

CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 4 5 8 _

WEIGHT: 1 4 8 8 Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	05/02/2024	178247 106625 01	LP49402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	14/02/2024	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	28/02/2024	178488 104640 01	P360091	
RCS 355	20 mm					

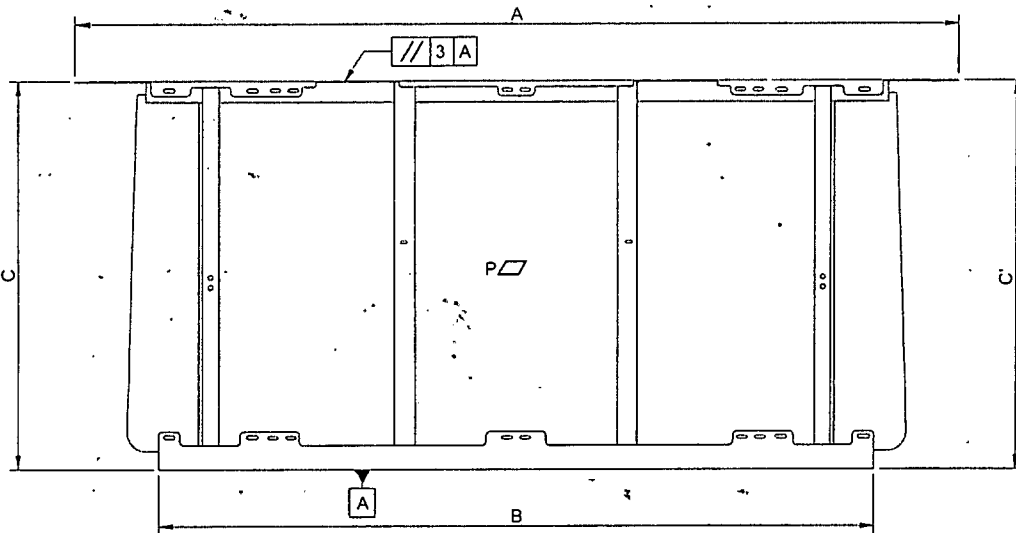
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegasus	12/02/2024			
RCS 355	30 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	08/02/2024	178489 104640 4	VHC 35578	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	14/02/2024	178815 104640 01	F207905 VHC 28402	
RCS 450	6 mm					
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	22/11/2024	175569 102206 01	F207906 VHS 58432	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

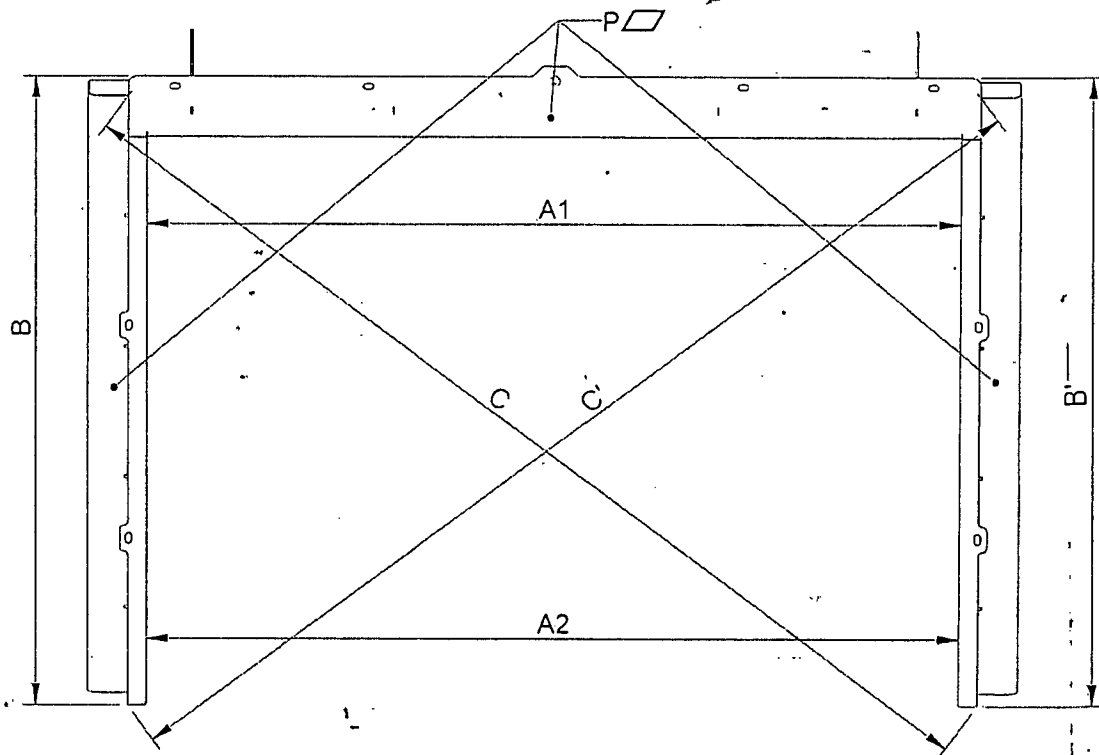
Cabin Roof Assembly: GN002839				
Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	DYLAN DAVIDS	Assembly Date:	20 24/03/22	
Sign:		Wire Batch No.:	107238201	



Welding Control				
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	Leon	Sign:		Date: 20 24/03/22
Dimensional Control				
Rep	Toler.	Dimension measured	Measuring Equipment	Observations
A	2216	+5/-0	Tape Measure	Acceptable
B	1800	± 4		Acceptable
C	976	+2/-3		Acceptable
QC Inspector:	Leon	Sign:		Date: 20 24/03/22
Geometrical Control				
Nature of Checks		Dimension Measured	Measuring Equipment	Observations
Planeity - P		6 mm	Ruler	Acceptable
//	3	A	Set Square	
QC Inspector:	Leon	Sign:		Date: 20 24/03/22

Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047	Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator: <u>Rambelo G. G. G.</u>	Assembly Date:	20 <u>24</u> / <u>03</u> / <u>22</u>	
Sign: <u>[Signature]</u>	Wire Batch No.:	SS2033	



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042	Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector: <u>Leon</u>	Sign: <u>[Signature]</u>	Date:	20 <u>24</u> / <u>03</u> / <u>22</u>

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	1910	± 2	1911		Tape Measure	Ausp. Th
A2	1910		1910			Ausp. Th
B	1475	± 1	1473.5	1474		Ausp. Th
C	Diagonals C - C' ≤ 3		2476	2475		Ausp. Th
QC Inspector:		Leon		Sign:		Date: 2024/03/22

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P : Planeity	4 mm	Ruler	Aufth
QC Inspector: <u>Leon</u>	Sign: <u>[Signature]</u>	Date:	20 <u>24</u> / <u>03</u> / <u>22</u>

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

Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>xander</i>	Assembly Date:	20 <u>24</u> / <u>03</u> / <u>13</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

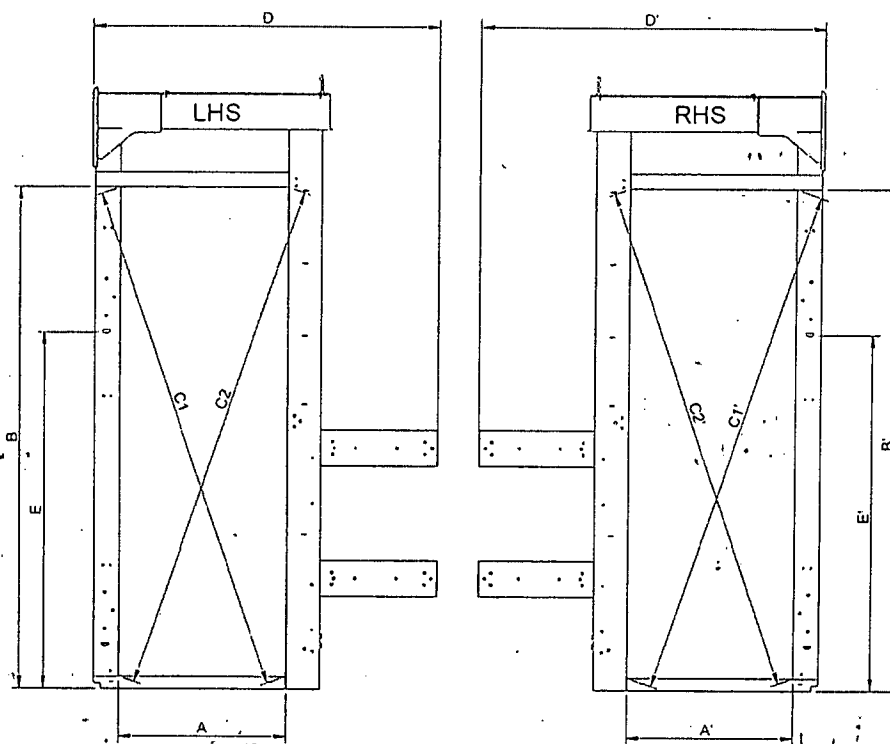
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Glenn</i>	Assembly Date:	20 <u>24</u> / <u>03</u> / <u>13</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

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:	20 <u>24</u> / <u>03</u> / <u>13</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	Glenn	Assembly Date:	2024/03/13	
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033	




Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	LEON	Sign:	<i>[Signature]</i>	Date: 2024/03/13

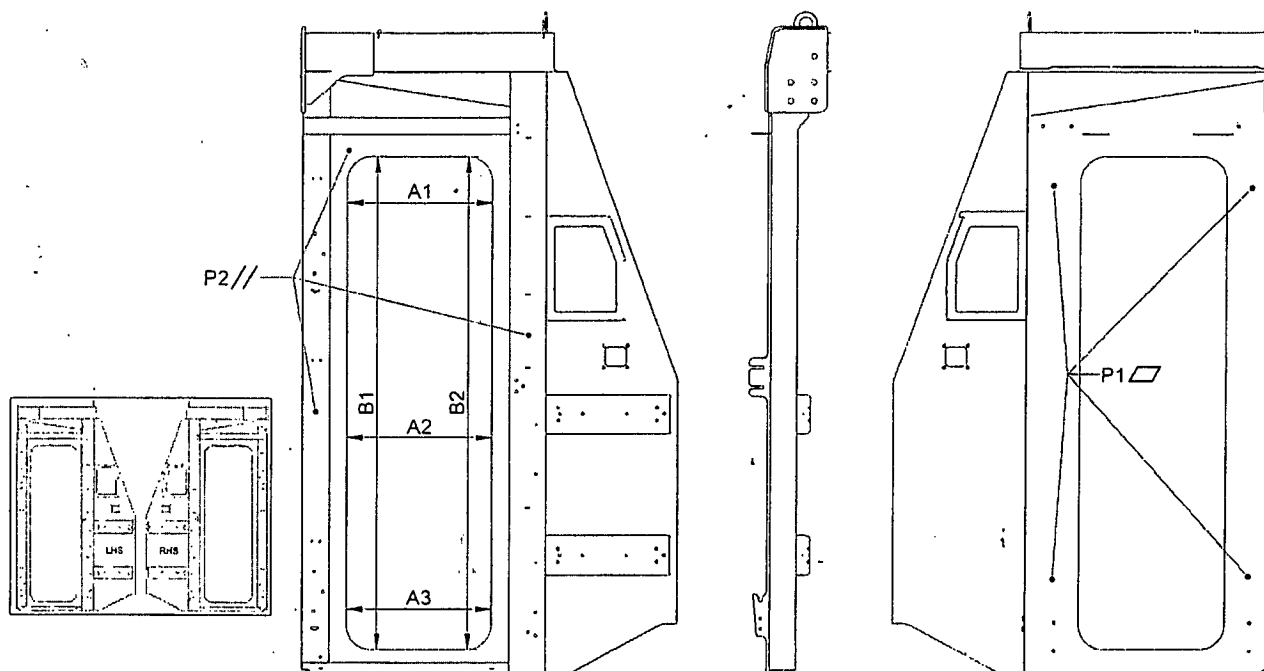
Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	696	Tape Measure	Acceptable
B	2086	+1/-3	2086	2085		Acceptable
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2152	2153		Acceptable
C1 - C2			2151	2151		Acceptable
D	1438	+2/-3	1438	1437		Acceptable
E			1482	1484		Acceptable
QC Inspector:		LEON	Sign:		<i>[Signature]</i>	Date: 2024/03/13

Geometrical Control


Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P1 : planeity of 2 edges	4 mm	PASSED		Ruler	Acceptable	
QC Inspector:	LGN		iSign:		Date:	2024/03/13

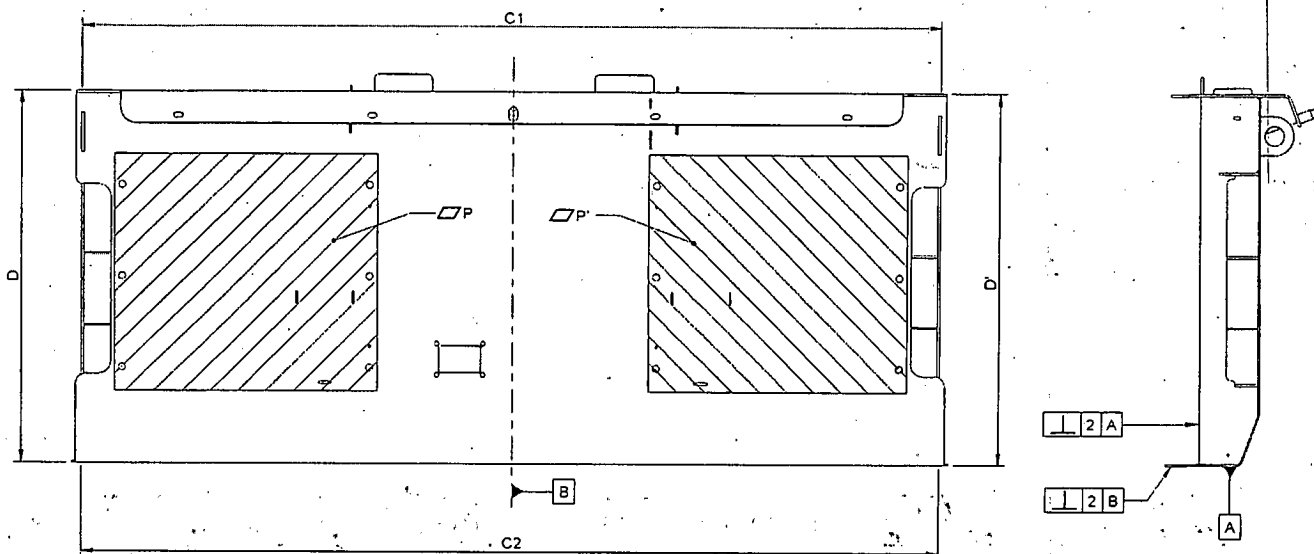
Cabin LHS/RHS Side Assembly: GN002838/GN002837			
Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>
Operator:	<i>Example</i>	Assembly Date:	2024/03/15
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033




Welding Control						
Assembly Completed as per WI/SOS MD_0044_0045		Confirmed		Yes <input checked="" type="checkbox"/>	No <input type="checkbox"/>	
QC Inspector: <i>LEON</i>		Sign: <i>[Signature]</i>		Date: 2024/03/22		
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	558	558	Tape Measure	Acceptable
A2			559	559		Acceptable
A3			559	560		Acceptable
B1	1900	± 2	1898	1898		Acceptable
B2			1898	1898		Acceptable
QC Inspector: <i>LEON</i>		Sign: <i>[Signature]</i>		Date: 2024/03/22		
Geometrical Control						
Nature of checks		Dimension Measured		Measuring Equipment		Observations
P1: Planarity		4 mm	Passed	Ruler		Acceptable
P2: Planarity		2 mm	Passed	Ruler		Acceptable
QC Inspector: <i>LEON</i>		Sign: <i>[Signature]</i>		Date: 2024/03/22		

Cabin Shield Assembly: GN002836


Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Rambelo G. Cuanan	Assembly Date:	2024/03/22			
Sign:		Wire Batch No.:	SS 1037			




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:	2024/03/22	

Dimensional Control

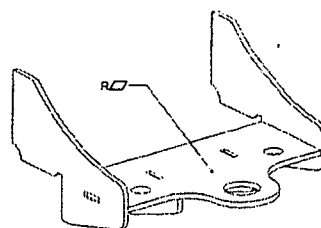
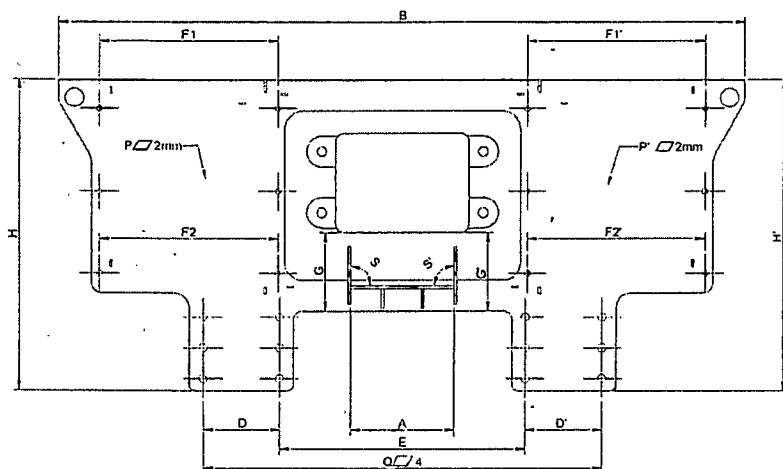
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2210	2214	Tape Measure	Aug 11/16
D / D'	956	± 2	955	955		Aug 11/16
QC Inspector:	Leon	Sign:		Date:	2024/03/22	

Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planarity P / P'		2 mm	Pass		Ruler	Aug 11/16
Perpendicularity	2	A	Pass		Set Square	Aug 11/16
	2	B	Pass		Set Square	Aug 11/16
QC Inspector:	Leon	Sign:		Date:	2024/03/22	

Cabin Front Headstock Assembly: GN002841


Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	T.K BOOLE	Assembly Date:	2024/03/16			
Sign:		Wire Batch No.:	552033			



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	LEON	Sign:		Date:	2024/03/16	

Dimensional Control

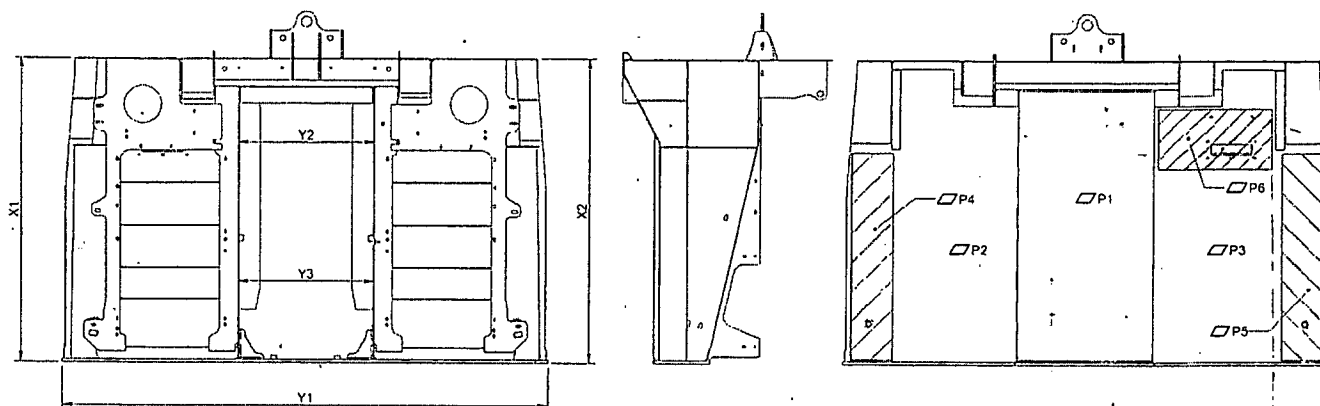
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	± 1	341		Tape Measure	Acceptable
B	2240	± 4	2244			Acceptable
D / D'	250	± 1	250.5	251		Acceptable
E	808	± 2	808			Acceptable
F1 / F1'	580	± 1	581	581		Acceptable
F2 / F2'			581	581		Acceptable
G / G'	258	± 1	258	259		Acceptable
H / H'	1019	± 2	1020	1020		Acceptable
QC Inspector:		Leon	Sign:			Date: 2024/03/16

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
O: Planeity of global assembly	4 mm	Pass	Ruler	Acceptable
P / P': Planeity	2 mm	Pass	Ruler	Acceptable
Q: Planeity Surface of Supports	4 mm	Pass	Ruler	Acceptable
R: Planeity Coupler Support	2 mm	Pass	Ruler	Acceptable
S: Perpendicularity coupler	1mm	Pass	Square	Acceptable
QC Inspector:	LEON	Sign:		Date: 2024/03/16

Cabin Underframe Assembly: GN002835


Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	Michael Wood	Assembly Date:	2024/03/22	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152	



Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
QC Inspector:	Leon	Sign:	<i>[Signature]</i>	Date: 2024/03/22

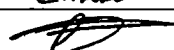
Dimensional Control

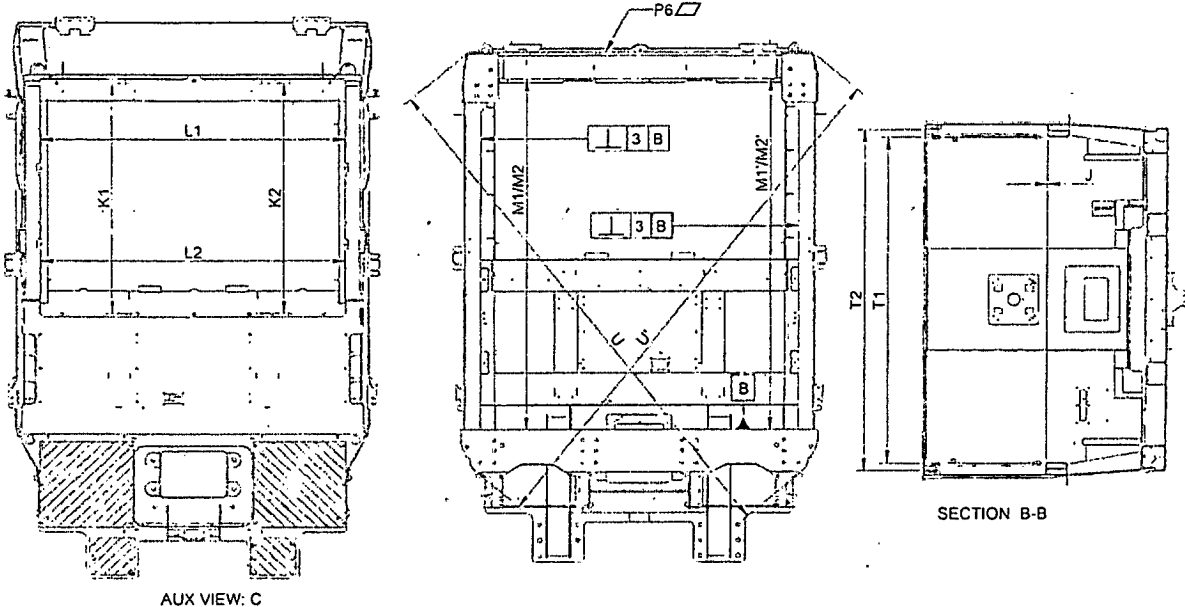
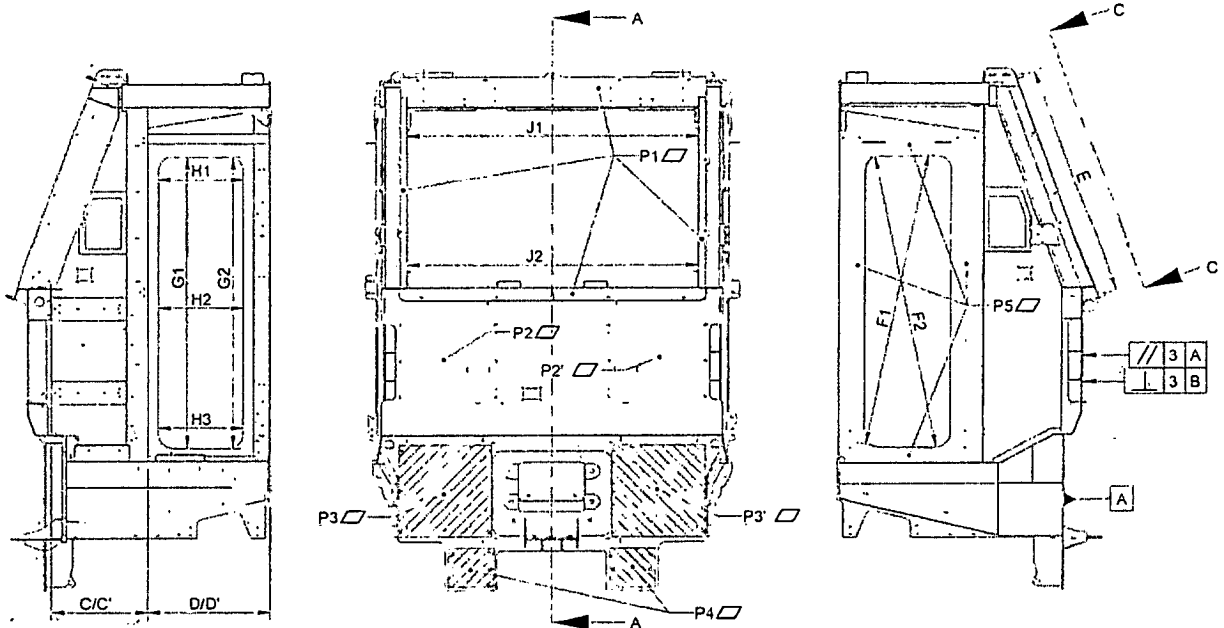
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
X1 / X2	1485	+5 / -2	1487	1486	Tape Measure	Acceptable	
Y 1	2354	± 3	2353			Acceptable	
Y2 / Y3	666	± 1	666	667		Acceptable	
QC Inspector:		Leon		Sign:		Date:	2024/03/22


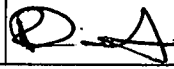
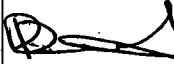
Geometrical Control


Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Ruler	Acceptable
P2 / P3 : Planeity	4 mm	Ruler	Acceptable
P4 / P5 : Planeity	2 mm	Ruler	Acceptable
P6 : Planeity	2 mm	Ruler	Acceptable
QC Inspector:	Leon	Sign:	<i>[Signature]</i> Date: 2024/03/22


Cabin Structure Assembly: GN002834

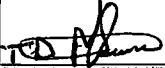
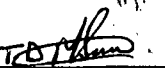


Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLOEM	Assembly Date:	20 24/03/22			
Sign:		Wire Batch No.:	220252			



Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed		Yes		No
QC Inspector:		Riccardo		Sign:				Date: 2024/05/27	
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	625	625	acceptable				
D / D'	813	± 2,5	812	812	acceptable				
E	1531.5	± 3	1529.5		acceptable				
G1 / G'1	Height 1900	+1	1898	1898	acceptable				
G2 / G'2		-3	1897	1898	acceptable				
H1 / H'1	Width 560	+1	558	558	acceptable				
H2 / H'2		-3	559	559	acceptable				
H3 / H'3			559	559	acceptable				
F1 / F'1	Diagonals 1939		1937	1936	acceptable				
F2 / F'2			1937	1937	acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	0	1	acceptable				
J	Gap of Doors	± 1,5	1	1	acceptable				
K1 / K2	1515	± 3	1514	1515	acceptable				
L1 / L2	1996	± 3	1995	1994	acceptable				
M1 / M'1	2300	± 3	2467	2467	acceptable				
M2 / M'2			2477	2477	acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2128	2128	acceptable				
T2 / T'2	2230 Top/Bottom		2132	2132	acceptable				
Difference	U - U' (3522)	≤ 4mm	2521	2522	acceptable				
QC Inspector:		Riccardo		Sign:				Date: 2024/05/27	
Geometrical Control									
Nature of checks				Toler.	LHS / Dimension Measured / RHS		Observations		
P1 / P'1		Planeity		2 mm	Passed		acceptable		
P2 / P'2		Planeity		2 mm	Passed		acceptable		
P3 / P'3		Planeity		4 mm	Passed		acceptable		
P4 / P'4		Planeity		4 mm	Passed		acceptable		
P5 / P'5		Planeity		4 mm	Passed		acceptable		
P6 Roof		Planeity		6 With 2m Ruler	Passed		acceptable		
Shield	//	3	A	3	Passed		acceptable		
Shield	⊥	3	A	3	Passed		acceptable		
Door Post	⊥	3	A	Front	Passed		acceptable		
				Back	Passed		acceptable		
QC Inspector:		Riccardo		Sign:				Date: 2024/05/27	

Cabin Bracket Assembly: GN002833				
Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	CHARL BLOEM	Assembly Date:	20 24/03/27	
Sign:		Wire Batch No.:	2202182	

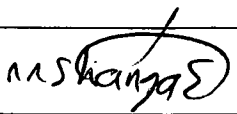
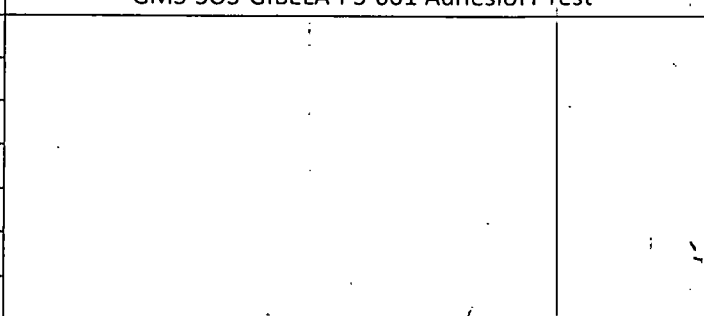

Cabin Rivnut Assembly: GN002832				
Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	Selygn	Assembly Date:	20 24/03/27	
Sign:		Wire Batch No.:		

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:			
Date:	2024/04/17				
Record of Shot Blasting					
Operator:		Date:	2024/04/17		
Start Time:	07 H 49	End Time:	15 H 20		
Temperature ($\geq 15^\circ$):	21-01 $^\circ$ C	Humidity ($\leq 75\%$):	68-06 %		
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:			
Date:	2024/04/17				
Shot Blasting Cleaning					
Cabin free of all sand		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:		Sign:			
Date:	2024/04/17				
Shot Blasting Control					
Temperature $\geq 15^\circ$:	20-04 $^\circ$ C	Humidity $\leq 75\%$:	68-03 %		
Internal Roughness $3.2 \leq Ra \leq 12.5$	10.365	External Roughness $3.2 \leq Ra \leq 12.5$	08.762		
QC Inspector:	LEON	Sign:			
Date:	17/04/24				

Record of Priming							
Start Time:		02:30		End Time:		05:30	
Temperature $\geq 15^{\circ}$:		31°C		Humidity $\leq 75\%$:		59%	
Paint Batch No.:		7978267		Paint Expiry Date:		06/25	
Hardener Batch No.:		733119		Hardener Expiry Date:		01/11/24	
Desolvation Start Time:		05:30		Desolvation End Time:		05:45	
Stoving Start Time:		05:45		Stoving End Time:		06:45	
Stoving Temp:		60°C					
Operator:		Mtutshoko		Sign:		na Stanger	
Date:		2024/04/18					
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 47.5	5: 63.5	1: 62.5	5: 43.6	1: 69.4	5: 75.5	1: 62.3	5: 78.0
2: 45.0	6: 71.6	2: 61.7	6: 50.4	2: 53.8	6: 72.4	2: 61.9	6: 68.4
3: 64.8	7: 46.9	3: 73.6	7: 45.2	3: 66.2	7: 88.8	3: 67.1	7: 72.6
4: 55.3	8: 76.1	4: 62.9	8: 84.3	4: 41.4	8: 44.2	4: 59.9	8: 68.6
Min:	45.0	Min:	45.2	Min:	41.4	Min:	41.9
Max:	76.1	Max:	84.3	Max:	88.8	Max:	78.0
Average:	60.5	Average:	64.7	Average:	64.8	Average:	59.9
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 61.1	5: 70.5	1: 71.7	5: 83.9	1: 46.4	5: 65.6	1: 82.2	5: 69.1
2: 44.0	6: 54.7	2: 82.2	6: 58.8	2: 51.2	6: 76.0	2: 77.3	6: 50.9
3: 45.2	7: 47.3	3: 68.6	7: 50.4	3: 58.3	7: 52.1	3: 73.4	7: 64.3
4: 50.8	8: 45.2	4: 43.5	8: 47.7	4: 45.9	8: 43.5	4: 42.0	8: 69.5
Min:	44.0	Min:	43.5	Min:	43.5	Min:	42.0
Max:	80.8	Max:	83.9	Max:	76.0	Max:	82.2
Average:	64.4	Average:	63.7	Average:	59.7	Average:	62.1
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 63.5	5: 69.3	1: 45.8	5: 42.8	1: 52	5: 67.9	1: 82.7	5: 69.6
2: 82.5	6: 80.2	2: 49.9	6: 41.5	2: 46.2	6: 50.1	2: 66.8	6: 78.9
3: 56.1	7: 76.7	3: 68.4	7: 73.8	3: 55.1	7: 49.4	3: 64.2	7: 41.8
4: 49.1	8: 70.0	4: 77.6	8: 81.1	4: 64.4	8: 52.6	4: 55.5	8: 73.0
Min:	49.1	Min:	41.5	Min:	46.2	Min:	41.8
Max:	82.5	Max:	81.1	Max:	67.9	Max:	82.7
Average:	66.8	Average:	61.3	Average:	57.0	Average:	62.2
Primer has been inspected and is free of defects				Confirmed		Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>	
QC Inspector:		Zothu'le		Sign:		[Signature]	
Date:		19/04/2024					

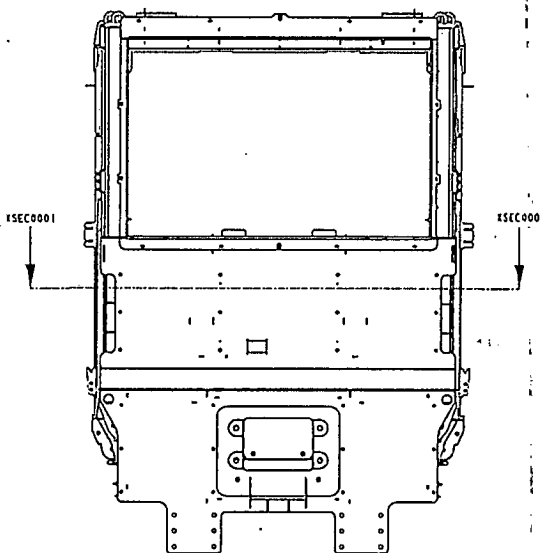
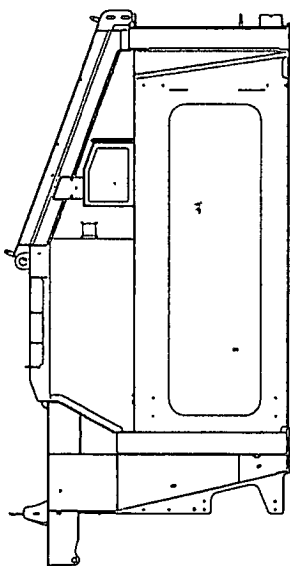
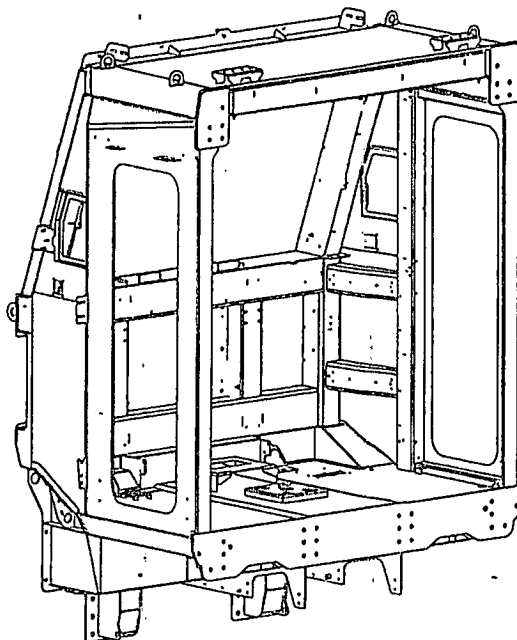
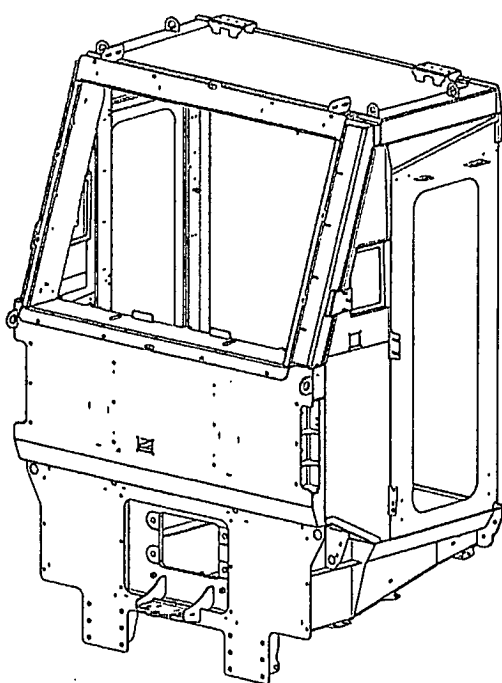
Record of Painting NCSS3010 R90B			
Start Time:	09:00	End Time:	10:00
Temperature $\geq 15^{\circ}$:	29 ^o	Humidity $\leq 75\%$:	42%
Paint Batch No.:	9196598	Paint Expiry Date:	23-02-2025
Hardener Batch No.:	813819513	Hardener Expiry Date:	11/26
Desolvation Start Time:	10:00	Desolvation End Time:	10:13
Stoving Start Time:	10:13	Stoving End Time:	11:13
Stoving Temp:	60 ^o		
Operator:	murta	Sign:	murta
Date:	20/04/23		
Painting NCSS3010 R90B Control			
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS	
1: 132	5: 134	1: 121	5: 94.6
2: 91.1	6: 129	2: 100	6: 148
3: 107	7: 117	3: 135	7: 155
4: 81.2	8: 108	4: 144	8: 142
Min:	84.2	Min:	94.6
Max:	134	Max:	155
Average:	100	Average:	130
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	332
QC Inspector:	Zothuile	Sign:	[Signature]
Date:	24/04/2024		

Record of Painting: Blue-NCSS1565 B			
Start Time:	12:00	End Time:	13:00
Temperature $\geq 15^{\circ}$:	28°C	Humidity $\leq 75\%$:	46%
Paint Batch No.:	8216298	Paint Expiry Date:	27-03-25
Hardener Batch No.:	8139195113	Hardener Expiry Date:	11/26
Desolvation Start Time:	13:00	Desolvation End Time:	13:15
Stoving Start Time:	13:15	Stoving End Time:	14:15
Stoving Temp:	60%		
Operator:	muso	Sign:	muso
Date:	20/04/23		
Painting Blue NCSS1565 B Control			
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS	
1: 157	5: 161	1: 155	5: 105
2: 149	6: 112	2: 160	6: 137
3: 121	7: 137	3: 152	7: 119
4: 136	8: 118	4: 143	8: 129
Min:	112	Min:	105
Max:	161	Max:	160
Average:	136	Average:	132
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	91.1
QC Inspector:	Zothulpe	Sign:	[Signature]
Date:	24/04/2024		

Record of RAL 7012							
Start Time:	03:00		End Time:	05:00			
Temperature $\geq 15^{\circ}$:	31°C		Humidity $\leq 75\%$:	57%			
Paint Batch No.:	8196593		Paint Expiry Date:	16.02.2025			
Hardener Batch No.:	8138195113		Hardener Expiry Date:	11/26			
Desolvation Start Time:	05:00		Desolvation End Time:	05:15			
Stoving Start Time:	05:15		Stoving End Time:	06:15			
Stoving Temp:	60°C						
Operator:	M. V. V. K. O.		Sign:				
Date:	2024/04/23						
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 135	5: 110	1: 146	5: 126	1: 119	5: 127	1: 114	5: 129
2: 124	6: 109	2: 924	6: 144	2: 153	6: 118	2: 123	6: 108
3: 949	7: 910	3: 129	7: 137	3: 132	7: 101	3: 108	7: 117
4: 124	8: 127	4: 946	8: 104	4: 124	8: 127	4: 972	8: 121
Min:	949	Min:	924	Min:	101	Min:	972
Max:	135	Max:	146	Max:	153	Max:	129
Average:	118	Average:	121	Average:	125	Average:	114
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 129	5: 104	1: 118	5: 124	1: 108	5: 138	1: 122	5: 116
2: 137	6: 973	2: 983	6: 131	2: 151	6: 124	2: 104	6: 100
3: 115	7: 120	3: 126	7: 109	3: 112	7: 113	3: 137	7: 101
4: 108	8: 846	4: 104	8: 121	4: 126	8: 102	4: 125	8: 946
Min:	846	Min:	983	Min:	102	Min:	946
Max:	137	Max:	131	Max:	151	Max:	137
Average:	111	Average:	116	Average:	126	Average:	112
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 135	5: 120	1: 137	5: 124				
2: 128	6: 119	2: 128	6: 130				
3: 126	7: 123	3: 121	7: 137				
4: 131	8: 129	4: 124	8: 101				
Min:	119	Min:	101				
Max:	135	Max:	137				
Average:	127	Average:	125				
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	38.6		
QC Inspector:		Zothule		Sign:			
Date:		24/04/2024					
SEALING OF CABIN							
All areas where there is no welding has been sealed with SIKA				Confirmed	YES	<input checked="" type="checkbox"/>	NO
All sealants have been neatly applied along joints				Confirmed	YES	<input checked="" type="checkbox"/>	NO
SIGN OFF							
CLOCK No:	2400		OPERATOR SIGN:	Aphile		DATE:	24/04/2024

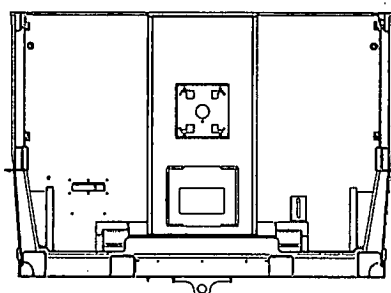
REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)



XSEC0001

XSEC0001



[illegible][illegible]



CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	0458	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	NO PAINT IN THREADS				
8					
9					
10					
11					
12					
13					
14					

Quality approval for release Signature	CO. NO.	DATE
	2285	26/04/2024