


PRASA PROJECT
APPLICABLE FROM TRAINSET 100+ 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 ?
				TCs	MA	M1	M2	M3	TCs		
DTR3000152640	AAD0001278566	CARBODY SHELL M1 ASSEMBLY	CB1210			(X)				PRA.CB1210.DTR30225 487/3.V25	YES

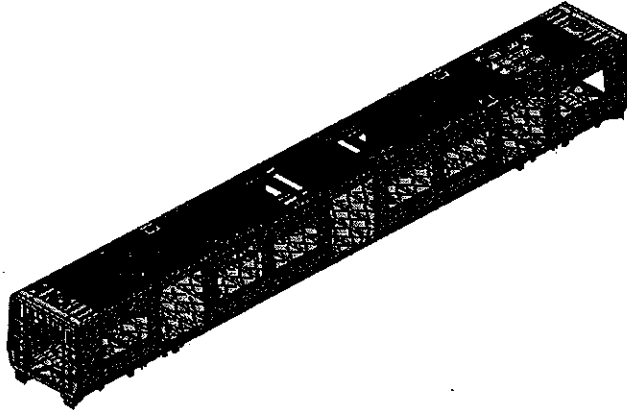
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018
			CHECKER	Nosizo Pindela	10/01/2018
			COMPILER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motama	2018/05/18
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230	APPROVER	Itumeleng Modiba	2018/07/04
			CHECKER	Nosizo Pindela	2018/07/04
			REVISED BY	Ramokone Motama	2018/07/04
3	2018/12/12	Added dimensional check points to CB1210	APPROVER	Itumeleng Modiba	2018/12/12
			CHECKER	Nosizo Pindela	2018/12/12
			REVISED BY	Ramokone Motama	2018/12/12
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	22/01/2019
			CHECKER	Nosizo Pindela	22/01/2019
			REVISED BY	Vanessa Ntuli	22/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	21/08/2019
			CHECKER	Nosizo Pindela	21/08/2019
			REVISED BY	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021
			CHECKER	Mpho Mulaudzi	
			REVISED BY	Mpho Mulaudzi	
25	19/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	19/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlampe Amogelang	
			REVISED BY	Mohlampe Amogelang	
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023
			CHECKER	Zwane Ntokozo	
			REVISED BY	Mohlampe Amogelang	
28	07/11/2023	Addition of welding traceability	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Andani Muthelo	
			REVISED BY	Ntokozo Zwane	
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
227	M1	LUNGA 471447	14/05/24	SI.CB1210.254.V28	17

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

Car: M1	NCR:	Work station: CB1210
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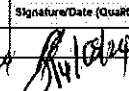


Safety Related



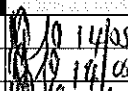
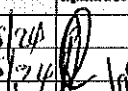
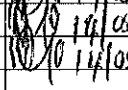
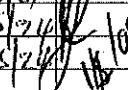
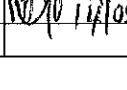
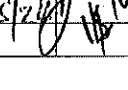
I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
	1	2	3	4	5	6						
DTR30225487/3	X						28		✓			

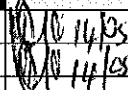
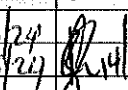
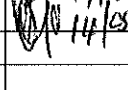
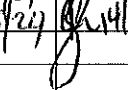
I.2 - Instruments Control

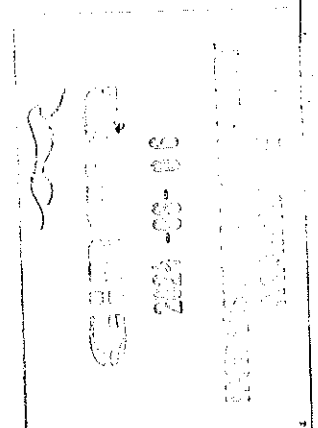
Monitoring and Measuring Instrument Control - Used for Special Process



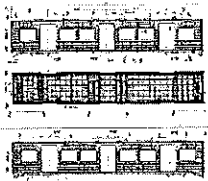
Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULAR	3'28'23-2	15/03/24	✓			
30 M TAPE	6187P0084	14/03/24	✓			
LASER TAPE	125425924	08/01/24	✓			

1.3 Consumables


Welding Consumable Control - Used for Special Process

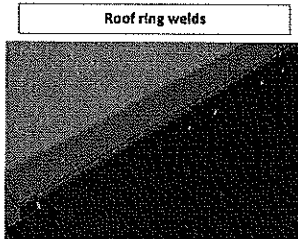
Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
AUTRON 308LS	95271880	MIG	✓			
ER 309 LSI	318394	MIG	✓			



		CARBODYSHELL M1 ASSEMBLY DTR30226487/3		Rev. 28	Project: PRASA SI.CB1210.254.V28	
				Date 07/11/2023		
II - Self Inspection - Items to Check						
II.1 - Items to check						
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls, Endframes, Roof and Underframe)	DT00000311225	✓	M/10 14/05/24	S 14/05/24
02	N/A	Corshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	M/10 14/05/24	S 14/05/24
03	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓	M/10 14/05/24	S 14/05/24
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	M/10 14/05/24	S 14/05/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	M/10 14/05/24	S 14/05/24
06		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓	M/10 14/05/24	S 14/05/24
07	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓	M/10 14/05/24	S 14/05/24

2023-05-15
 14:00:00
 14/05/24

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Welder Traceability			

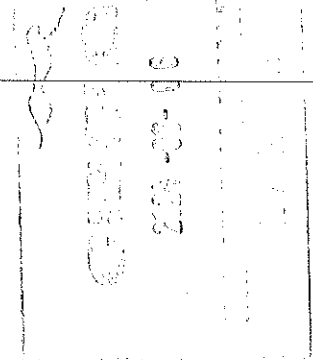



<u>LHS</u>	
Boiler maker (Name & Sign): <u>LAWRENCE [Signature]</u>	Welder (Name & Sign): <u>[Signature]</u>
<u>RHS</u>	
Boiler maker (Name & Sign): <u>PONTSO [Signature]</u>	Welder (Name & Sign): <u>[Signature]</u>



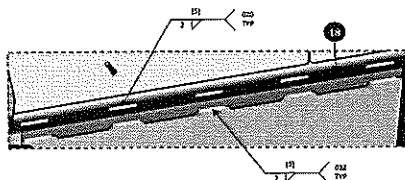
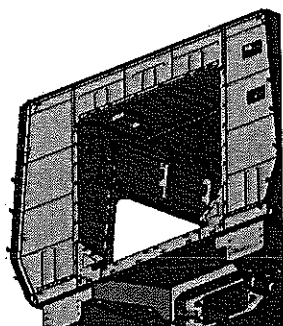
<u>LHS</u>	
Boiler maker (Name & Sign): <u>GERARD [Signature]</u>	
Welder (Name & Sign): <u>MITHOKOZISI [Signature]</u>	

<u>RHS</u>	
Boiler maker (Name & Sign): <u>GERARD [Signature]</u>	
Welder (Name & Sign): <u>MITHOKOZISI [Signature]</u>	



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EUF Reinforcement Plates

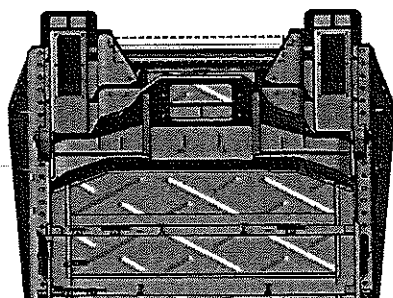


END 1

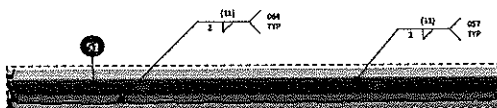
Boiler maker (Name & Sign): GEFALD G. Mab

Welder (Name & Sign): KEITH K. Mase

END 2



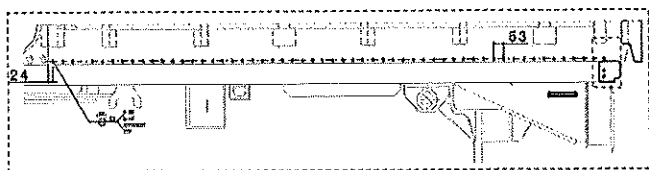
Underneath the CAR



END 2

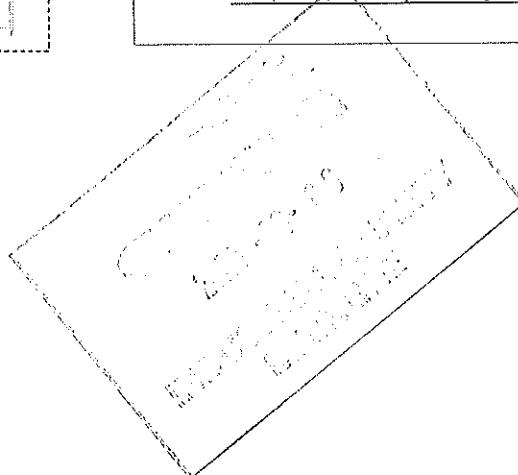
Boiler maker (Name & Sign): Innocent M.


Welder (Name & Sign): BOBBY B.



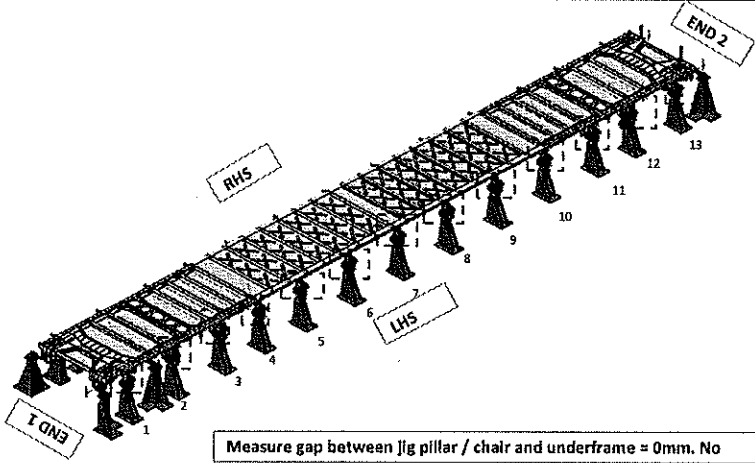
FEDOLI

OPERATOR: SIPHOKAZI



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

Specifications of Details for CBS measurement



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	00	10	000	000	11	0000							
Right Hand Side	1	00	000	000	000	000	000	000	1	00			

Signature Operations:

Date: 14/05/24

After Welding.

Fill in the gap found each jig pillars / chair and underframe should be 0mm.

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side	0	000	000	000	000	000	000	000	000	000	000	000	000
Right Hand Side	0	0	000	000	000	000	000	000	000	000	000	000	000

Signature Industrial Quality:

Date: 14/05/24

Handwritten notes and stamps on the right side of the page, including a large rectangular stamp with illegible text and some scribbles.



CARBODYSHELL M1 ASSEMBLY DTR30225487/3

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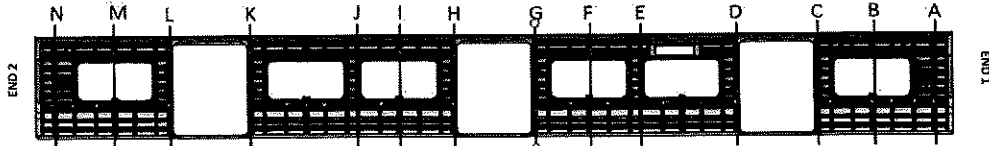
Date

07/11/2023

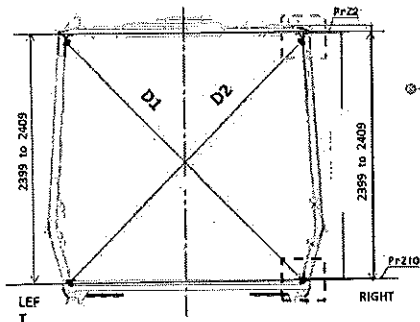
Project: PRASA

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Specifications of Details for CBS measurement



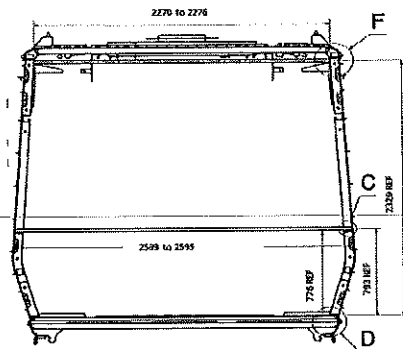
9



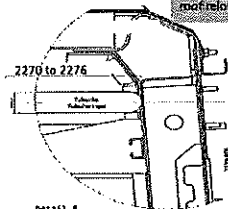
Measurement positions on roof rail and sidewall omega corner



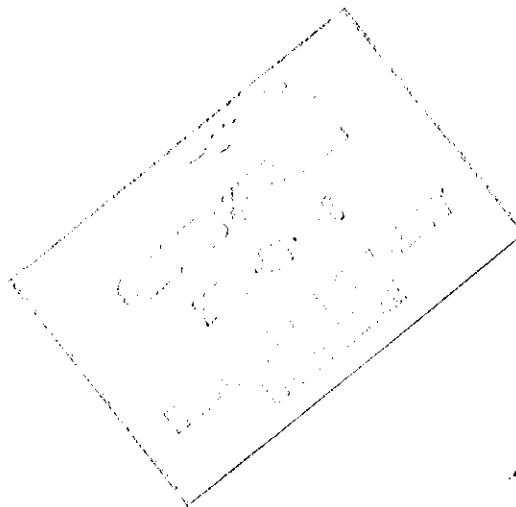
Measurement positions on sidewall and side sill corner



Reinforcement area measurement positions on roof reinforcement area



Don't measure the roof reinforcement

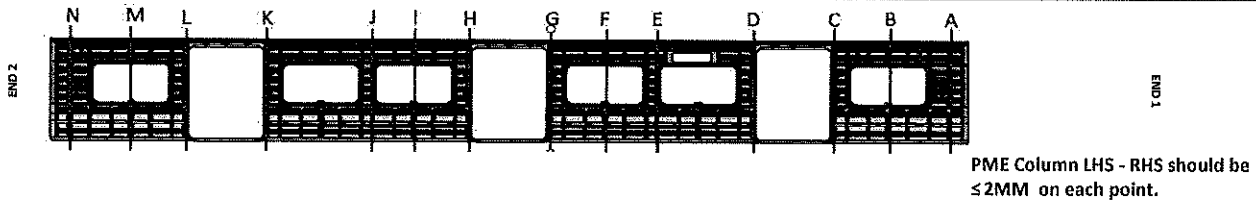




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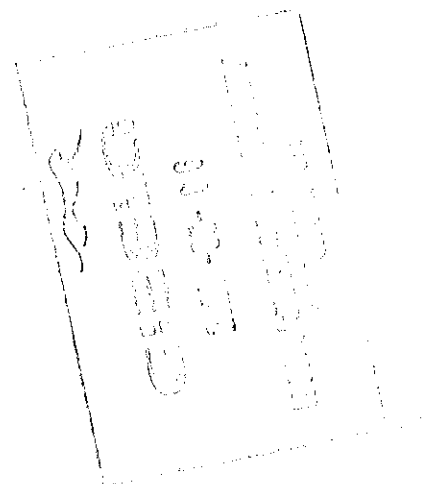
Specifications of Details for CBS measurement



BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3268	3268	0	2406	2407	1
B	3269	3266	3	2405	2406	1
C	3268	3268	0	2405	2404	1
D	3268	3269	1	2406	2404	2
E	3266	3265	1	2405	2405	0
F	3265	3265	0	2404	2405	1
G	3268	3267	1	2405	2406	1
H	3267	3267	0	2406	2407	1
I	3264	3265	1	2404	2405	1
J	3266	3266	0	2406	2406	0
K	3268	3268	0	2405	2405	0
L	3267	3268	1	2406	2407	1
M	3265	3269	3	2405	2406	1
N	3270	3269	1	2408	2407	1

14/05/24

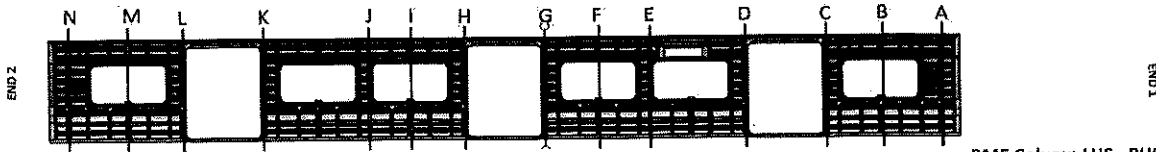




CARBODYSHELL M1 ASSEMBLY DTR30225487/3

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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	3295	3295	0	2407	2408	1
B	3266	3268	2	2406	2406	0
C	3295	3295	0	2405	2404	1
D	3295	3294	1	2407	2406	1
E	3265	3265	0	2406	2406	0
F	3265	3264	1	2405	2406	1
G	3295	3295	0	2407	2405	2
H	3295	3296	1	2406	2406	0
I	3264	3265	1	2404	2405	1
J	3266	3266	0	2406	2404	2
K	3294	3295	1	2407	2406	1
L	3295	3295	0	2406	2406	0
M	3268	3265	3	2405	2406	1
N	3294	3296	2	2407	2407	0

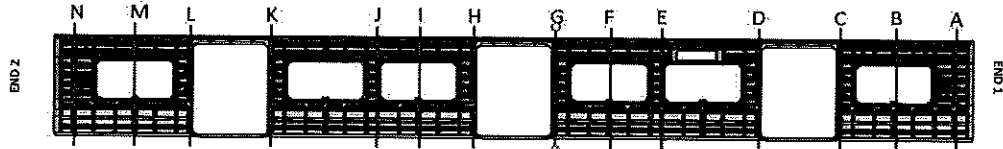
14/05/24



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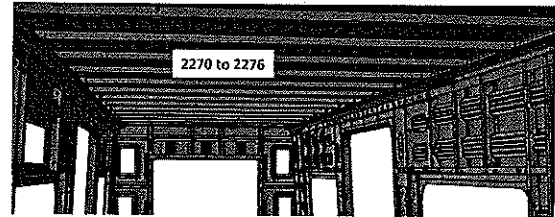
CBS measurement

BEFORE WELDING

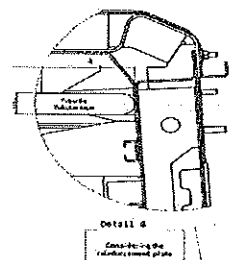
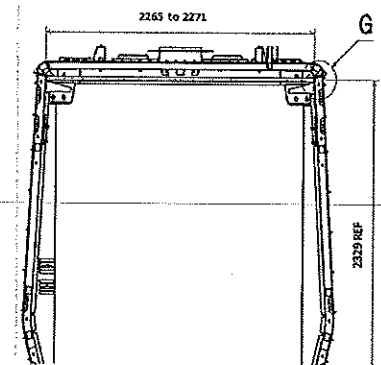


	2270 to 2276
A	2271
B	2274
C	2273
D	2272
E	2278
F	2276
G	2274
H	2272
I	2275
J	2277
K	2270
L	2272
M	2274
N	2271

1990 to



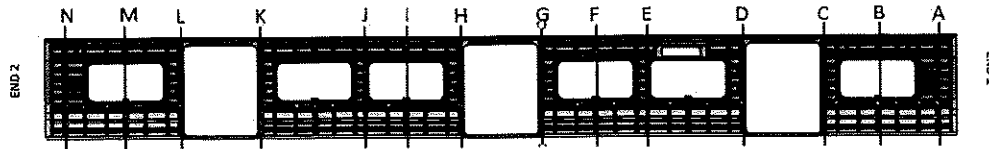
Do not consider reinforcement (Take measurements top area of zee profile



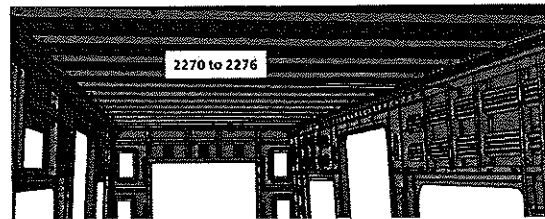
14/05/24

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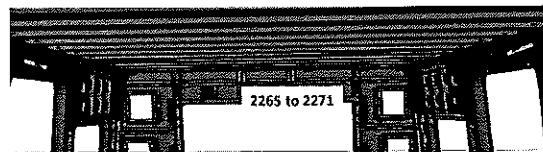
AFTER WELDING



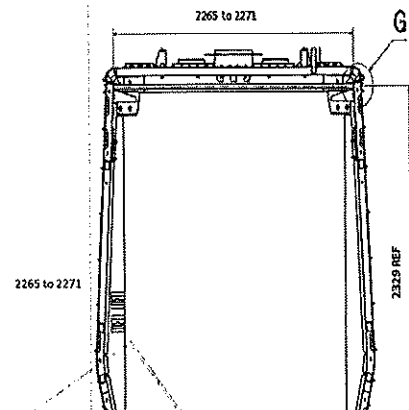
	2265 to 2271	2270 to 2276
A	2266	NA
B	NA	2273
C	2268	NA
D	2269	NA
E	NA	2276
F	NA	2275
G	2265	NA
H	2268	NA
I	NA	2274
J	NA	2276
K	2269	NA
L	2269	NA
M	NA	2274
N	2268	NA



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

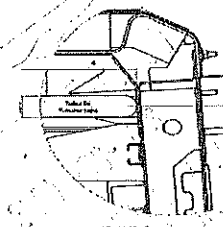


Take measurement close to radius (considering reinforcement)



14/05/24

2265 to 2271



Detail G
Considering the reinforcement plate

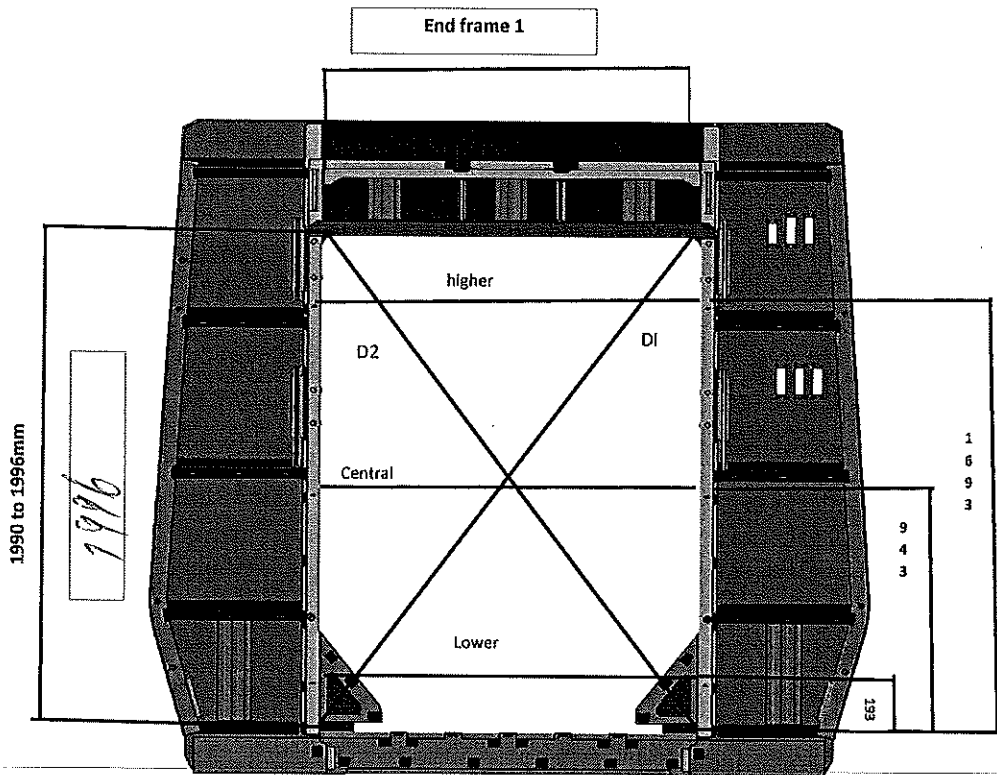


CARBODYSHELL M1 ASSEMBLY DTR30225487/3

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Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3mm$

Higher Dimension

1381

D1

2413

Central Dimension

1381

D2

2413

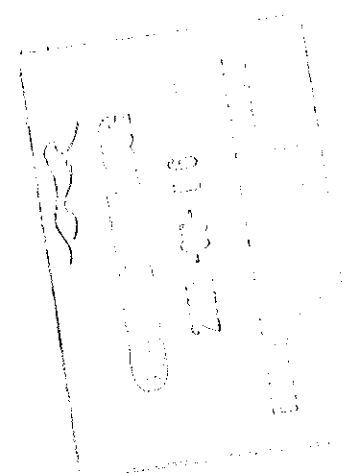
Lower Dimension

1380

D1-D2

0

11/10/2023

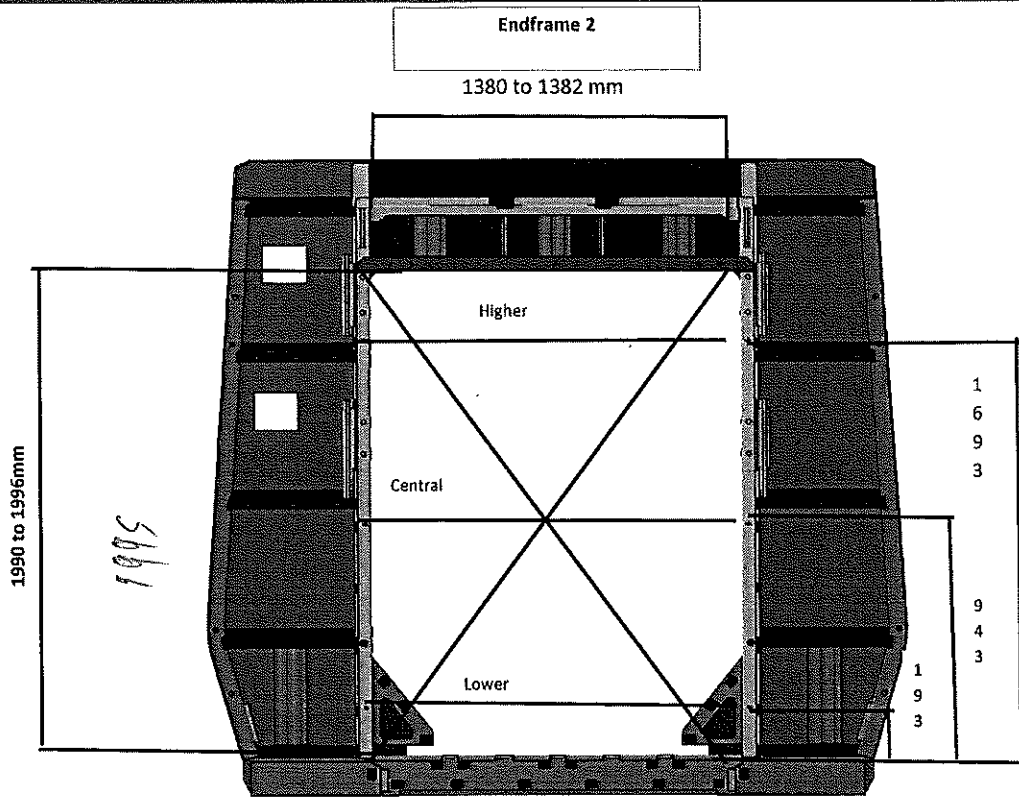




CARBODYSHELL M1 ASSEMBLY DTR30225407/3

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Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1382

D1

2414

Central Dimension

1381

D2

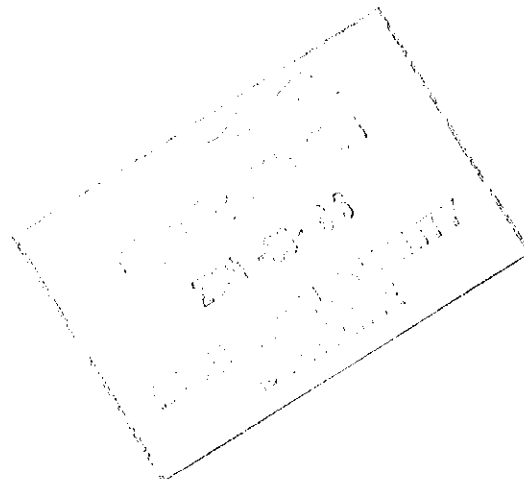
2415

Lower Dimension

1381

D1-D2

1

10
14/05/24

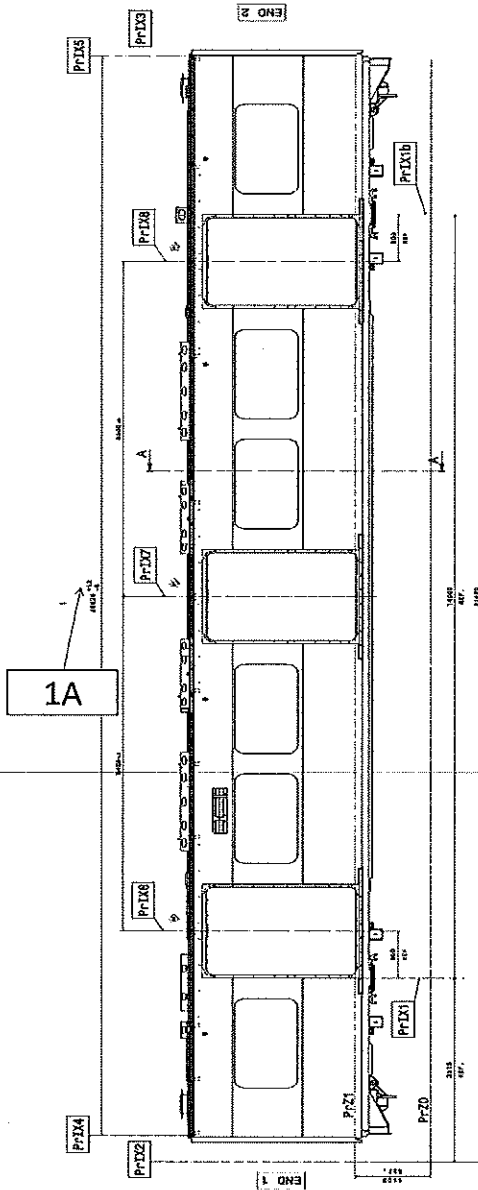


CARBODYSHELL M1 ASSEMBLY DTR30226487/3

Rev.
28
Date
07/11/2023

Project: PRASA
SI.CB1210.254.V28

Specifications of Details for CBS measurement

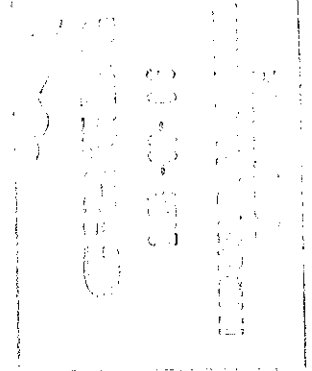



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20616



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

Dye penetrant test

Dye-penetration test to be performed by quality personnel



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

Self Inspection - Final Result						
				DATE	NAME	SIGNATURE
HOLD POINT		GO	(If activities are not complete, the missing activities must not impact the next stage)	14/05/24	LUNGU Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	14/05/24	Ntokoze Industrial Quality	
			There are activities pendings that impact/stop the activities 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)			

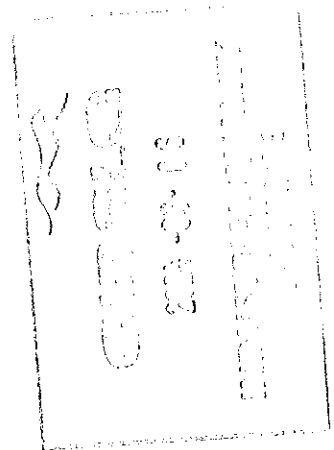
In case of "NO GO", describe blocking problems

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

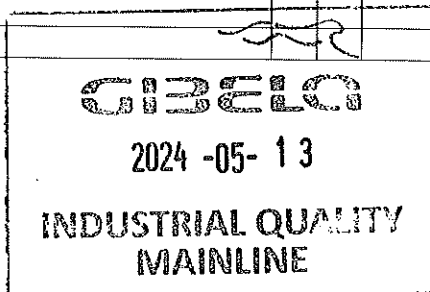
Operations



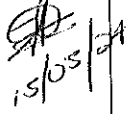
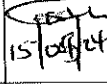

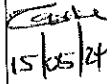

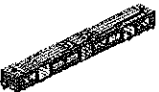
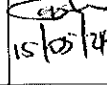
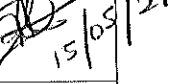
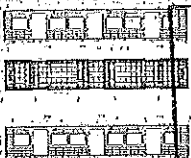
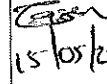
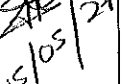



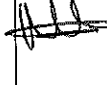

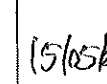
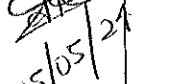

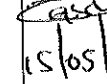
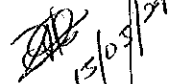
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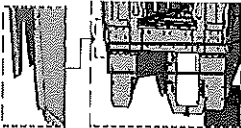
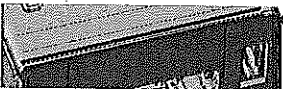


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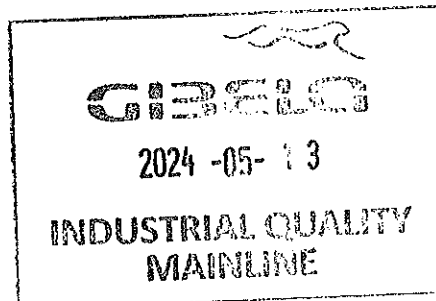


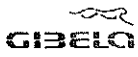
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB1220.250.V29																																					
		29																																						
		Date																																						
				28/10/2023																																				
CAM: M1,M3&M4		NCR:		Work station: CB1220																																				
Safety Related																																								
I - Documentation and Instruments Control																																								
I.1 - Documentation Control																																								
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th rowspan="2" style="width: 25%;">Document</th> <th colspan="5" style="width: 15%;">Type of car</th> <th rowspan="2" style="width: 10%;">Revision</th> <th rowspan="2" style="width: 15%;">Observation</th> <th rowspan="2" style="width: 5%;">OK</th> <th rowspan="2" style="width: 5%;">N/A</th> <th rowspan="2" style="width: 15%;">Signature/Date (Manufacturing)</th> <th rowspan="2" style="width: 10%;">Signature/Date (Quality)</th> </tr> <tr> <th>M1</th> <th>M2</th> <th>M3</th> <th>M4</th> <th>M5</th> </tr> <tr> <td>DTR30225487/2</td> <td style="text-align: center;">X</td> <td></td> <td></td> <td></td> <td></td> <td style="text-align: center;">29</td> <td></td> <td style="text-align: center;">✓</td> <td></td> <td style="text-align: center;">N/A</td> <td> 15/05/24 </td> <td> 15/05/24 </td> </tr> </table>						Document	Type of car					Revision	Observation	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)	M1	M2	M3	M4	M5	DTR30225487/2	X					29		✓		N/A	15/05/24 	 15/05/24					
Document	Type of car						Revision	Observation	OK	N/A	Signature/Date (Manufacturing)							Signature/Date (Quality)																						
	M1	M2	M3	M4	M5																																			
DTR30225487/2	X					29		✓		N/A	15/05/24 	 15/05/24																												
I.2 - Instruments Control																																								
Monitoring and Measuring Instrument Control - Used for Special Process																																								
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th style="width: 20%;">Instruments</th> <th style="width: 15%;">Serial number</th> <th style="width: 25%;">Calibration or Verification Validation Date</th> <th style="width: 5%;">OK</th> <th style="width: 5%;">N/A</th> <th style="width: 20%;">Signature/Date (Manufacturing)</th> <th style="width: 15%;">Signature/Date (Quality)</th> </tr> <tr> <td>measuring tape</td> <td>010190425</td> <td>17/04/24 - 17/04/25</td> <td style="text-align: center;">✓</td> <td></td> <td>15/05/24</td> <td> 15/05/24 </td> </tr> <tr> <td>Tubular</td> <td>32.823-3</td> <td>15/03/24 - 15/03/25</td> <td style="text-align: center;">✓</td> <td></td> <td>15/05/24</td> <td> 15/05/24 </td> </tr> <tr> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> </tr> </table>						Instruments	Serial number	Calibration or Verification Validation Date	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)	measuring tape	010190425	17/04/24 - 17/04/25	✓		15/05/24	 15/05/24	Tubular	32.823-3	15/03/24 - 15/03/25	✓		15/05/24	 15/05/24														
Instruments	Serial number	Calibration or Verification Validation Date	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)																																		
measuring tape	010190425	17/04/24 - 17/04/25	✓		15/05/24	 15/05/24																																		
Tubular	32.823-3	15/03/24 - 15/03/25	✓		15/05/24	 15/05/24																																		
1.3 Consumables																																								
Welding Consumable Control - Used for Special Process																																								
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th style="width: 20%;">Filler Material</th> <th style="width: 15%;">Heat Number</th> <th style="width: 25%;">Welding Process</th> <th style="width: 5%;">OK</th> <th style="width: 5%;">N/A</th> <th style="width: 20%;">Signature/Date (Manufacturing)</th> <th style="width: 15%;">Signature/Date (Quality)</th> </tr> <tr> <td>308 LSI</td> <td>373779</td> <td>mig welding</td> <td style="text-align: center;">✓</td> <td></td> <td>15/05/24</td> <td> 15/05/24 </td> </tr> <tr> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> </tr> <tr> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> </tr> <tr> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> </tr> </table>						Filler Material	Heat Number	Welding Process	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)	308 LSI	373779	mig welding	✓		15/05/24	 15/05/24																					
Filler Material	Heat Number	Welding Process	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)																																		
308 LSI	373779	mig welding	✓		15/05/24	 15/05/24																																		



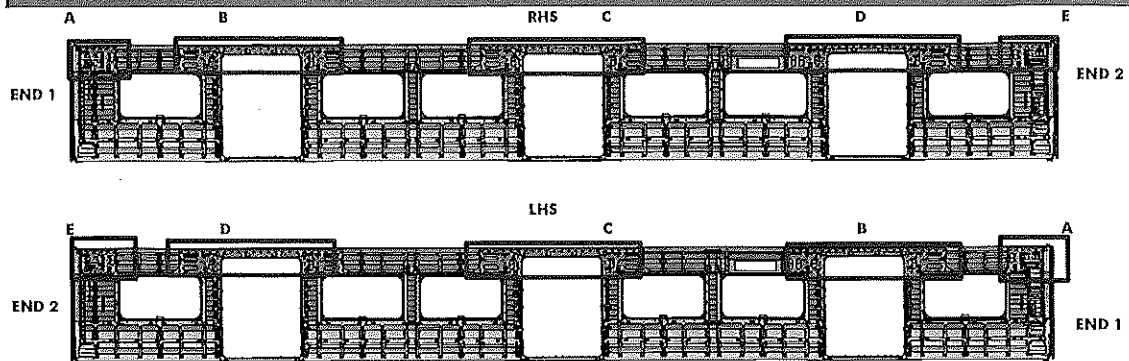
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29	Project: PRASA SI.CB1220.250.V29				
		Date 28/10/2023					
II - Self Inspection - Items to Check							
II.1 - Items to check							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Not OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB1220.DTR30225487/2	✓		 15/05/24	 15/05/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		 15/05/24	 15/05/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 15/05/24	 15/05/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 15/05/24	 15/05/24
05		Functionals dimensions approved according drawing or manufacturing documents approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		 15/05/24	 15/05/24
06		INDUSTRIAL QUALITY MAINTENANCE Run by penetrant testing in electric arc welding (welding procedure IND-SAL-WMS-016 and DTD0000210658). Run by penetrant testing (welding) and fillet sampling as described in DTD0000210658.		✓		 15/05/24	 15/05/24
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 (I) Min - Max 10°C - 35°C Relative humidity Min - Max (I) 25% - 60% Actuals Temperature: 19 Humidity: 48	Sealant Batch No: 153497/100/24 Exp Date: 1.05.24	✓		 15/05/24	 15/05/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓		 15/05/24	 15/05/24
09		Verification of safety welds	Approved according to DTD000210658 reference and Self inspection	✓		 15/05/24	 15/05/24

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB1220.250.V29
		29	
		Date	
		28/10/2023	
II - Self Inspection - Items to Check			
SEALANT APPLICATION			
		AREA 1 & 2 END 1	
		Operator (Name & sign): Mthohoziso 	
		Operator (Name & sign): Mthohoziso 	

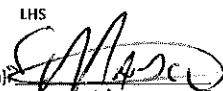
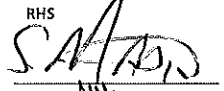
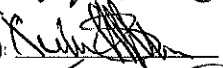

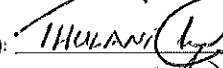
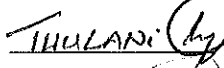
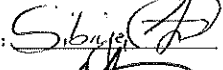
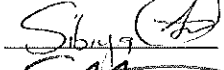
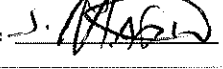



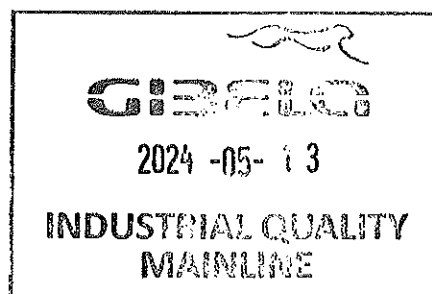
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA
		29	
		Date	
		28/10/2023	SI.CB1220.250.V29


II - Self Inspection - Items to Check

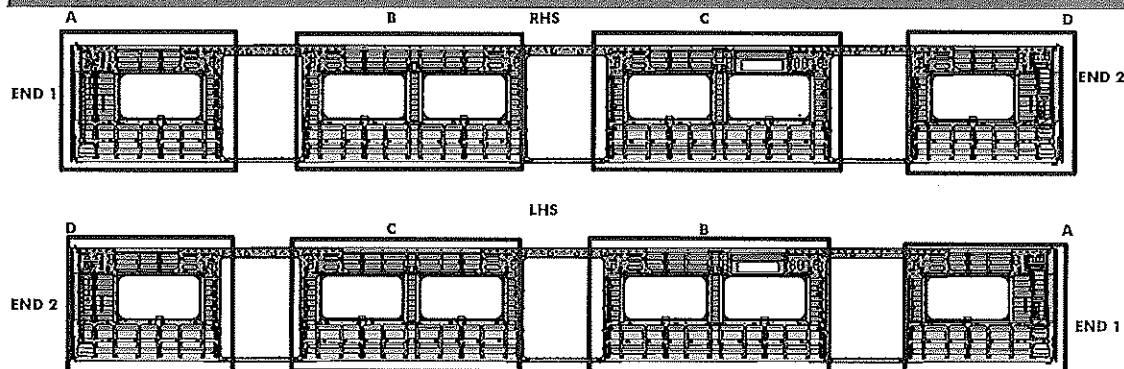


REINFORCEMENT WELDING

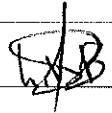
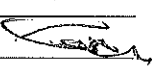
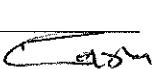


AREA	LHS	RHS
A	Operator (Name&sign): 	
B	Operator (Name&sign): 	
C	Operator (Name&sign): THULANI 	THULANI 
D	Operator (Name&sign): Sibisi 	Sibisi 
E	Operator (Name&sign): S. MABENI 	

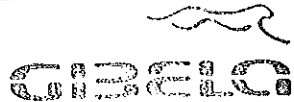


	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29	Project: PRASA SI.CB1220.250.V29
		Date 28/10/2023	
II - Self Inspection - Items to Check			




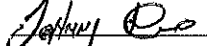





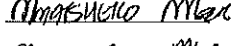
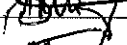
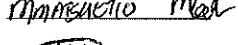
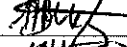
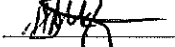
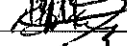





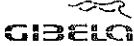
BRACKETING

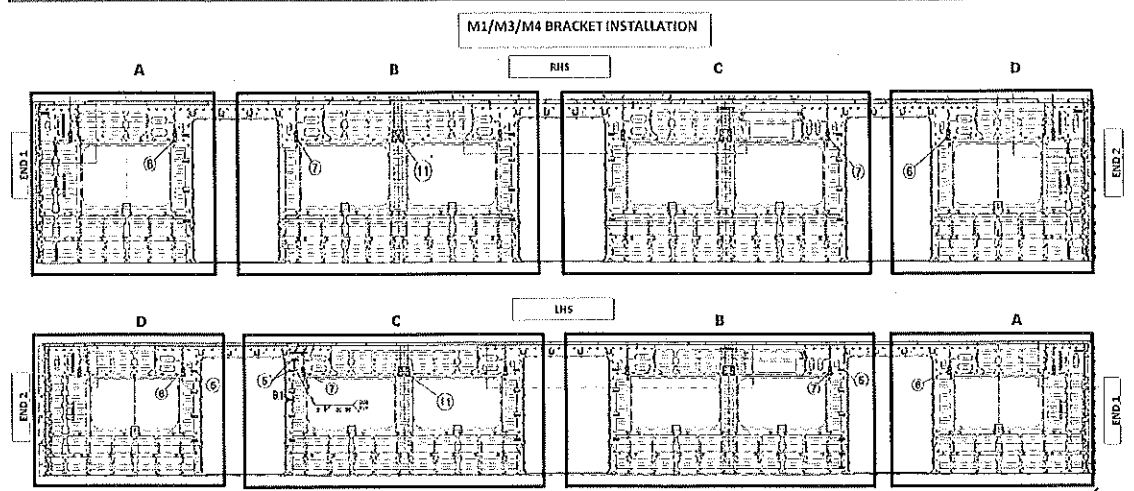
C-RAILS:		Operator:	<div>INSTALLATION</div> Lini 
		Operator:	
DOOR MECHANISMS:		Operator:	Piscilla 
		Operator:	
TAPPING PADS		Operator:	Piscilla 
		Operator:	
SEAT & LUGGAGE BRACKETS:		Operator:	<div>INSTALLATION & VERIFICATION</div> Tetele 
		Operator:	
SEAT BRACKETS VERIFICATION:		Operator:	Tetele 
		Operator:	


2024 -05- 13
INDUSTRIAL QUALITY
MAINLINE

WELDING

AREA	LHS	RHS
A (Seat brackets)	: Operator (Name&sign): LINDO 	LINDO 
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): LINDO 	Johny 
B (Seat brackets)	: Operator (Name&sign): LINDO 	Johny 
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): LINDO 	Johny 
C (Seat brackets)	: Operator (Name&sign): MARIUSCU MARIU 	MARIUSCU MARIU 
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): 	MARIUSCU MARIU 
D (Seat brackets)	Operator (Name&sign): 	
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): 	MARIUSCU MARIU 
<div>ENDS</div>		
END 1 TAPPING PADS WELDING:	Operator (Name&sign): Kulya 	
END 1 TAPPING PADS WELDING:	Operator (Name&sign): Kulya 	

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

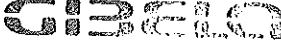


QUANTITIES (M3/M4)				
RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7		
	B	4		
	C	8		
	D	8		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	5		
	C	4		
	D	3		
ROOF ENDS: CRAILS 2 OFF EACH END EARTH BUSH 6 OFF EACH END VERIFICATION BY: <u>N/A</u>				

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	8		
	C	11		
	D	8		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	5		
	C	6		
	D	2		
ROOF ENDS: CRAILS 2 OFF EACH END EARTH BUSH 6 OFF EACH END VERIFICATION BY: <u>N/A</u>				

QUANTITIES (M1)				
RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7	✓	
	B	8	✓	
	C	8	✓	
	D	8	✓	
SEAT BRACKETS	A	13	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	2	✓	
	B	4	✓	
	C	5	✓	
	D	3	✓	
ROOF ENDS: CRAILS 2 OFF EACH END EARTH BUSH 6 OFF EACH END VERIFICATION BY: <u>[Signature]</u>				

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2	✓	
	B	10	✓	
	C	11	✓	
	D	8	✓	
SEAT BRACKETS	A	13	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	3	✓	
	B	7	✓	
	C	6	✓	
	D	2	✓	
ROOF ENDS: CRAILS 2 OFF EACH END EARTH BUSH 6 OFF EACH END VERIFICATION BY: <u>[Signature]</u>				



2024 -05- 13

INDUSTRIAL QUALITY

MAINLINE

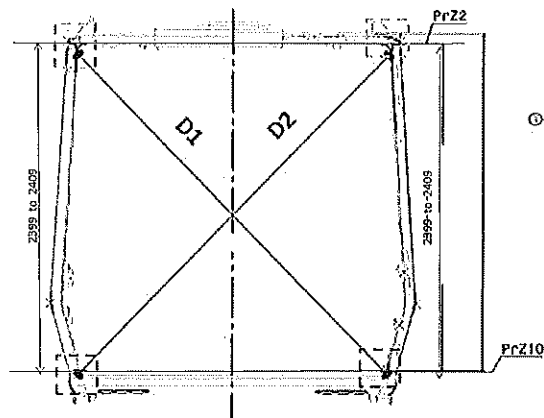


CARBODYSHELL M1,M3,M4 ASSEMBLY
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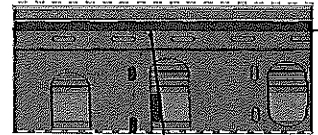
Specifications of Details for CBS measurement



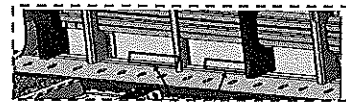
①



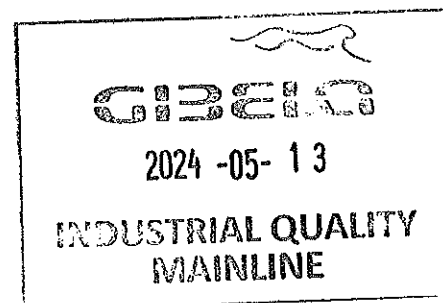
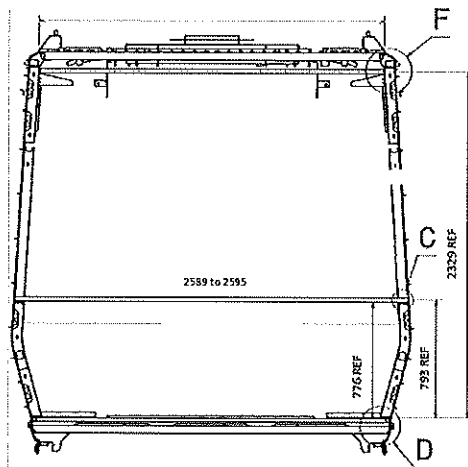
Measurement positions on roof rail and sidewall omega corner.

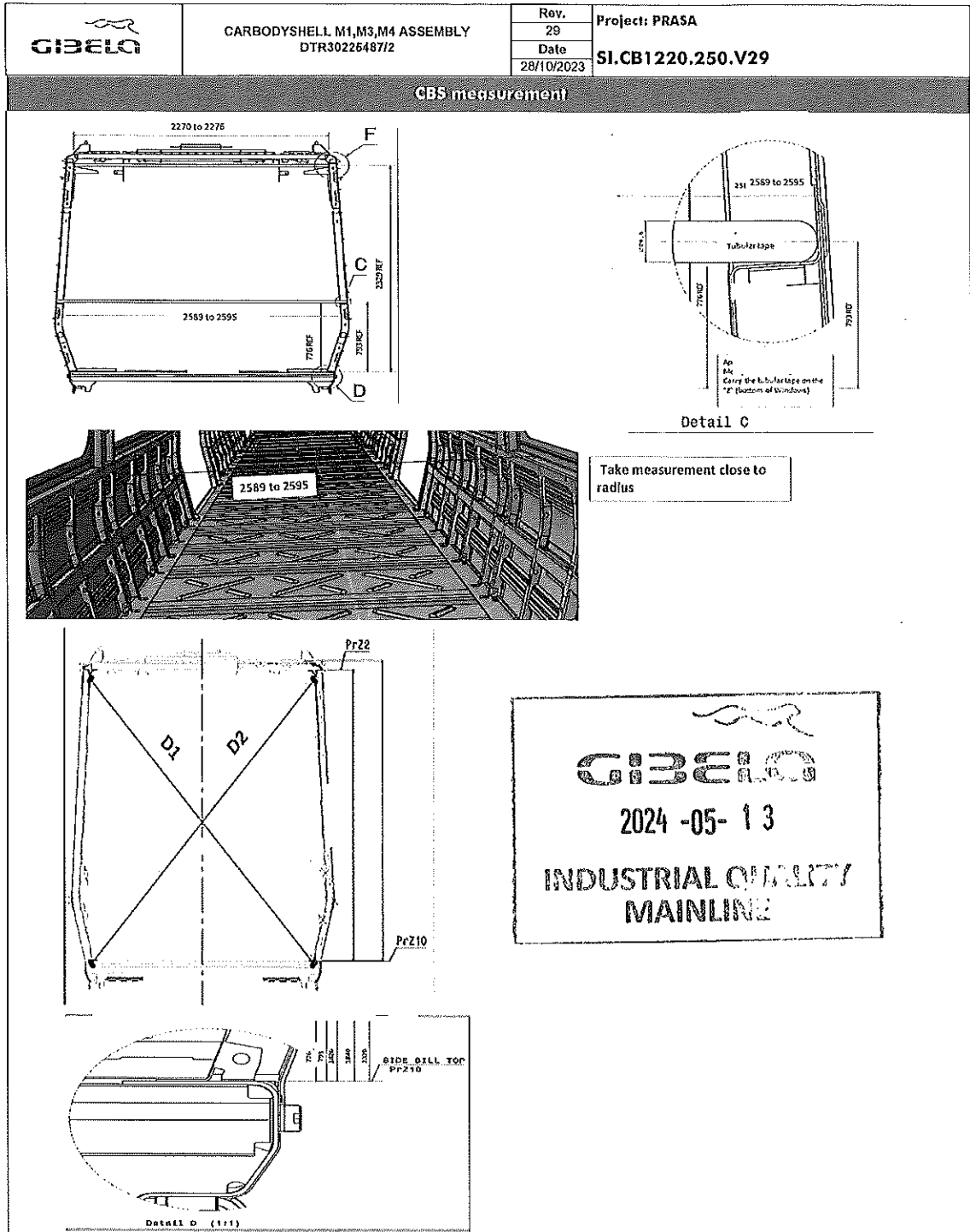



Reinforcement area measurement positions on roof reinforcement area.

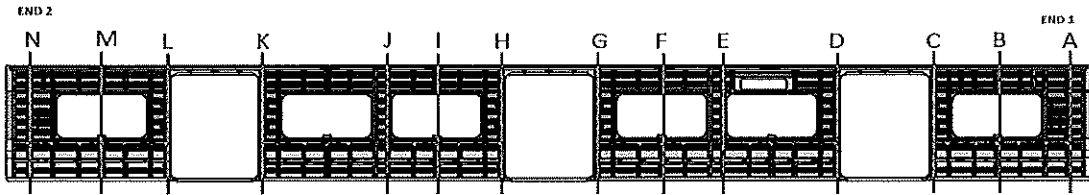


Measurement positions on sidewall and side sill corner.



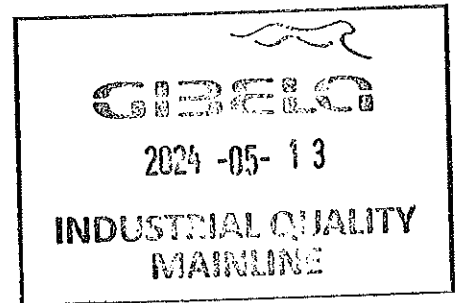



	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB1220.250.V29
		29	
		Date	
		28/10/2023	
CBS measurement			



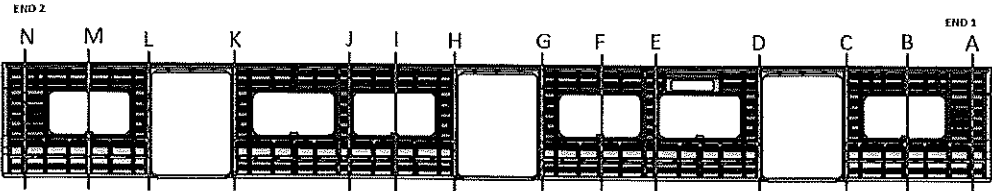
BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3300	3300	0	
B	3265	3270	5	
C	3296	3297	3	
D	3297	3300	3	
E	3265	3264	1	
F	3265	3264	1	
G	3297	3296	1	
H	3295	3300	5	
I	3266	3265	1	
J	3264	3269	5	
K	3297	3295	2	
L	3297	3296	1	
M	3267	3266	1	
N	3300	3297	3	



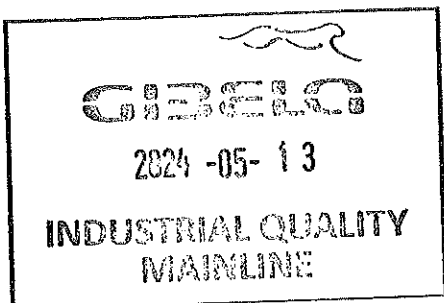
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB1220.250.V29
		29	
		Date	
		28/10/2023	

CBS measurement

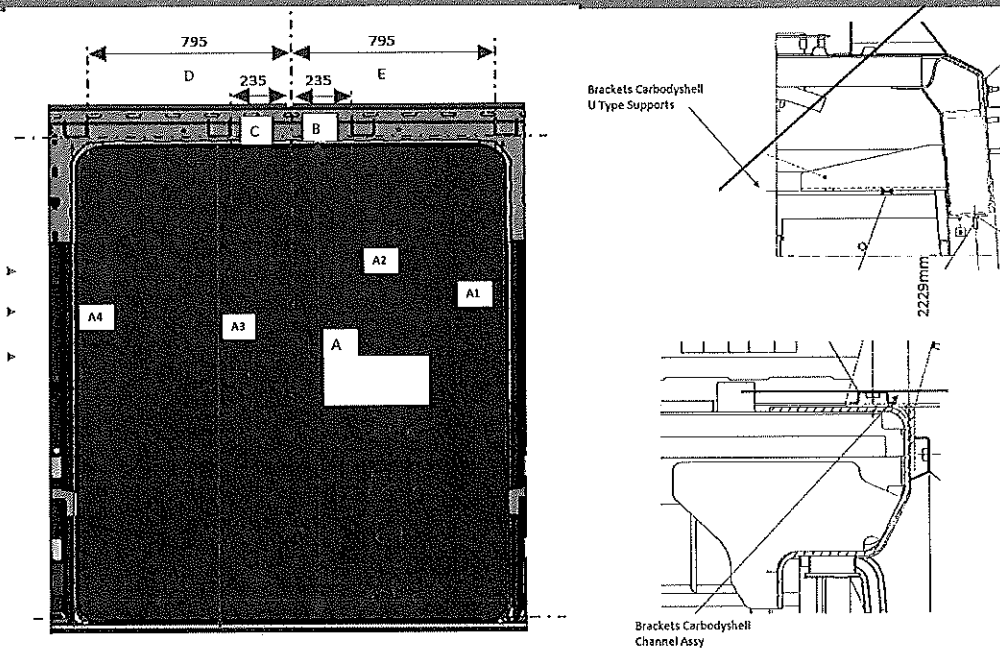


AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3299	3298	1	2595
B	3285	3266	3	2591
C	3295	3293	2	2589
D	3299	3296	3	2595
E	3260	3262	2	2595
F	3265	3265	0	2595
G	3295	3295	0	2595
H	3295	3298	3	2595
I	3262	3265	3	2595
J	3265	3262	3	2595
K	3293	3295	2	2594
L	3296	3295	1	2595
M	3265	3266	1	2595
N	3299	3295	4	2595



Specifications of Details for GBS measurement CB1220



DOOR 1 - LHS		
	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2232
A3	2230 to 2232	2233
A4	2230 to 2232	2233
B	234 to 236	234
C	234 to 236	235
D	794 to 796	795
E	794 to 796	796

DOOR 2 - LHS		
	VALUE	ACTUAL
A1	2230 to 2232	2233
A2	2230 to 2232	2233
A3	2230 to 2232	2233
A4	2230 to 2232	2232
B	234 to 236	234
C	234 to 236	235
D	794 to 796	796
E	794 to 796	794

DOOR 2 - RHS		
	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2230
A3	2230 to 2232	2233
A4	2230 to 2232	2233
B	234 to 236	236
C	234 to 236	235
D	794 to 796	794
E	794 to 796	795

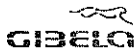
DOOR 1 - RHS		
	VALUE	ACTUAL
A1	2230 to 2232	2233
A2	2230 to 2232	2233
A3	2230 to 2232	2232
A4	2230 to 2232	2232
B	234 to 236	235
C	234 to 236	236
D	794 to 796	795
E	794 to 796	794

DOOR 2 - RHS		
	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2232
A3	2230 to 2232	2233
A4	2230 to 2232	2233
B	234 to 236	236
C	234 to 236	234
D	794 to 796	794
E	794 to 796	794

DOOR 3 - RHS		
	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2230
A3	2230 to 2232	2232
A4	2230 to 2232	2233
B	234 to 236	234
C	234 to 236	235
D	794 to 796	794
E	794 to 796	795

2024-05-13

INDUSTRIAL QUALITY
MAINLINE



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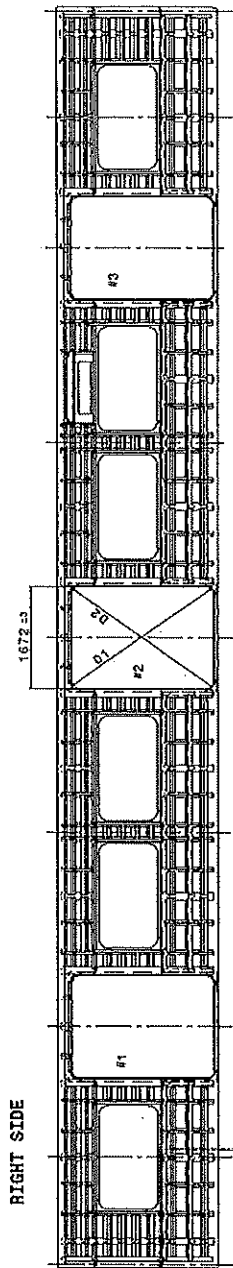
Project: PRASA

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Specifications of Details for CB5 measurement CB1220

End #2

End #1



Doors diagonal D1-D2 maximum difference ≤4mm

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

#1	#2	#3
HIGHER DIMENSION	1671	1670
CENTRAL DIMENSION	1672	1670
LOWER DIMENSION	1671	1671

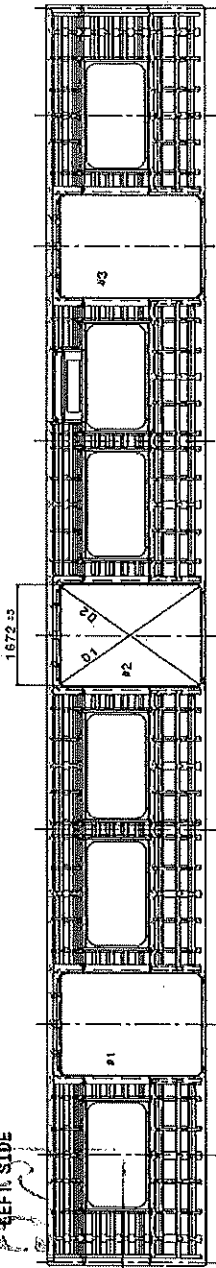
Doors Length - 1672 ±3mm

RIGHT SIDE

End #1

2024 -05- 13

LEFT SIDE



Doors diagonal D1-D2 maximum difference ≤4mm

#1	#2	#3
D1	2743	2745
D2	2747	2747
D1-D2	1	1


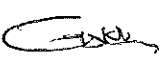

#1	#2	#3
HIGHER DIMENSION	1673	1670
CENTRAL DIMENSION	1673	1671
LOWER DIMENSION	1670	1670

Doors Length - 1672 ±3mm

End #2

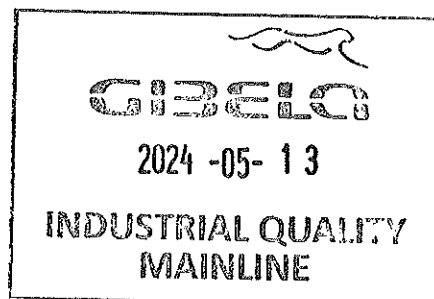
INDUSTRIAL QUALITY
MAINLINE

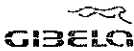
Caron

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB1220.250.V29		
		29			
		Date			
		28/10/2023			
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	(if activities are not complete, the missing activities must not impact the next stage)	15/05/24	Pascilla <small>Operations</small>	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party)	15/05/24	Arno <small>Industrial Quality</small>	
	NO GO	There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)		<small>Operations</small>	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)		<small>Industrial Quality</small>	
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	

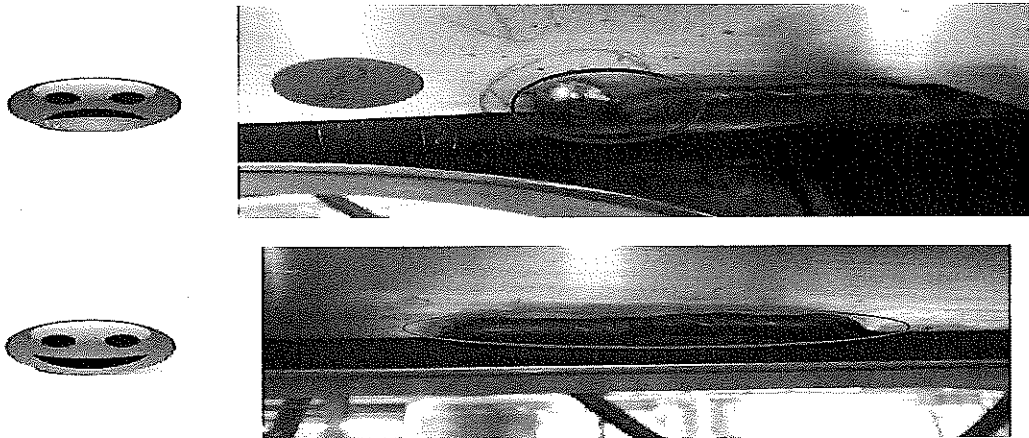
Operations

Quality

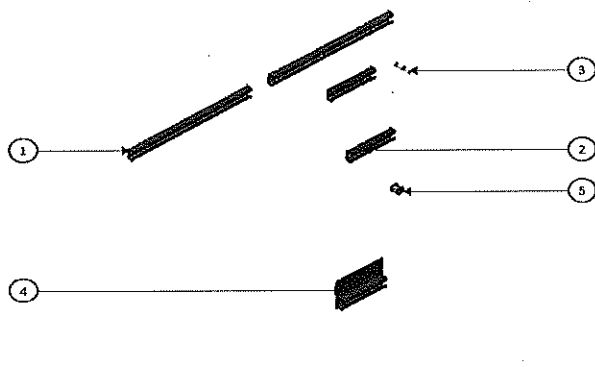


	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB1220.250.V29
		29	
		Date 28/10/2023	

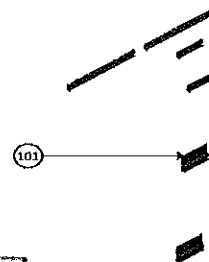
ANNEXURE A: Arc Welding Quality Acceptance Standard



Station: CB1220-004- U108 & U107



PART NO.	ITEM NO.	QTY	DESCRIPTION	MASS (KG)
DTF0000076003	5	6	EARTH STUD 6	0.096
AJ00001201648	4	6	ASSEMBLY SUPPORT	0.271
DTF0000344306	3	12	WELDING STUD ISO13918 PT-M20x20-SS7	0.007
AJ00001162424	2	12	ASSEMBLY SUPPORT	0.193
AJ00001164438	1	14	ASSEMBLY SUPPORT	0.522
AJ00001161080	101	6	CARBODYSHELL BRACKETS CARBODYSHELL M1/M3/M4 CAR[SIDE FRAME MODULE EHO - GPP]	12.132




APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

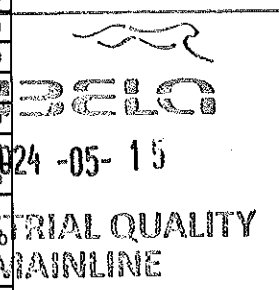
CONFIDENTIAL INFORMATION


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.

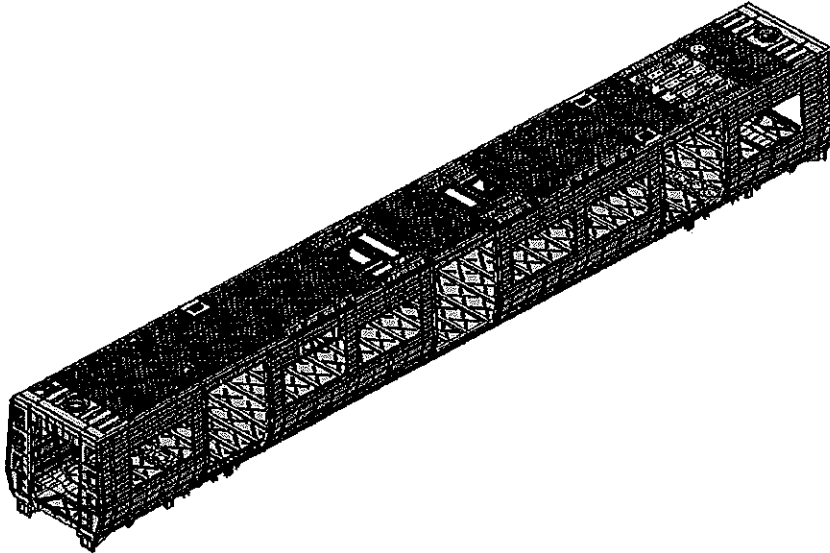
APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ? 
				TC1	M4	M1	M2	M3	TC2		
<input type="checkbox"/>	DT00000225487	AAD0001278566	CARBOODYSHELL M1, M3, M4 ASSEMBLY	CB1230		X	X		X	PRA.CB1230.DT000002 25487.V20	YES
<input type="checkbox"/>											
<input type="checkbox"/>											

	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
			COMPILER	Nosizo Pindela	2018/08/02
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	30/5/2018
			CHECKER	Nosizo Pindela	30/5/2018
			REVISED BY	Nosizo Pindela	30/5/2018
2	2018/05/07	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	2018/05/07
			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
			REVISED BY	Vanessa Ntuli	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
			REVISED BY	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
			REVISED BY	Nosizo Pindela	23/08/2019
11	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
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	20/02/2022
			CHECKER	Andani Muthelo	20/02/2022
			REVISED BY	Andani Muthelo	20/02/2022
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbhombhi	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	APPROVER	Collins Mbhombhi	19/10/2022
			CHECKER	Ntokozo Zwane	19/10/2022
			REVISED BY	Amogelang Mohlampe	19/10/2022
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	14/04/2023
			REVISED BY	Amogelang Mohlampe	14/04/2023
29	06/11/2023	Added thresholds traceability for boiler makers and welders	APPROVER	Tyson Ngobeni	06/11/2023
			CHECKER	Andani Muthelo	06/11/2023
			REVISED BY	Ntokozo Zwane	06/11/2023
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
227	MO1	mmathapelo 483004	15/05/24	SI.CB1230.256.V28	11

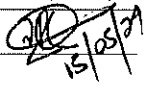


	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 29	Project: PRASA SI.CB1230.256.V28
		Date	
		06/11/2023	
Car:	NCR:	Work station: CB1230	



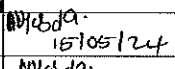
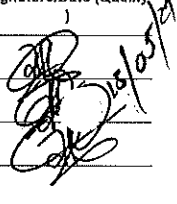
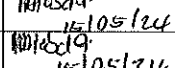
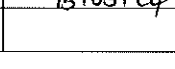
I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car					Revision	Observation	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4	TC2						
PRA.CB1230.DT00000225487	✓							✓		N/A	 15/05/24

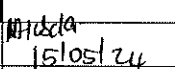
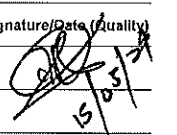
I.2 - Instruments Control

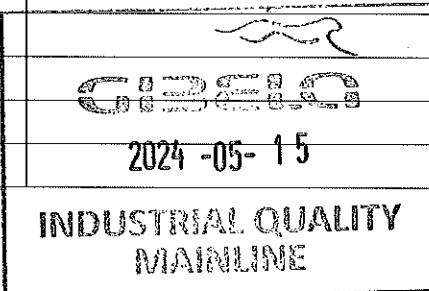
Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
Tubular	32823-3	15/03/2025	✓		 15/05/24	 15/05/24
measuring Tape	4180794	25/04/24	✓		 15/05/24	
combination square	01130002	27/02/24	✓		 15/05/24	

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308 LSi	37379	MIG	✓		 15/05/24	 15/05/24





CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.

29

Date

06/11/2023

Project: PRASA

SI.CB1230.256.V28

II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NO	Not OK	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering nº PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	✓			M. Bda. 15/05/24	 15/05/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓			M. Bda. 15/05/24	 15/05/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓			M. Bda. 15/05/24	 15/05/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓			M. Bda. 15/05/24	 15/05/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			M. Bda. 15/05/24	 15/05/24
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓			M. Bda. 15/05/24	 15/05/24
07	N/A	2024 -05- 15 INDUSTRIAL QUALITY MAINLINE Before applying 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 (1) Min-Max 10°C - 35°C Relative humidity Min - Max (1) Min-Max 25% - 80%	Sealant Batch No: 112240 Exp Date: 09 / June / 24 Actuals Temperature: 20,9°C Humidity: 41%	✓			M. Bda. 15/05/24	 15/05/24
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.	✓			M. Bda. 15/05/24	 15/05/24

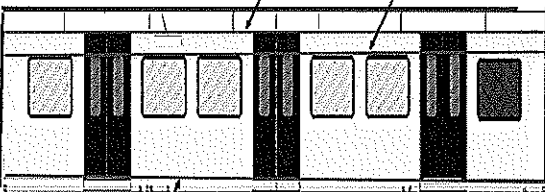
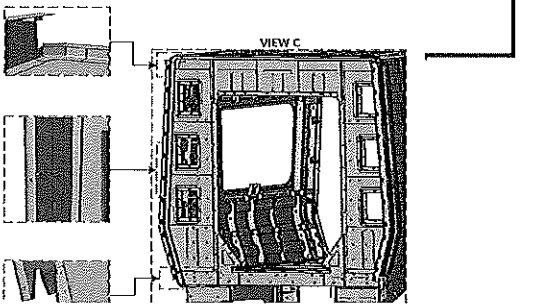
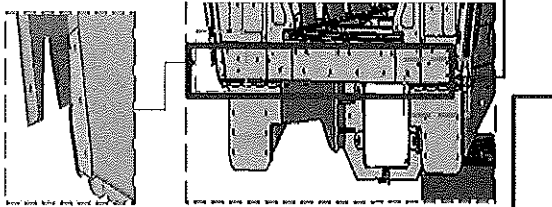


CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

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AREA 1



END 2 SEALANT

OPERATOR
(Name & sign):

Leroy

OPERATOR
(Name & sign):

Leroy

OPERATOR
(Name & sign):

Lerato
Boitumelo

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

Operator (Name & sign):

Operator (Name & sign): Lerato

Operator (Name & sign): Mhankhlo

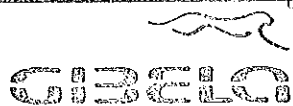
Operator (Name & sign): _____

Operator (Name & sign): _____

Operator (Name & sign): _____

RHS

DE,F,G,H,I
Buhle
DE,F,G,H,I
Boitumelo



2024 -05- 15

INDUSTRIAL QUALITY
MAINLINE



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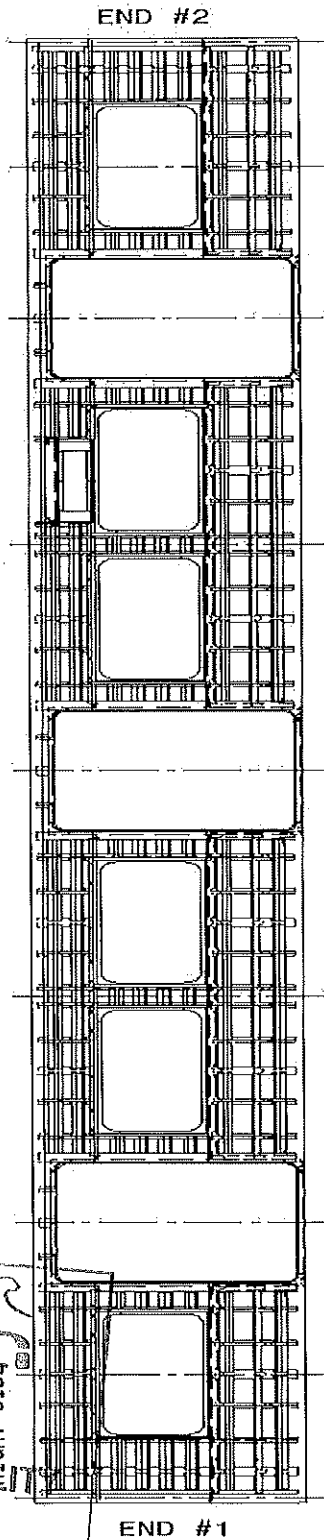
SI.CB1230.256.V28

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 found and indicate the corresponding region.

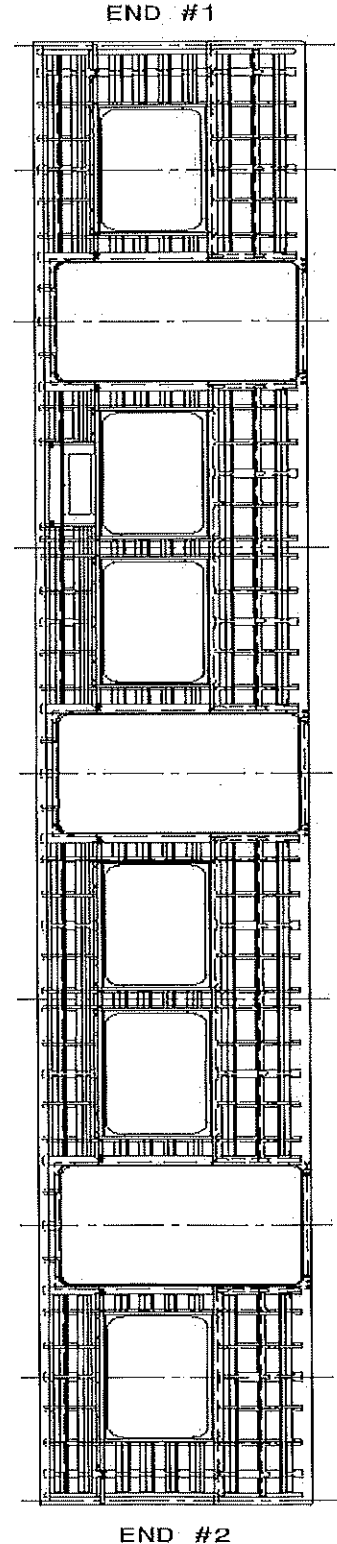
2024-05-15

INDUSTRIAL QUALITY
LINE



1-7
MAXIMUM
1-2
MINIMUM

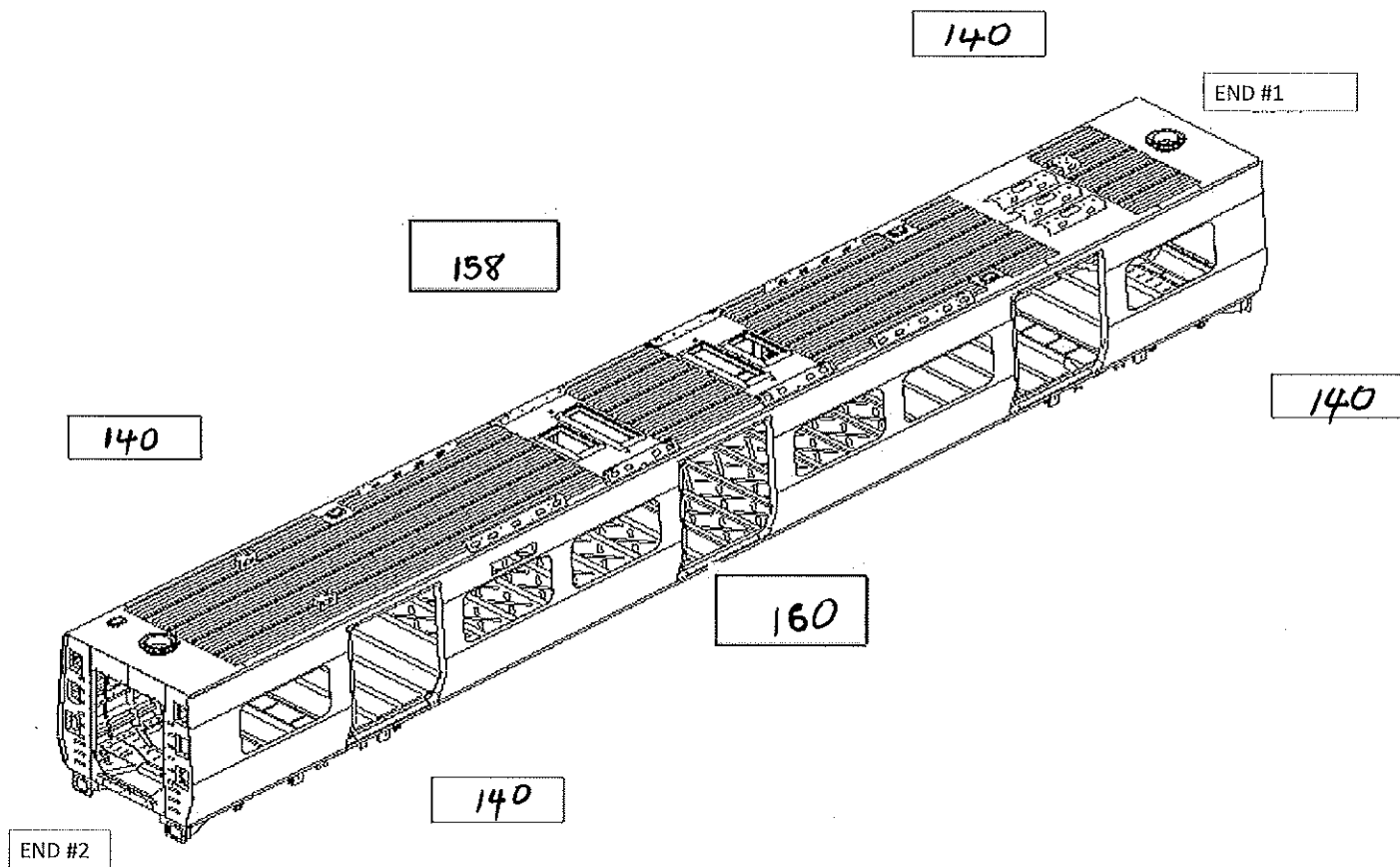
LEFT SIDE



1-6
MAXIMUM
1-4
MINIMUM

Specifications of Details for CBS measurement CB1230

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



MEASURED CAMBER VALUES

RIGHT	¹ _e	20
LEFT	^{a1} _{a1}	18



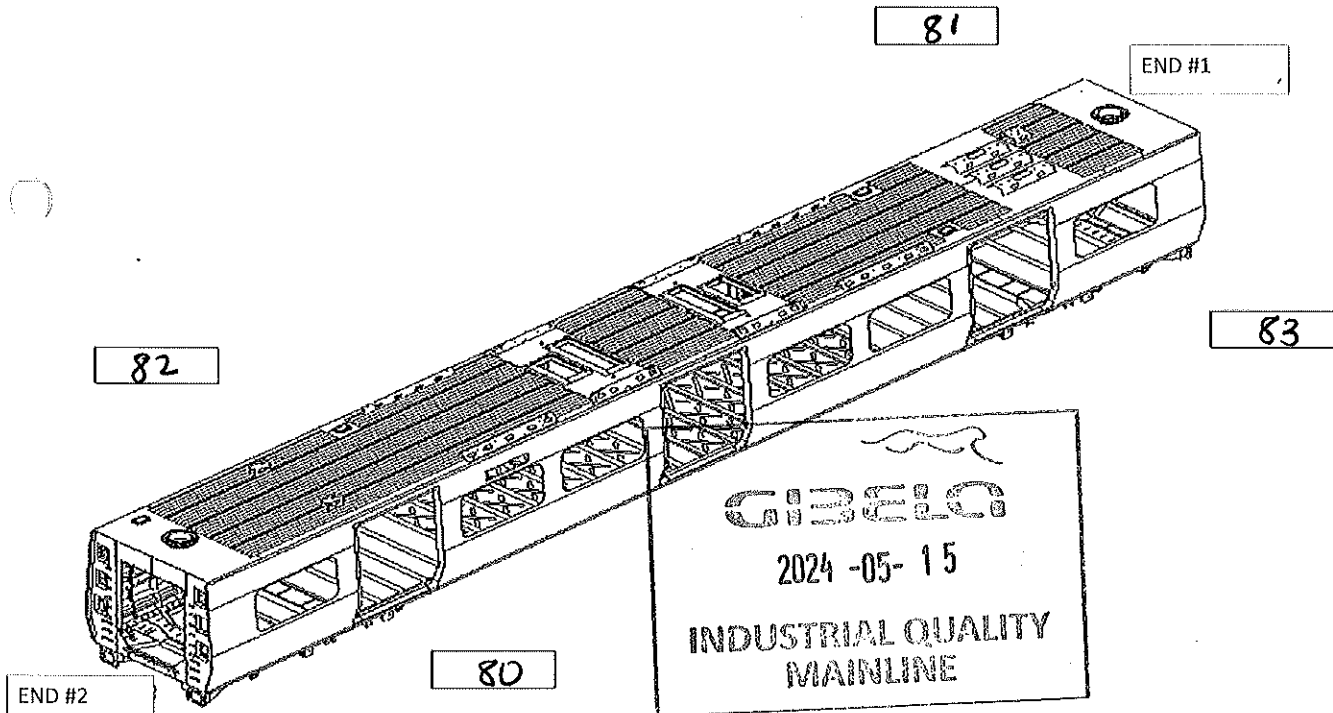
CARBODYSHELL M1,M3,M4 ASSEMBLY
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Specifications of Details for CBS measurement CB1230

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.



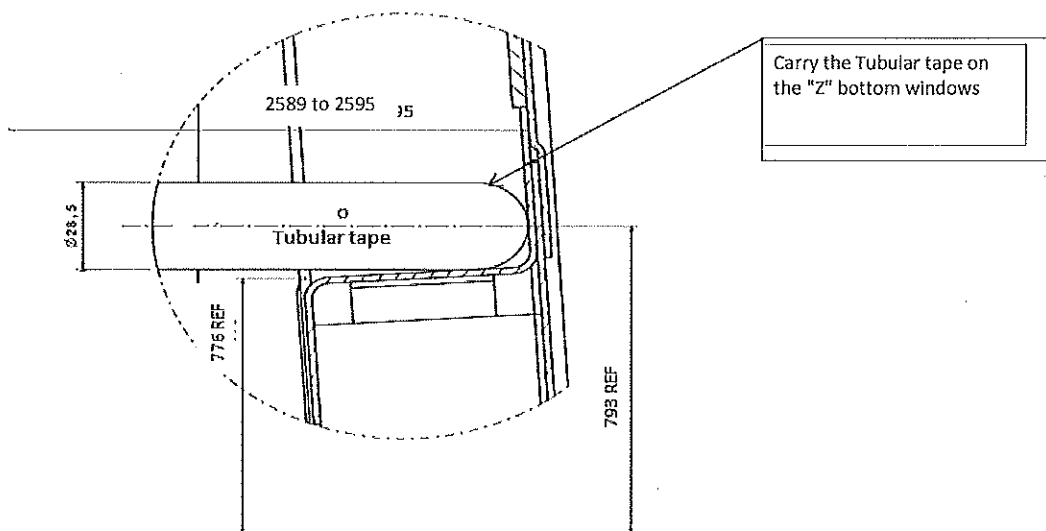
TWIST FOUND ON END 1

TRANVERS	2
LONGITUDIN	3

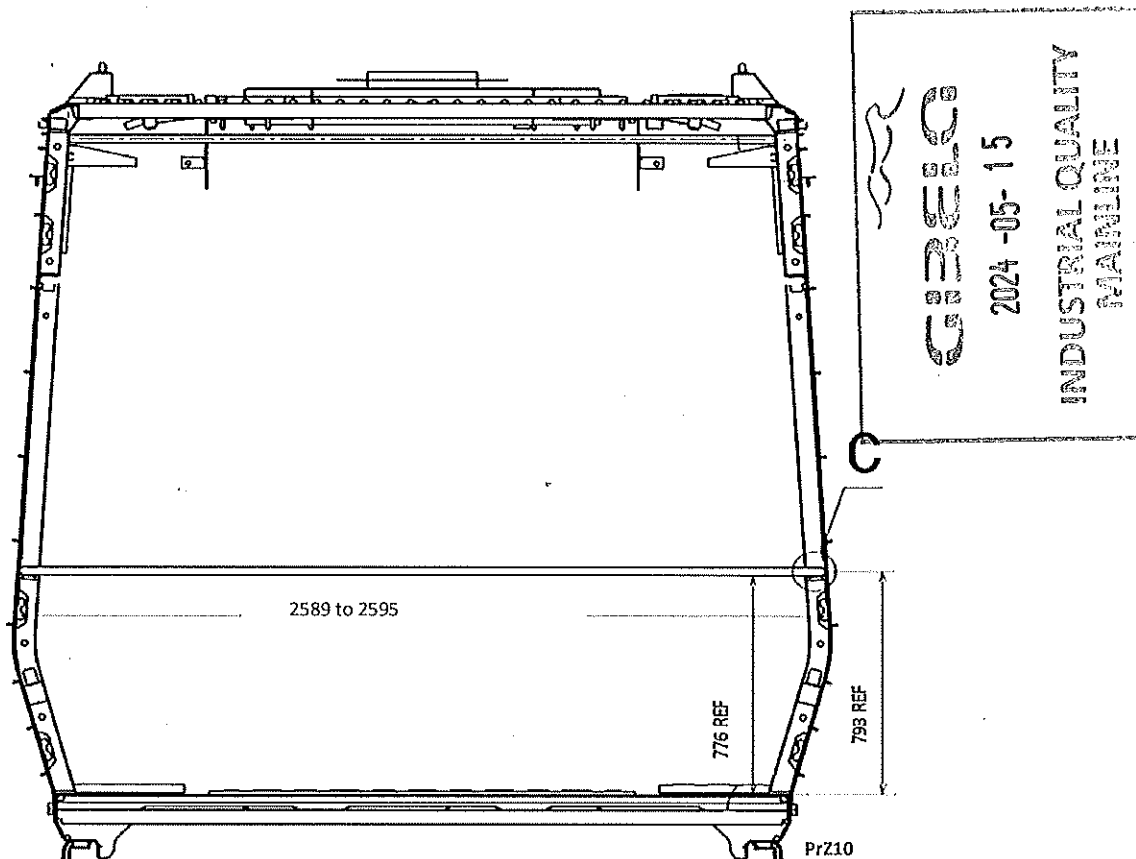
TWIST FOUND ON END 2

TRANVERSE	2
LONGITUDINAL	1

Specifications of Details for CBS measurement CB1230



Detail C





CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

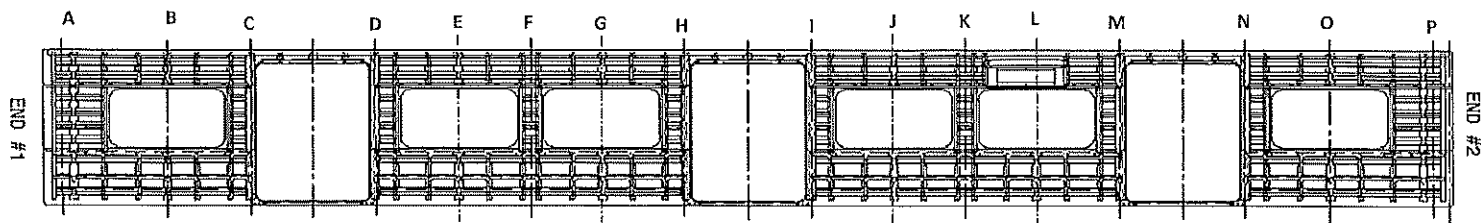
Rev.
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Date
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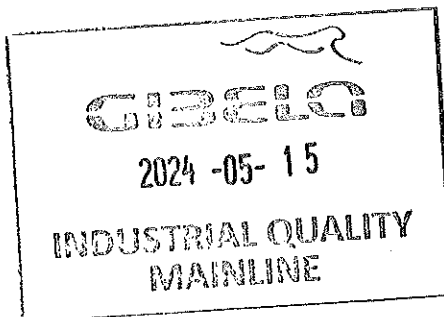
SI.CB1230.256.V28

Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	25 95
B	25 94
C	25 94
D	25 96
E	25 97
F	25 97
G	25 60
H	25 96
I	25 95
J	25 63
K	25 60
L	25 97
M	25 94
N	25 98
O	25 97
P	25 95



Threshold verification

Nominal value :38

Door 1

Door 2

Door 3

Door 4

Door 5


Door 6

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

BOILER MAKER:

Tsheno10

Welder mmathapelo

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Dye penetrant test

Dye-penetration test to be performed by quality personnel




Specifications of Details for CBS measurement				
Item	Description of the issue	OK	Signature/Date (Operations)	Signature/Date (Quality)


II.2 - Check List REX

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



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		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	(If f activities are not complete, the missing activities must not impact the next stage!		15/05/24	Mmathapeto Operations	Mtola.
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)		15/05/24	Amo Industrial Quality	
	NO GO	There are activities pandings that impact/stop the activities of the next process Obs: (To describe problems below)			Operations	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)			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

