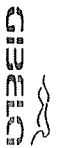
After Welding:

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	0	0	0	0	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0

Signature Industrial Quality:  Date: 18/03/24



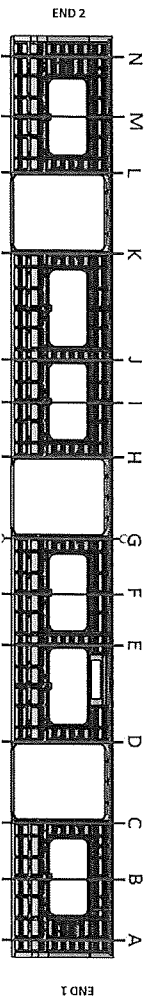


CARBODYSHELL M1 ASSEMBLY DTR3022548/3

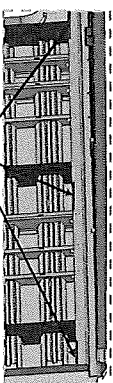
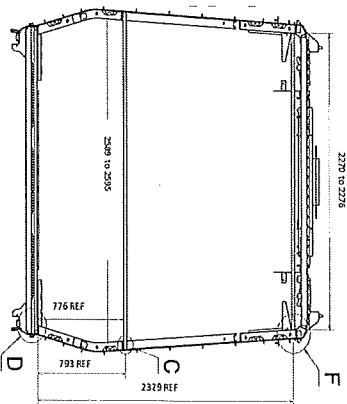
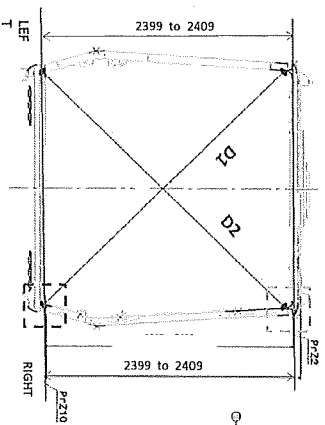
Rev. 28  
Date 07/11/2023

Project: PRASA  
SI.CB1210.254.V28

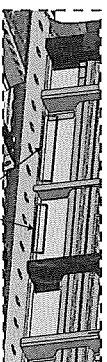
Specifications of Details for CBS measurement



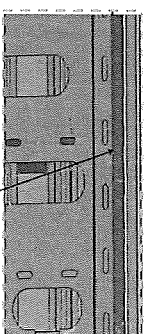
9



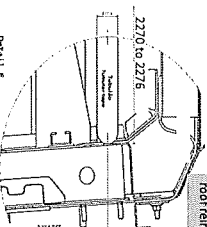
Measurement positions on roof rail and sidewall omega corner.



Measurement positions on sidewall and side sill corner.



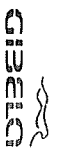
Reinforcement area measurement positions on roof reinforcement area.



Detail F

Detail F

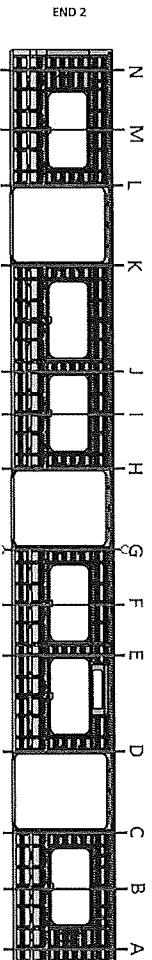
**GIBECO**  
2024-03-19  
INDUSTRIAL QUALITY  
MAINLINE



CARBODYSHELL M1 ASSEMBLY DTR30225487/3

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


Specifications of Details for GBS measurement



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

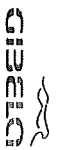
BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3269	3269	0	2408	2407	1
B	3266	3269	3	2406	2406	0
C	3269	3268	1	2405	2407	2
D	3261	3261	0	2408	2409	2
E	3266	3266	0	2407	2405	2
F	3266	3265	1	2406	2405	1
G	3261	3268	7	2404	2405	1
H	3268	3269	1	2406	2406	0
I	3264	3266	2	2404	2405	1
J	3266	3266	0	2406	2406	0
K	3261	3268	1	2407	2405	2
L	3268	3268	0	2405	2407	2
M	3269	3265	4	2406	2405	1
N	3268	3269	1	2409	2408	1



**GIBELCO**  
2024-03-19  
INDUSTRIAL QUALITY  
MAINLINE

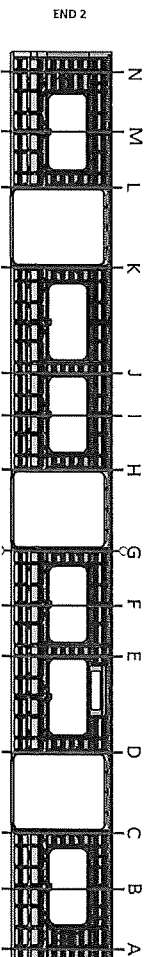
18/05/24



CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev. 28  
Date 07/11/2023  
Project: PRA5A  
SI.CB1210.254.V28

## Specifications of Details for GBS measurement

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

## AFTER WELDING

Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A 3295	3296	1	2408	2408	0
B 3264	3266	2	2406	2405	1
C 3295	3296	1	2407	2405	2
D 3297	3295	2	2406	2405	1
E 3266	3266	0	2404	2404	0
F 3265	3264	1	2406	2407	1
G 3295	3295	0	2405	2404	1
H 3294	3296	2	2406	2406	0
I 3265	3266	1	2405	2407	2
J 3266	3265	1	2407	2406	1
K 3295	3296	1	2404	2405	1
L 3296	3296	0	2405	2406	1
M 3265	3268	3	2407	2406	1
N 3294	3296	2	2409	2408	1

GIBBEL

2024-03-19

INDUSTRIAL QUALITY  
MAINLINE

18/03/24



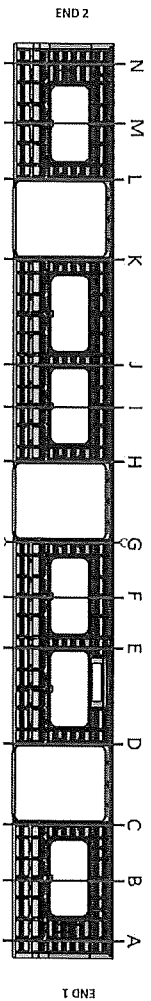


CARBOYSHELL M1 ASSEMBLY DTR30225487/3

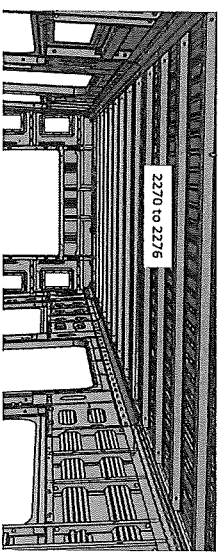
Rev.	28	Project: PRASA SI.CB1210.254.V28
Date	07/11/2023	

GBS measurement

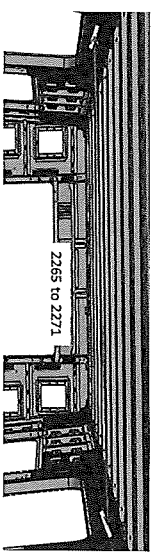
AFTER WELDING



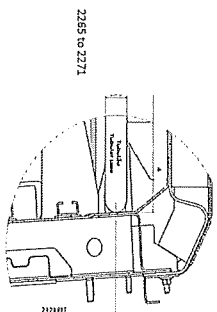
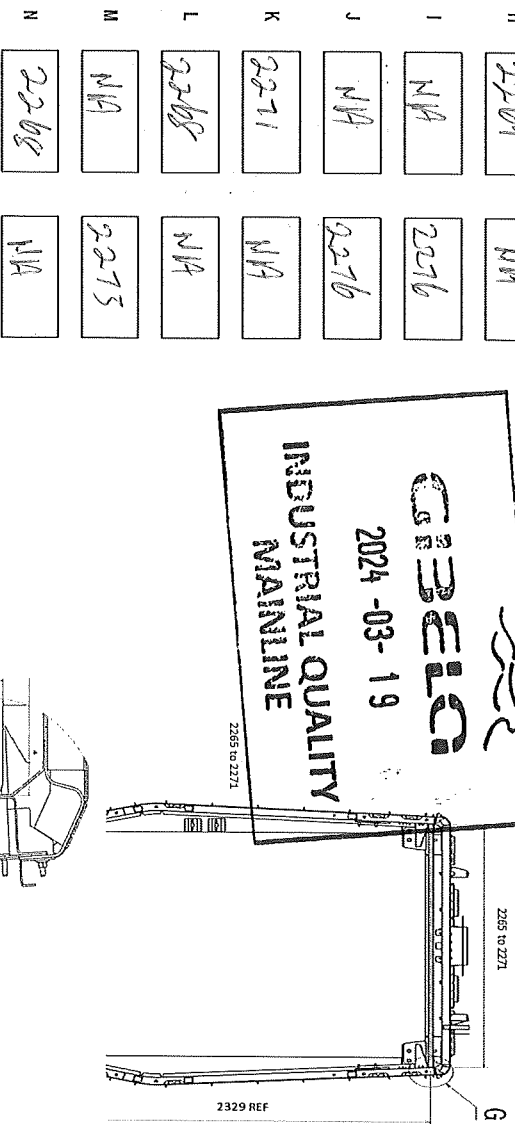
	2265 to 2271	2270 to 2276
A	2270	N/A
B	N/A	2274
C	2268	N/A
D	2266	N/A
E	N/A	2276
F	N/A	2275
G	2265	N/A
H	2269	N/A
I	N/A	2276
J	N/A	2276
K	2271	N/A
L	2268	N/A
M	N/A	2275
N	2268	N/A



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



Take measurement close to radius (considering reinforcement)



DETAIL C  
Considering the  
radius of the zee profile



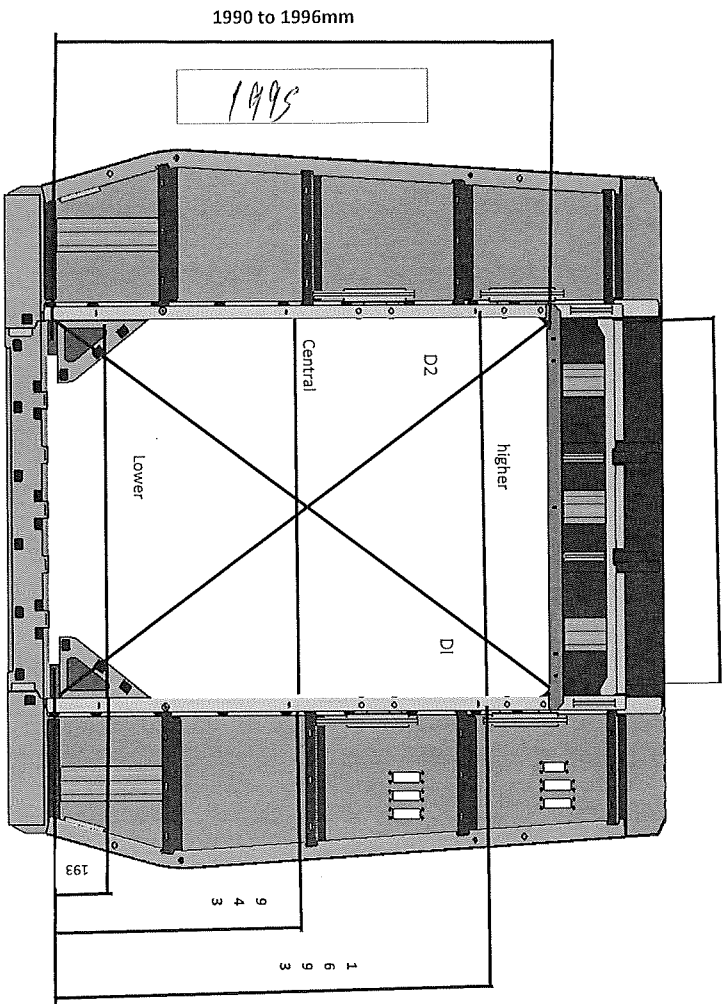
CARBODYSHELL M1 ASSEMBLY DTR30225467/3

Rev.  
28  
Date  
07/11/2023

Project: PRASA  
SI.CB1210.254.V28

Specifications of Details for GBS measurement

End frame 1



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2  $\leq$  3mm

Higher Dimension

1382

D1

2415

Central Dimension

1382

D2

2414

Lower Dimension

1381

D1-D2

1



2024-03-19

INDUSTRIAL QUALITY  
MAINLINE

18/03/24





CARBODYSHELL M1 ASSEMBLY DTR0225487/3

Rev.  
28

Date

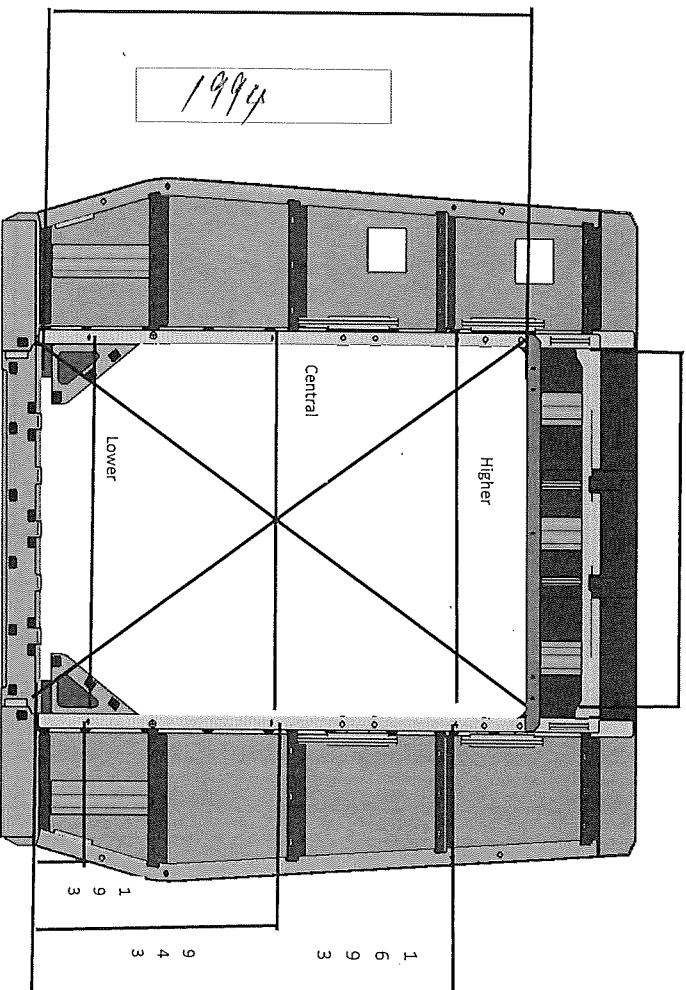
07/11/2023

Project: PRASA  
SI.CB1210.254.V28

Specifications of Details for GBS measurement

Endframe 2

1380 to 1382 mm



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1381

D1

2413

Central Dimension

1381

D2

2413

Lower Dimension

1381

D1-D2

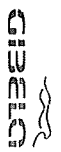
0



2024 -03- 19

INDUSTRIAL QUALITY  
MAINLINE

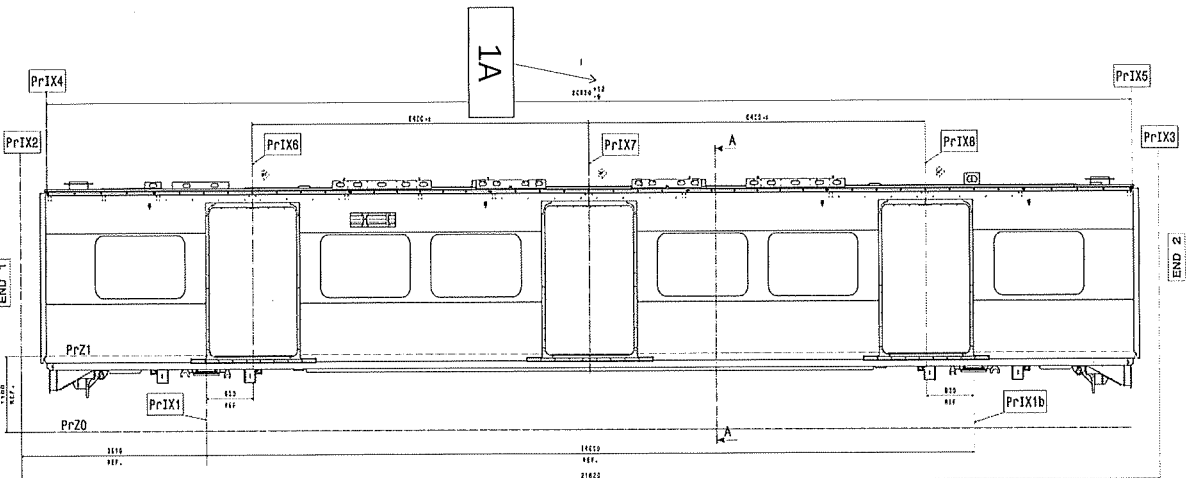
18/05/24



CARBOYSHELL M1 ASSEMBLY DTR30225487/3


Rev.	Project: PRA5A
28	SI.CB1210.254.V28
Date	
07/1/2023	

Specifications of Details for GBS measurement



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

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




**CIBEL**  
2024-03-19  
INDUSTRIAL QUALITY  
MAINLINE

Dye penetrant test


Dye-penetration test to be performed by quality personnel





	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRA5A SI.CB1210.254.V28
		Date 07/11/2023	

Self Inspection - Final Result

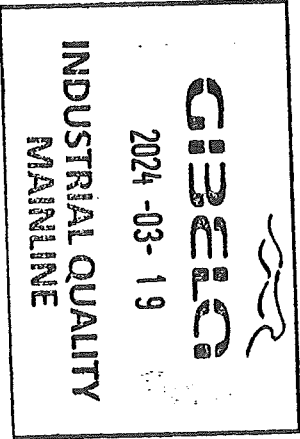
		DATE	NAME	SIGNATURE
HOLD POINT	GO	18/03/24	LMGA Operations	NO/10
		18/03/24	Amo Industrial Quality	
	NO GO			
			Operations	
			Industrial Quality	


In case of "NO GO", describe blocking problems

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

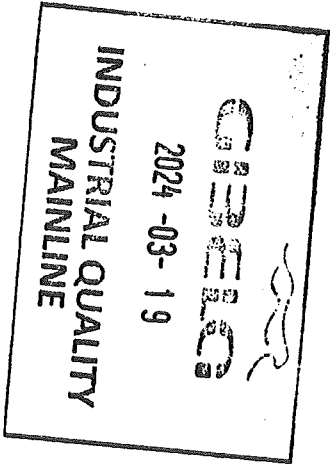
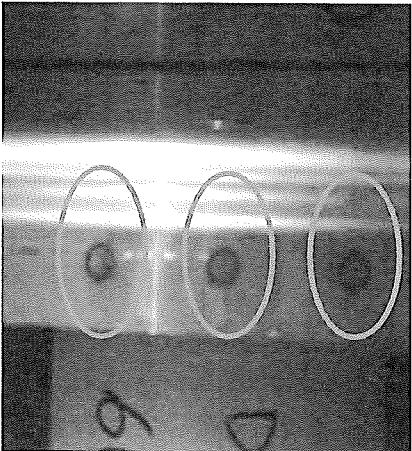
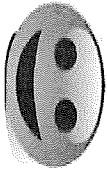
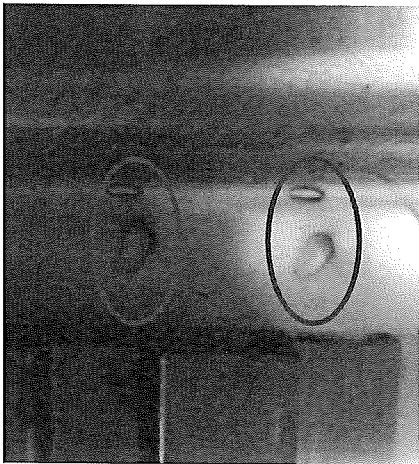
Operations

Quality



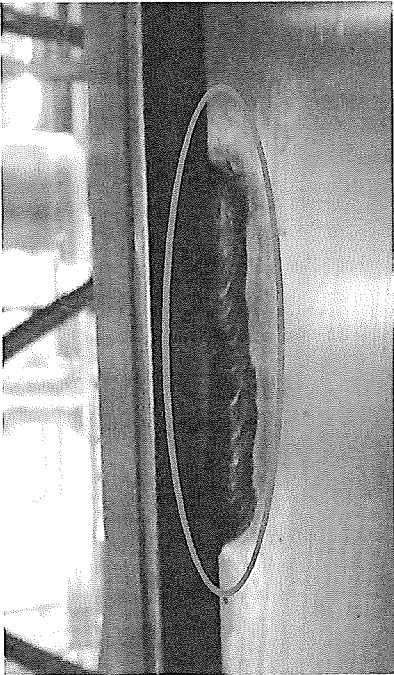
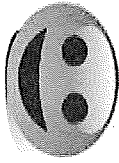
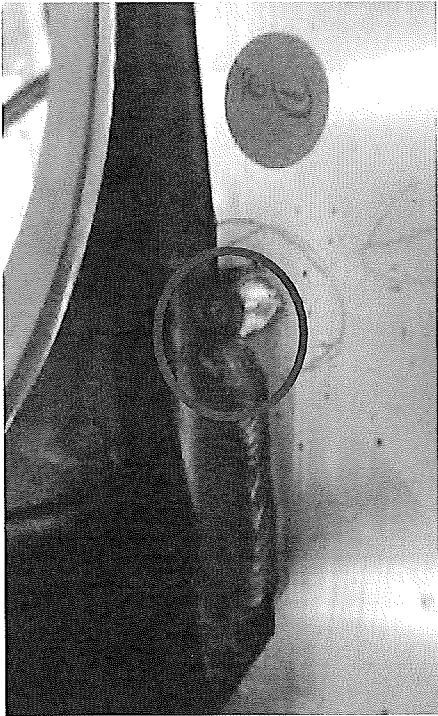
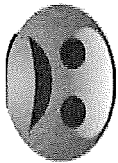
	CARBODYSHELL M1 ASSEMBLY DTR302254873	Rev. 28 Date	Project: PRASA SI.CB1210.254.V28
		07/11/2023	

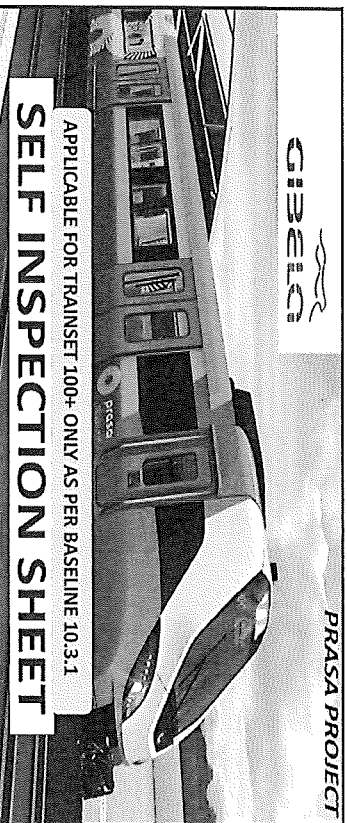
ANNEXURE A: Spot Welding Quality Acceptance Standard



	CARBODYSHELL M1 ASSEMBLY DTR302254873	Rev. 28 Date 07/11/2023	Project: PRA5A SI.CB1210.254.V28

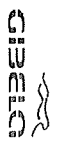
ANNEXURE B: Arc Welding Quality Acceptance Standard





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									
QUANTITY	DRAWING	DESCRIPTION	STATION	CARTYPE				WORK INSTRUCTION	SAFETY ?
				TCL	ML	MS	MO		
<input type="checkbox"/>	DT8022548/72	CARBODY+SHELL	GR120		X	X		PRA,CB1220,DT8022548	YES
<input type="checkbox"/>	MA0000178666	ML,MS,M,ASSEMBLY					X	712/V21	
<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	Imeneing Modiba			01/02/2018	
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PWE Manager to Quality manager		CHECKER	Imeneing Modiba			01/02/2018	
2	2018/07/05	Certain dimensional checks added and others moved to CB1210		CHECKER	Imeneing Modiba			2018/07/05	
3	2018/06/12	Width tolerance as per DT000038600		APPROVER	Imeneing Modiba			2018/06/12	
5	24/01/2019	As per Baseline 10.2		CHECKER	Nosizo Pholela			2018/06/12	
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements		REMOVED BY	Nosizo Pholela			2018/06/12	
10	22/08/2019	New Baseline 10.2.5		APPROVER	Imeneing Modiba			22/08/2019	
15	06/08/2020	New Baseline 10.2.6		CHECKER	Nosizo Pholela			22/08/2019	
20	19/04/2021	New Baseline change 10.3		REMOVED BY	Nosizo Pholela			22/08/2019	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING		APPROVER	Imeneing Modiba			13/03/2019	
25	20/02/2022	New Baseline change 10.3.1		CHECKER	Nosizo Pholela			13/03/2019	
26	14/06/2022	Update minimum temperature requirement for sealant application		REMOVED BY	Nosizo Pholela			13/03/2019	
27	17/10/2022	Addition of traceability for sealant application and welding		APPROVER	Imeneing Modiba			24/01/2019	
28	14/04/2023	Added sealant batch number & welding consumables traceability		CHECKER	Nosizo Pholela			24/01/2019	
29	28/10/2023	Addition of bracket quantity		REMOVED BY	Nosizo Pholela			24/01/2019	
TRANSET	CUR	OPERATOR NAME, ALPS NO	DATE	SELF INSPECTION NUMBER		PAGES			
219	M01	Asa-84-9097419-03-24	SI,CB1220,250,V29	14					



CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR302254872

Rev. 29  
Date 28/10/2023  
Project: PRASA  
SI.CB1220.250.V29

Car: M1,M3,M4

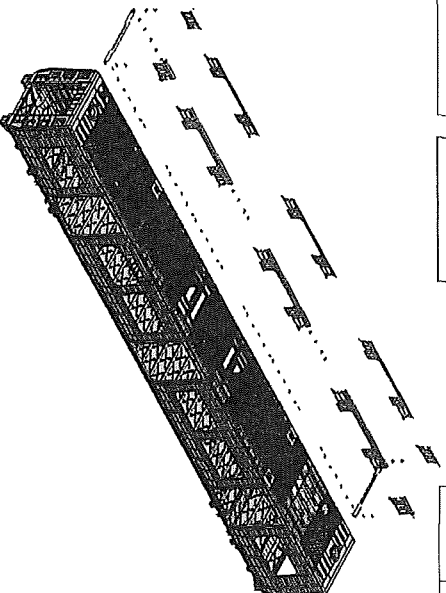
NCR:

Work station:

CB1220


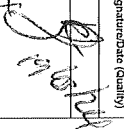


Safety Related



### I - Documentation and Instruments Control

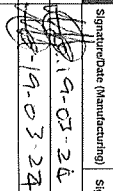
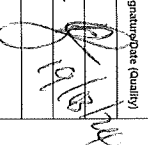
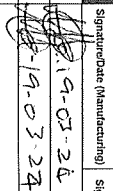
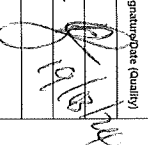
#### 1.1 - Documentation Control

Document	Type of car					Revision	Observation	OK	NOK	Revert	Signature/Date (Manufacturing)	Signature/Date (Quality)
	1	2	3	4	5							
DTR302254872	X					29	28-10-2023	X		N/A		

19-03-24

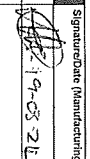
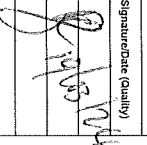
#### 1.2 - Instruments Control

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

Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Tubular	32823	15/03/2025	X			
measuring tape	31510231	03/01/2025	X			

#### 1.3 Consumables

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

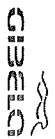
Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308	231064	MIG	X			



2024-03-13

INDUSTRIAL QUALITY  
MAINTENANCE



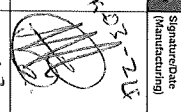

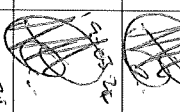
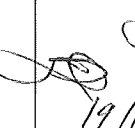
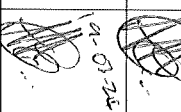
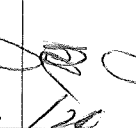
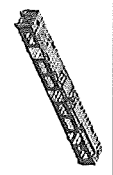
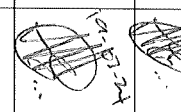
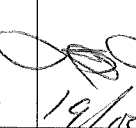
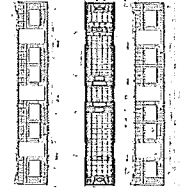


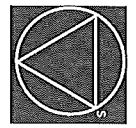
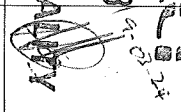

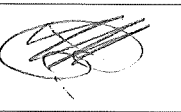
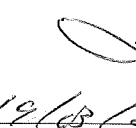
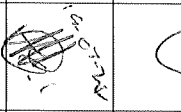


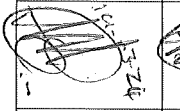



CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR302284872


Rev. 29  
Date 28/10/2023  
Project: PRASA  
SI.CB1220.250.V29

II - Self Inspection - Items to Check

II.1 - Items to check

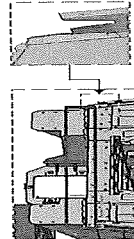
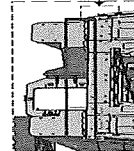

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Not OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1220.DTR302284872 Verification of fitment for all reinforcement brackets.	PRA.CB1220.DTR302284872	<input checked="" type="checkbox"/>	<input type="checkbox"/>	 19/03/24	 19/03/24
02	N/A	Carbshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	<input checked="" type="checkbox"/>	<input type="checkbox"/>	 19/03/24	 19/03/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPEDEF - ARC - 0000	<input checked="" type="checkbox"/>	<input type="checkbox"/>	 19-03-24	 19/03/24
04		Cleaning of all Stainless Steel Surface	According to GIB-WEL - PROC-0002	<input checked="" type="checkbox"/>	<input type="checkbox"/>	 19-03-24	 19/03/24
05		Functional dimensions approved according drawing or complementary document approved by Adson engineering and registered in this document.	Approved according specified on page 2800000210675	<input checked="" type="checkbox"/>	<input type="checkbox"/>	 19-03-24	 19/03/24
06		Perform visual inspection of welds in 100% of the project. Run by penetron testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetron testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658	<input checked="" type="checkbox"/>	<input type="checkbox"/>	 19-03-24	 19/03/24
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 (°) Min-Max 10°C - 35°C Relative humidity Min - Max (%) Min-Max 60% Max (°)	Seglent,Belch's No. 418885 Exp Date: 1-03-124 Actuals Temperature: 24 Humidity: 45	<input checked="" type="checkbox"/>	<input type="checkbox"/>	 19-03-24	 19/03/24
08	N/A	Verification of sealant application in certain regions in the drawing.	AA0000217866	<input checked="" type="checkbox"/>	<input type="checkbox"/>	 19-03-24	 19/03/24
09		Verification of safety welds	Approved according to DTD0000210658 reference and Self Inspection	<input checked="" type="checkbox"/>	<input type="checkbox"/>	 19-03-24	 19/03/24

GIBELCO  
2024-03-13  
INDUSTRIAL QUALITY  
MANLINE


	<b>CARBODYSHELL M1 M3 M4 ASSEMBLY</b> DTR30225487/2		Rev. 29	Project: PRASA
	<b>II - Self Inspection - Items to Check</b>		Date 28/10/2023	SI.CB1220.250.V29

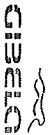
SEALANT APPLICATION

AREA 1 & 2 END 1

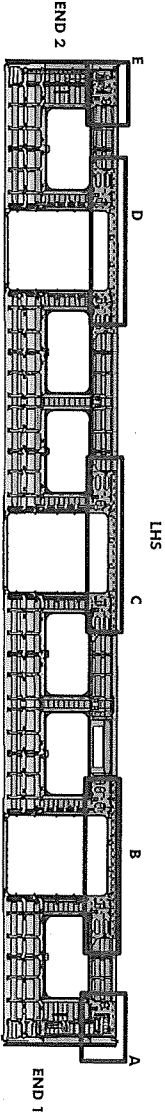
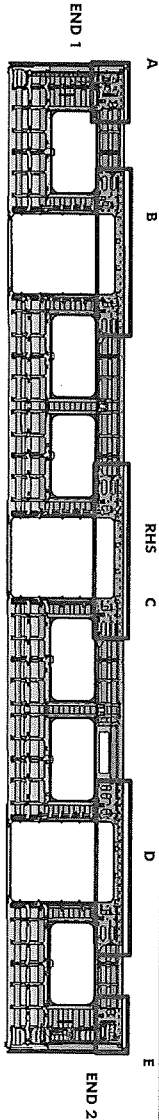




Operator (Name & sign): *ptlohozi* *HS*  
Operator (Name & sign): *ptlohozi* *HS*

  
**GIBBELCO**  
2024-03-13  
INDUSTRIAL QUALITY  
WARRANTY

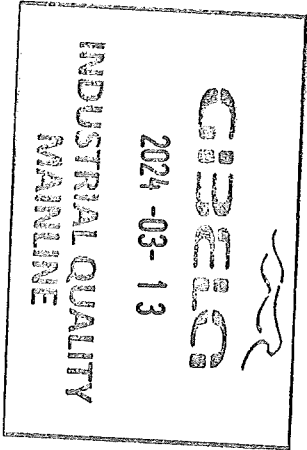
	CARBODYSHELL M1 M3 M4 ASSEMBLY DTR302254872		Rev.	Project: PRASA
			29 Date 28/10/2023	SI.CB1220.250.V29

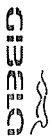
II - Self Inspection - Items to Check



REINFORCEMENT WELDING

AREA	LHS	RHS
A	Operator (Name&sign): <u>Ludo M&amp;E</u>	<u>Teky D</u>
B	Operator (Name&sign): <u>Ludo M&amp;E</u>	<u>Teky D</u>
C	Operator (Name&sign): <u>Skipper</u>	<u>Welding Office</u>
D	Operator (Name&sign): <u>Marsilio M&amp;E</u>	<u>M&amp;E</u>
E	Operator (Name&sign): <u>Marsilio M&amp;E</u>	<u>M&amp;E</u>

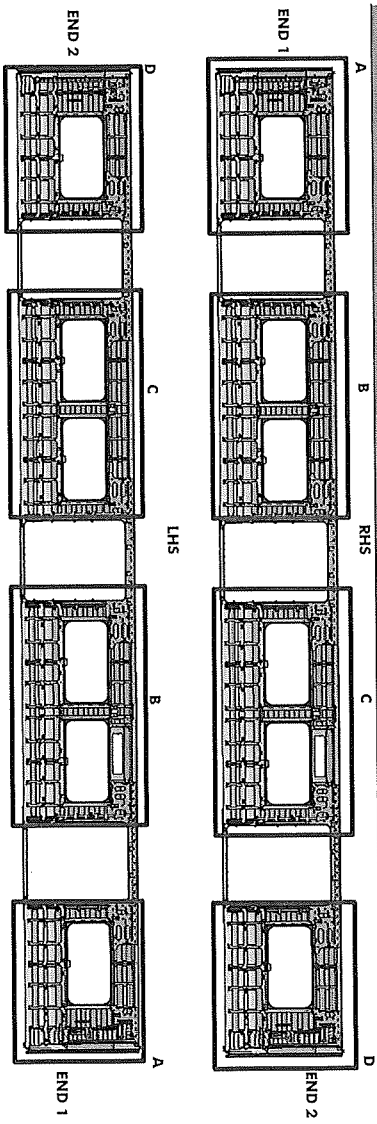




CARBOVYSHELL M1 M3 M4 ASSEMBLY  
DTR302254872

Rev.	Project: PRASA
29	
Date	
28/10/2023	SI CB1220.250.V29

II - Self Inspection - Items to Check



BRACKETING

INSTALLATION

C-RAILS:	Operator:	<u>Priscilla</u>
	Operator:	<u>Leni</u>
DOOR MECHANISMS:	Operator:	<u>Leni</u>
	Operator:	<u>Leni</u>
TAPPING PADS	Operator:	
	Operator:	
SEAT & LUGGAGE BRACKETS:	Operator:	<u>ASTHIDE</u>
	Operator:	<u>Lolo</u>
SEAT BRACKETS VERIFICATION:	Operator:	<u>ASHIDE</u>
	Operator:	

INSTALLATION & VERIFICATION

WELDING

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

ENDS  
2024-03-13  
END 1 TAPPING PADS WELDING: Operator (Name&sign): Monstere Mbar  
END 2 TAPPING PADS WELDING: Operator (Name&sign): Monstere Mbar  
MANUAL



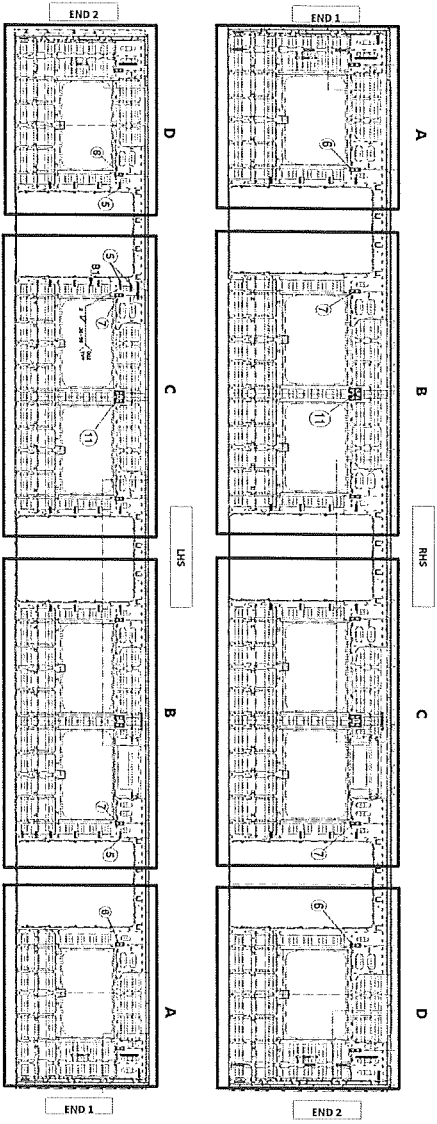
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR3032548712

Rev. 29  
Date 29/10/2023

Project: PRASA  
SI.CB1220.250.V29

## II - Self Inspection - Items to check

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

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

ROOF ENDS:

CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: N/A

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	6	
	D	2	

ROOF ENDS:

CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: N/A

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	2	
EARTH BUSH	A	4	
	B	5	
	C	3	
	D	3	

ROOF ENDS:

CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: ASARIDA

LHS			
SECTION	QUANTITY	OK	NOK
C-RAILS	A	10	
	B	11	
	C	11	
	D	11	
SEAT BRACKETS	A	13	
	B	21	
	C	21	
	D	13	
EARTH BUSH	A	3	
	B	5	
	C	6	
	D	2	

ROOF ENDS:

CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: ASARIDA

**GIBBELCO**  
2024-03-13  
INDUSTRIAL QUALITY  
MAINLINE



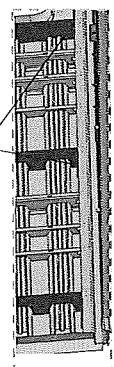
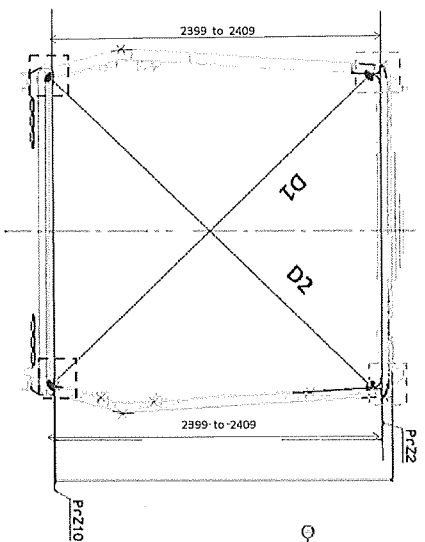
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2

Rev.
29
Date
28/10/2023

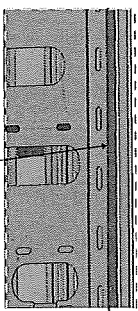
Project: PRASA

SI.CB1220.250.V29

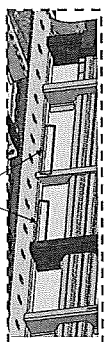
### Specifications of Details for CBS measurement



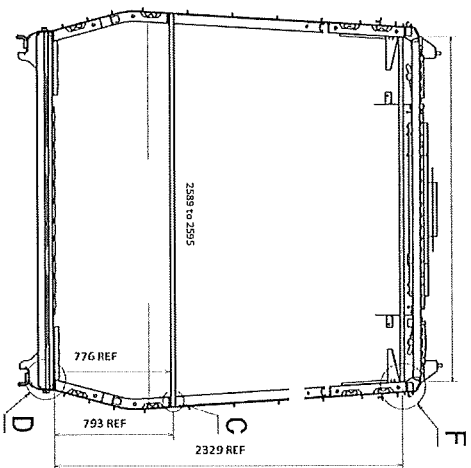
Measurement positions on roof rail and sidewall omrig corner.



Reinforcement area measurement positions on roof reinforcement area.

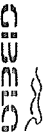


Measurement positions on sidewall and side sill corner.

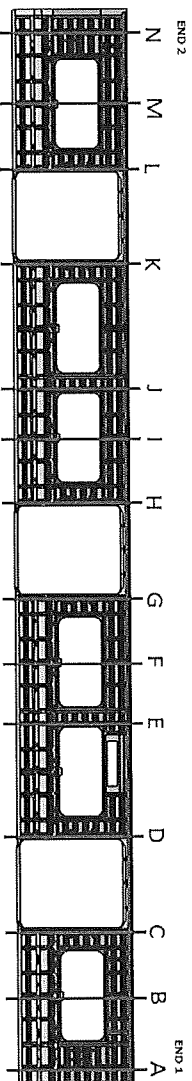


**GIBECO**  
2024-03-13  
INDUSTRIAL QUALITY  
MAINTENANCE



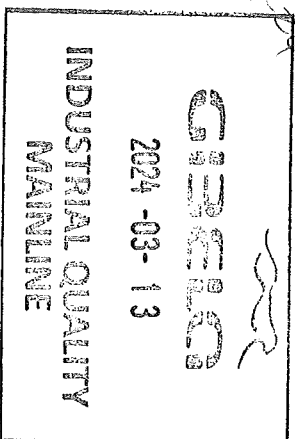
	CARBODYSHELL M1,M3,M4 ASSEMBLY		Rev.	Project: PRASA
	DTR30225487/2		29	
			Date	SI,CB1220.250.V29
			28/10/2023	

GBS measurement



BEFORE WELDING

Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A 3295	3297	2	
B 3260	3260	0	
C 3294	3294	0	
D 3293	3295	2	
E 3262	3265	3	
F 3262	3264	2	
G 3294	3298	4	
H 3294	3297	3	
I 3260	3264	4	
J 3264	3264	0	
K 3297	3297	0	
L 3298	3296	2	
M 3266	3265	3	
N 3296	3299	6	







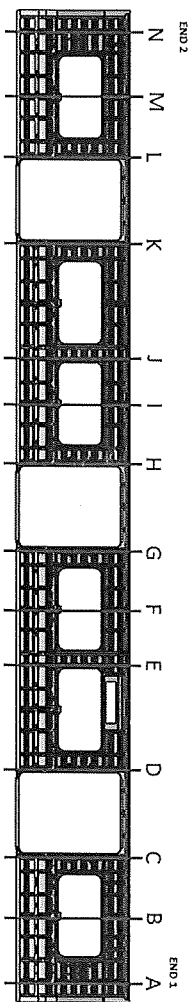
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2

Rev.	29
Date	28/10/2023

Project: PRASA

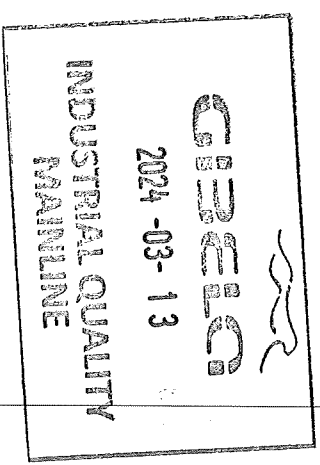
SI.CB1220.250.V29

GBS measurement



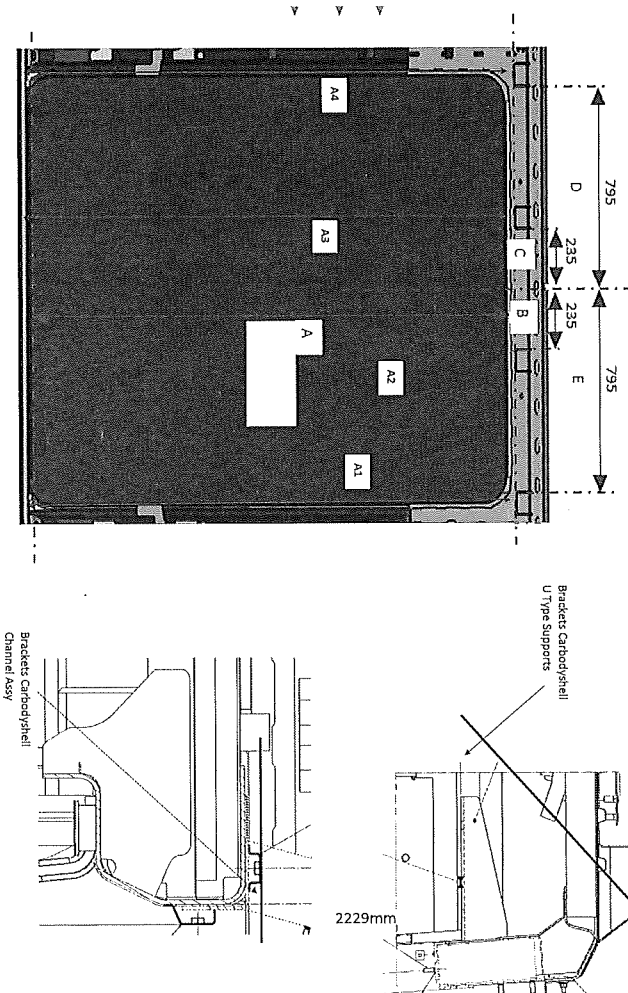
AFTER WELDING

Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A 3296	3300	4	2595
B 3263	3269	6	2589
C 3291	3296	5	2589
D 3300	3294	6	2589
E 3265	3266	1	2591
F 3263	3263	0	2589
G 3294	3294	3	2591
H 3300	3298	2	2589
I 3262	3262	0	2592
J 3266	3299	3	2593
K 3299	3294	5	2590
L 3294	3300	3	2589
M 3269	3265	6	2589
N 3294	3295	1	2594



19-03-24

## Specifications of Details for GBS measurement CB1220



DOOR 1 - LHS	
VALUE	ACTUAL
A1	2232
A2	2232
A3	2231
A4	2231
B	235
C	235
D	194
E	195

DOOR 2 - LHS	
VALUE	ACTUAL
A1	2230
A2	2232
A3	2230
A4	2232
B	2340
C	2342
D	7940
E	7942

DOOR 2 - HIS	
VALUE	ACTUAL
A1 2230 to 2232	2 2231
A2 2230 to 2232	2231
A3 2230 to 2232	2231
A4 2230 to 2232	2232
B 234 to 236	235
C 234 to 236	235
D 794 to 796	795
E 794 to 796	795

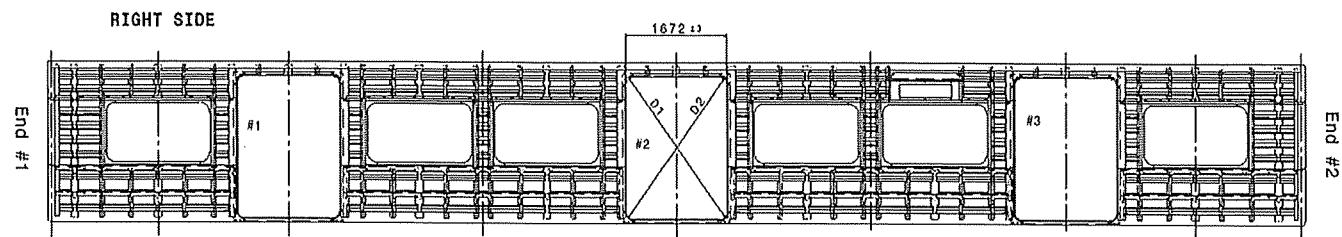
DOOR 1 - RMS	
VALUE	ACTUAL
A1	2230 to 2232
A2	2230 to 2232
A3	2230 to 2232
A4	2230 to 2232
B	234 to 236
C	234 to 236
D	794 to 796
E	794 to 796

DOOR 2 - RMS	
VALUE	ACTUAL
A1	2232
A2	2232
A3	2232
A4	2231
B	2235
C	2235
D	795
E	795

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

INDUSTRIAL QUALITY  
HYDRA-MINE  
-03-13

Specifications of Details for GBS measurement CB1220

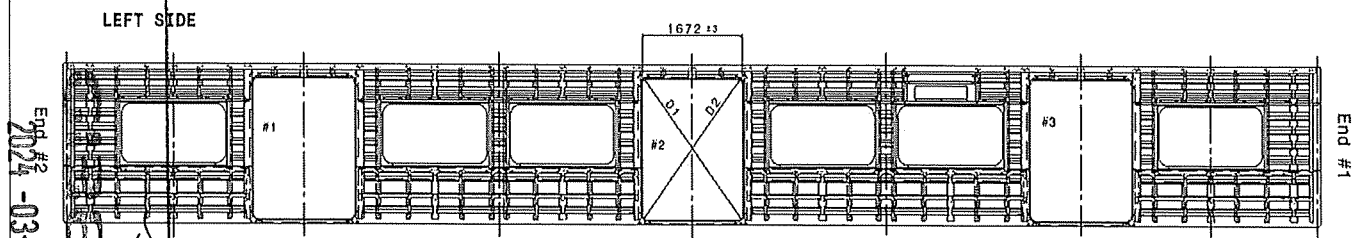


Doors length - 1672 ±3mm

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

Doors diagonal D1-D2 maximum difference ≤4mm

#1	#2	#3
D1 2747	2746	2744
D2 2746	2745	2746
D1-D2 1	1	2



Doors length - 1672 ±3mm

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

Doors diagonal D1-D2 maximum difference ≤4mm

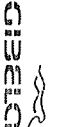
#1	#2	#3
D1 2747	2746	2744
D2 2746	2747	2747
D1-D2 1	1	3

*[Signature]*  
19-03-24

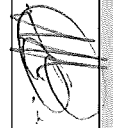

**INDUSTRIAL QUALITY**  
**WARRINE**

End #2  
2024-03-13



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

Self Inspection - Final Result

Is the car good to advance to the next workstation/process? (Approval of Operations Manager and Industrial Quality)		DATE	NAME	SIGNATURE
HOLD POINT	GO	19-03-24	Ag. H. 124 Operations	
		19/03/24	Ntkluno Industrial Quality	
	NO GO			
			Operations	
			Industrial Quality	

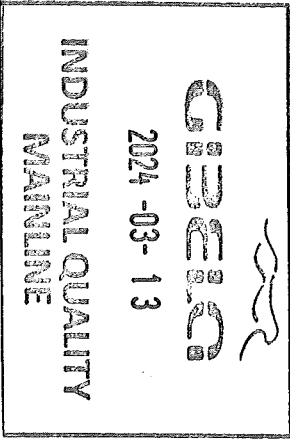
In case of "NO GO", describe blocking problems

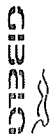
In case of "NO GO", the operations manager must define below action plan to ensure "GO":

Item	Description	Responsible	Due date	Status

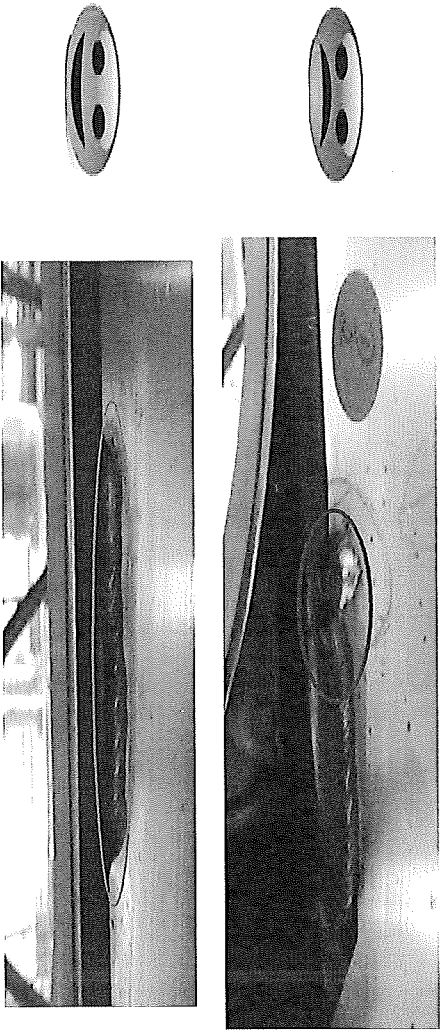
Operations

Quality



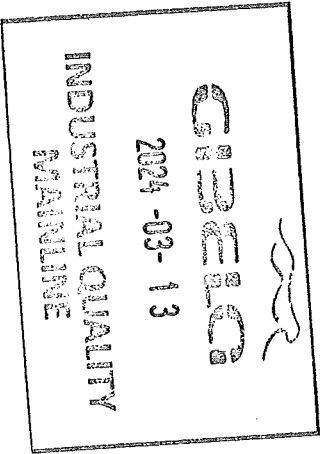
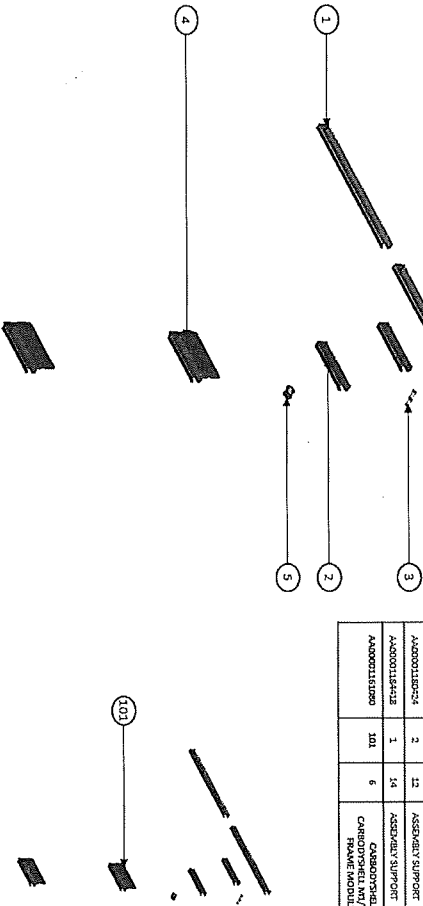
	Rev.		Project: PRASA SI.CB1 220.250.V29
	29		
	Date	29/10/2023	
CARBODYSHELL M1.M3.M4 ASSEMBLY DTR302254872			

ANNEXURE A: Arc Welding Quality Acceptance Standard



Station: CB1220-004- U108 & U107

PART NO.	ITEM NO.	QTY	DESCRIPTION	MASS (KG)
DTR0000704628	5	6	BRATTY STUD 6	0.026
A400001271843	4	6	ASSEMBLY SUPPORT	0.271
DTR0000048005	3	12	WELDING STUD 603194 PT - M20x1.57	0.007
A400001180524	2	12	ASSEMBLY SUPPORT	0.193
A400001164018	1	14	ASSEMBLY SUPPORT	0.522
A400001161090	101	6	CARBODYSHELL BRACKETS FOR RAKE MODULE END - 079	12.112



# 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 ?	
				TCL	M4	M5	M2	M3			TG2
<input type="checkbox"/>	DT0000225487	AAD0001279556	CH880D/SHELL M4, M5, ASSEMBLY		X	(X)		X		PRA-CB2230, DT000002 25487 V20	YES
<input type="checkbox"/>											
<input type="checkbox"/>											
RE	DATE	MODIFICATION CONTENT					RESPONSIBLE	NAME	DATE		
0	2018/08/02	GIBELA NEW CREATION					APPROVER	Phillipe Marques	2018/08/02		
							CHECKER	Nosizo Pindela	2018/08/02		
							COMPIER	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	Izumeleng 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	Izumeleng Modiba	2018/05/07		
							CHECKER	Nosizo Pindela	2018/05/07		
							REVISED BY	Ramokone Motema	2018/05/07		
5	24/01/2019	As per Baseline 10.2					APPROVER	Izumeleng 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	Izumeleng 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	Izumeleng 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	Izumeleng Modiba	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 Mkhombhi	20/02/2022		
							CHECKER	Andani Muthelo			
							REVISED BY	Andani Muthelo			
26	14/06/2022	Update minimum temperature requirement for sealant application					APPROVER	Collins Mkhombhi	14/06/2022		
							CHECKER	Andani Muthelo			
							REVISED BY	Andani Muthelo			
27	26/07/2022	Threshold measurements addition					APPROVER	Collins Mkhombhi	26/07/2022		
							CHECKER	Andani Muthelo			
							REVISED BY	Andani Muthelo			
28	17/10/2022	Added traceability of sealant application					APPROVER	Collins Mkhombhi	17/10/2022		
							CHECKER	Ntokozo Zwane			
							REVISED BY	Amogelang Mochlamepe			
29	14/04/2023	Added sealant batch number & welding consumables traceability					APPROVER	Vanessa Ntuli	14/04/2023		
							CHECKER	Ntokozo Zwane			
							REVISED BY	Amogelang Mochlamepe			
30	06/11/2023	Added threshold traceability for boiler makers and welders					APPROVER	Ngothent Tyson	06/11/2023		
							CHECKER	Andani Muthelo			
							REVISED BY	Ntokozo Zwane			
TRAINSET	CAR	OPERATOR NAME/ ALPS NO	DATE	SELF INSPECTION NUMBER		PAGES					
219	M1	Choy 447409	2018124	SI-CB2230.256.V29		12					



CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.  
30  
Date  
06/11/2023

Project: PRASA  
SI.CB2230.256.V29

Car:

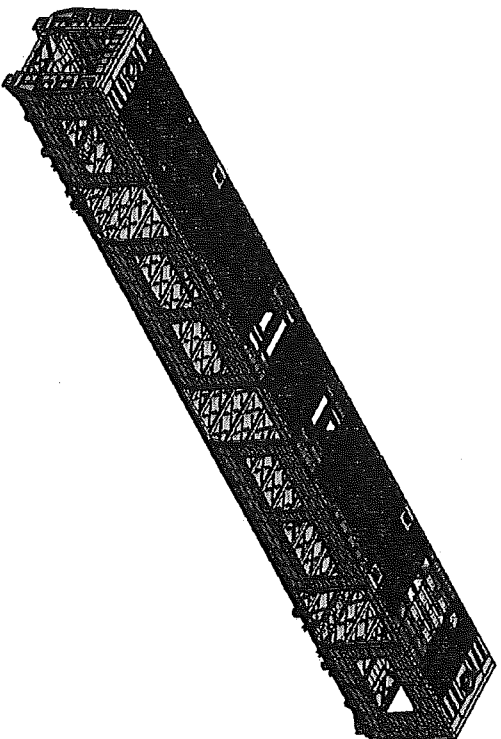
NCR:

Work station:

CB2230



Safety Related









### I - Documentation and Instruments Control

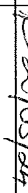
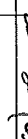
#### I.1 - Documentation Control

Document	Type of car					Revision	Observation	OK	NOK	Drawn	Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4	TOL							
PRASA CB2230.DT00000225487	X					V30		OK		N/A	<i>[Signature]</i> 20/03/24	<i>[Signature]</i> 20/03/24

#### I.2 - Instruments Control


Monitoring and Measuring Instrument Control - Used for Special Process						
Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
IRBULAR	22615	2024/08/02	OK		 20/03/24	 20/03/24
COMBINATION SQUARE	G1805P131	2024/10/04	OK		 20/03/24	 20/03/24
MEASURING TAPE	G181AC514	2024/04/05	OK		 20/03/24	 20/03/24

#### 1.3 Consumables

Welding Consumable Control - Used for Special Process						
Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)	
308 LS1	E237067	MIG	OK	 20/03/24	 20/03/24	



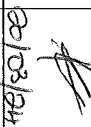

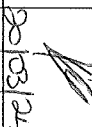

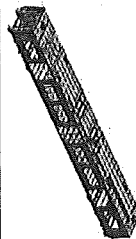
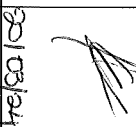

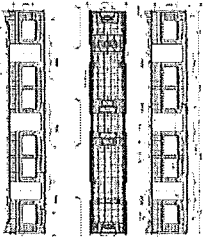


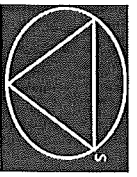








WELDING PROCESS SUPERVISOR  
FITTING QUALITY  
2024-02-15  
Signature .....



	CARBODYSHELL M1,M3,M4 ASSEMBLY		Rev. 30		Project: PRASA	
	DT00000225487		Date		SI.CB2230.256.V29	
			06/11/2023			

II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Not OK	Signature/Date (Operators)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering nº PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	OK		 20/03/24	 20/03/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD00000210675	OK		 20/03/24	 20/03/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	OK		 20/03/24	 20/03/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	OK		 20/03/24	 20/03/24
05		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	OK		 20/03/24	 20/03/24
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 filler sampling as described in DTD00000210658.	As the welding procedure IND-SAL-WMS-018 and DTD00000210658.	OK		 20/03/24	 20/03/24
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 (°) : Min-Max 10°C - 35°C Relative humidity Min - Max (%) : Min-Max 25% - 80%	Sealant Batch No: <u>152-70</u> 08 Exp Date: <u>05/24</u>  Actuals Temperature: <u>33°C</u> Humidity: <u>30%</u>	OK		 20/03/24	 20/03/24
08	N/A	Verification of sealant application on the roof and sidewall finishers.	Sealant must be: -Applied straight and even -Free of gaps, cracks, damage and debris (flashes, dirt, dust)  Refer to Annexure B	OK		 20/03/24	 20/03/24
09	N/A	Verification of sealant application in certain regions in the drawing.	AAD0001278566	OK		 20/03/24	 20/03/24

Signature \_\_\_\_\_  
2024-02-15



CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.	30
Date	06/11/2023

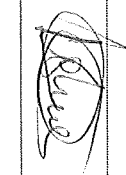
Project: PRASA

SI.CB2230.256.V29

II - Self Inspection - Items to Check

END 2 SEALANT


OPERATOR  
(Name & sign):

Leverey 

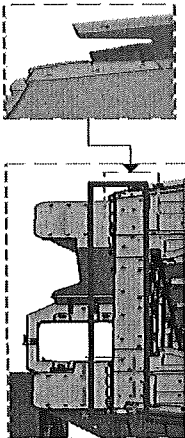
OPERATOR  
(Name & sign):

Leverey 

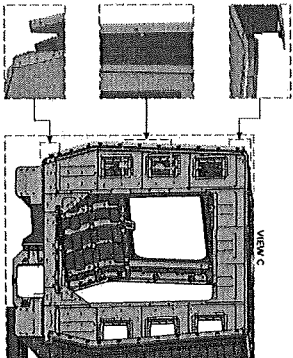
OPERATOR  
(Name & sign):

Leverey 

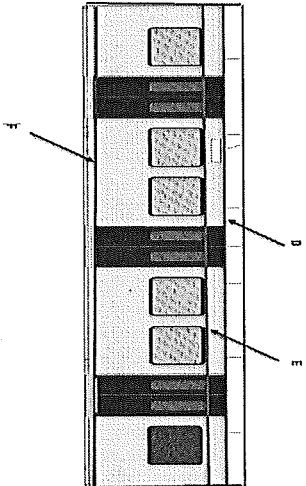
AREA 1



AREA 2 (VIEW G)



H



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

Operator (Name & sign) : D,E,F,G,H,I

LHS

Operator (Name & sign) :

Operator (Name & sign) :

Operator (Name & sign) :

Operator (Name & sign) :

Operator (Name & sign) :

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

RHS

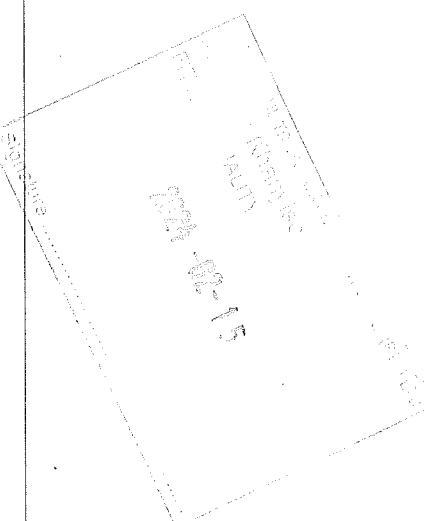
Operator (Name & sign) :

Operator (Name & sign) :

Operator (Name & sign) :

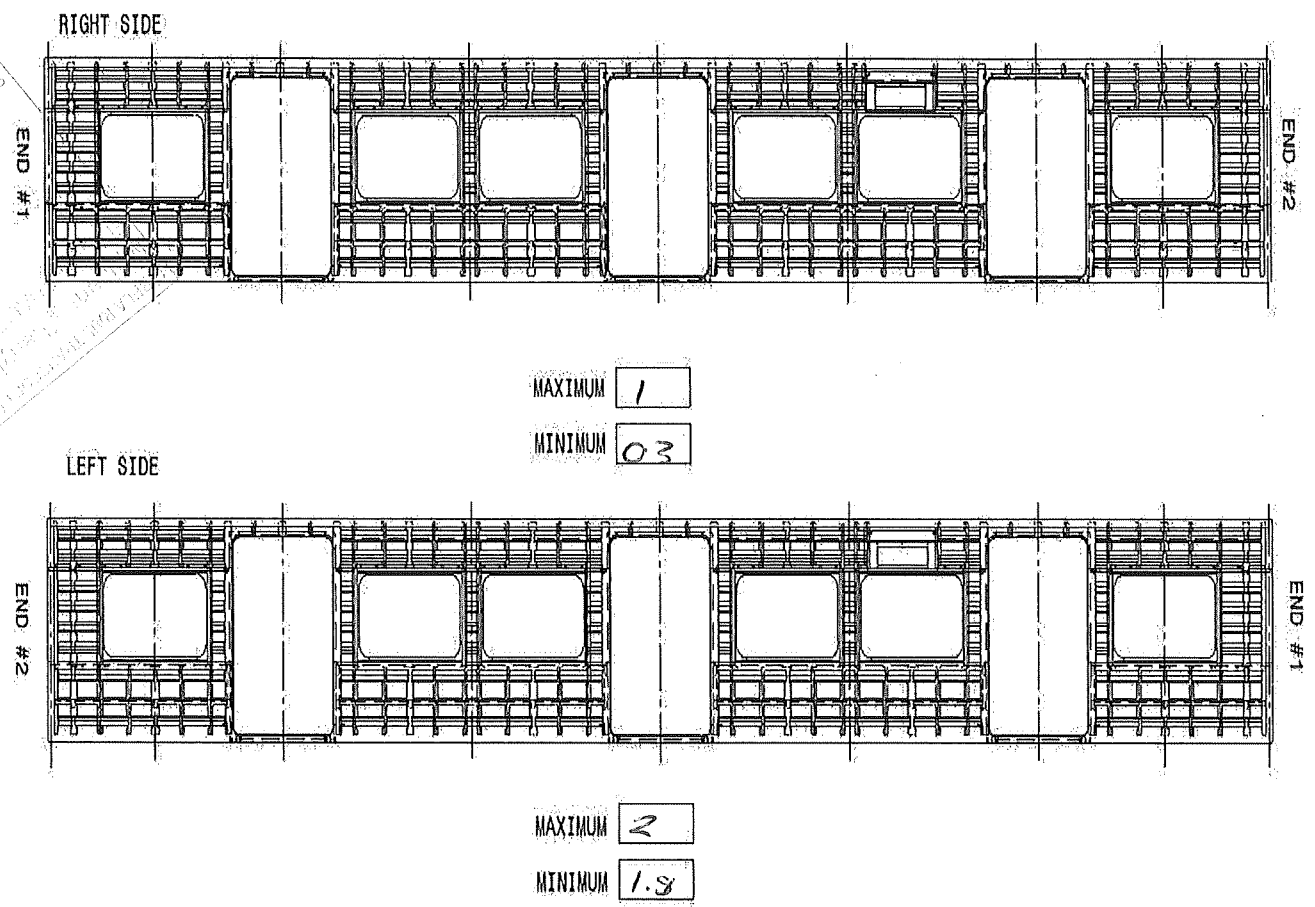
Operator (Name & sign) :

Operator (Name & sign) :

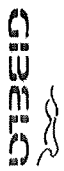


Specifications of Details for CBS measurement CB1230

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



Signature  
2024-02-15



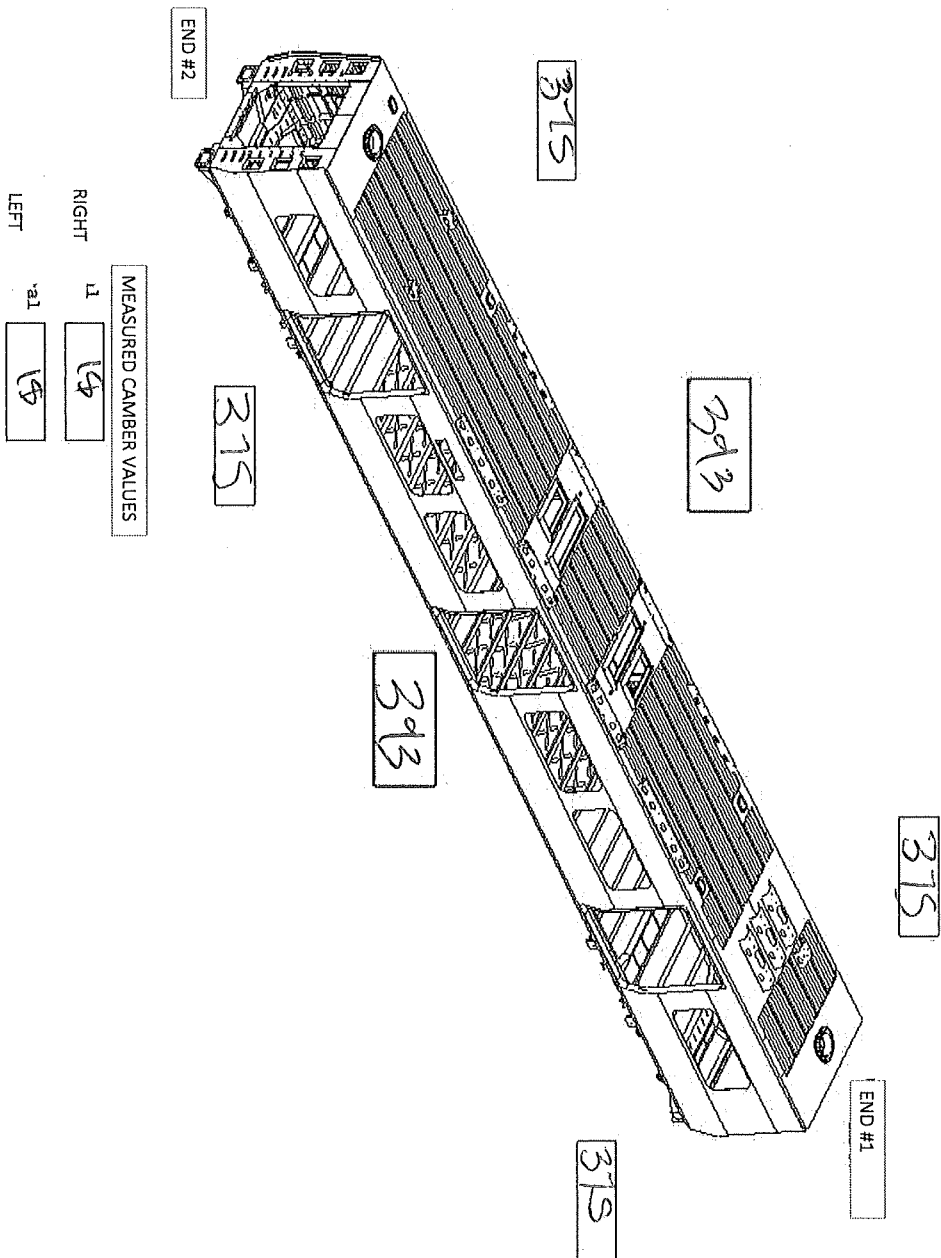
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.
30
Date
06/11/2023

Project: PRASA  
SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230


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



GIBELD PROJECTS & CONSULTING PTW LTD  
10012 10012 10012  
10012 10012 10012

2024-02-15

Signature

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

06/11/2023

Specifications of Details for CBS measurement CB1230

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

115

117

115

END #1

115

117

115

END #2

TWIST FOUND ON END 1

TRANVERSE

2

LONGITUDINAL

2

TWIST FOUND ON END 2

TRANVERSE

2

LONGITUDINAL

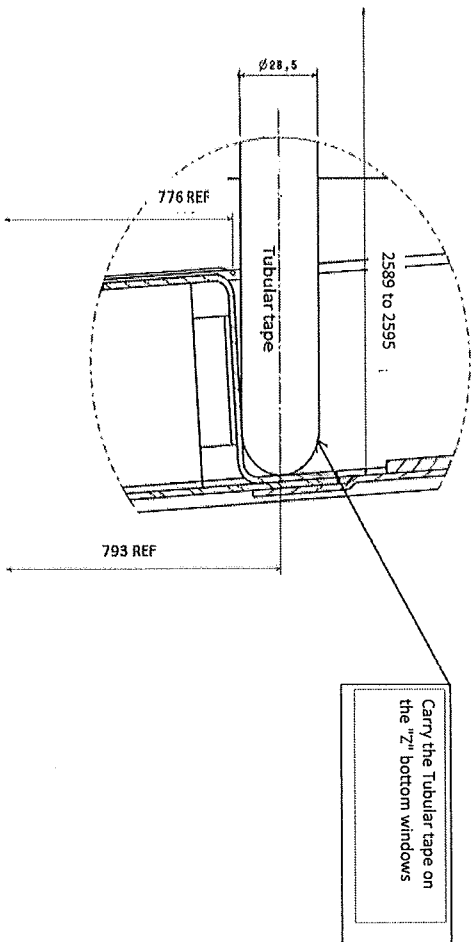
2

Signature

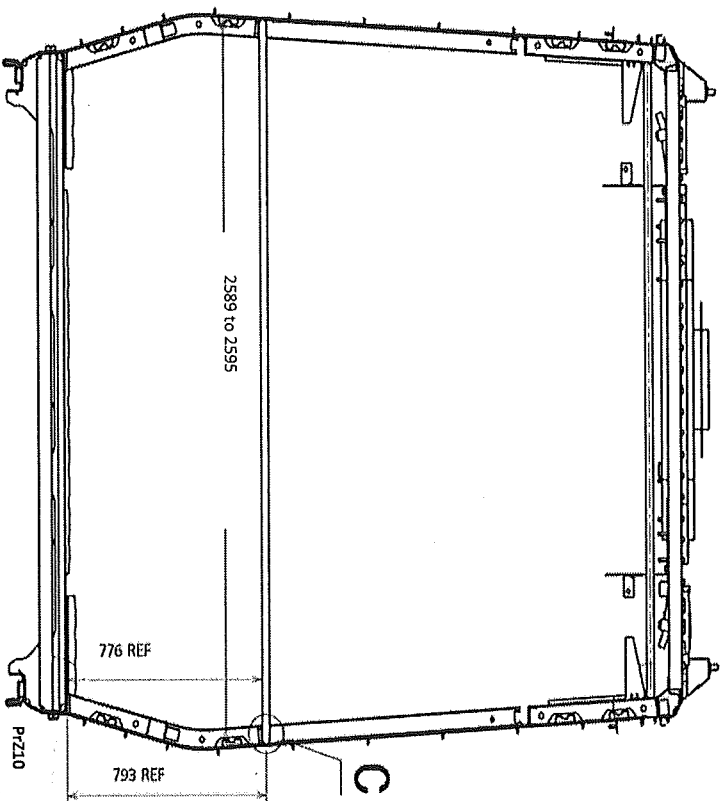
2024-02-15

7

Specifications of Details for CBS measurement CB1230

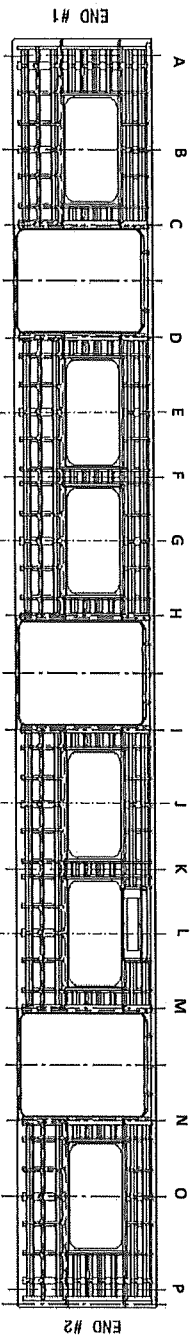


Detail C



2024-02-15

## Specifications of Details for CBS measurement CB1230



2589 to 2595mm

257

25 of

250

255

850

2592

১৫০

857

Q57D

25/3

8592

0569

2594

0512

050

2594

## Threshold verification

Threshold verification				Nominal value :38
Door 1		Door 2		Door 3
L	R	L	R	L R
38	38	38	38	38
Door 4		Door 5		Door 6
L	R	L	R	L R
38	38	38	38	38

BOILER MAKER:

**WELDER:**

27-140602151

11/11/11

Signature

## Dye penetrant test

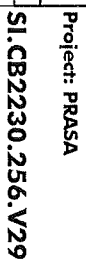
**Dye-penetration test to be performed by quality personnel**



51-38-1000

ALL INFORMATION CONTAINED  
HEREIN IS UNCLASSIFIED  
DATE 01-11-2001 BY 60322 UCBAW

**INTERNATIONAL INFORMATION REPORT (IIR) LTD**




## Description of the issue

## II.2 - Check List REX




Item	Picture/Drawing	Description	Criteria/Record	OK	Not OK	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX				





	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev.	Project: PRASA
		30 Date 06/11/2023	SI.CB2230.256.V29

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)	20.03.24	CHOSSY Operations		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	20/03/24	Andenani Industrial Quality		
	NO GO	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)	20/03/24	Andenani 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	Status

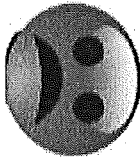
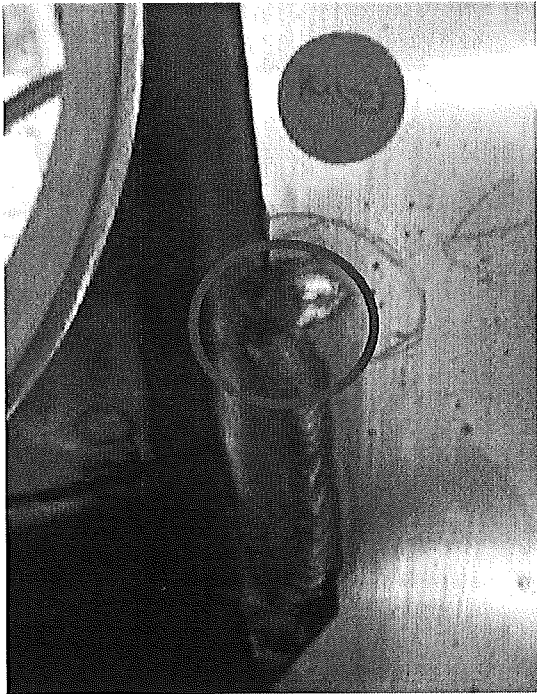
Operations


Quality

Signature .....  
 2024-02-15  
 IMPROVED QUALITY  
 GIBELD INDUSTRIAL QUALITY

	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487		Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29
--	---	--	----------------------------------	-------------------------------------

**ANNEXURE A: Arc Welding Quality Acceptance Standard**



 <b>GIBELCO</b>	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DT00000225487		Rev. 30	Project: <b>PRASA</b>  <b>SI.CB2230.256.V29</b>
			Date 06/11/2023	

**ANNEXURE B: Sealant**

