

CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 4 4 5 _

WEIGHT: 1 5 0 0 Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	09/02/24	178247 104825 01	LP-49402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	4/02/24	178820 104640 01	F205272	
RCS 355	3 mm					
RCS 355	3 mm					

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


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

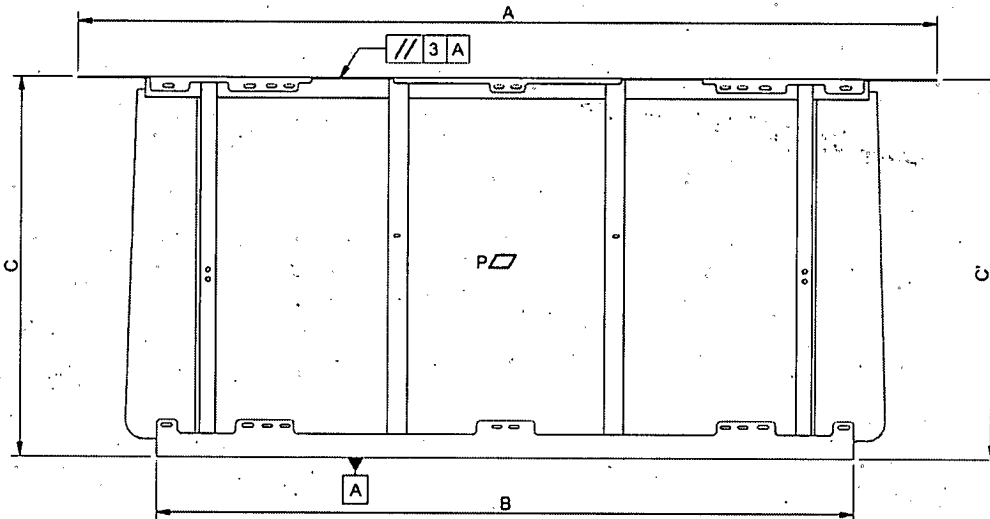
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	08/02/24	178489 104640 01	VHL 35578	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

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


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	22/11/23	175969 102200 01	FV07906 VHS58432	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

Cabin Roof Assembly: GN002839


Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DYLAN DAVIDS	Assembly Date:	2024 02/21			
Sign:		Wire Batch No.:	107238201			




Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
QC Inspector:	Budley	Sign:		Date:	2024 02/21	

Dimensional Control

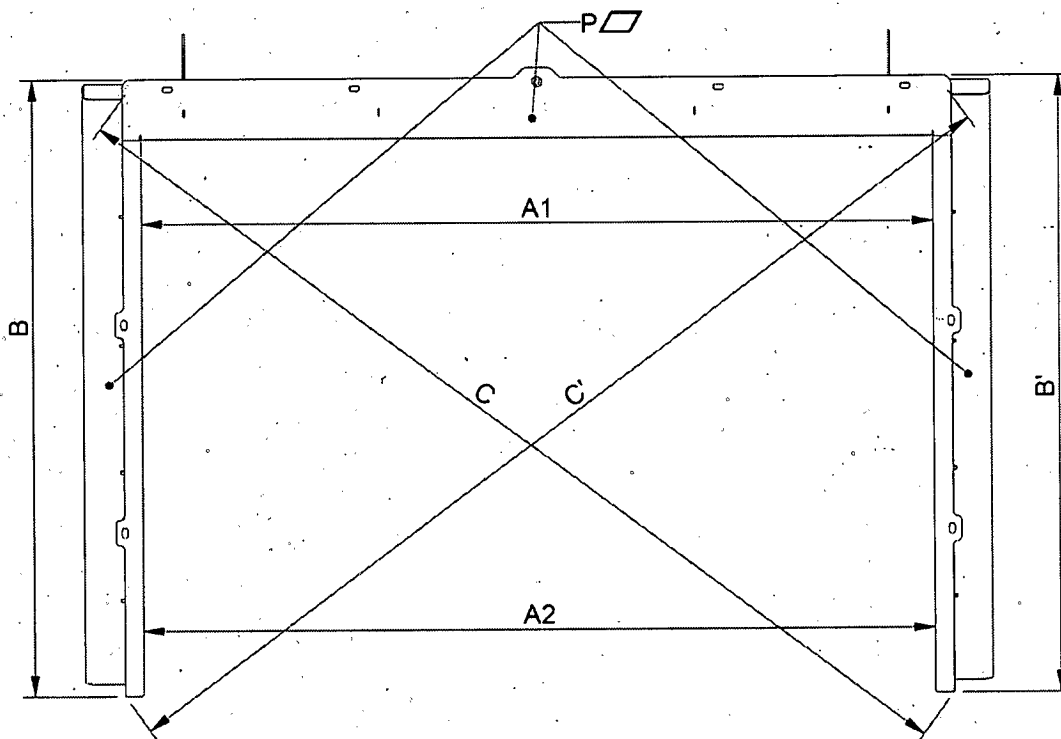
Rep		Toler.	Dimension measured	Measuring Equipment	Observations	
A	2216	+5/-0	2212	Tape Measure	Acceptable	
B	1800	± 4	1801			
C	976	+2/-3	977		Acceptable	
QC Inspector:	Budley	Sign:		Date:	2024 02/21	

Geometrical Control

Nature of Checks		Dimension Measured	Measuring Equipment	Observations		
Planeity P	6 mm	Passed	Ruler	Acceptable		
//	3	Passed	Set Square	Acceptable		
QC Inspector:	Budley	Sign:		Date:	2024 02/21	

Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	Bambelo G. Cuñan.	Assembly Date:	2024/02/21	
Sign:	<i>[Signature]</i>	Wire Batch No.:	22021 S2	



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input type="checkbox"/> No
QC Inspector:	<i>Budley</i>	Sign:	<i>[Signature]</i>	Date: 2024/02/21

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	1910	± 2	1910		Tape Measure	Acceptable	
A2	1910		1910			Acceptable	
B	1475	± 1	1475	1475		Acceptable	
C	Diagonals C - C' ≤ 3		2475	2477		Acceptable	
QC Inspector:		Buckley		Sign:	Res	Date:	2024/02/21

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P: Planarity	4 mm	<i>[Signature]</i>	Ruler
QC Inspector:	<i>Budley</i>	Sign:	<i>[Signature]</i>
Date:	2024/02/21		

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

Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Xander</i>	Assembly Date:	2024/02/13			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

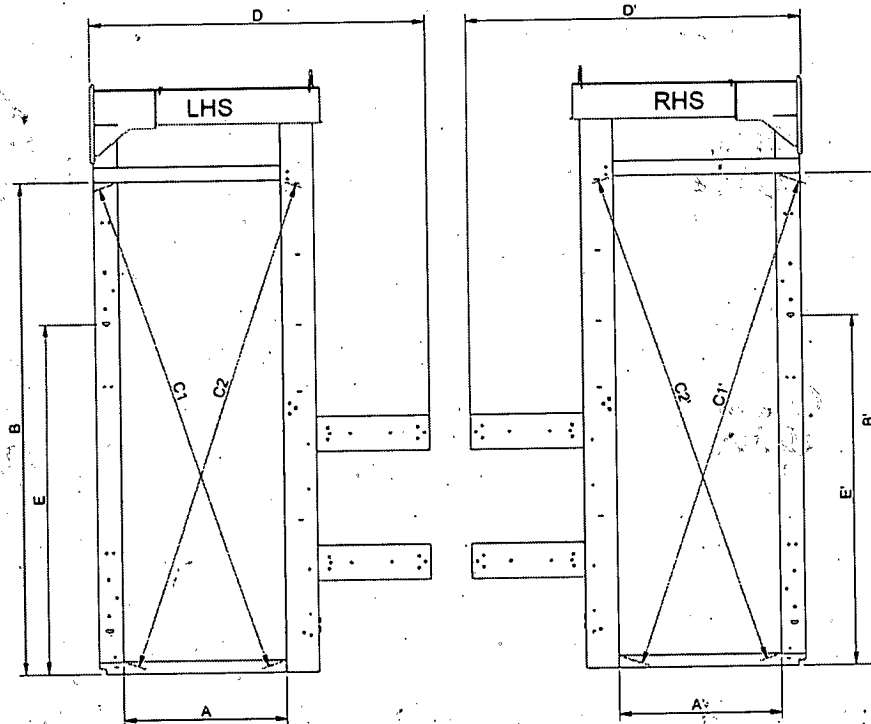
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Glenn</i>	Assembly Date:	2024/02/12			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Glenn</i>	Assembly Date:	2024/02/12			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>T. K. [Signature]</i>	Assembly Date:	2024/02/15	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152	



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	<i>S. Bortolo</i>	Sign:	<i>[Signature]</i>	Date: 2024/02/15

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	695	Tape Measure	ACCEPTABLE
B	2086	+1/-3	2087	2087		ACCEPTABLE
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2185	2155		ACCEPTABLE
$ C1 - C2 $			2185	2155		ACCEPTABLE
D	1438	+2/-3	1438	1439		ACCEPTABLE
E						

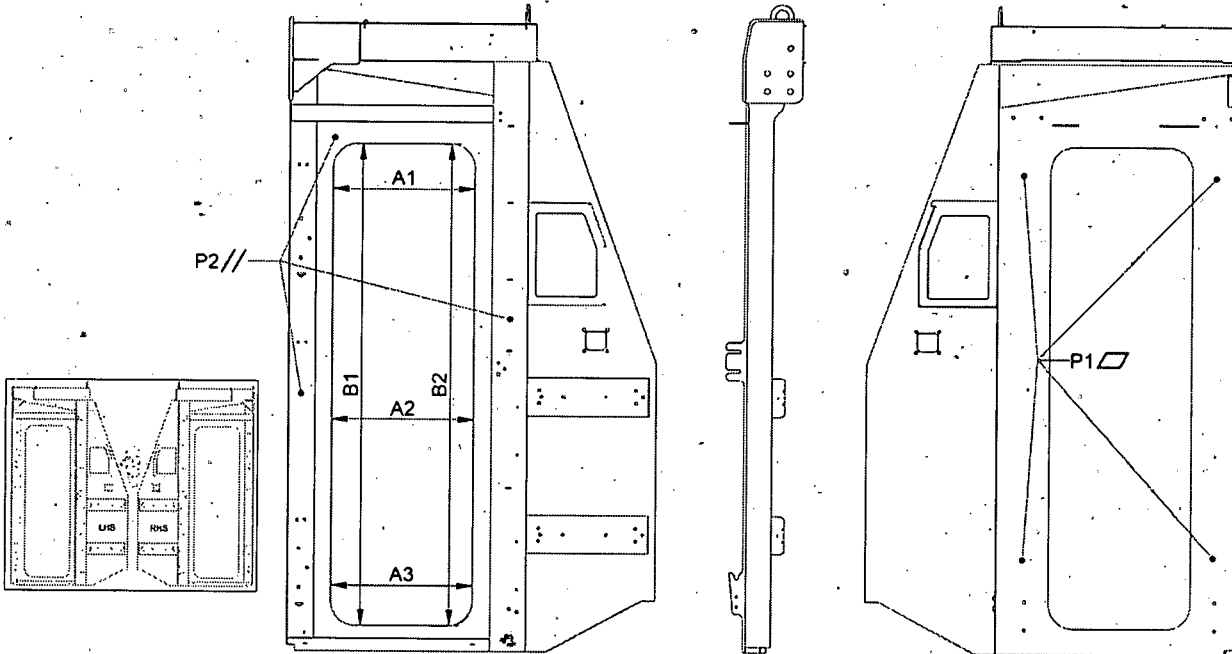
QC Inspector:	<i>S. Bortolo</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/15
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Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	<i>Passes</i>	Ruler
QC Inspector:	<i>S. Bortolo</i>	Sign:	<i>[Signature]</i>
		Date:	2024/02/15

Cabin LHS/RHS Side Assembly: GN002838/GN002837

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Xander</i>	Assembly Date:	2024/02/15			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			



Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Bridley</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/21	

Dimensional Control

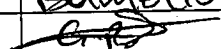
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	559	565	Tape Measure	Acceptable
A2			559	560		Keepable
A3			560	560		Acceptable
B1	1900	± 2	1898	1899		Acceptable
B2			1898	1899		Keepable

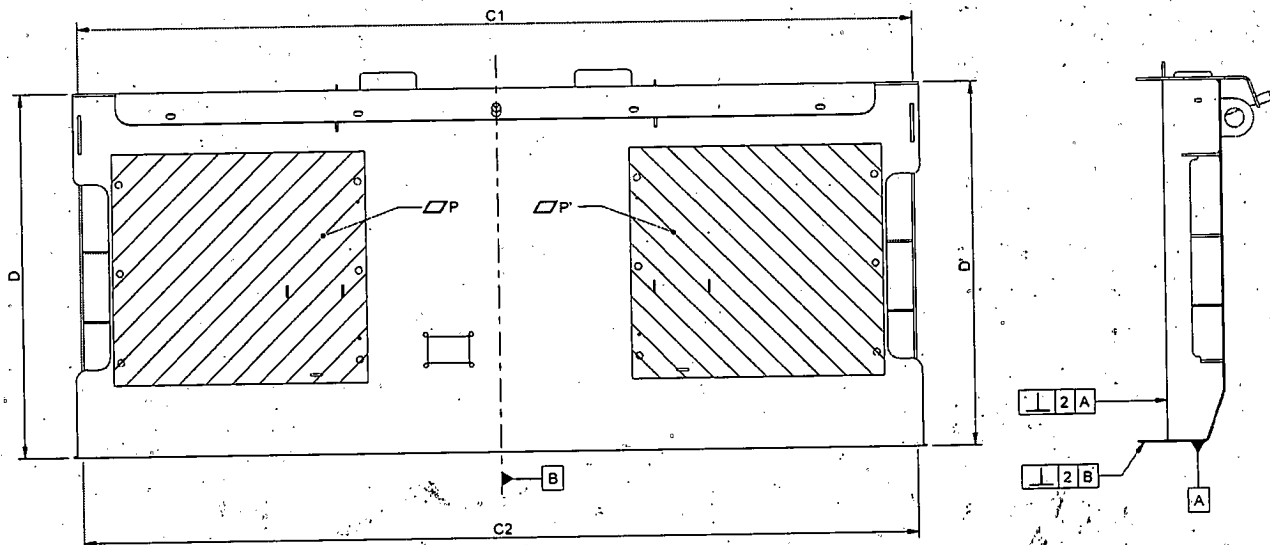
QC Inspector:	<i>Bridley</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/21
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Geometrical Control


Nature of checks		Dimension Measured		Measuring Equipment	Observations
P1: Planarity	4 mm	<i>Pass</i>	<i>Pass</i>	Ruler	Acceptable
P2: Planarity	2 mm	<i>Pass</i>	<i>Pass</i>	Ruler	Acceptable
QC Inspector:	<i>Bridley</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/21

Cabin Shield Assembly: GN002836


Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Bambelo G. Cinan	Assembly Date:	2024/02/21			
Sign:		Wire Batch No.:	2702152			




Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Leon	Sign:		Date:	2024/02/21	

Dimensional Control

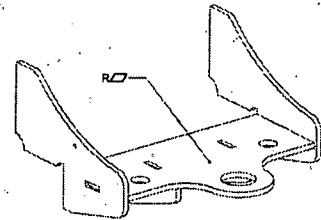
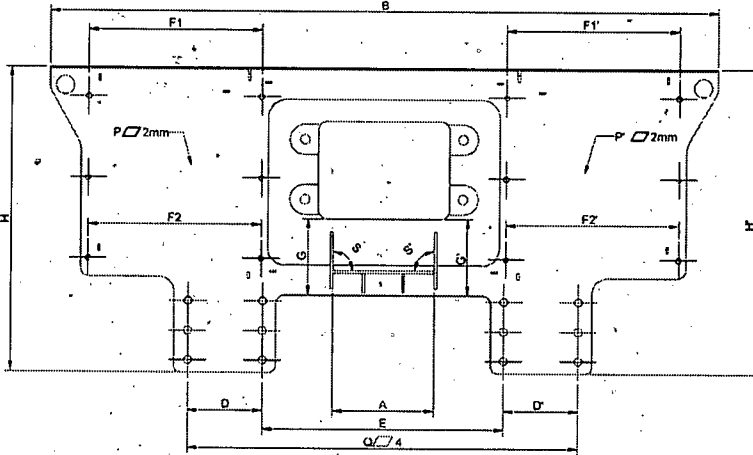
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2213	2214	Tape Measure	Accepted
D' / D'	956	± 2	954	954		Accepted
QC Inspector:	Leon	Sign:		Date:	2024/02/21	

Geometrical Control

Nature of Checks				Dimension Measured	Measuring Equipment	Observations
Planarity P / P'		2 mm		Passed	Ruler	Accepted
Perpendicularity	2	A		Passed	Set Square	Accepted
	2	B		Passed	Set Square	Accepted
QC Inspector:	Leon	Sign:		Date:	2024/02/21	

Cabin Front Headstock Assembly: GN002841

Assembly Completed as per WI/SOS MD_0019	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator: <i>TK Botu</i>	Assembly Date:	2024/02/15			
Sign: <i>[Signature]</i>	Wire Batch No.:	2202152			



Welding Control

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

Dimensional Control

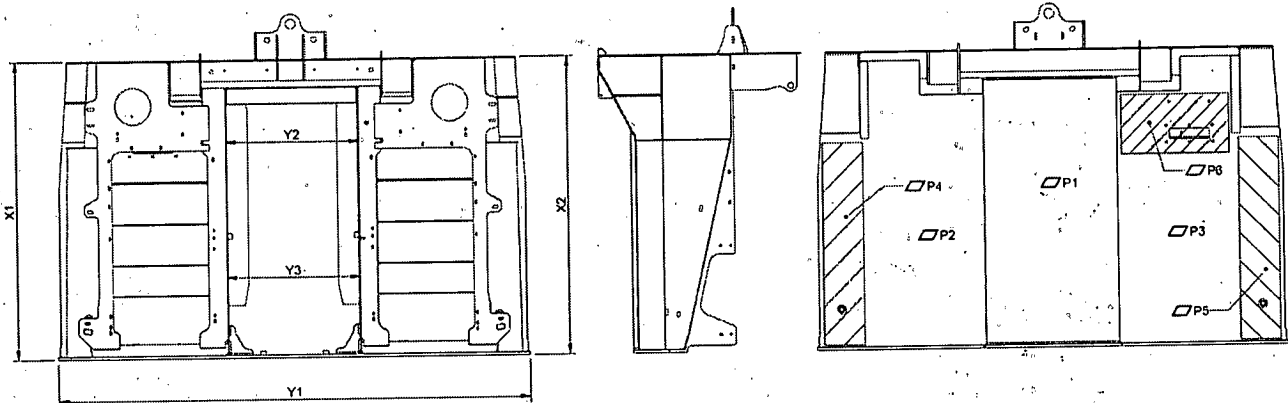
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	± 1	339		Tape Measure	Acceptable
B	2240	± 4	2244			Acceptable
D / D'	250	± 1	250.5	250.5		Acceptable
E	808	± 2	808			Acceptable
F1 / F1'	580	± 1	581	581		Acceptable
F2 / F2'			581			Acceptable
G / G'	258	± 1	259	259		Acceptable
H / H'	1019	± 2	1020	1020		Acceptable
QC Inspector: <i>Leon</i>	Sign: <i>[Signature]</i>	Date:	2024/01/19			

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
O: Planeity of global assembly	4 mm	Ruler	Acceptable
P / P': Planeity	2 mm	Ruler	Acceptable
Q: Planeity Surface of Supports	4 mm	Ruler	Acceptable
R: Planeity Coupler Support	2 mm	Ruler	Acceptable
S: Perpendicularity coupler	1mm	Square	Acceptable
QC Inspector: <i>Leon</i>	Sign: <i>[Signature]</i>	Date:	2024/01/19

Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Michael Voed</i>	Assembly Date:	2024-02-21			
Sign:	<i>[Signature]</i>	Wire Batch No.:	22 02162			



Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Rudley</i>	Sign:	<i>[Signature]</i>	Date:	2024-02-21	

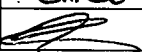
Dimensional Control

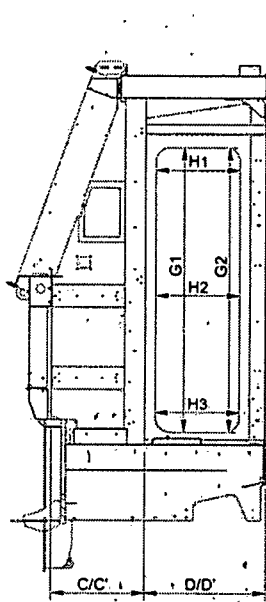
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1489	1487	Tape Measure	<i>Acceptable</i>
Y 1	2354	± 3	2351			<i>Acceptable</i>
Y2 / Y3	666	± 1	667	667		<i>Acceptable</i>
QC Inspector:		<i>Rudley</i>	Sign:		<i>[Signature]</i>	Date: 2024-02-21

Geometrical Control

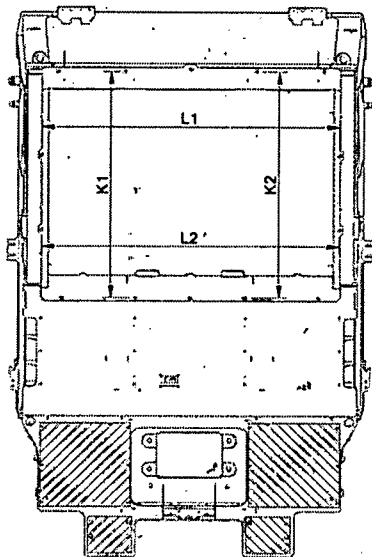
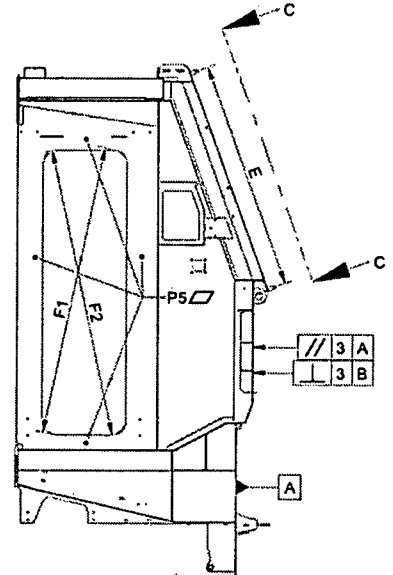
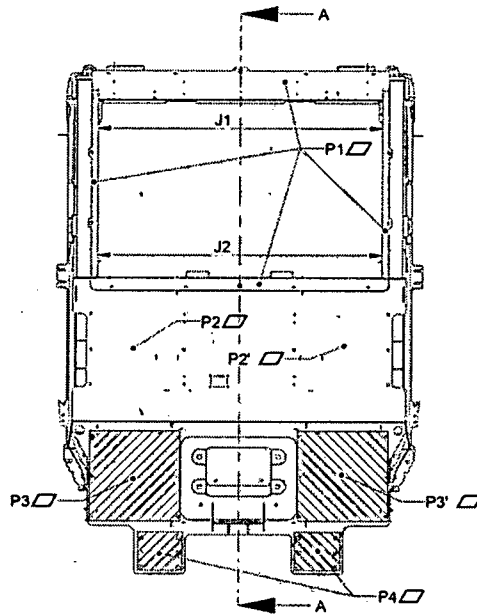
Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : Planéité	4 mm	<i>P1 1500</i>	Ruler	<i>Acceptable</i>
P2 / P3 : Planéité	4 mm	<i>P2 1500</i>	Ruler	<i>Acceptable</i>
P4 / P5 : Planéité	2 mm	<i>P4 1500</i>	Ruler	<i>Acceptable</i>
P6 : Planéité	2 mm	<i>P6 1500</i>	Ruler	<i>Acceptable</i>
QC Inspector:		<i>Rudley</i>	Sign:	<i>[Signature]</i>
			Date:	2024-02-21

Cabin Structure Assembly: GN002834

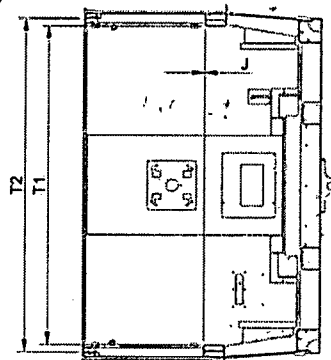
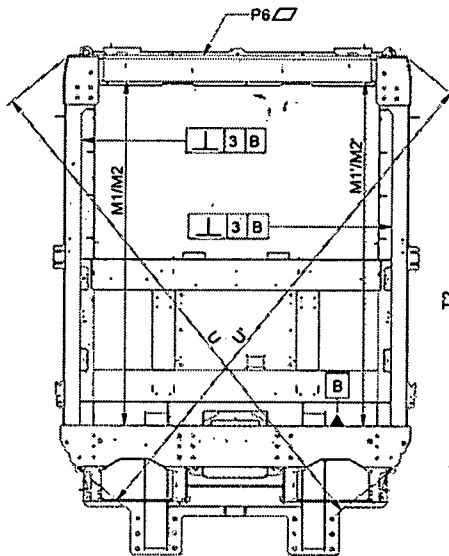
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL ZLOTH	Assembly Date:	20 24/02/26			
Sign:		Wire Batch No.:	220252			



SECTION A-A




AUX VIEW: C



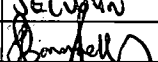
SECTION B-B

Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed		Yes	X	No
QC Inspector:		Leon		Sign:		A		Date:	2024/02/26
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	625	624	Acceptable				
D / D'	813	± 2,5	813	812	Acceptable				
E	1531.5	± 3	1530		Acceptable				
G1 / G'1	Height	+1	1898	1899	Acceptable				
G2 / G'2	1900	-3	1899	1897	Acceptable				
H1 / H'1	Width	+1 -3	557	558	Acceptable				
H2 / H'2			557	558,5	Acceptable				
H3 / H'3			559	559	Acceptable				
F1 / F'1	Diagonals		1938	1936	Acceptable				
F2 / F'2			1936	1936	Acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	2	0	Acceptable				
J	Gap of Doors	± 1,5	1		Acceptable				
K1 / K2	1515	± 3	1114	1114	Acceptable				
L1 / L2	1996	± 3	1997	1995	Acceptable				
M1 / M'1	2306	± 3	2469	2468	Acceptable				
M2 / M'2			2473	2474	Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2127	2129	Acceptable				
T2 / T'2	2230 Top/Bottom		2230	2231	Acceptable				
Difference	U - U' (3522)	≤ 4mm	3520	3519,5	Acceptable				
QC Inspector:		Leon		Sign:		D		Date:	2024/02/26
Geometrical Control									
Nature of checks				Toler.	LHS / Dimension Measured / RHS				
P1 / P'1	Planeity			2 mm	passed		Acceptable		
P2 / P'2	Planeity			2 mm	passed		Acceptable		
P3 / P'3	Planeity			4 mm	passed		Acceptable		
P4 / P'4	Planeity			4 mm	passed		Acceptable		
P5 / P'5	Planeity			4 mm	passed		Acceptable		
P6 Roof	Planeity			6 With 2m Ruler	passed		Acceptable		
Shield	//	3	A	3	passed		Acceptable		
Shield	⊥	3	A	3	passed		Acceptable		
Door Post	⊥	3	A	Front	passed		Acceptable		
				Back	passed		Acceptable		
QC Inspector:		Leon		Sign:		D		Date:	2024/02/26


Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Damien	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>26</u>			
Sign:		Wire Batch No.:	2202162			

Cabin Rivnut Assembly: GN002832

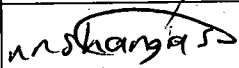

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	SELYAN	Assembly Date:	20 <u>24</u> / <u>03</u> / <u>19</u>			
Sign:		Wire Batch No.:				

Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Fasteners positioned in all Rivnuts and Bosses	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Masked as per GMS-SOS-GIBELA-CABIN-001	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID	Sign:		T. D. [Signature]	
Date:	2024/03/13				
Record of Shot Blasting					
Operator:		Date:	2024/02/13		
Start Time:	08 H 05	End Time:	17 H 01		
Temperature ($\geq 15^\circ$):	21 - 07 °C	Humidity ($\leq 75\%$):	65 - 04 %		
Shot Blasting Self-Inspection					
Interior of Cabin: Sa 1 - Light Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID	Sign:		T. D. [Signature]	
Date:	2024/03/13				
Shot Blasting Cleaning					
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID	Sign:		T. D. [Signature]	
Date:	2024/03/13				
Shot Blasting Control					
Temperature $\geq 15^\circ$:	19 - 09 °C	Humidity $\leq 75\%$:	62 - 03 %		
Internal Roughness $3.2 \leq Ra \leq 12.5$	7.765	External Roughness $3.2 \leq Ra \leq 12.5$	7.562		
QC Inspector:	2388	Sign:		[Signature]	
Date:	13/03/24				

Record of Priming							
Start Time:		21:00		End Time:		23:30	
Temperature $\geq 15^{\circ}$:		25°C		Humidity $\leq 75\%$:		49%	
Paint Batch No.:		7878267		Paint Expiry Date:		06/25	
Hardener Batch No.:		7331119		Hardener Expiry Date:		01/11/24	
Desolvation Start Time:		23:30		Desolvation End Time:		23:45	
Stoving Start Time:		23:45		Stoving End Time:		00:45	
Stoving Temp:		60°C					
Operator:		Ntuthuko		Sign:		nn Changas	
Date:		20 24/03/13					
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 54.4	5: 51.7	1: 56.8	5: 49.1	1: 63.1	5: 64.1	1: 65.6	5: 81.4
2: 64.1	6: 41.9	2: 43.8	6: 59.8	2: 66.0	6: 76.5	2: 75.9	6: 78.6
3: 47.1	7: 40.1	3: 89.0	7: 59.0	3: 79.2	7: 54.4	3: 61.2	7: 70.3
4: 72.5	8: 49.5	4: 76.4	8: 62.9	4: 71.5	8: 64.3	4: 59.7	8: 71.1
Min:	40.1	Min:	43.8	Min:	54.4	Min:	59.7
Max:	72.5	Max:	89.0	Max:	79.2	Max:	81.4
Average:	52.6	Average:	61.8	Average:	59.0	Average:	65.5
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 72.3	5: 74.4	1: 63.2	5: 73.0	1: 73.9	5: 63.7	1: 49.1	5: 67.5
2: 82.0	6: 67.5	2: 67.0	6: 64.8	2: 78.2	6: 59.8	2: 52.9	6: 46.3
3: 71.3	7: 61.1	3: 62.9	7: 59.3	3: 63.1	7: 41.1	3: 53.1	7: 37.9
4: 79.4	8: 80.0	4: 72.0	8: 73.2	4: 63.2	8: 68.7	4: 58.7	8: 52.9
Min:	61.1	Min:	59.3	Min:	41.1	Min:	37.9
Max:	82.0	Max:	73.0	Max:	83.2	Max:	67.5
Average:	71.55	Average:	66.1	Average:	62.15	Average:	52.7
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 62.5	5: 79.4	1: 69.8	5: 73.2	1: 68.0	5: 86.7	1: 41.3	5: 72.0
2: 79.4	6: 80.1	2: 65.2	6: 91.1	2: 46.7	6: 70.4	2: 58.9	6: 54.3
3: 71.2	7: 86.6	3: 75.8	7: 84.7	3: 80.0	7: 69.0	3: 61.2	7: 48.7
4: 78.7	8: 70.5	4: 73.7	8: 79.3	4: 81.4	8: 57.7	4: 67.9	8: 53.3
Min:	62.5	Min:	65.2	Min:	46.7	Min:	41.3
Max:	86.6	Max:	91.1	Max:	86.7	Max:	72.0
Average:	74.5	Average:	78.1	Average:	66.7	Average:	56.6
Primer has been inspected and is free of defects				Confirmed		Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>	
QC Inspector:		Zothile		Sign:			
Date:		14 Mar 2024					

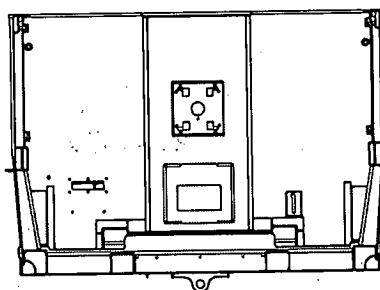
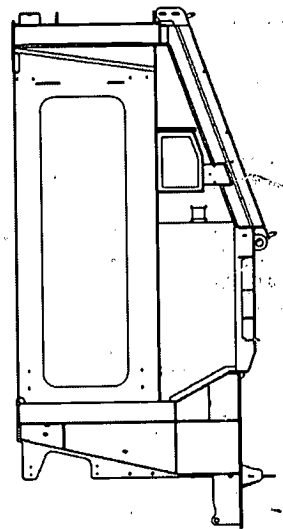
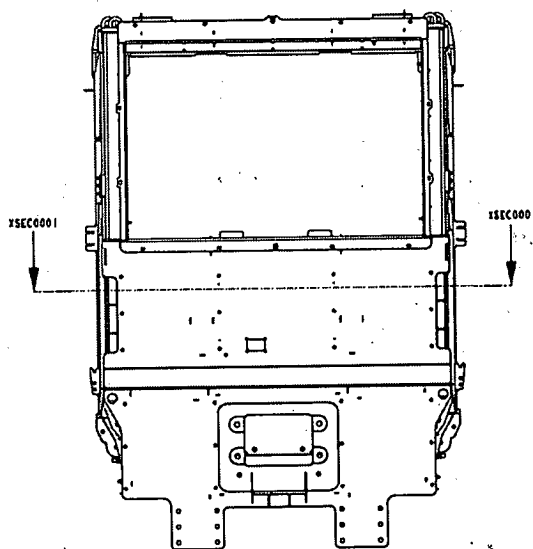
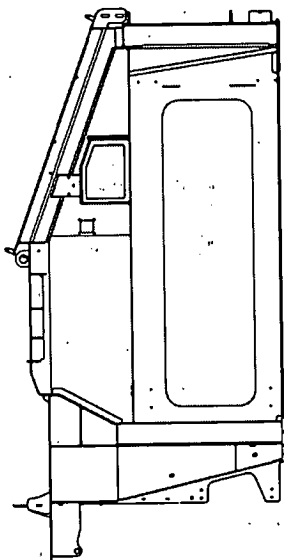
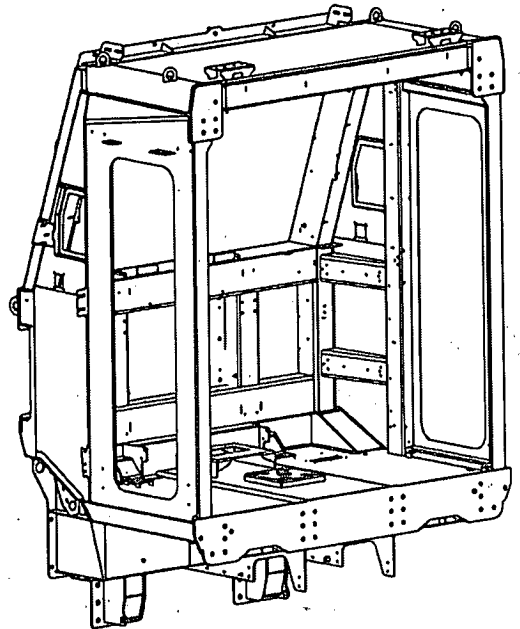
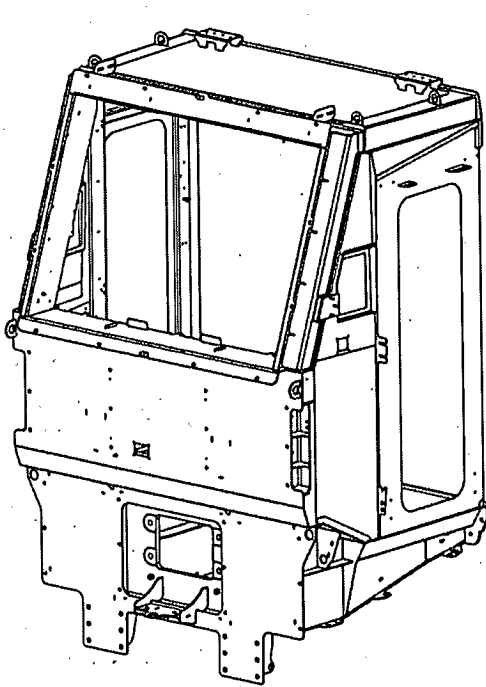
Record of Painting NCSS3010 R90B			
Start Time:	22:00	End Time:	22:30
Temperature $\geq 15^{\circ}$:	27°C	Humidity $\leq 75\%$:	42%
Paint Batch No.:	8156903	Paint Expiry Date:	23/01/2025
Hardener Batch No.:	7502115121	Hardener Expiry Date:	12/24
Desolvation Start Time:	22:30	Desolvation End Time:	22:45
Stoving Start Time:	22:45	Stoving End Time:	23:45
Stoving Temp:	60°C		
Operator:	Ntuthuko	Sign:	<i>[Signature]</i>
Date:	2024/03/14		
Painting NCSS3010 R90B Control			
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS	
1: 131	5: 128	1: 107	5: 127
2: 92.4	6: 119	2: 84.7	6: 125
3: 106	7: 101	3: 96.6	7: 111
4: 126	8: 120	4: 110	8: 105
Min: 92.4		Min: 96.6 84.7	
Max: 131		Max: 127	
Average: 114		Average: 105	
Painting NCSS3010 R90B has been inspected and is free of defects		Confirmed	Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	38.6
QC Inspector:	Zothile	Sign:	<i>[Signature]</i>
Date:	15 Mar 2024		

Record of Painting Blue NCSS1565 B					
Start Time:		10:00		End Time:	
Temperature $\geq 15^{\circ}$:		29°C		Humidity $\leq 75\%$:	
Paint Batch No.:		8126818		Paint Expiry Date:	
Hardener Batch No.:		7502115121		Hardener Expiry Date:	
Desolvation Start Time:		10:30		Desolvation End Time:	
Stoving Start Time:		10:45		Stoving End Time:	
Stoving Temp:		60°C			
Operator:		MUSA		Sign:	
Date:		2024/03/15		MUSA	
Painting Blue NCSS1565 B Control					
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)	
1: 24	5: 134	1: 119	5: 110		
2: 129	6: 128	2: 120	6: 123		
3: 144	7: 130	3: 108	7: 132		
4: 100	8: 126	4: 97.3	8: 127		
Min: 100		Min: 97.3			
Max: 144		Max: 132			
Average: 122		Average: 114			
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed	Yes
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	92.3
QC Inspector:		15 Mar 2024		Sign:	
Date:		Paul (Zothile)		Paul	

Record of RAL 7012							
Start Time:		09:00		End Time:		05:00	
Temperature $\geq 15^{\circ}$:		31 $^{\circ}$ C		Humidity $\leq 75\%$:		34%	
Paint Batch No.:		8156853		Paint Expiry Date:		06/02/2025	
Hardener Batch No.:		7502113121		Hardener Expiry Date:		12/24	
Desolvation Start Time:		05:00		Desolvation End Time:		05:15	
Stoving Start Time:		05:15		Stoving End Time:		06:15	
Stoving Temp:		60 $^{\circ}$ C					
Operator:		Nitvthuko		Sign:			
Date:		20/03/25					
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 116	5: 162	1: 147	5: 110	1: 129	5: 165	1: 106	5: 106
2: 153	6: 107	2: 133	6: 106	2: 86.7	6: 112	2: 90.5	6: 110
3: 105	7: 106	3: 152	7: 90.9	3: 92.9	7: 137	3: 109	7: 87.6
4: 112	8: 141	4: 143	8: 95.1	4: 82.6	8: 145	4: 104	8: 96.4
Min: 105		Min: 90.9		Min: 82.6		Min: 87.6	
Max: 162		Max: 152		Max: 137		Max: 110	
Average: 134		Average: 121		Average: 109		Average: 98.8	
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 83.6	5: 139	1: 124	5: 159	1: 124	5: 109	1: 107	5: 135
2: 91.0	6: 91.7	2: 121	6: 128	2: 154	6: 151	2: 119	6: 139
3: 98.7	7: 100	3: 163	7: 151	3: 161	7: 145	3: 154	7: 134
4: 152	8: 96.7	4: 140	8: 139	4: 143	8: 113	4: 145	8: 108
Min: 83.6		Min: 121		Min: 113		Min: 107	
Max: 152		Max: 163		Max: 161		Max: 154	
Average: 117		Average: 142		Average: 137		Average: 130	
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 138	5: 82.4	1: 107	5: 90.0				
2: 125	6: 85.3	2: 145	6: 91.0				
3: 116	7: 100	3: 93.8	7: 118				
4: 120	8: 91.2	4: 88.6	8: 140				
Min: 82.4		Min: 88.6					
Max: 138		Max: 145					
Average: 110		Average: 116					
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	47.8		
QC Inspector:		Zothule		Sign:			
Date:		15 Mar 2024					
SEALING OF CABIN							
All areas where there is no welding has been sealed with SIKA						Confirmed	YES
All sealants have been neatly applied along joints						Confirmed	YES
SIGN/OFF							
CLOCK No:	A2400		OPERATOR SIGN:	Aptule		DATE:	15 Mar 2024

REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)



FAULT TRACKING

[illegible]

REMINDERS / COMMENTS

[illegible]



CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	0445	Checks Updated:	2022/08/26

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

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

Quality approval for release Signature	CO. NO.	DATE
	2291/2285	15/03/24