

APPLICABLE FROM TRAINSET 190+ AS PER BASELINE 10.4

SELF INSPECTION SHEET

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

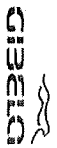
APPLICATION REFERENCE										
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE					WORK INSTRUCTION	SAFETY
				TCS	MA	MA	MA	TCS		
<input type="checkbox"/>	DT30225487/3	CARBODYSHELL M3 M4 ASSEMBLY	CB2210		X				PRA CB2210.DTR30225 487/3.V30	YES
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager								
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230								
3	2018/12/12	Added dimensional check points to CB2210								
5	22/01/2019	As per Baseline 10.2								
6	13/03/2019	Added D1 and D2 on Self - Inspection								
10	21/08/2019	New Baseline 10.2.5								
15	06/08/2020	New Baseline 10.2.6								
20	19/04/2021	New Baseline change 10.3								
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING								
25	19/02/2022	New Baseline change 10.3.1								
26	14/04/2023	Addition of welding consumable traceability								
30	20/07/2023	New Baseline change 10.4								
31	07/11/2023	Added traceability for welding sections								
TRAINSET	CAR	OPERATOR NAME:ALPS NO	DATE	SELF INSPECTION NUMBER				PAGES		

15219 M3 PENTSO 201564 409964

51.CB2210.254.V30

17

QUALITY  
13  
GIBELA  
PRASA PROJECT



CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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

Car: M3 & M4

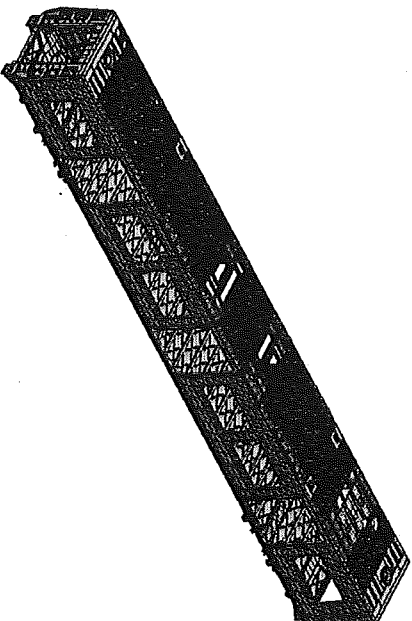
NGR:

Work station:

CB2210


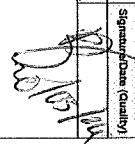


Safety Rated




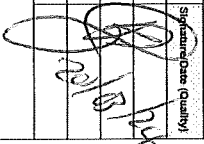


### 1 - Documentation and Instruments Control

#### L1 - Documentation Control

Document	Type of car					Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	L01	M1	M2	M3	M4	T02				
DTR30225487/3				Y				✓	 07/11/23	 07/10/23

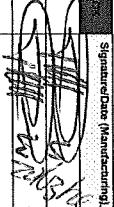
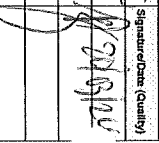
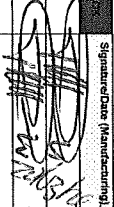
#### L2 - Instruments Control

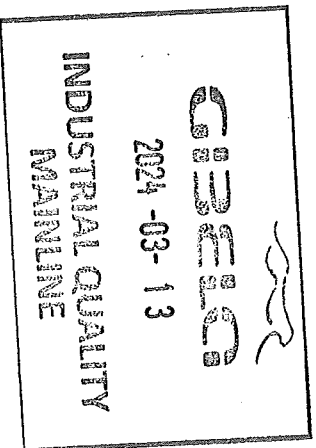
#### Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation day	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
INFILIAK	30823-2	15/05/25	✓	 07/10/23	 07/10/23
LASER APP	125425924	08/10/25	✓	 07/10/23	
3DM APP	EMB D0102	18/11/24	✓	 07/10/23	

#### 1.3 Consumables

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

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSi	314013-74007	MIG	✓	 07/10/23	 07/10/23
ER 308 L	297604-7032	MIG	✓	 07/10/23	












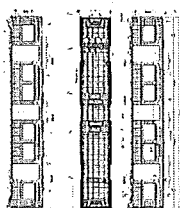
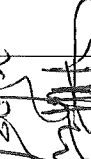

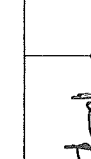




CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

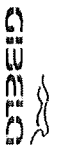
Rev. 31  
Date 07/11/2023  
Project: PRASA  
SI CB2210.254.V30

II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Not OK	Signature/Date (Manufacturer)	Signature/Date (Quality)
01	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD00000210675	✓		 20/03/24	 20/03/24
02	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD00000210675	✓		 20/03/24	 20/03/24
03	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 20/03/24	 20/03/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 20/03/24	 20/03/24
05		Functional's dimensions approved according drawing or complementary document approved by Astion engineering and registered in this document	Approved according specified on pages below.	✓		 20/03/24	 20/03/24
06	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and filler sampling as described in DTD00000210658.	As the welding procedure IND-SAL-WMS-018 and DTD00000210658.	✓		 20/03/24	 20/03/24

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

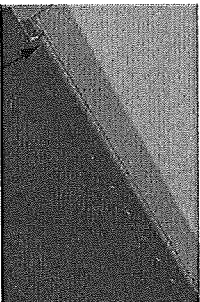


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.	Project: PRA5A
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Date	
07/11/2023	

Welding Traceability

Roof ring welds



Boiler maker (Name & Sign): <u>Justice</u>	LHS	Welder (Name & Sign): <u>Barry Blue</u>	RHS
Boiler maker (Name & Sign): <u>Justice</u>	RHS	Welder (Name & Sign): <u>Barry Blue</u>	RHS

END 1

Boiler maker (Name & Sign): <u>Justice</u>	LHS	Welder (Name & Sign): <u>Barry Blue</u>	RHS
Boiler maker (Name & Sign): <u>Justice</u>	RHS	Welder (Name & Sign): <u>Barry Blue</u>	RHS

END 2

Door ring welds



Boiler maker (Name & Sign): <u>Lawrence Moly</u>	LHS
Welder (Name & Sign): <u>Thobey</u>	RHS

Boiler maker (Name & Sign): <u>Lawrence Moly</u>	RHS
Welder (Name & Sign): <u>Thobey</u>	RHS

**CEC**  
2024-03-13  
INDUSTRIAL QUALITY  
MANUFA

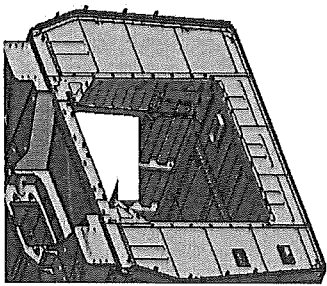
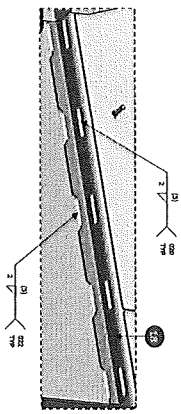




CARBOOVSHELL M3,M4 ASSEMBLY DTR30225487/3

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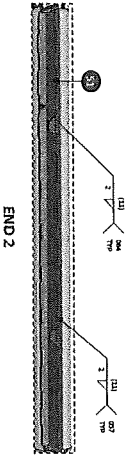
EUF Reinforcement Plates



END 1

Boiler maker (Name & Sign): Lawrence Moly

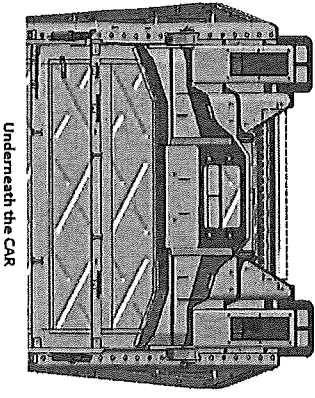
Welder (Name & Sign): Roby R



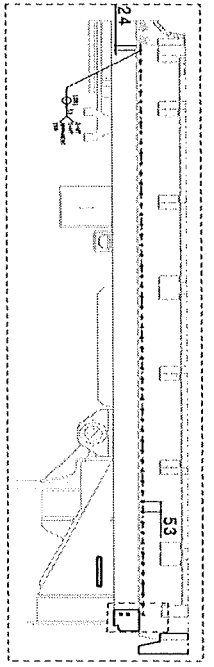
END 2

Boiler maker (Name & Sign): Francis M

Welder (Name & Sign): Kelly R




Underneath the CAR



FEDOU

Operator: Bob M



2024 -03- 13

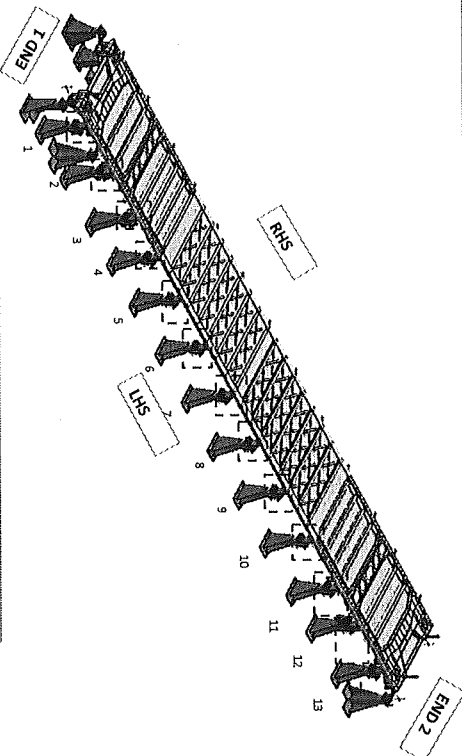
INDUSTRIAL QUALITY  
MAINLINE



CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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

Specifications of Details for GBS measurement



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

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	4	5	4	0	0

Signature Operator:

Date:

20/03/24

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	3	4	3	0	0

Signature Industrial Quality:

Date:

20/03/24

**GIBELD**  
2024-03-13  
INDUSTRIAL QUALITY  
MANAGER

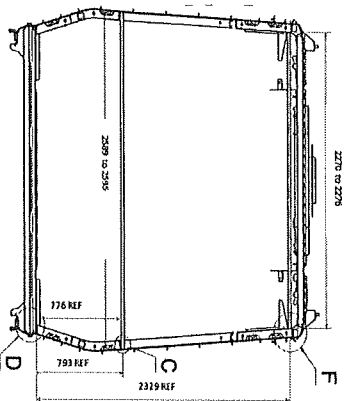
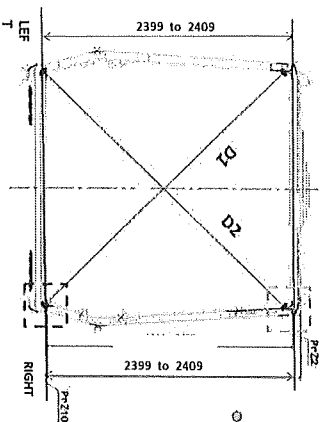
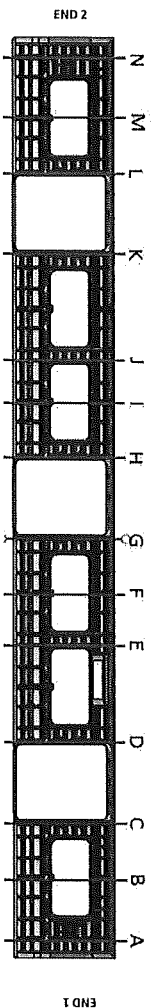


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

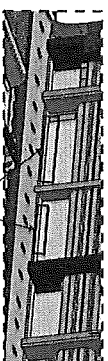
Rev.  
31  
Date  
07/11/2023

Project: PRASA  
SI.CB2210.254.V30

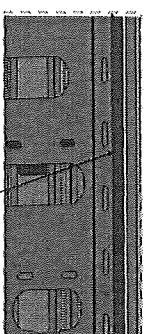
Specifications of Details for CBS measurement



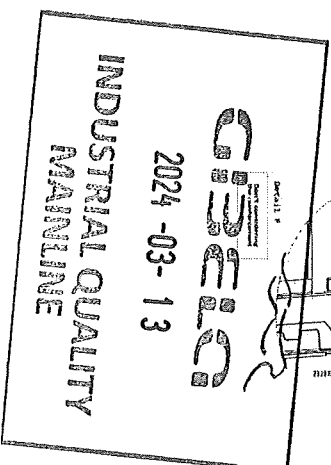
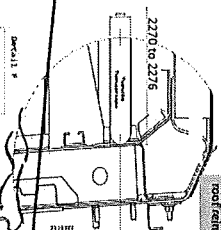
Measurement positions on roof rail and side wall corner.



Measurement positions on side wall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.

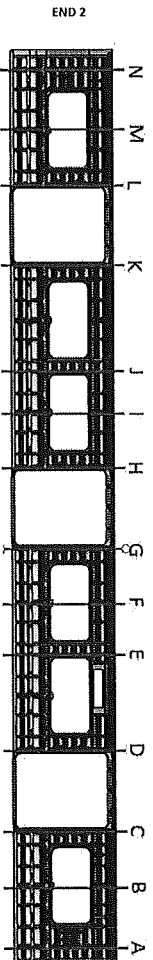




CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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Specifications of Details for GBS measurement



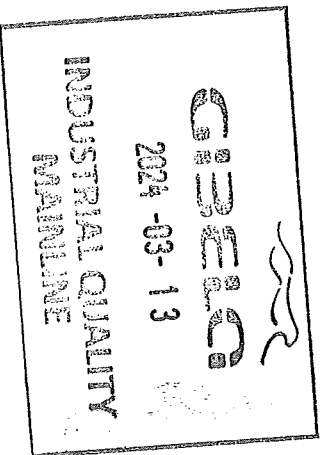
PME Column LHS - RHS should be  
≤ 2MM on each point.

BEFORE WELDING

Record D1 values		Record D2 values		D1-D2 ≤ 5mm		2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3069	3069		0		2404	2404	0
B	3068	3067		1		2405	2404	1
C	3070	3071		1		2406	2404	2
D	3069	3068		1		2404	2405	1
E	3068	3065		0		2404	2406	2
F	3067	3070		1		2404	2404	0
G	3068	3066		2		2404	2405	1
H	3069	3068		1		2405	2404	1
I	3071	3072		1		2404	2404	0
J	3070	3070		0		2406	2404	2
K	3069	3068		1		2405	2404	1
L	3068	3066		2		2406	2404	2
M	3066	3066		0		2405	2406	1
N	3071	3070		1		2404	2404	0



45997979  
20/05/2023

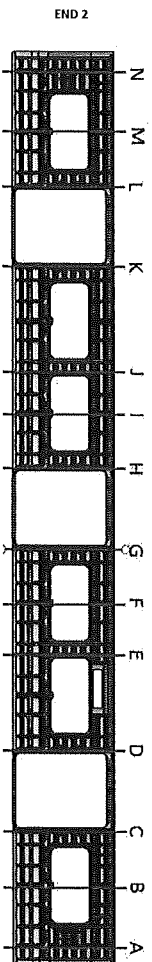




CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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Specifications of Details for CBS measurement



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

AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3378	3379	1	2404	2406	2
B	3069	3068	1	2404	2404	0
C	3096	3098	2	2404	2404	0
D	3096	3096	0	2407	2405	1
E	3070	3071	1	2404	2406	2
F	3069	3069	0	2404	2405	1
G	3095	3096	1	2404	2406	2
H	3094	3094	0	2406	2404	2
I	3069	3068	1	2404	2404	0
J	3068	3069	1	2404	2403	1
K	3096	3094	1	2405	2406	1
L	3078	3078	0	2404	2405	1
M	3069	3067	2	2404	2404	0
N	3076	3074	2	2406	2404	2

2024-03-13  
INTERNAL QUALITY  
MANAGEMENT  
2024-03-13

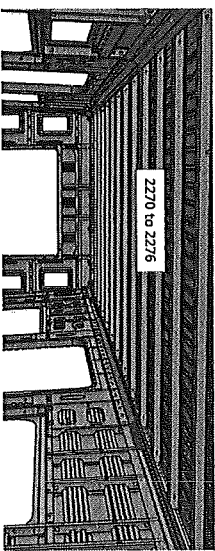
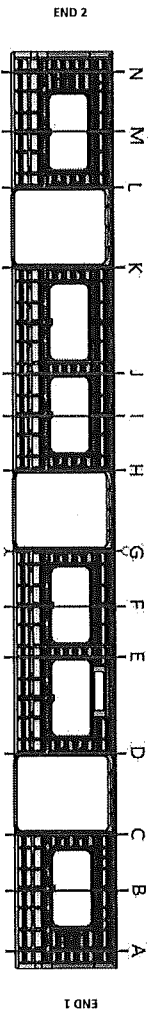
**CIBELCA**

CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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Date	07/11/2023	

**CBS measurement**

**BEFORE WELDING**

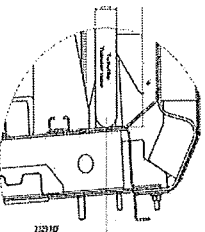
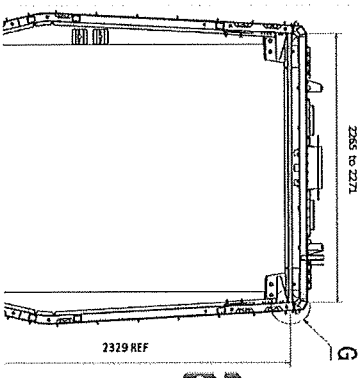


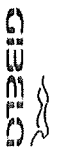
2270 to 2276

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

**CIBELCA**  
2024-08-11/13  
INDUSTRIAL QUALITY  
MANUFACTURING  
201903 B1

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



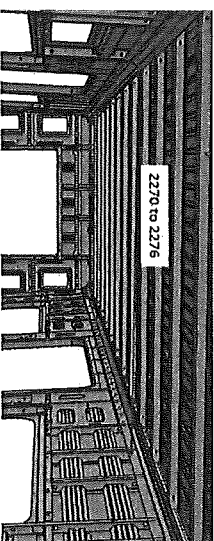
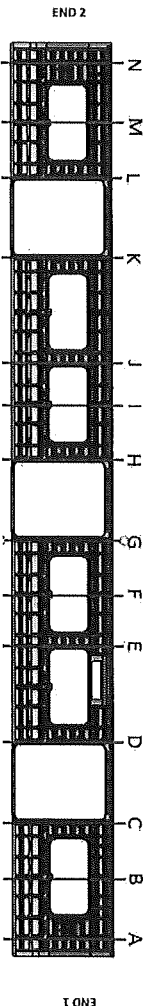


CARBOYSHELL M3,M4 ASSEMBLY DTR30225487/3

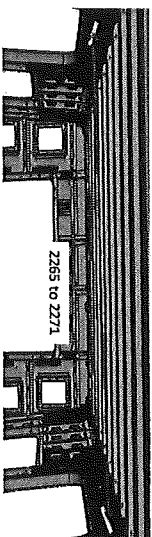
Rev.	Project: PRA5A
31	SI.CB2210.254.V30
Date	
07/11/2023	

GBS measurement

AFTER WELDING



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



Take measurement close to radius ( considering reinforcement)

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

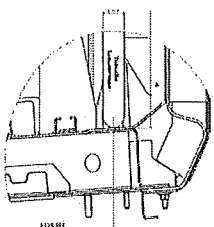
GIBCO  
2024-03-13  
INDUSTRIAL QUALITY  
MAINLINE

2265 to 2271

2265 to 2271

2265 to 2271

2329 REF



Detail: 0

Checklist: 0

18.11.23

2270 to 2276  
2265 to 2271



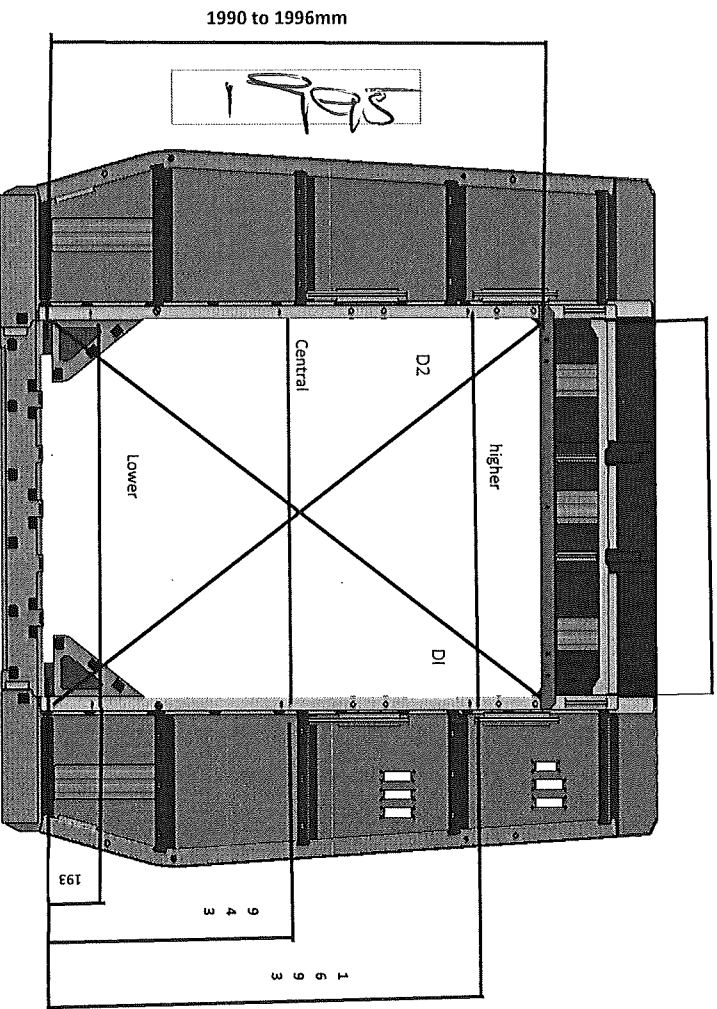


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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Date	
07/11/2023	

Specifications of Details for CBS measurement

End frame 1



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1388

D1

2415

Central Dimension

1381

D2

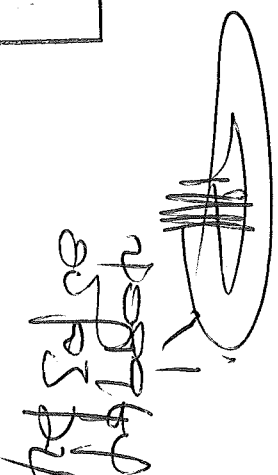
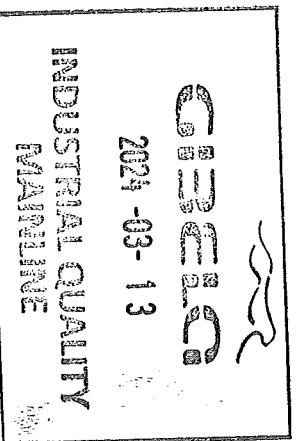
2415

Lower Dimension

1380

D1-D2

0





CARBODYSHELL M3,M4 ASSEMBLY DTR3025487/3

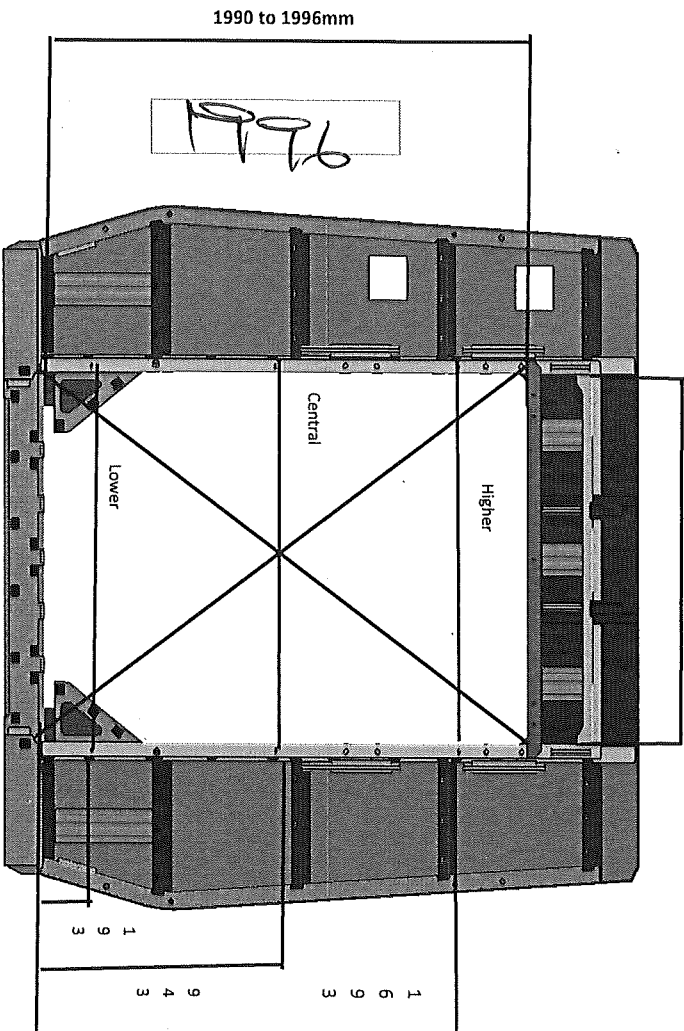
Rev.  
31  
Date  
07/11/2023

Project: PRASA  
SI.CB2210.254.V30

Specifications of Details for CBS measurement

Endframe 2

1380 to 1382 mm



HIGHER Dimension

1381

D1

2416

CENTRAL Dimension

1380

D2

2414

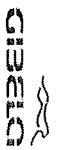
LOWER Dimension

1380

D1-D2

2416

INDUSTRIAL  
MANUFACTURING  
2011-03-13  
2011-03-13  
2011-03-13  
2011-03-13



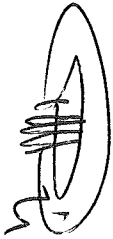
CARBOV-SHELL M3,M4 ASSEMBLY DTR30225487/3

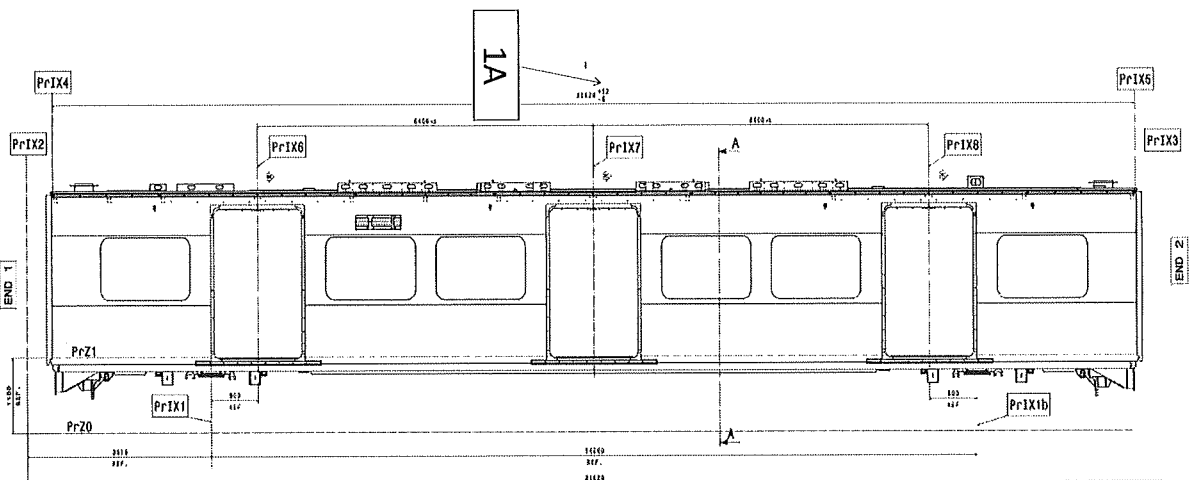
Rev.	31	Project: PRASA
Date	07/11/2023	SI.CB2210.254.V30

Specifications of Details for CBS measurement

LEFT SIDE	
SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614

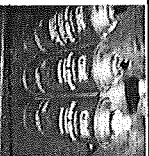
RIGHT SIDE	
SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614

  
4099169  
20703179



Dye penetrant test


Dye penetration test to be performed by quality personnel



2024-03-13

INDUSTRIAL QUALITY  
PAINTLINE



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

Self Inspection - Final Result

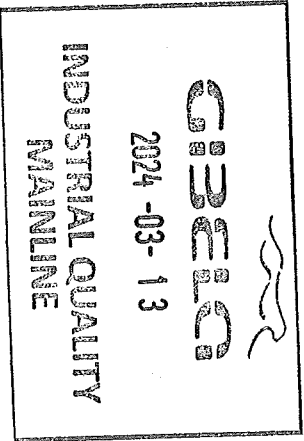
		DATE	NAME	SIGNATURE
(If activities are not complete, the missing activities must not impact the next stage)			Operations	
Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)			Industrial Quality	
There are activities pending that impact/stop the activities of the next process Ole: (To describe problems below)			Operations	
There are non-conformities impact the quality of the product and there is no corrective action defined yet)			Industrial Quality	

In case of "NO GO", describe blocking problems

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

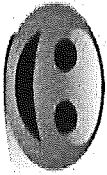
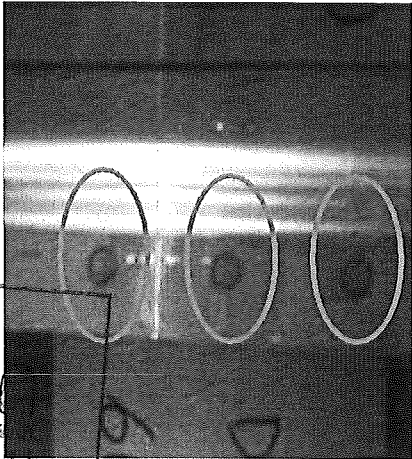
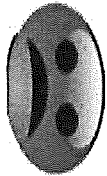
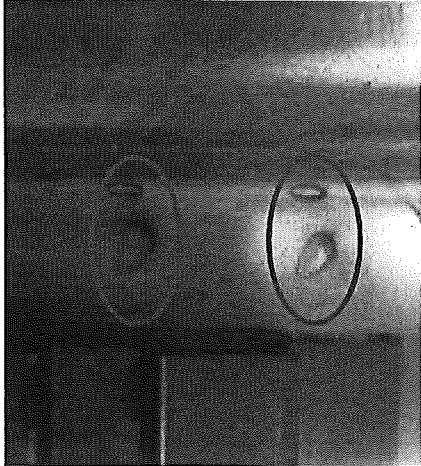
Operations


Quality




	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3		Rev. 31	Project: PRASA SI.CBZ210.254.V30
			Date 07/1/2023	

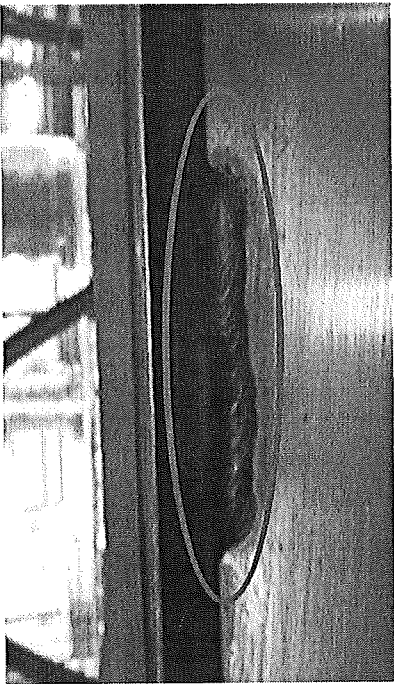
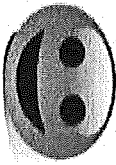
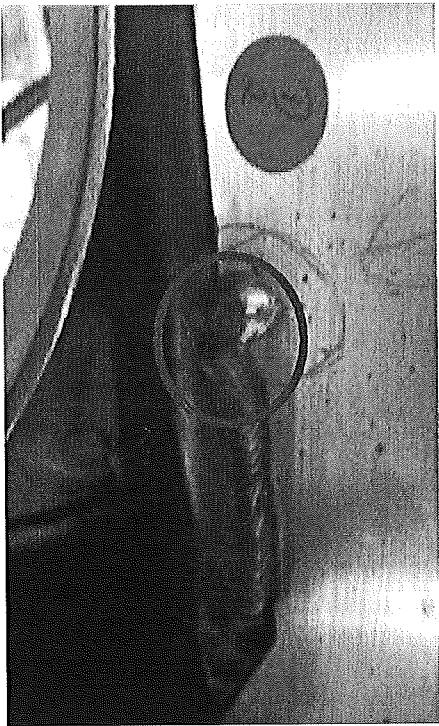
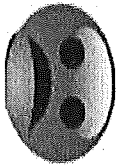
**ANNEXURE A: Spot Welding Quality Acceptance Standard**




  
**INDUSTRIAL QUALITY**  
**MANLINE**  
 2024-03-13

	CARBODYSHELL M3,M4 ASSEMBLY DTR3025487/3		Rev. 31 Date 07/11/2023	Project: PRASA SI.CB2210.254.V30
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**ANNEXURE B: Arc Welding Quality Acceptance Standard**







PRASA PROJECT



APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

CONFIDENTIAL INFORMATION

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APPLICATION REFERENCE										WORK INSTRUCTION	SAFETY
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE				NAME	DATE		
				TG	M1	M2	M3			TG2	
<input type="checkbox"/>	DT0023548/72	CARBODY/SHELL M.L.M.M. ASSEMBLY	CR2210		X	X		X		P04-CB2220.DT0023548 7/2.V21	YES
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
REV	DATE	MODIFICATION CONTENT							RESPONSIBLE		
0	01/02/2018	GIBELA NEW CREATION							APPROVER	Iumeleng Modiba	01/02/2018
									CHECKER	Nosizo Pindela	01/02/2018
									COMPIER	Thangani Mathengu	01/02/2018
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager							APPROVER	Iumeleng Modiba	18/05/2018
									CHECKER	Nosizo Pindela	18/05/2018
									REVISED BY	Ramokone Mcdama	18/05/2018
2	2018/07/05	Certain dimensional checks added and others moved to CB1210							APPROVER	Iumeleng Modiba	2018/07/05
									CHECKER	Nosizo Pindela	2018/07/05
									REVISED BY	Ramokone Mcdama	2018/07/05
3	2018/06/12	Width tolerance as per DT000036600							APPROVER	Iumeleng Modiba	2018/06/12
									CHECKER	Nosizo Pindela	2018/06/12
									REVISED BY	Nosizo Pindela	2018/06/12
5	24/01/2019	As per Baseline 10.2							APPROVER	Iumeleng Modiba	24/01/2019
									CHECKER	Nosizo Pindela	24/01/2019
									REVISED BY	Vanesa Ntuli	2024-08-13
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements							APPROVER	Iumeleng Modiba	13/03/2019
									CHECKER	Nosizo Pindela	13/03/2019
									REVISED BY	Nosizo Pindela	22/08/2019
10	22/08/2019	New Baseline 10.2.5							APPROVER	Iumeleng Modiba	22/08/2019
									CHECKER	Nosizo Pindela	22/08/2019
									REVISED BY	Nosizo Pindela	22/08/2019
15	06/08/2020	New Baseline 10.2.6							APPROVER	Timothy Maimela	06/08/2020
									CHECKER	Bongane Masina	06/08/2020
									REVISED BY	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3							APPROVER	Timothy Maimela	19/04/2021
									CHECKER	Bongane Masina	19/04/2021
									REVISED BY	Bongane Masina	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING							APPROVER	Mkhombi Collins	17/08/2021
									CHECKER	Mpho Mulaudzi	17/08/2021
									REVISED BY	Mpho Mulaudzi	17/08/2021
25	20/02/2022	New Baseline change 10.3.1							APPROVER	Collins Mkhombhi	19/02/2022
									CHECKER	Andani Muthelo	19/02/2022
									REVISED BY	Andani Muthelo	19/02/2022
26	14/06/2022	Update minimum temperature requirement for sealant application							APPROVER	Collins Mkhombhi	14/06/2022
									CHECKER	Andani Muthelo	14/06/2022
									REVISED BY	Andani Muthelo	14/06/2022
27	19/10/2022	Addition of traceability for sealant application & welding							APPROVER	Collins Mkhombhi	19/10/2022
									CHECKER	Nickozo Zwane	19/10/2022
									REVISED BY	Amogelang Mholampe	19/10/2022
28	14/04/2023	Added sealant batch number & welding consumables traceability							APPROVER	Vanesa Ntuli	14/04/2023
									CHECKER	Nickozo Zwane	14/04/2023
									REVISED BY	Amogelang Mholampe	14/04/2023
29	28/10/2023	Addition of bracket quantity							APPROVER	Ngothi Tyson	28/10/2023
									CHECKER	Nickozo Zwane	28/10/2023
									REVISED BY	Amogelang Mholampe	28/10/2023
TRAINSET	CAR	OPERATOR NAME	ALPS NO	DATE	SELF INSPECTION NUMBER				PAGES		
219	M03	Tebele		22/08/24	SI.CB2220.250.V29				13		



PRASA PROJECT

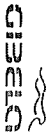



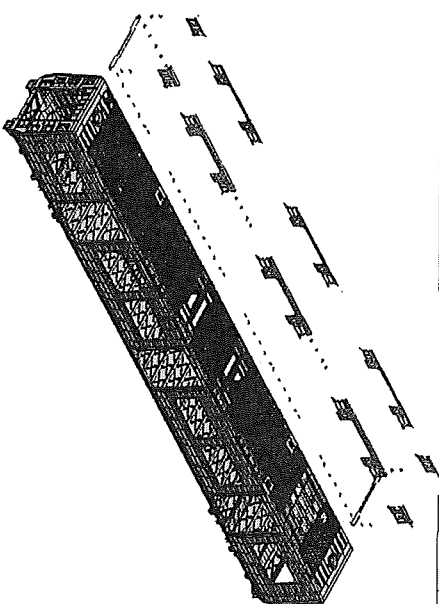
APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET


CONFIDENTIAL INFORMATION

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	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR302254872	Rev.	Project: PRASA	
		29		
		Date	28/07/2023	
		SI.CB2220.250.V29		
Car: M1,M3,M4	NCR:	Work station:	CB2220	
	Safety Reel			





I - Documentation and Instruments Control


Document	Type of car					Revision	Operation	OK	NOK	Signature Date (Manufacturing)	Signature Date (Quality)
	I01	I11	I21	I31	I02						
DTR302254872						29	22/03/24	✓		 22/03/24	

12 - 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)
Tabular	22113	08/08/24	✓		22/05	22/05
Measuring tape	0810051	08/04/24	✓		22/03	22/03

1.3 Consumables

Welding Consumable Control - Used for Special Process						
Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Welding - wire	E23106	MIG	✓		 22/03/24	 22/03/24




**CIBEL**

2024-03-13

**INDUSTRIAL QUALITY**

**MANLINE**

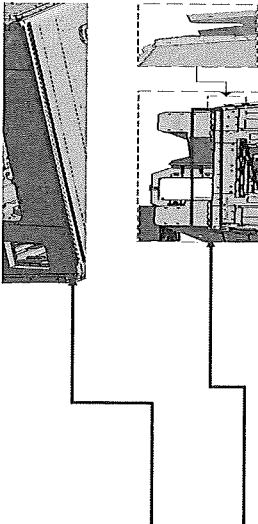
GIBELG		CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2			Rev. 29 Date 28/10/2023		Project: PRASA SI.CB2220.250.V29	
II - Self Inspection - Items to Check								
II.1 - Items to check								
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature (Manufacturing)	Signature Date (Quality)		
01	N/A	Assembly according to Instruction Engineering n° PRA.CB2220.DTR30225487/2 Verification of fltment for all reinforcement brackets.	PRA.CB2220.DTR30225487/2	✓		22/03/24		
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		22/03/24		
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 TO GIB - TYPDEF - ARC - 0000	✓		22/03/24		
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		22/03/24		
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in the document.				22/03/24		
06		Perform visual inspection of welds according to the project. Run by penetrant testing in electric arc welding (weld metal IND-SAL-WMS-018. Run by penetrant test (weld metal) and fillet sampling as described in DTD0000210658.				22/03/24		
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 35% - 65%	Sealant Batch Noted: 22/03/24 Exp Date: 22/03/24 Actuals Temperature: 24 Humidity: 60	✓		22/03/24		
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓		22/03/24		
09		Verification of safety welds	Approved according to DTD0000210658 reference and Self inspection	✓		22/03/24		

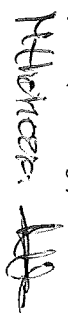
	CARBODYSHELL M1 M3 M4 ASSEMBLY DTR30224487/2		Rev. 29	Project: PRASA
			Date 28/10/2023	SI.CB2220.250.V29


II - Self Inspection - Items to Check

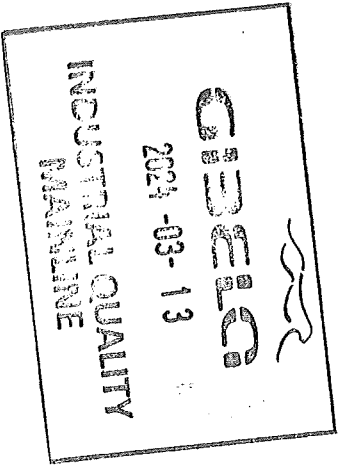
SEALANT APPLICATION

AREA 1 & 2 END 1



Operator (Name & sign):  


Operator (Name & sign):  




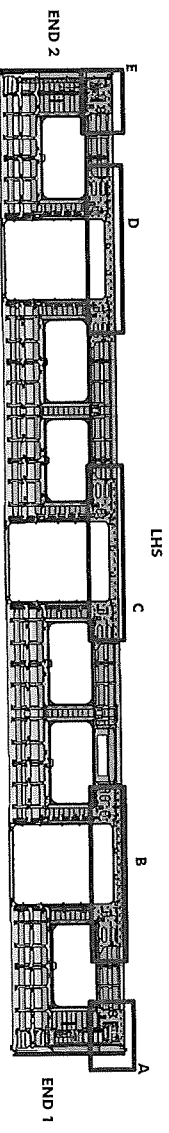
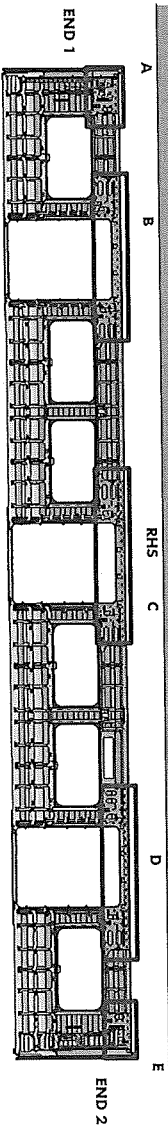


CARBODYSHELL M1 M3 M4 ASSEMBLY  
DTR30224872

Rev.  
29  
Date  
28/10/2023

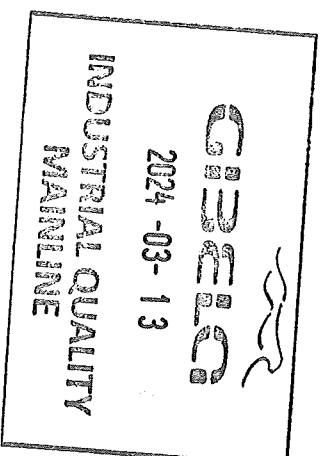
Project: PRASA  
SI.CB2220.250.V29

II - Self Inspection - Items to Check

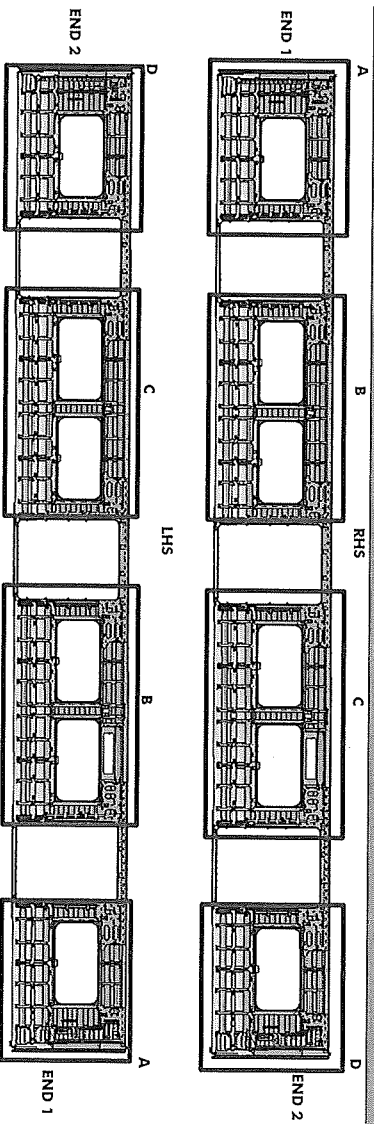


REINFORCEMENT WELDING

AREA	LHS	RHS
A	Operator (Name&sign): <i>[Signature]</i>	<i>[Signature]</i>
B	Operator (Name&sign): <i>[Signature]</i>	<i>[Signature]</i>
C	Operator (Name&sign): <i>[Signature]</i>	<i>[Signature]</i>
D	Operator (Name&sign): <i>[Signature]</i>	<i>[Signature]</i>
E	Operator (Name&sign): <i>[Signature]</i>	<i>[Signature]</i>



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



**BRACKETING**

<b>INSTALLATION</b>	
C-RAILS:	Operator: <u>heui</u> <u>hpb</u>
	Operator: <u>Wkize</u> <u>SPB</u>
DOOR MECHANISMS:	Operator: <u>Wkize</u> <u>SPB</u>
	Operator: <u>Wkize</u> <u>SPB</u>
TAPPING PADS	Operator: <u>Wkize</u> <u>SPB</u>
	Operator: <u>Wkize</u> <u>SPB</u>
<b>INSTALLATION &amp; VERIFICATION</b>	
SEAT & LUGGAGE BRACKETS:	Operator: <u>Wkize</u> <u>SPB</u>
	Operator: <u>Wkize</u> <u>SPB</u>
SEAT BRACKETS VERIFICATION:	Operator: <u>Wkize</u> <u>SPB</u>
	Operator: <u>Wkize</u> <u>SPB</u>

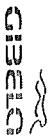
**WELDING**

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

**ENDS**

END 1 TAPPING PADS WELDING	Operator (Name&sign): <u>Wkize</u> <u>SPB</u>
END 2 TAPPING PADS WELDING	Operator (Name&sign): <u>Wkize</u> <u>SPB</u>

**INDUSTRIAL QUALITY**  
**MAINTENANCE**



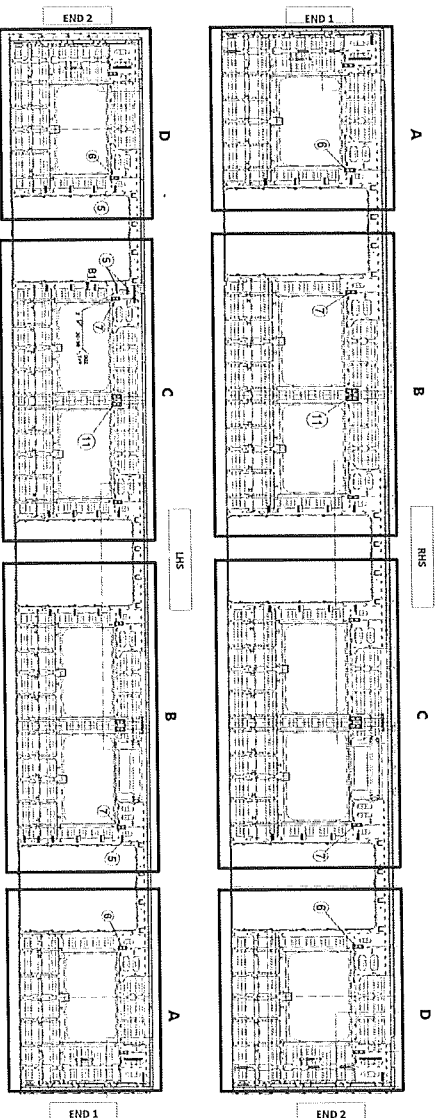
CARBODYSHELL M1/M3/M4 ASSEMBLY  
DTR302294872

Rev. 29  
Date 28/10/2023  
Project: PRASA

SI.CB2220.250.V29

II - Self Inspection - Items to Check

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

RHS

SECTION	QUANTITY	OK	NOK
A	7	✓	
B	4	✓	
C	8	✓	
D	8	✓	
A	13	✓	
B	13	✓	
C	21	✓	
D	13	✓	
A	3	✓	
B	5	✓	
C	4	✓	
D	3	✓	

ROOF ENDS:

CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: Tefel

LHS

SECTION	QUANTITY	OK	NOK
A	2	✓	
B	8	✓	
C	11	✓	
D	6	✓	
A	13	✓	
B	21	✓	
C	21	✓	
D	13	✓	
A	3	✓	
B	5	✓	
C	6	✓	
D	2	✓	

ROOF ENDS:

CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: Tefel

QUANTITIES (M1)

RHS

SECTION	QUANTITY	OK	NOK
A	7		
B	8		
C	8		
D	8		
A	13		
B	21		
C	21		
D	13		
A	2		
B	4		
C	5		
D	3		

ROOF ENDS:

CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: \_\_\_\_\_

LHS

SECTION	QUANTITY	OK	NOK
A	2		
B	10		
C	11		
D	6		
A	13		
B	21		
C	21		
D	13		
A	3		
B	7		
C	6		
D	2		

ROOF ENDS:


CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END



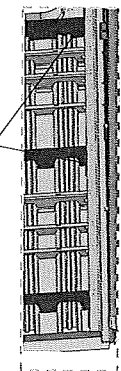
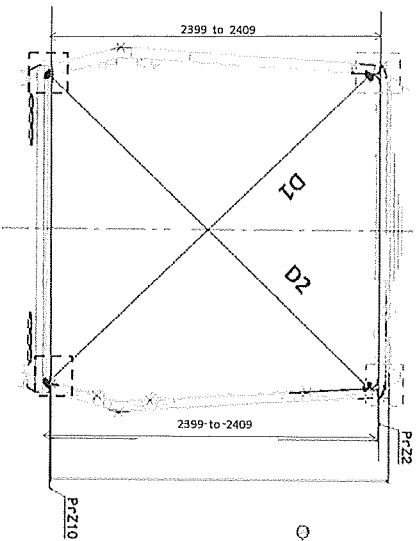
2024-03-13

INDUSTRIAL QUALITY  
WARRANTY

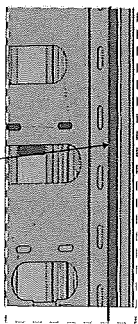


 <b>GIBELCO</b>	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2		Rev.	Project: PRASA
			29	
			Date	
			28/10/2023	
			S1.CB2220.250.V29	

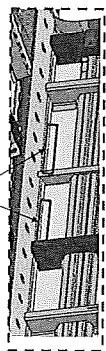
Specifications of Details for GBS measurement



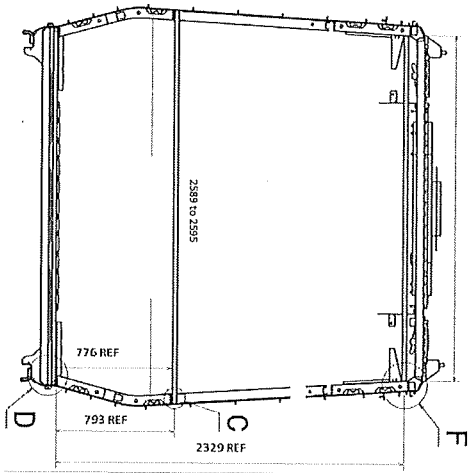
Measurement positions on roof rail and sidewall (omega corner).




Reinforcement area measurement positions on roof reinforcement area.

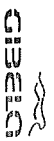


Measurement positions on sidewall and side sill corner.





**GIBELCO**  
2024-03-13  
INDUSTRIAL QUALITY  
PAANLINE



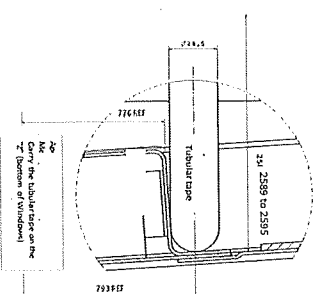
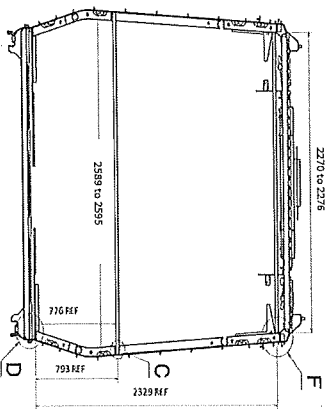
CARBODYSHELL M1 M3 M4 ASSEMBLY  
DTR302254871Z

Rev.  
29  
Date  
28/10/2023

Project: PRASA

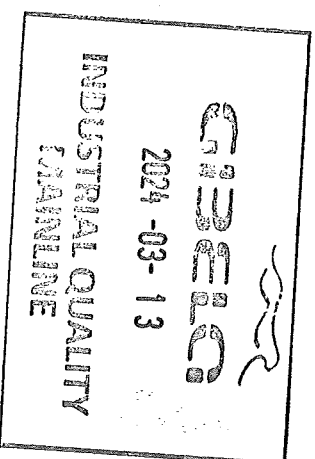
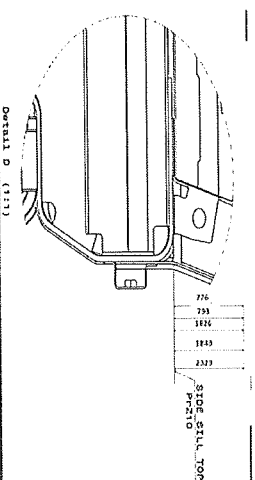
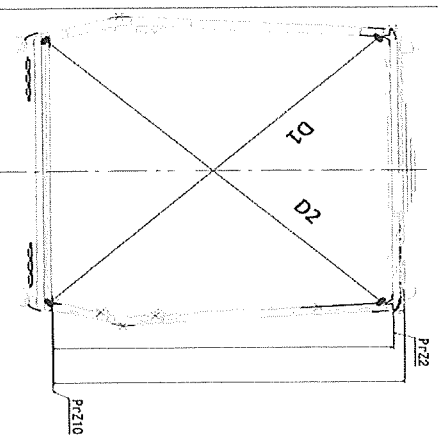
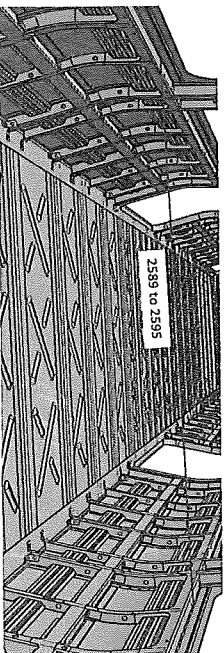
SI.CB2220.250.V29


GBS measurement

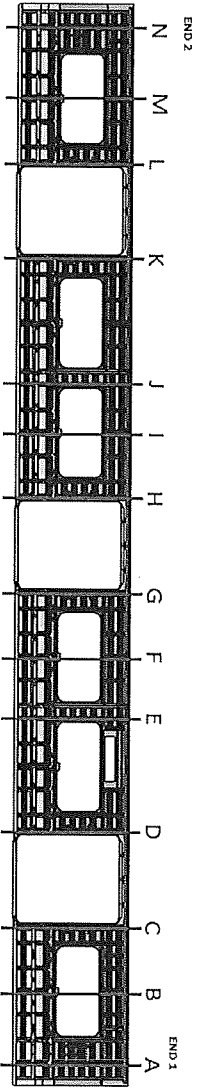


Detail C

Take measurement close to  
radius




 GIBELCO	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2			Rev.	Project: PRASA
				29	
				Date	
				28/10/2023	
				SI.CB2220.250.V29	
G35 measurement					



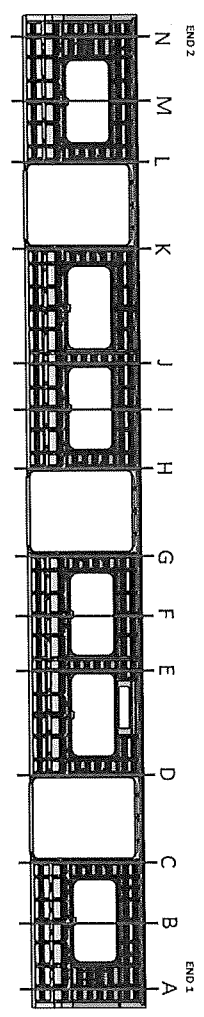
BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3308	3298	2	—
B	3268	3266	2	—
C	3297	3299	2	—
D	3298	3299	1	—
E	3265	3268	3	—
F	3268	3266	2	—
G	3299	3296	3	—
H	3296	3299	3	—
I	3265	3268	3	—
J	3267	3265	2	—
K	3295	3297	2	—
L	3299	3300	1	—
M	3268	3265	3	—
N	3299	3300	1	—




**GIBELCO**  
 2024-03-13  
 INDUSTRIAL QUALITY  
 MANLINE

CBS measurement

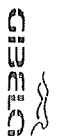


AFTER WELDING

Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A 3300	3299	1	2594
B 3267	3267	0	2589
C 3300	3300	0	2593
D 3299	3300	1	2589
E 3267	3265	2	2592
F 3268	3265	3	2591
G 3297	3299	2	2593
H 3298	3296	2	2591
I 3268	3269	1	2593
J 3268	3269	1	2591
K 3300	3299	1	2592
L 3297	3299	2	2591
M 3269	3267	2	2590
N 3300	3299	1	2594



2024-03-13  
 INDUSTRIAL QUALITY  
 MAINLINE

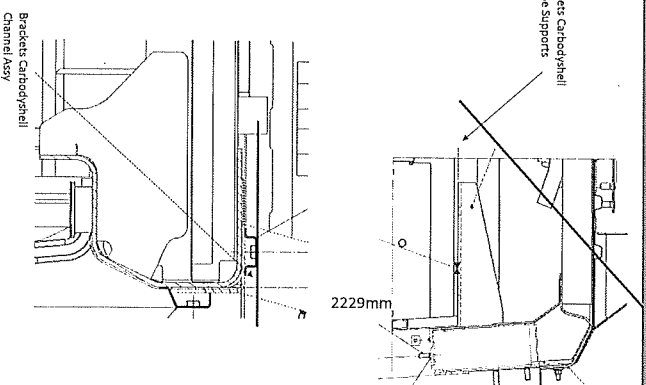
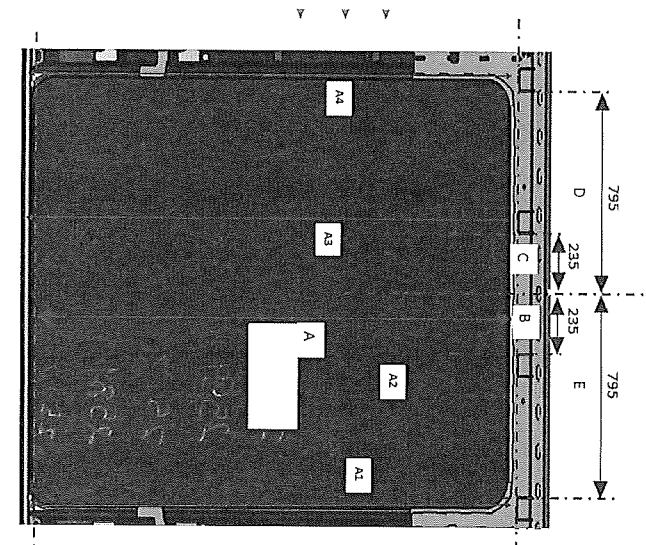


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2

Rev.  
29  
Date  
28/10/2023

Project: PRASA  
SI,CB2220.250.V29

Specifications of Details for CBS measurement GB1220



DOOR 1 - LHS

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

DOOR 2 - LHS

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

DOOR 2 - RHS

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

DOOR 1 - RHS

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

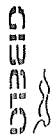
DOOR 2 - RHS

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

DOOR 3 - RHS

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

CIBELD  
2024-03-13  
INDUSTRIAL QUALITY  
MANUAL



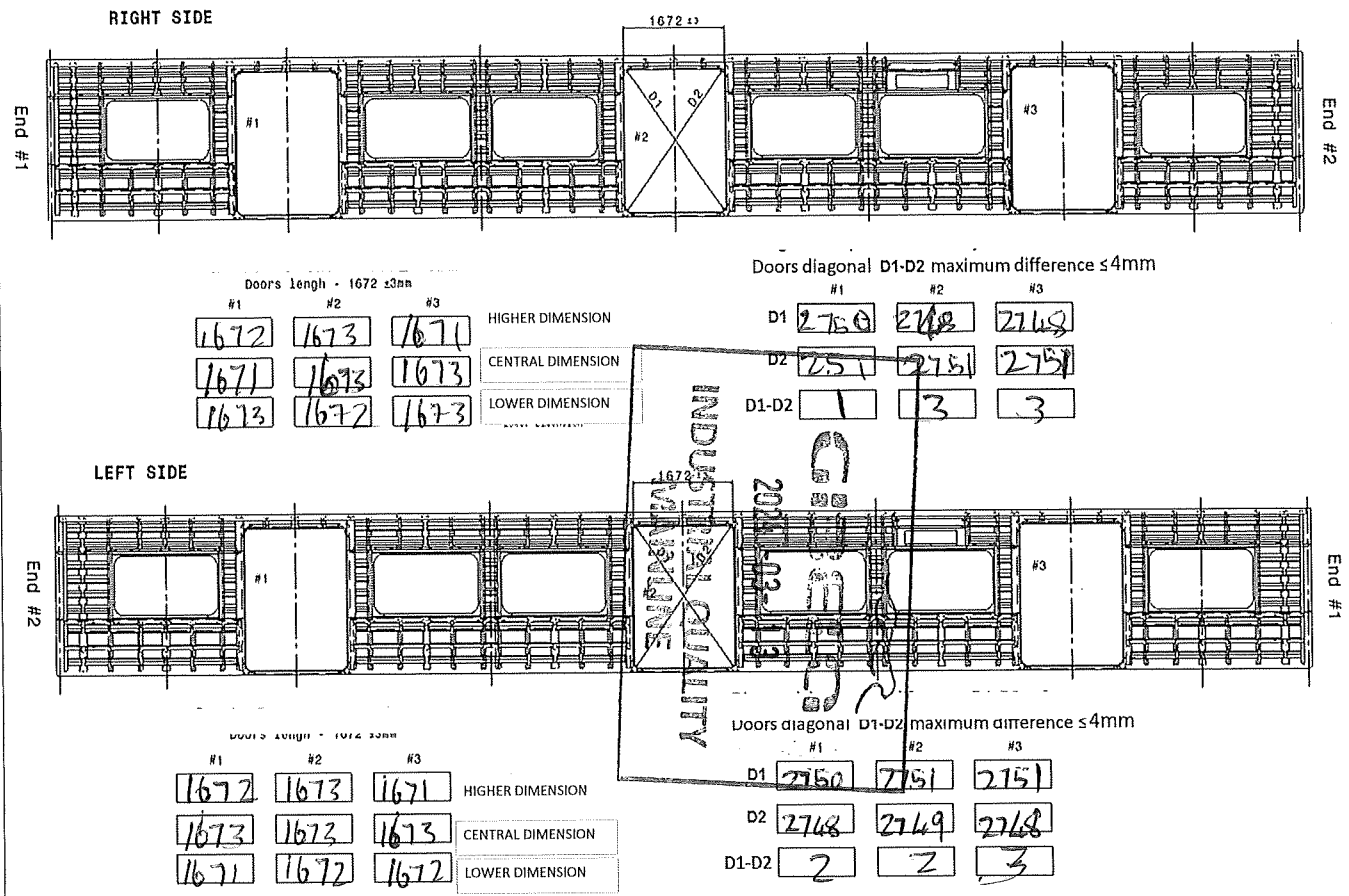
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DIR3025487/2


Rev.  
29  
Date  
28/10/2023

Project: PRASA

S1.CB2220.250.V29

Specifications of Details for CBS measurement CB1220



	CARBODYSHELL M1,M3,M4 ASSEMBLY		Rev.	Project: PRASA
	DTR3022548712		29	
		Date		
		28/10/2023		SI.CB2220.250.V29


**CBS measurement (Manufacturing)**

## Dye penetrant test



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

[illegible]

INDUSTRIAL QUALITY  
WARRANTY  
2024-03-13  
CUBECUB

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR3022548712	Rev.	Project: PRASA	
		29		
		Date	28/10/2023	
		SI.CB2220.250.V29		

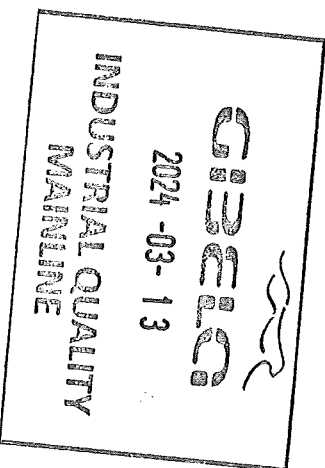
Self Inspection - Final Result

Is the car good to advance to the next workstation/process? (Approval of Operations Manager and Industrial Quality)		DATE	NAME	SIGNATURE
HOLD POINT	GO	22/03/24	Tetele Operations	
	NO GO	22/03/24	Andoni Industrial Quality	
(If activities are not complete, the missing activities must not impact the next stage)  Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party)  There are activities pending that impact the capabilities of the next process Obs: (To describe problems below)  There are non-conformities impact the quality of the product and there is no corrective action defined yet)			Operations	
In case of "NO GO", describe blocking problems			Industrial Quality	


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

  
Operations

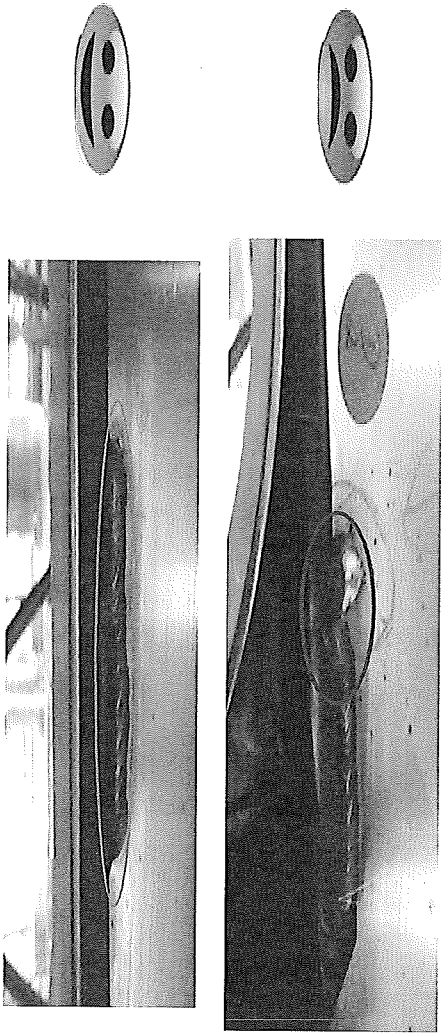
\_\_\_\_\_  
Quality





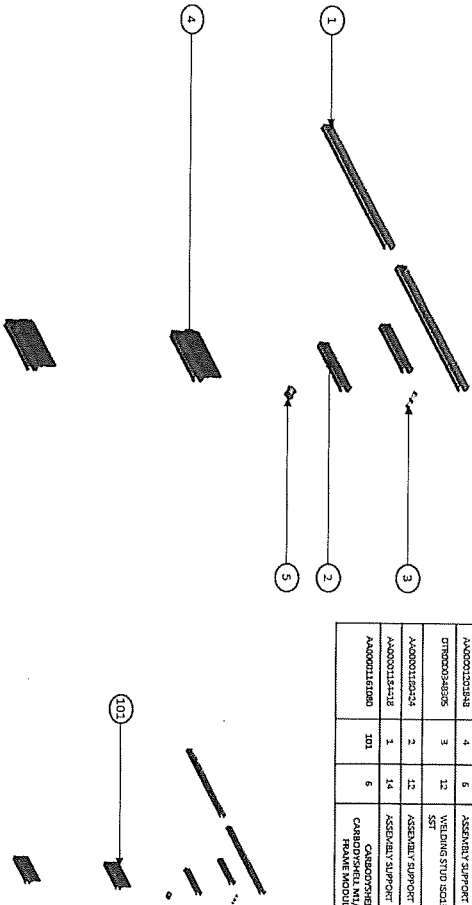
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2		Rev.	Project: PRASA
			29 Date 28/10/2023	SI,CB2220.250.V29


ANNEXURE A: Arc Welding Quality Acceptance Standard




Station: CB1220-004- U108 & U107

PART NO.	ITEM NO.	QTY	DESCRIPTION	MASS (KG)
DTR020074028	5	6	EMPTY STUD 6	0.028
AA00001253848	4	6	ASSEMBLY SUPPORT	0.271
DTR000348305	3	12	WELDING STUD 8013814 PT - M5X20 - SST	0.007
AA00001160124	2	12	ASSEMBLY SUPPORT	0.193
AA00001154918	1	14	ASSEMBLY SUPPORT	0.552
AA00001161080	101	6	CARBODYSHELL BRACKETS CARBODYSHELL END - OPN FRAME MODULE END - OPN	12.112





PRASA PROJECT




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 ?		
				TG	M1	M2	M3	TG				
<input type="checkbox"/>	DT00000256487	AAD0001278566	CARBOD/SHELL M1, M3, M4 ASSEMBLY						PR1.CB2230.DT000002 25487.V20	YES		
<input type="checkbox"/>				X	X		X					
<input type="checkbox"/>												
RI	DATE	MODIFICATION CONTENT							RESPONSIBLE	NAME	DATE	
0	2018/08/02	GIBELA NEW CREATION							APPROVER	Philippe Marques	2018/08/02	
									CHECKER	Nosizo Pindela	2018/08/02	
									COMPLIER	Nosizo Pindela	2018/08/02	
									APPROVER	Itumeleng Modiba	30/5/2018	
									CHECKER	Nosizo Pindela	30/5/2018	
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager							REVISED BY	Nosizo Pindela	30/5/2018	
									APPROVER	Itumeleng Modiba	2018/05/07	
2	2018/05/07	Certain dimensional checks moved to CB1220							CHECKER	Nosizo Pindela	2018/05/07	
									REVISED BY	Ramokone Motama	2018/05/07	
5	24/01/2019	As per Baseline 10.2							APPROVER	Itumeleng Modiba	24/01/2019	
									CHECKER	Nosizo Pindela	24/01/2019	
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements							APPROVER	Itumeleng Modiba	13/03/2019	
									CHECKER	Nosizo Pindela	13/03/2019	
10	23/08/2019	New Baseline 10.2.5							APPROVER	Itumeleng Modiba	23/08/2019	
									CHECKER	Nosizo Pindela	23/08/2019	
15	06/08/2020	New Baseline 10.2.6							APPROVER	Timothy Maimela	06/08/2020	
									CHECKER	Bongane Masina	06/08/2020	
20	19/04/2021	New Baseline change 10.3							APPROVER	Bongane Masina	19/04/2021	
									CHECKER	Timothy Maimela	19/04/2021	
25	20/02/2022	New Baseline change 10.3.1							APPROVER	Collins Mhlonbhi	20/02/2022	
									CHECKER	Andani Muthelo	20/02/2022	
26	14/06/2022	Update minimum temperature requirement for sealant application							APPROVER	Andani Muthelo	14/06/2022	
									CHECKER	Collins Mhlonbhi	14/06/2022	
27	26/07/2022	Threshold measurements addition							APPROVER	Andani Muthelo	26/07/2022	
									CHECKER	Andani Muthelo	26/07/2022	
28	17/10/2022	Added traceability of sealant application							APPROVER	Collins Mhlonbhi	17/10/2022	
									CHECKER	Ntokozo Zwane	17/10/2022	
29	14/04/2023	Added sealant batch number & welding consumables traceability							APPROVER	Amogelang Mohlamepe	14/04/2023	
									CHECKER	Ntokozo Zwane	14/04/2023	
30	06/11/2023	Added threshold traceability for boiler makers and welders							APPROVER	Ngobeni Tyson	06/11/2023	
									CHECKER	Andani Muthelo	06/11/2023	
TRAINSET	CAR	OPERATOR NAME, ALPS NO	DATE	SELF INSPECTION NUMBER					PAGES			
219	M03	Amogelang P20 #83004	18/10/2024	SI.CB2230.256.V29					12			



INDUSTRIAL QUALITY  
MAINTENANCE

2024-03-13



CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

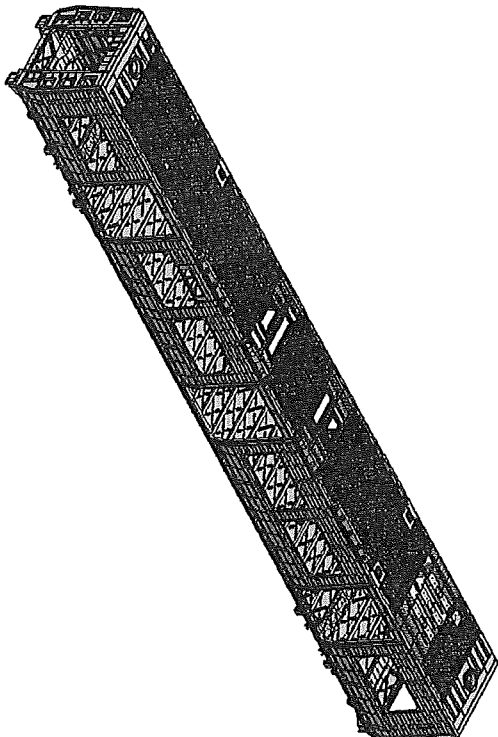
Rev. 30  
Date 06/11/2023  
Project: PRASA  
SI.CB2230.256.V29

Car: NCR:

Work station: CB2230



Safety Related



## I - Documentation and Instruments Control

### 1.1 - Documentation Control

Document	Type of car				Revision	Observation	OK	NOK	Revok	Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4							
PRA.CB2230.DT00000225487					30		✓		N/A	23/03/24	23/03/24

### 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 (Operations)	Signature/Date (Quality)
Tubular	12066-2	2025/02/19		✓	23/03/24	23/03/24
Measuring Tape	907170396	2024/06/05		✓	23/03/24	23/03/24
Combination square	9059 0079	2025/02/13		✓	23/03/24	23/03/24

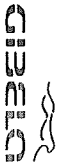
### 1.3 Consumables

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

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308LSi	231007	M19		✓	23/03/24	23/03/24

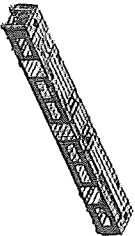
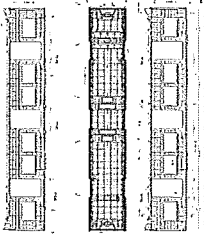
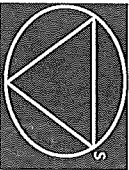
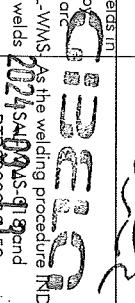
INDUSTRIAL QUALITY  
MAINLINE

2024-03-13

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

## II - Self Inspection - Items to Check

### II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NCH	Repair	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1 230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1 230 DT00000225487	✓			23/03/24 [Signature]	23/03/24 [Signature]
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD00000210675	✓			23/03/24 [Signature]	23/03/24 [Signature]
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPEDEF - ARC - 0000	✓			23/03/24 [Signature]	23/03/24 [Signature]
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓			23/03/24 [Signature]	23/03/24 [Signature]
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			23/03/24 [Signature]	23/03/24 [Signature]
06		Perform VISUAL inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) of IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and filler sampling as described in DTD00000810658.	 As the welding procedure IND-018. 20240925-912 and DTD0000210658. <b>INDUSTRIAL QUALITY</b> <b>MAINTENANCE</b>	✓			23/03/24 [Signature]	23/03/24 [Signature]
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:	Sealant Batch No: 20464257 Exp Date: 23/03/24 Actuals Temperature: 17°C Humidity: 75%	✓			23/03/24 [Signature]	23/03/24 [Signature]
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) <b>Refer to Annexure B</b>	✓			23/03/24 [Signature]	23/03/24 [Signature]
09	N/A	Verification of sealant application in certain regions in the drawing.	AADD0001278566	✓			23/03/24 [Signature]	23/03/24 [Signature]



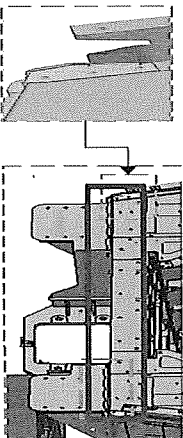
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.	30
Date	06/11/2023

Project: PRASA  
SI.CB2230.256.V29

II - Self Inspection - Items to Check

AREA 1



OPERATOR  
(Name & sign):

*Levy* *[Signature]*

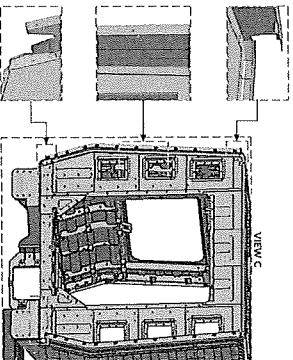
OPERATOR  
(Name & sign):

*Levy* *[Signature]*

OPERATOR  
(Name & sign):

*Levy* *[Signature]*

AREA 2 (VIEW C)



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

Operator (Name & sign):

*[Signature]* *[Signature]*

Operator (Name & sign):

*[Signature]* *[Signature]*

Operator (Name & sign):

*[Signature]* *[Signature]*

Operator (Name & sign):

*[Signature]* *[Signature]*

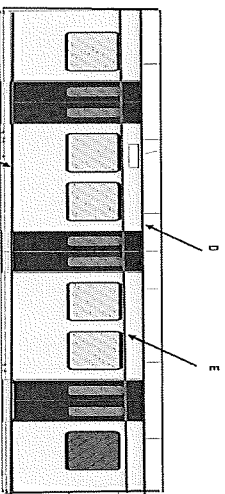
Operator (Name & sign):

*[Signature]* *[Signature]*

Operator (Name & sign):

*[Signature]* *[Signature]*

H

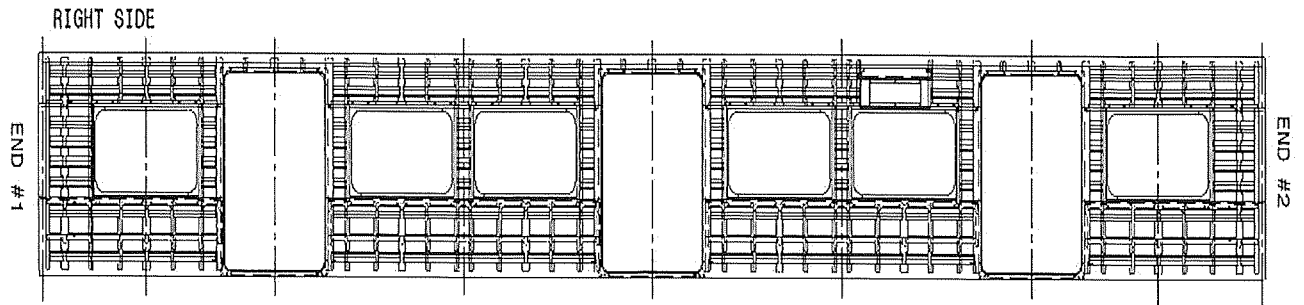


2024-03-13

INDUSTRIAL QUALITY  
MAINTENANCE

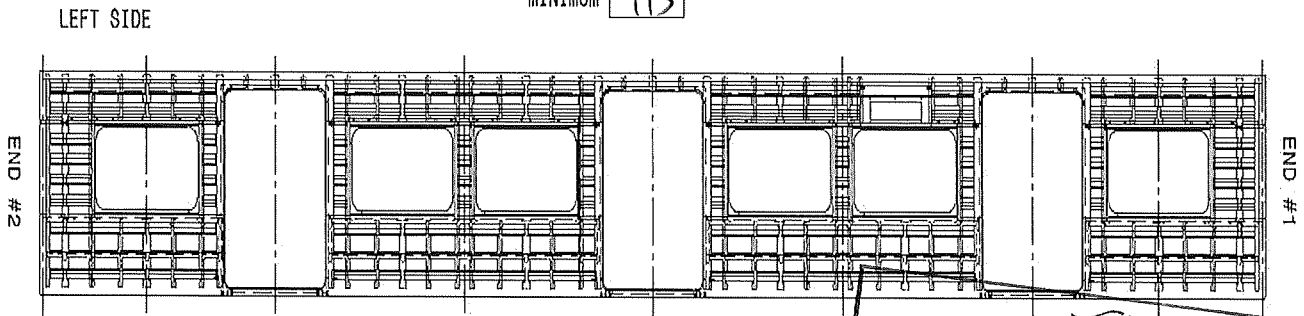
Specifications of Details for CBS measurement CB1230

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.



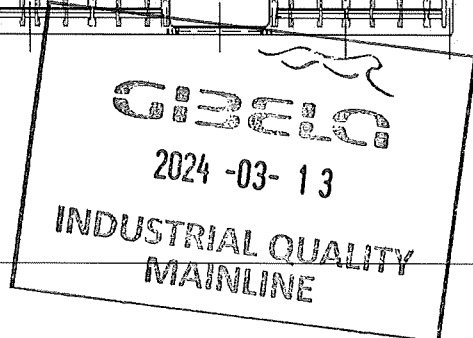
MAXIMUM 1.6

MINIMUM 1.3



MAXIMUM 1.7

MINIMUM 1.2





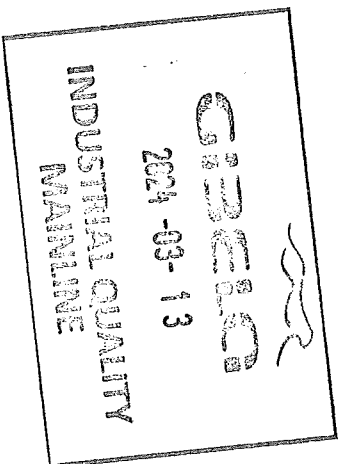
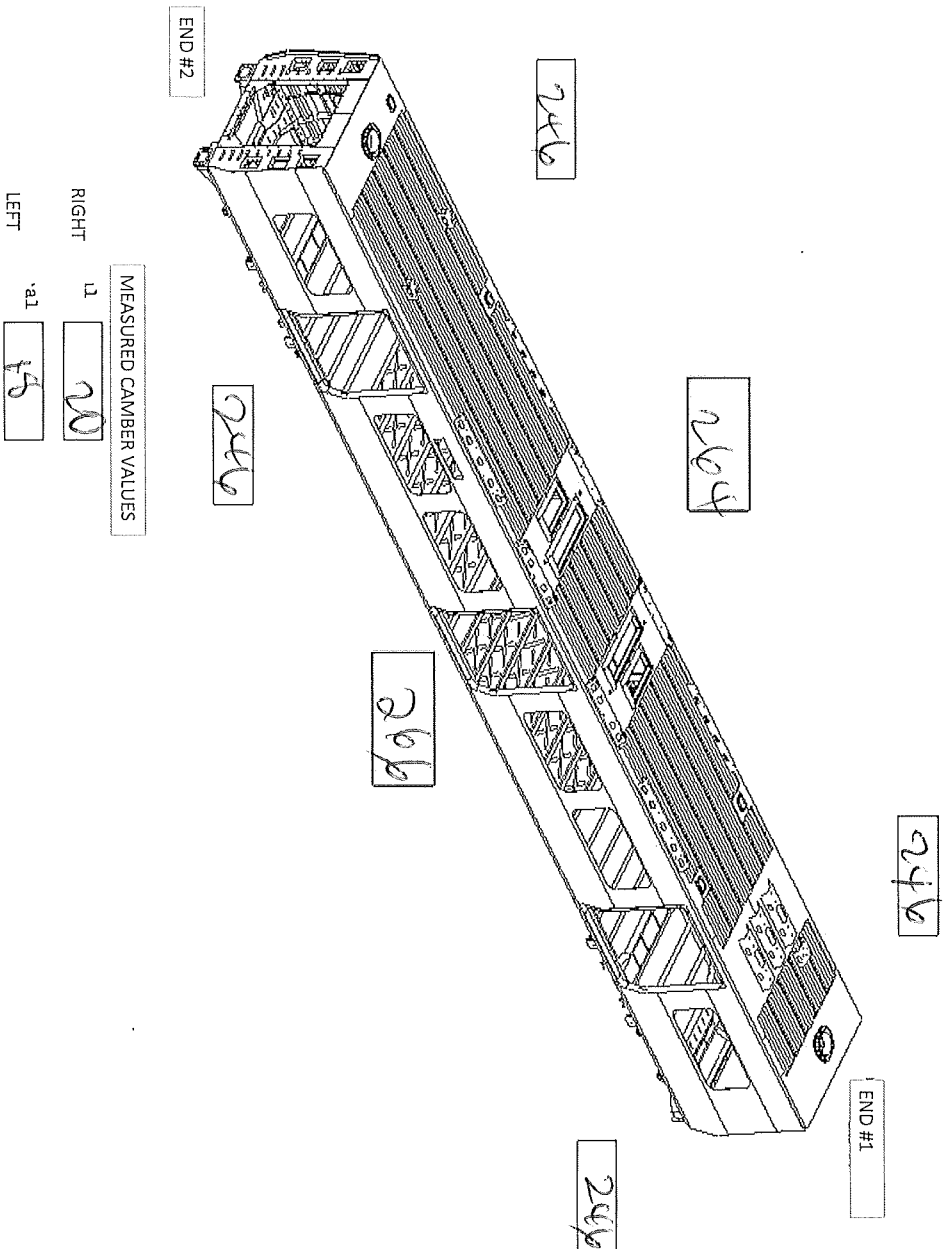
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.
30
Date
06/11/2023

Project: PRASA  
SI.CB2230.256.V29

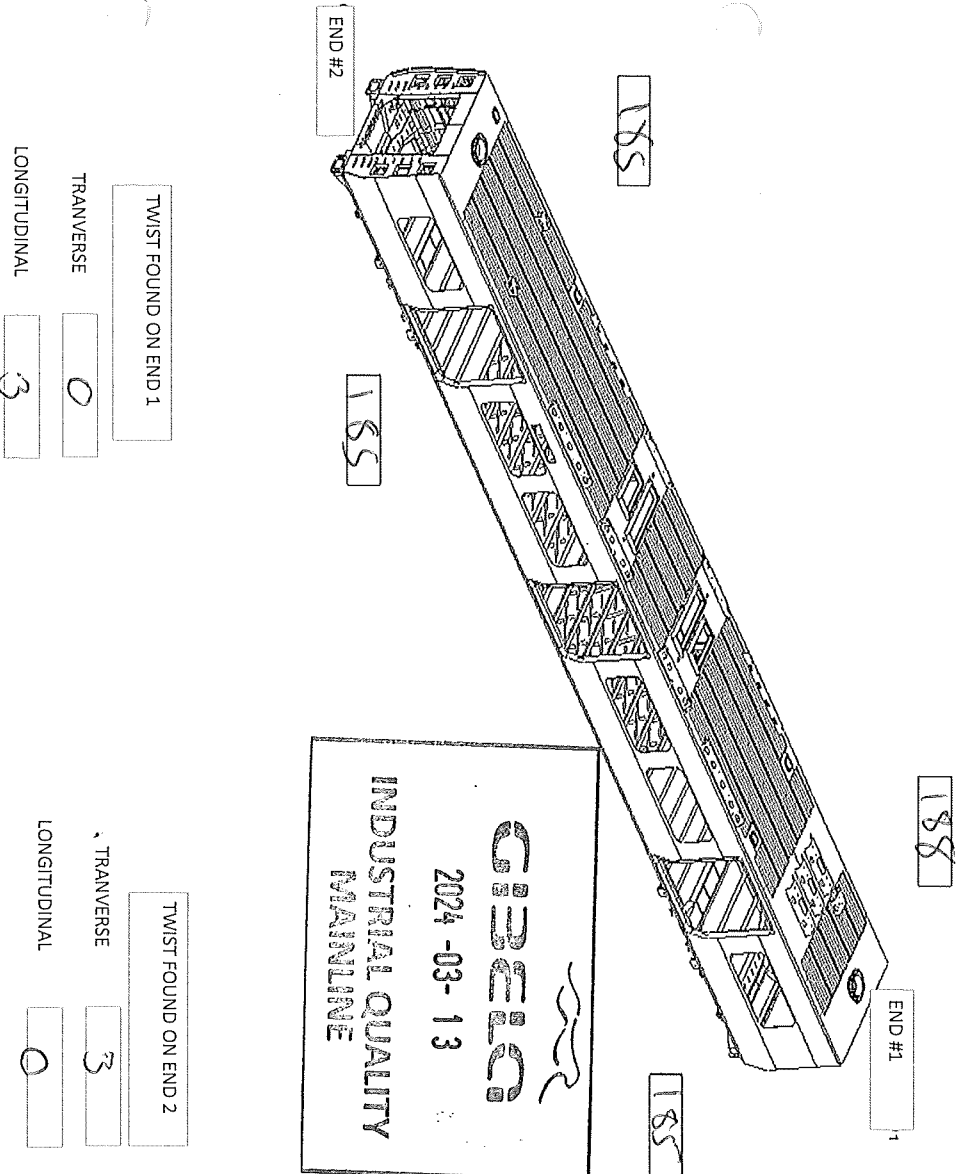
Specifications of Details for GBS measurement GB1230

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



## 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.





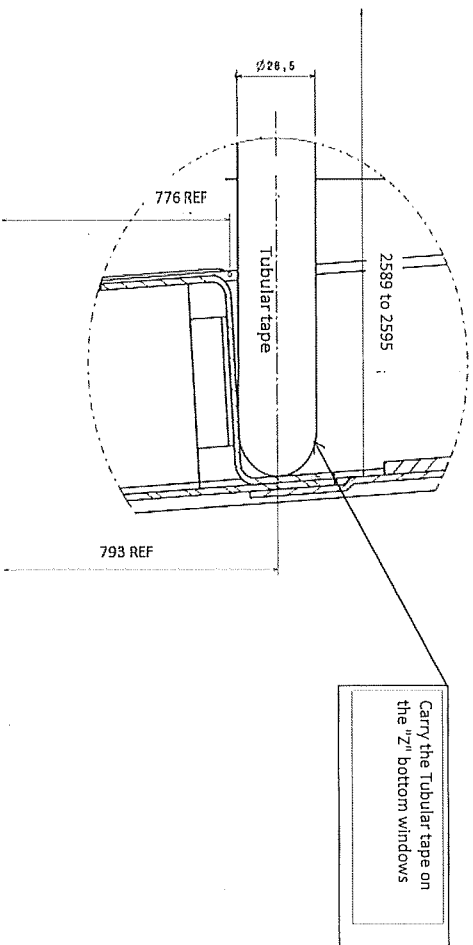


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

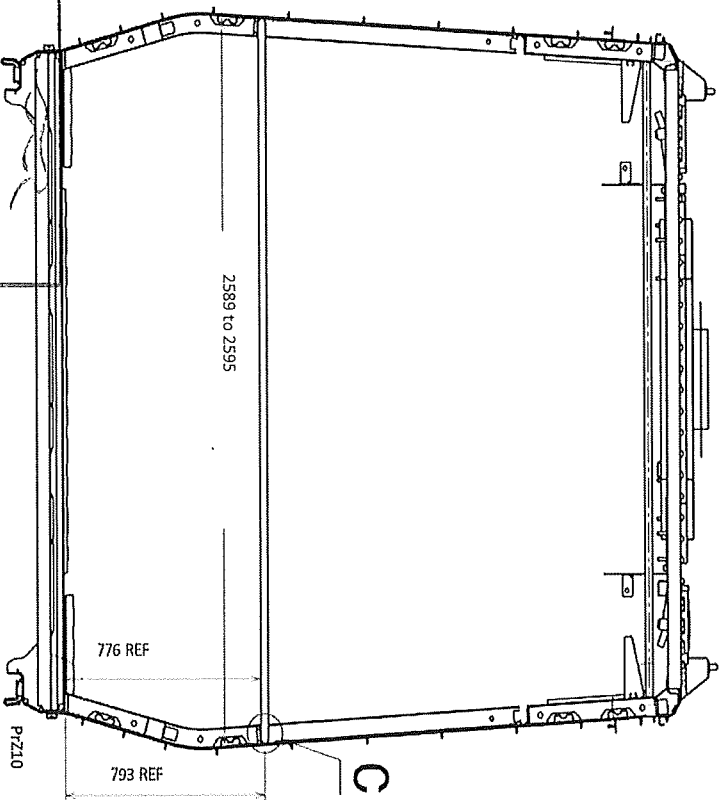
Rev.	Date
30	06/11/2023

Project: PRASA  
SI.CB2230.256.V29

Specifications of Details for GBS measurement GB1230



Detail C



GIBCO

2024-03-13

INDUSTRIAL QUALITY  
MARLINE

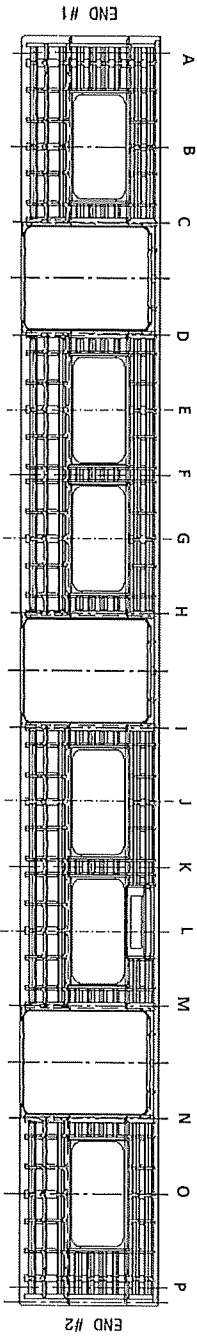


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.  
30  
Date  
06/11/2023

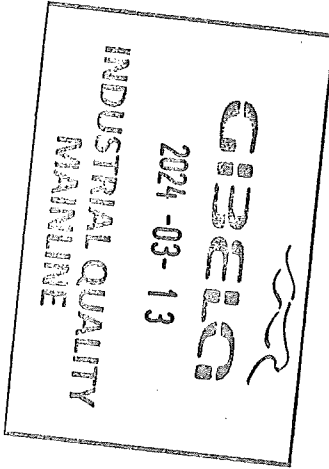
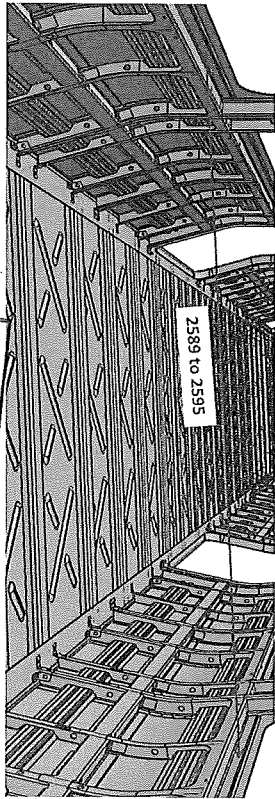
Project: PRASA  
SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	2595
B	25 85
C	25 93
D	25 95
E	25 96
F	25 96
G	25 96
H	25 93
I	25 96
J	25 90
K	25 96
L	25 96
M	25 93
N	25 99
O	25 93
P	25 95



Threshold verification

Nominal value :38

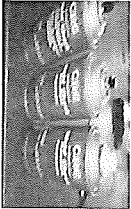
Door 1		Door 2		Door 3	
L	R	L	R	L	R
38	38	37	38	38	38
Door 4		Door 5		Door 6	
L	R	L	R	L	R
38	39	39	38	38	37

BOILER MAKER: mmathapeto thaga.


WELDER: Zante Any

Dye penetrant test

Dye-penetration test to be performed by quality personnel





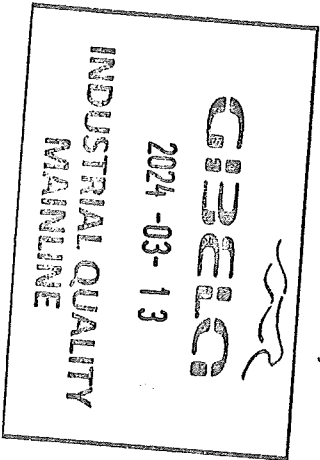
	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30	Project: PRASA  SI.CB2230.256.V29
		Date 06/11/2023	

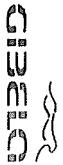
Self Inspection - Final Result

Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)		DATE	NAME	SIGNATURE
HOLD POINT	GO	23/03/24	matthias pad Operations	W. G. G. Industrial Quality
	NO GO		N. Holan 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

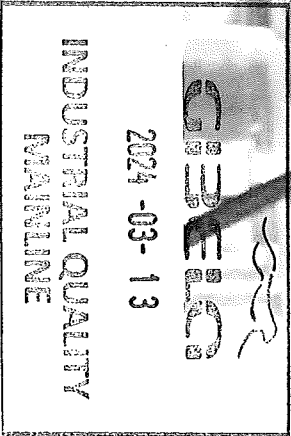
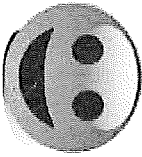
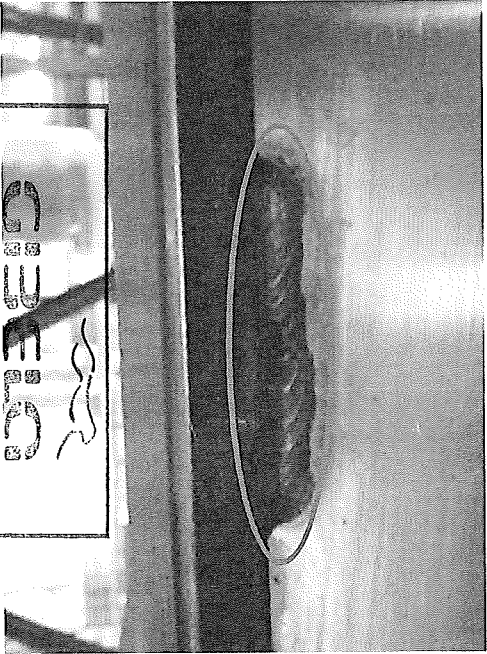
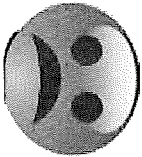
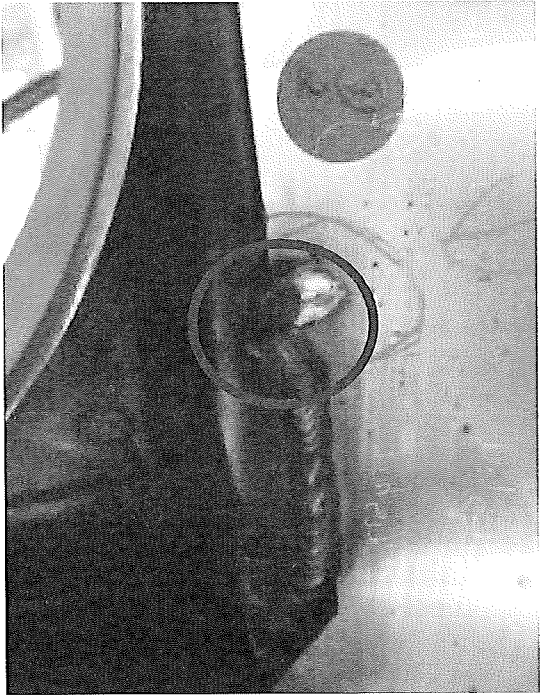
Operations


Quality



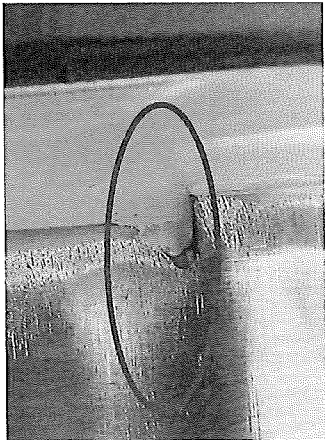
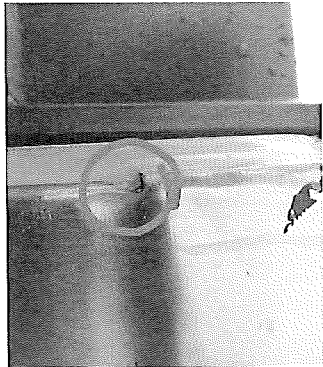
		CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487		Rev. 30	Project: PRASA
				Date 06/11/2023	SI.CB2230.256.V29


ANNEXURE A: Arc Welding Quality Acceptance Standard



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

ANNEXURE B: Sealant





GIBCO

2024 -03- 13

INDUSTRIAL QUALITY  
MAINTENANCE