

**GIBELA**

**PRASA PROJECT**


APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

# **SELF INSPECTION SHEET**


## **CONFIDENTIAL INFORMATION**

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

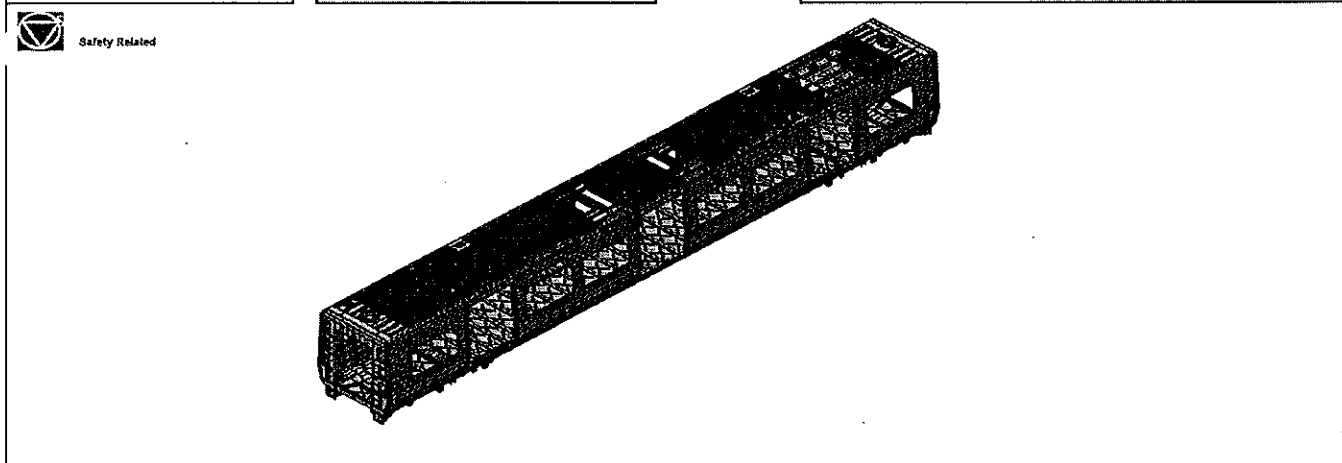
### **APPLICATION REFERENCE**

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY? 
				TC1	M1	M2	M3	M4	TC2		
<input checked="" type="checkbox"/> DTR3000152647	AAD0001413329	CARBOYSHELL M2 ASSEMBLY	CB1210				<input checked="" type="checkbox"/>			PRA.CB1210.DTR313744 97/3.V25	YES
<input type="checkbox"/>											
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	12/12/2018						
			CHECKER	Nosizo Pindela	12/12/2018						
			REVISED BY	Ramokone Motama	12/12/2018						
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	06/08/2020						
			REVISED BY	Bongane Masina	06/08/2020						
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021						
			CHECKER	Bongane Masina	19/04/2021						
			REVISED BY	Bongane Masina	19/04/2021						
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021						
			CHECKER	Mpho Mulaudzi	17/08/2021						
			REVISED BY	Mpho Mulaudzi	17/08/2021						
25	21/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	21/02/2022						
			CHECKER	Andani Muthelo	21/02/2022						
			REVISED BY	Andani Muthelo	21/02/2022						
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023						
			CHECKER	Mohlampe Amogelang	14/04/2023						
			REVISED BY	Mohlampe Amogelang	14/04/2023						
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023						
			CHECKER	Zwane Ntokozo	27/07/2023						
			REVISED BY	Mohlampe Amogelang	27/07/2023						
28	07/11/2023	Addition of welder traceability	APPROVER	Ngobeni Tyson	07/11/2023						
			CHECKER	Andani Muthelo	07/11/2023						
			REVISED BY	Ntokozo Zwane	07/11/2023						
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES						
B2027	M2	PONTSO	15/05/24	SI.CB1210.247.V28	17						

407964

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB1210.247.V28
		Date 07/11/2023	

Car: M2	NCR:	Work station: CB1210
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# I - Documentation and Instruments Control

## I.1 - Documentation Control

Document	Type of car					Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
	M1	M2	M3	M4	M5						
DTR31374497/3				X		V28		2		N/A	

## I.2 - Instruments Control

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


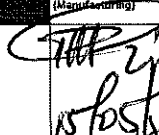
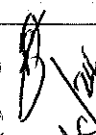
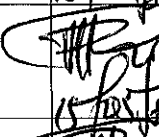

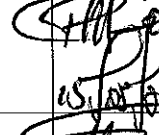

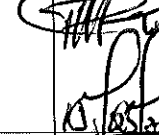


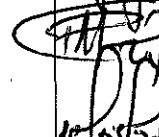

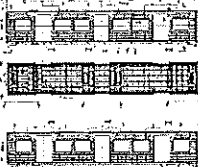


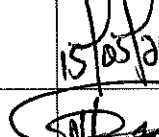

Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
WBLUAC	30823-0	15/03/25	✓			
LASER TAPE	105425924	08/02/25	✓			
SEM TAPE	313TP0108	18/11/24	✓			

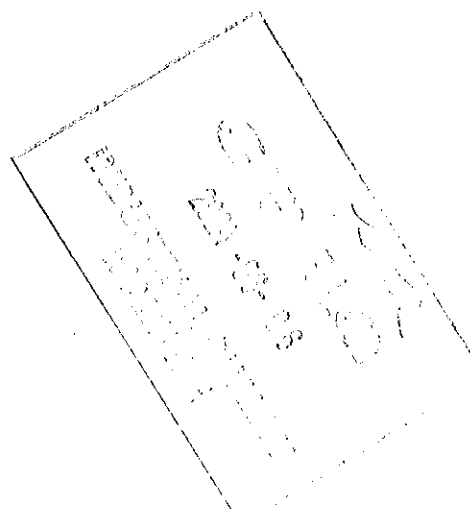
## 1.3 - Consumables


### Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LS1	314018-74097	MIG	✓			
ER 308 L	2991687-70308	TIG	✓			

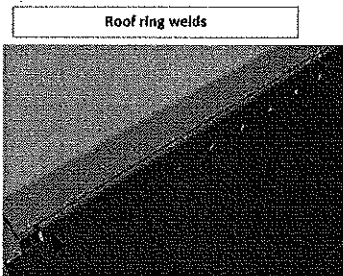
2024-06-06  
2024-06-06  
2024-06-06





		<b>CARBODYSHELL M2 ASSEMBLY DTR31374497/3</b>		Rev. 28 Date 07/11/2023	<b>Project: PRASA SI.CB1210.247.V28</b>	
<b>II - Self Inspection - Items to Check</b>						
<b>II.1 - Items to check</b>						
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturer)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls, Endframes, Roof and Underframe)	AA00001375051	✓	 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	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 • DTD0000210675	✓	 15/05/24	 15/05/24
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	 15/05/24	 15/05/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	 15/05/24	 15/05/24
06		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓	 15/05/24	 15/05/24
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.	✓	 15/05/24	 15/05/24

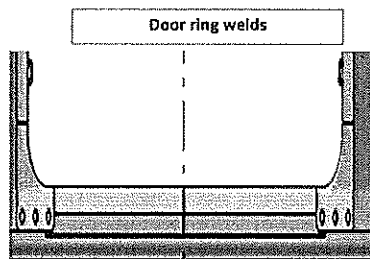


	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRA5A SI.CB1210.247.V28
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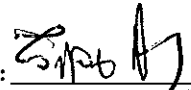
**Welder traceability**




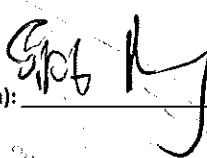
<u>LHS</u>	
Boiler maker (Name & Sign): <u>LUNGA </u>	Welder (Name & Sign): <u>BOBERG </u>
<u>RHS</u>	
Boiler maker (Name & Sign): <u>LUNGA </u>	Welder (Name & Sign): <u>BOBERG </u>

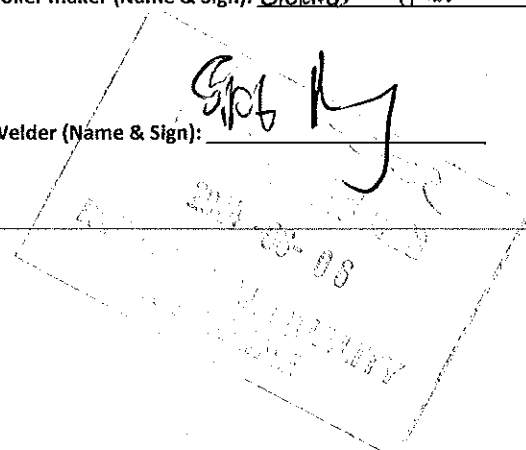



LHS

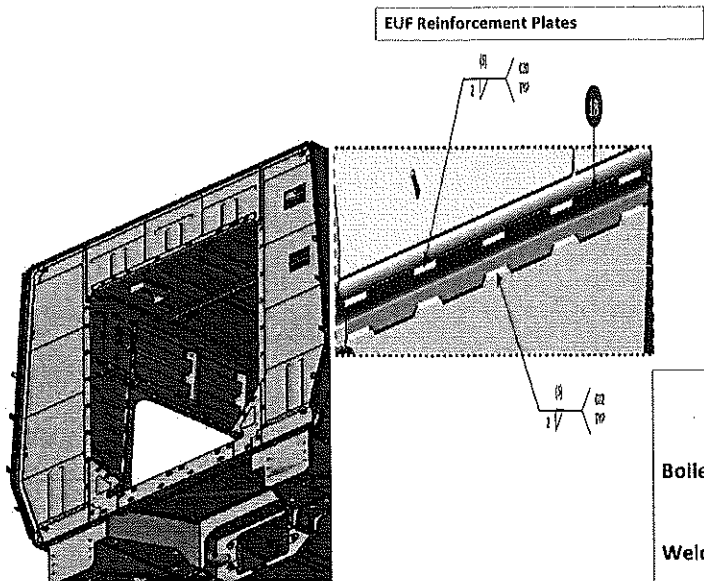
Boiler maker (Name & Sign): <u>GERARD </u>	Welder (Name & Sign): <u>Sipb </u>
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RHS

Boiler maker (Name & Sign): <u>GERARD </u>	Welder (Name & Sign): <u>Sipb </u>
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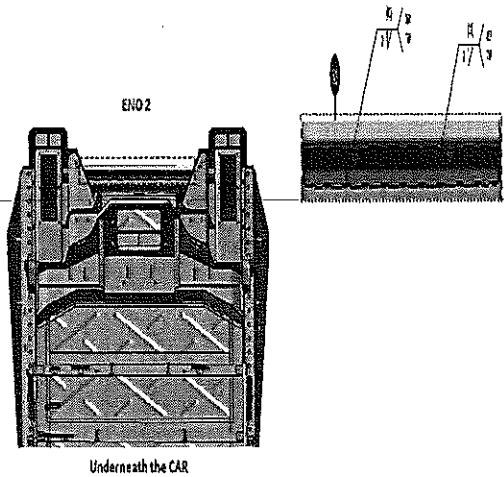
	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB1210.247.V28
		Date 07/11/2023	



**END 1**

Boiler maker (Name & Sign): Gerardo R. Mole

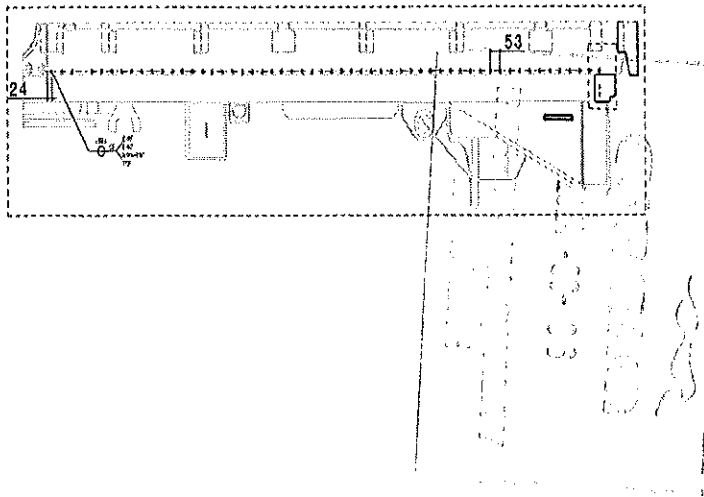
Welder (Name & Sign): GIFT Ky



**END 2**


Boiler maker (Name & Sign): Gerardo R. Mole

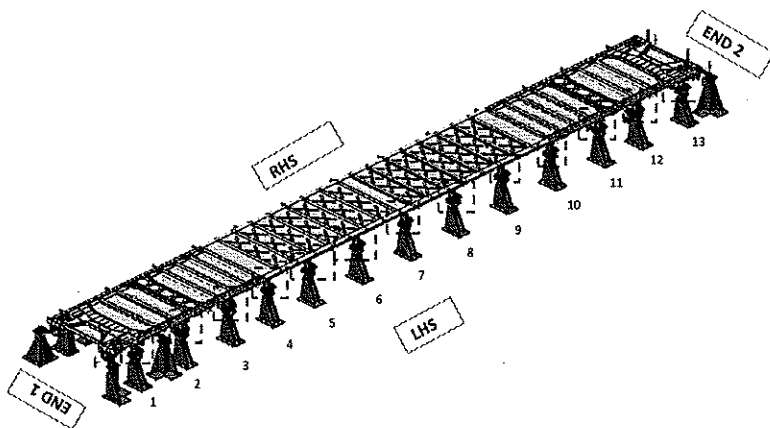
Welder (Name & Sign): Theborg (signature)



**FEDOLI**

OPERATOR: Leon G. M. (signature)

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRA5A SI.CB1210.247.V28
		Date 07/11/2023	
Specifications of Details for CBS measurement			



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

After loading and clamping

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

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

Signature Operations:

Date:

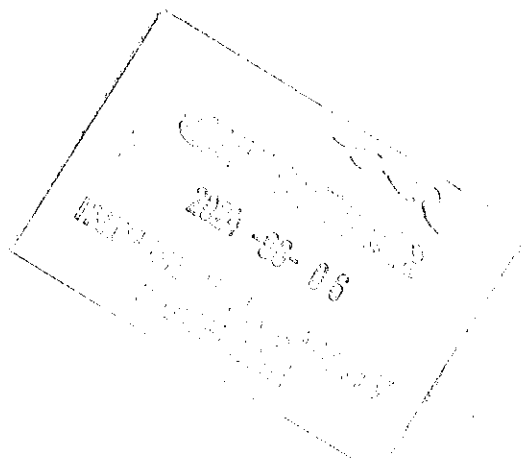
After Welding.

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

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

Signature Industrial Quality:

Date:





CARBODYSHELL M2 ASSEMBLY DTR31374497/3

Rev.

28

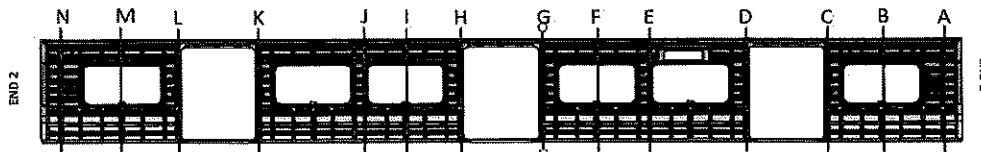
Date

07/11/2023

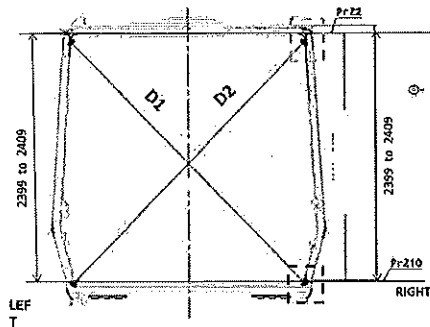
Project: PRASA

SI.CB1210.247.V28

### Specifications of Details for CBS measurement



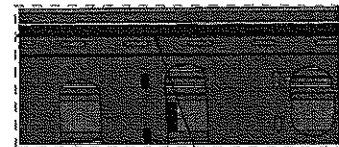
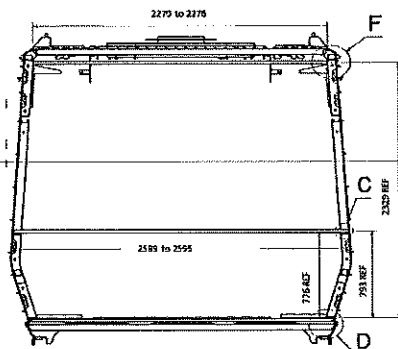
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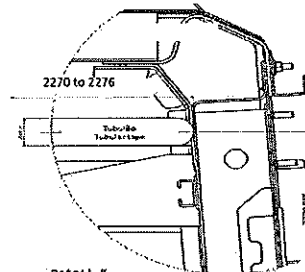
Measurement positions on roof rail and side sill corner



Measurement positions on side sill and side sill corner

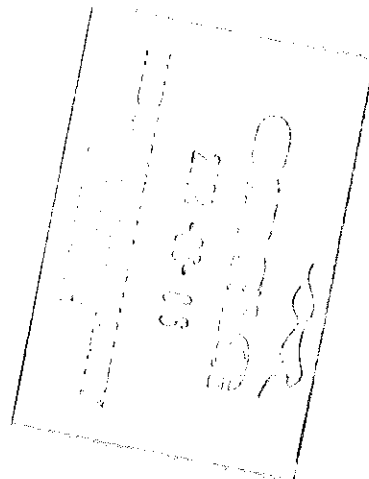



Reinforcement area measurement positions on roof reinforcement area



Detail F

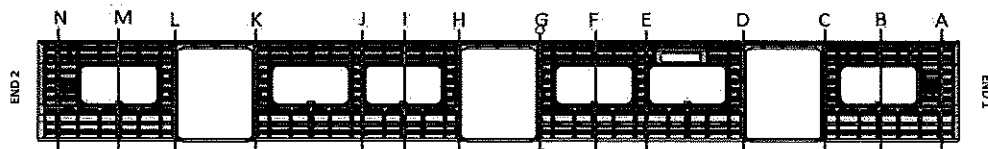
Don't considering the reinforcement



	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA <b>SI.CB1210.247.V28</b>
		Date 07/11/2023	

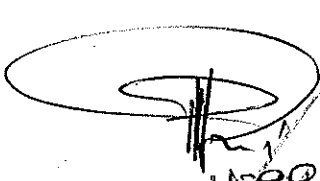
Specifications of Details for CBS measurement

BEFORE WELDING



Note: The difference in Height values measured on the LHS and RHS should be  $\leq 2\text{MM}$  on each point.

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS $\leq 2$
A	3269	3268	1	2404	2404	0
B	3268	3268	0	2406	2404	2
C	3270	3271	1	2405	2404	1
D	3269	3270	1	2404	2404	0
E	3269	3269	0	2404	2406	2
F	3271	3270	1	2404	2406	2
G	3271	3269	2	2404	2403	1
H	3271	3271	0	2406	2406	0
I	3268	3266	2	2404	2404	0
J	3266	3267	1	2405	2404	1
K	3268	3267	1	2403	2404	1
L	3266	3266	0	2404	2405	1
M	3269	3268	1	2404	2406	2
N	3269	3269	0	2404	2404	0

  
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18/05/24  
07/11/2023  
2399-2409





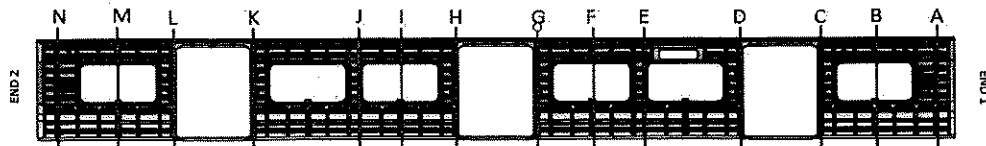
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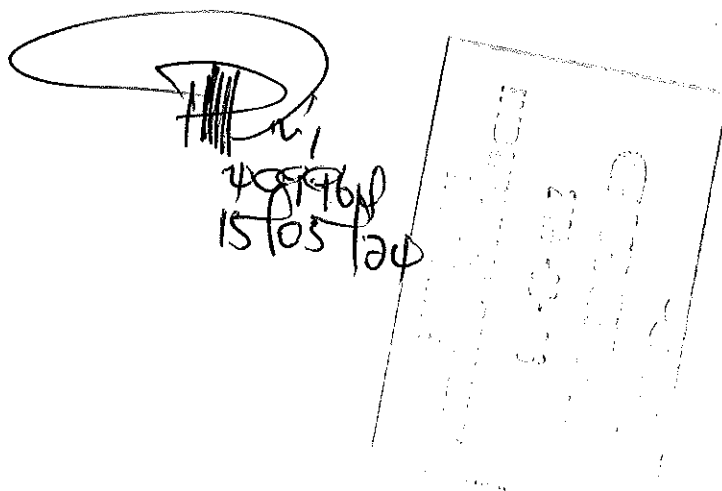
Specifications of Details for CBS measurement

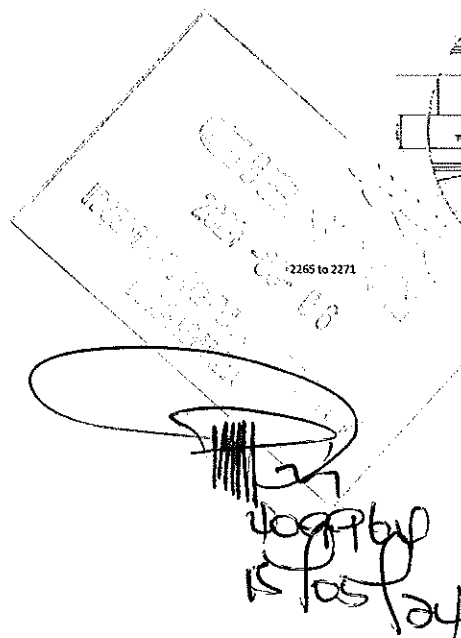
AFTER WELDING




Note: The difference in Height values measured on the LHS and RHS should be  $\leq 2\text{MM}$  on each point.

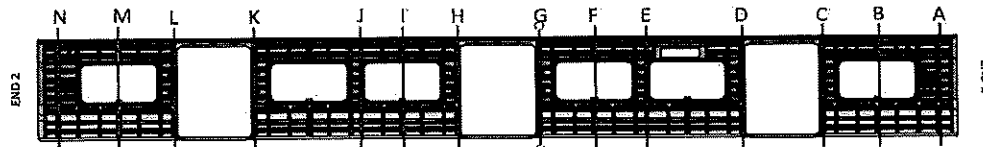
	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS $\leq 2$
A	3296	3296	0	2404	2404	0
B	3268	3267	1	2405	2406	1
C	3298	3298	0	2404	2405	1
D	3296	3297	1	2406	2405	1
E	3269	3270	1	2404	2404	0
F	3271	3270	1	2406	2404	2
G	3296	3298	2	2403	2404	1
H	3299	3299	0	2404	2405	1
I	3269	3268	1	2404	2406	2
J	3267	3269	2	2404	2403	1
K	3298	3299	1	2404	2404	0
L	3299	3298	1	2403	2404	1
M	3268	3268	0	2406	2404	2
N	3297	3297	0	2404	2404	0



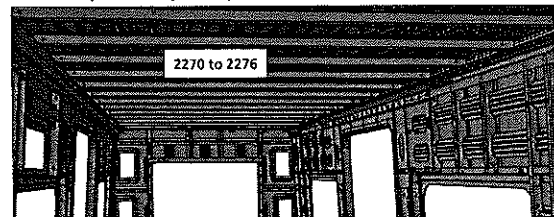


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		CBS measurement	

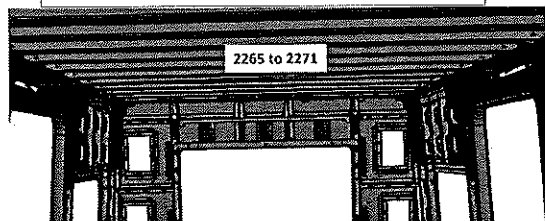
AFTER WELDING



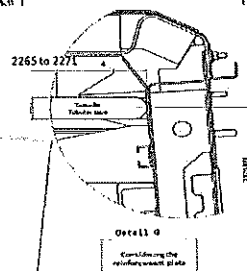
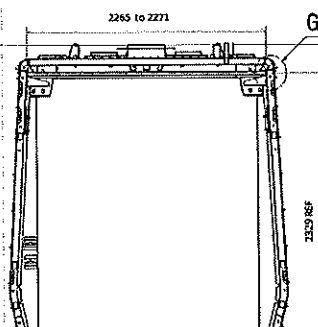
	2265 to 2271	2270 to 2276
A	2269	
B		2270
C	2267	
D	2268	
E		2271
F		2272
G	2266	
H	2267	
I		2273
J		2274
K	2269	
L	2268	
M		2275
N	2267	



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



Take measurement close to radius ( considering reinforcement)



Handwritten notes and signatures:

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18/05/24



CARBODYSHELL M2 ASSEMBLY DTR31374497/3

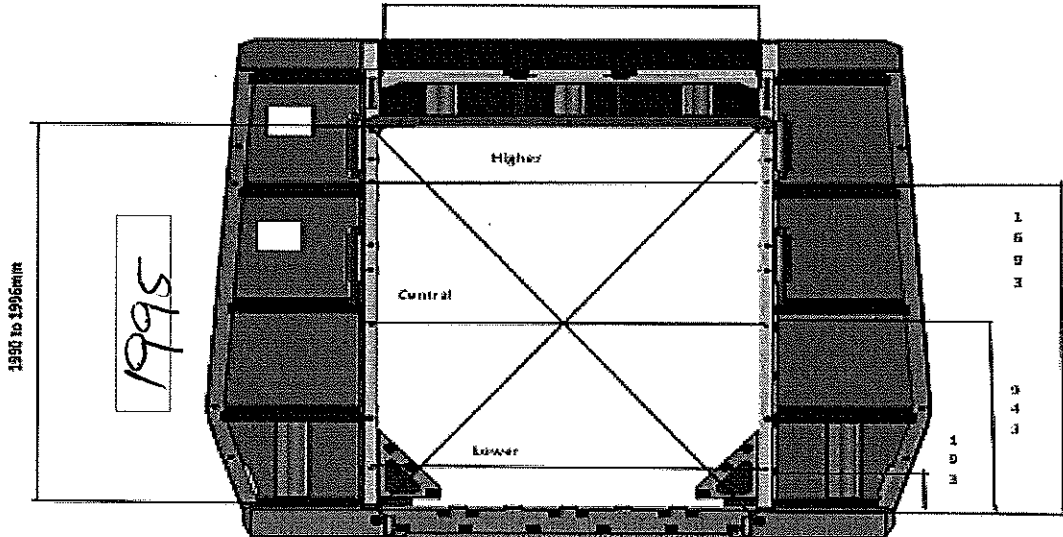
Rev.  
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07/11/2023

Project: PRASA  
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CBS measurement

End frame 1

1380 to 1382 mm



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1351

D1

2416

Central Dimension

1380

D2

0415

Lower Dimension

1380

D1-D2

1

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409964  
15/05/24

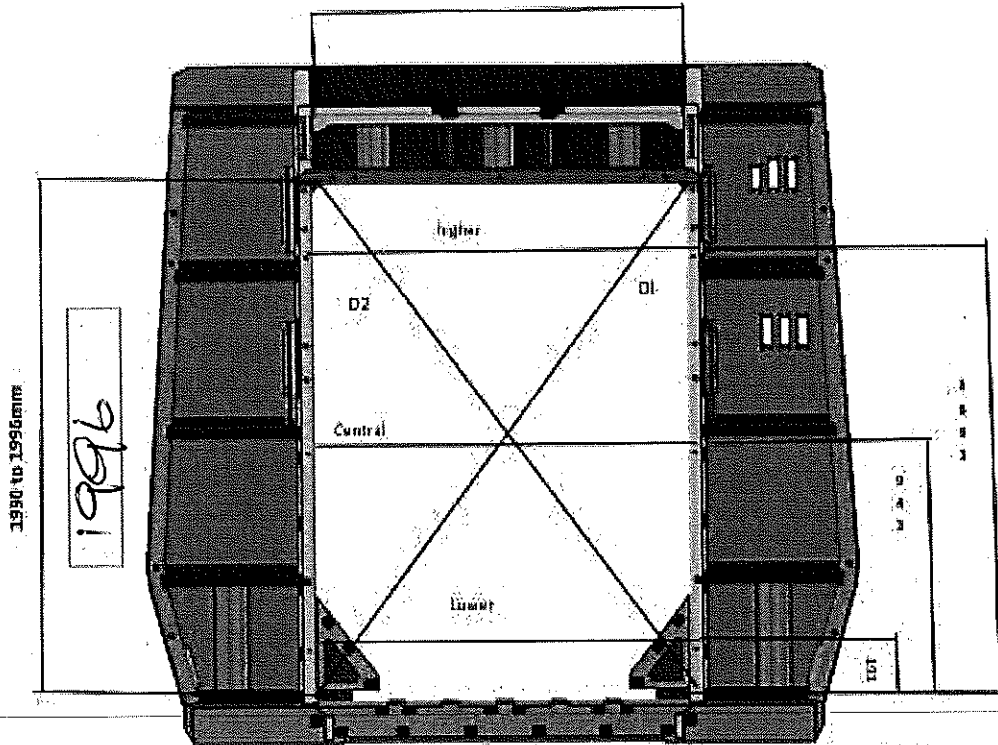


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End frame 2



1380 to 1392 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1380

D1

2415

Central Dimension

1381

D2

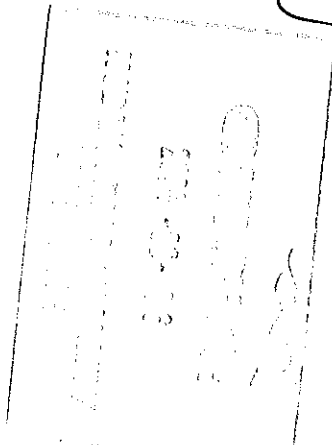
2415

Lower Dimension

1381

D1-D2

0



*[Signature]*  
209964  
15/05/24



CARBODYSHELL M2 ASSEMBLY DTR31374497/3

Rev.

28

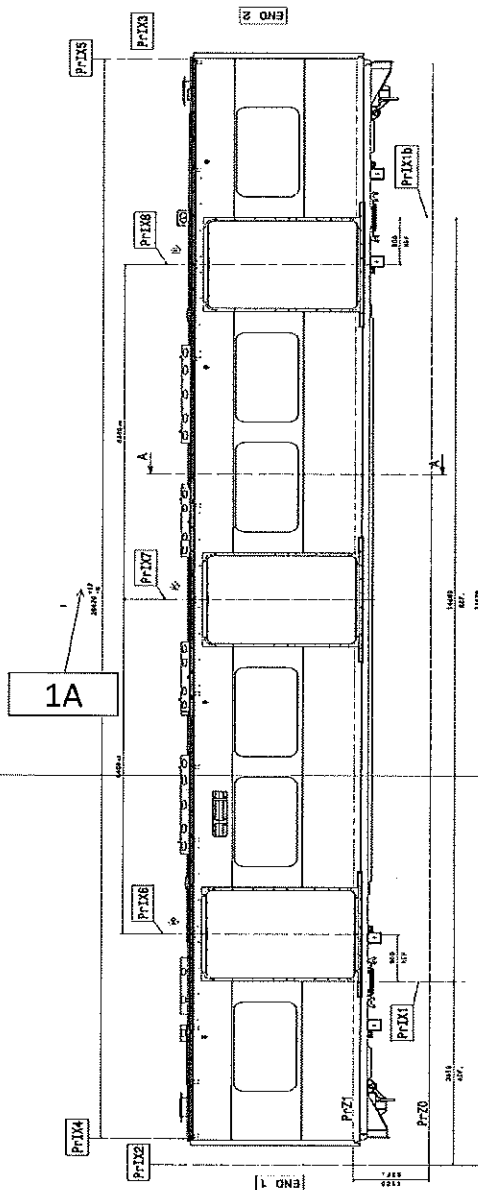
Date

07/11/2023

Project: PRA5A

SI.CB1210.247.V28

Specifications of Details for CBS measurement

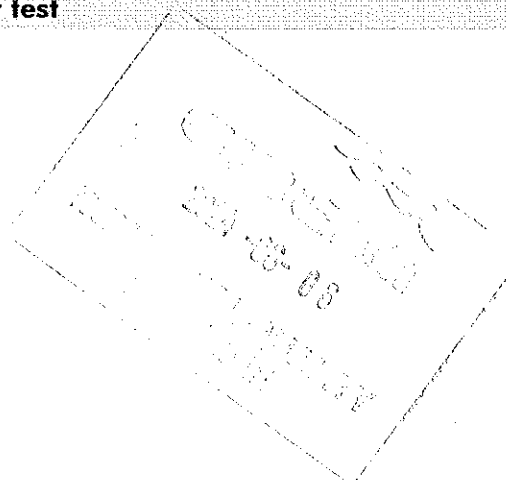


LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20616



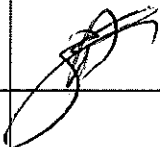
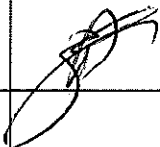
RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20616

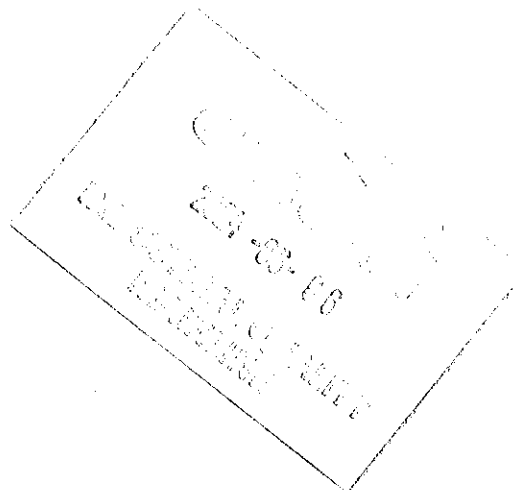
Dye penetrant test

Dye-penetration test to be performed by quality personnel






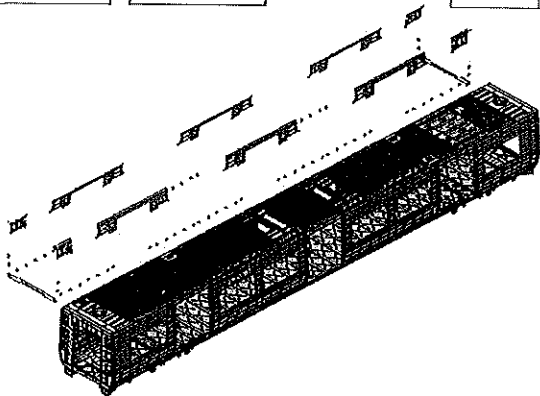

















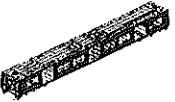


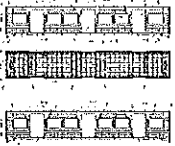


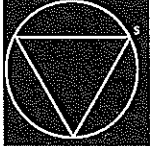






		CARBODYSHELL M2 ASSEMBLY DTR31374497/3		Rev. 28 Date 07/11/2023	Project: PRASA SI.CB1210.247.V28	
<b>Self Inspection - Final Result</b>						
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)	15/05/2024	P. ANTISO Operations		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.	16/05/24	N. Alvarez Industrial Quality		
	NO GO	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			Quality			





GIBELA		PRASA PROJECT												
														
APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1 <b>SELF INSPECTION SHEET</b>														
<b>CONFIDENTIAL INFORMATION</b> 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	MA1	MA2	MA3	MA4	MA5	TC2				
<input type="checkbox"/>	DTR31374497/2	AAD000413379	CARBODY SHELL M2 ASSEMBLY	CRS2210						X			PRA.CB1220.DTR31374497/2.V21	YES
<input type="checkbox"/>														
<input type="checkbox"/>														
<input type="checkbox"/>														
<input type="checkbox"/>														
<input type="checkbox"/>														
<input type="checkbox"/>														
<input type="checkbox"/>														
REV	DATE	MODIFICATION CONTENT			RESPONSIBLE		NAME		DATE					
0	01/02/2018	GIBELA NEW CREATION			APPROVER	Itumeleng Modiba	01/02/2018							
					CHECKER	Nosizo Pindela	01/02/2018							
					COMPILER	Thonyani Mathegu	01/02/2018							
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager			APPROVER	Itumeleng Modiba	18/05/2018							
					CHECKER	Nosizo Pindela	18/05/2018							
					REVISED BY	Ramokone Motama	18/05/2018							
2	2018/07/05	Certain dimensional checks added and others moved to CB1210			APPROVER	Itumeleng Modiba	2018/07/05							
					CHECKER	Nosizo Pindela	2018/07/05							
					REVISED BY	Ramokone Motama	2018/07/05							
3	2018/06/12	Width tolerance as per DT0000336600			APPROVER	Itumeleng Modiba	2018/06/12							
					CHECKER	Nosizo Pindela	2018/06/12							
					REVISED BY	Nosizo Pindela	2018/06/12							
5	24/01/2019	As per Baseline 10.2			APPROVER	Itumeleng Modiba	24/01/2019							
					CHECKER	Nosizo Pindela	24/01/2019							
					REVISED BY	Vanessa Ntuli	24/01/2019							
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements Remove			APPROVER	Itumeleng Modiba	13/03/2019							
					CHECKER	Nosizo Pindela	13/03/2019							
					REVISED BY	Nosizo Pindela	13/03/2019							
7	27/05/2019	Removed measurement positions on the display windows			APPROVER	Itumeleng Modiba	27/05/2019							
					CHECKER	Nosizo Pindela	27/05/2019							
					REVISED BY	Nosizo Pindela	27/05/2019							
10	22/08/2019	New Baseline 10.2.5			APPROVER	Itumeleng Modiba	22/08/2019							
					CHECKER	Nosizo Pindela	22/08/2019							
					REVISED BY	Nosizo Pindela	22/08/2019							
15	06/08/2020	New Baseline 10.2.6			APPROVER	Timothy Maimela	06/08/2020							
					CHECKER	Bongane Masina	06/08/2020							
					REVISED BY	Bongane Masina	06/08/2020							
20	19/04/2021	New Baseline change 10.3			APPROVER	Timothy Maimela	19/04/2021							
					CHECKER	Bongane Masina	19/04/2021							
					REVISED BY	Bongane Masina	19/04/2021							
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING			APPROVER	Mbhombi Collins	17/08/2021							
					CHECKER	Mpho Mulaudzi	17/08/2021							
					REVISED BY	Mpho Mulaudzi	17/08/2021							
25	20/02/2022	New Baseline change 10.3.1			APPROVER	Mbhombi Collins	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	Mbhombi Collins	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 and welding.			APPROVER	Mbhombi Collins	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	28/10/2023	Addition of bracket quantity			APPROVER	Tyson Ngobeni	28/10/2023							
					CHECKER	Kefebone Mathapo	28/10/2023							
					REVISED BY	Amogelang Mohlampe	28/10/2023							
TRAINSET	CAR	OPERATOR NAME & ALPS NO		DATE	SELF INSPECTION NUMBER		PAGES							
227	M2	Mpho Mulaudzi 40041		16/05/24	SI.CB1220.276.V29		15							

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA																		
		29																			
		Date	SI.CB1220.276.V29																		
		28/10/2023																			
Obr: M2	NCR:	Work station:	CB1220																		
 Safety Related																					
																					
<b>I - Documentation and Instruments Control</b>																					
<b>I.1 - Documentation Control</b>																					
	<table border="1"> <tr> <th colspan="5">Type of car</th> </tr> <tr> <th>T01</th> <th>M1</th> <th>M2</th> <th>M3</th> <th>T02</th> </tr> <tr> <td></td> <td></td> <td>✓</td> <td></td> <td></td> </tr> </table>	Type of car					T01	M1	M2	M3	T02			✓			Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Type of car																					
T01	M1	M2	M3	T02																	
		✓																			
DTR31374497/2					✓	N/A	 27/6/24	 27/6/24													
<b>I.2 - Instruments Control</b>																					
Monitoring and Measuring Instrument Control - Used for Special Process																					
Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)																
Tubuler	32823-3	15/03/2025	✓	 28/6/24	 28/6/24																
Measuring tape	616110399	2023/04/16	✓	 28/6/24	 28/6/24																
<b>1.3 Consumables</b>																					
Welding Consumable Control - Used for Special Process																					
Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)																
308 1.0mm	314613	MIG	✓	 27/6/24	 27/6/24																

		CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB1220.276.V29		
			28			
			Date			
			28/10/2023			
<b>II - Self Inspection - Items to Check</b>						
<b>II.1 - Items to check</b>						
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1220 DTR31374497/2 Verification of fitment for all reinforcement brackets	PRA.CB1220 DTR31374497/2	✓	 16/05/24	 16/05/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	 16/05/24	 16/05/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	 16/05/24	 16/05/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	 16/05/24	 16/05/24
05		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below	✓	 16/05/24	 16/05/24
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.	✓	 16/05/24	 16/05/24
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 (°C) : 10°C - 35°C Relative humidity Min - Max (%) : 25% - 60%	Sealant Batch No: <u>P349763</u> Exp Date: <u>04/05/24</u> Actuals: Temperature: <u>23</u> Humidity: <u>33</u>	✓	 16/05/24	 16/05/24
08	NA	Verification of sealant application in certain regions in the drawing	AAD0001413329	✓	 16/05/24	 16/05/24



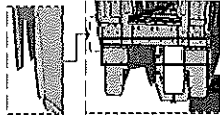
CARBODYSHELL M2 ASSEMBLY DTR31374497/2

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29
Date
28/10/2023

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SEALANT APPLICATION

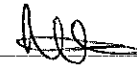



AREA 1 & 2 END 1

Operator (Name & sign):

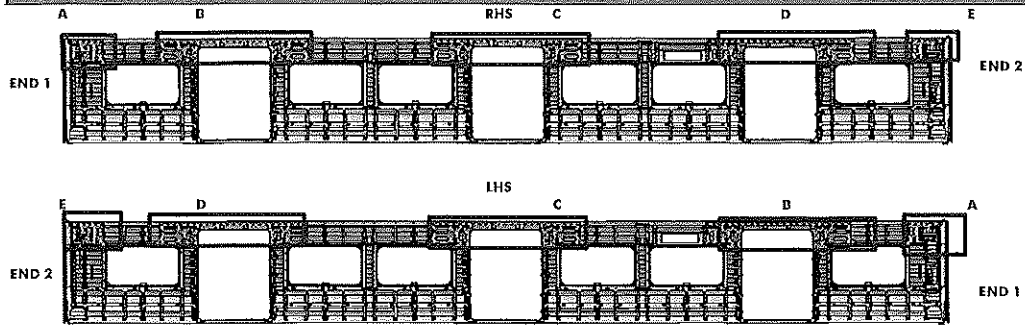
Mthokozisi 

Operator (Name & sign):

Mthokozisi 


	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB1 220.276.V29
		29	
		Date	
		28/10/2023	

II - Self Inspection - Items to Check

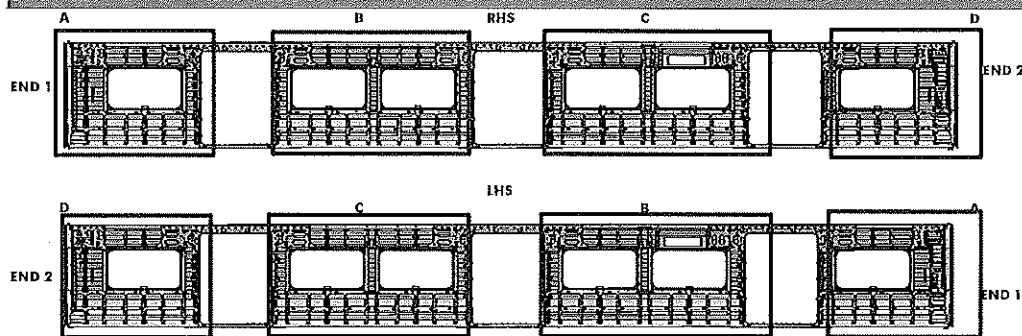


REINFORCEMENT WELDING

AREA	LHS	RHS
A	Operator (Name&sign): <u>LINDA (signature)</u>	<u>(signature)</u>
B	Operator (Name&sign): <u>LINDA (signature)</u>	<u>(signature)</u>
C	Operator (Name&sign): <u>(signature)</u>	<u>(signature)</u>
D	Operator (Name&sign): <u>(signature)</u>	<u>MMAISWELIO MAN</u>
E	Operator (Name&sign): <u>(signature)</u>	<u>MMAISWELIO MAN</u>

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA
		29	
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		28/10/2023	

### III - Self Inspection - Items to Check



#### BRACKETING

##### INSTALLATION

C-RAILS:

Operator:

ASHIDA

Operator:

DOOR MECHANISMS:

Operator:

Mashuda Mashuda

Operator:

TAPPING PADS

Operator:

LYNDY

Operator:

##### INSTALLATION & VERIFICATION

SEAT & LUGGAGE BRACKETS:

Operator:

MARQUELO MARQUELO

Operator:

SEAT BRACKETS VERIFICATION:

Operator:

HILKELOIS

Operator:

#### WELDING

AREA

LHS

A (Seat brackets)

: Operator (Name&sign):

LYNDY

(C-rails, Luggage and earth bushes):

: Operator (Name&sign):

LYNDY

B (Seat brackets)

: Operator (Name&sign):

LYNDY

(C-rails, Luggage and earth bushes):

: Operator (Name&sign):

LYNDY

C (Seat brackets)

: Operator (Name&sign):

MARQUELO MARQUELO

(C-rails, Luggage and earth bushes):

: Operator (Name&sign):

MARQUELO

D (Seat brackets)

: Operator (Name&sign):

LYNDY

(C-rails, Luggage and earth bushes):

: Operator (Name&sign):

LYNDY

RHS

LYNDY

MARQUELO MARQUELO

LYNDY


#### ENDS

END 1 TAPPING PADS WELDING: Operator (Name&sign):

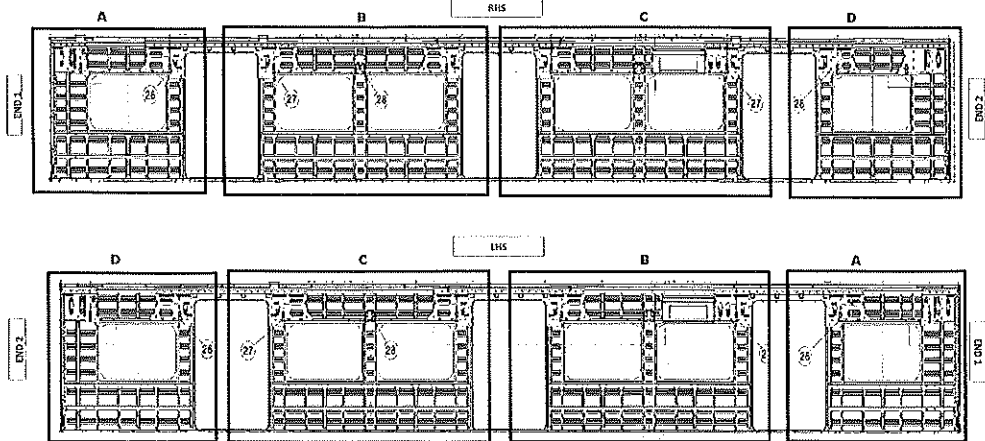
LYNDY

END 2 TAPPING PADS WELDING: Operator (Name&sign):

LYNDY

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB1220.276.V29
		29	
		Date	
		28/10/2023	

M2 BRACKET INSTALLATION



QUANTITIES (M2)

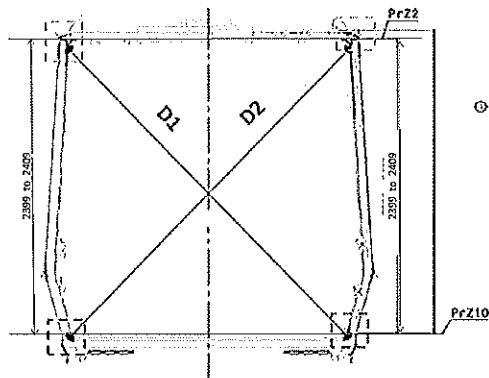
RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	8	✓	
	B	8	✓	
	C	8	✓	
	D	2	✓	
SEAT BRACKETS	A	13	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	2	✓	
	B	4	✓	
	C	5	✓	
	D	3	✓	

ROOF ENDS:  
CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END  
VERIFICATION BY: Mashudh

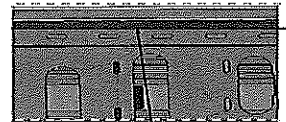
LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	9	✓	
	B	11	✓	
	C	11	✓	
	D	12	✓	
SEAT BRACKETS	A	12	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	3	✓	
	B	7	✓	
	C	6	✓	
	D	2	✓	

ROOF ENDS:  
CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END  
VERIFICATION BY: Mashudh

Project: PRA5A  
SI.CB1220.276.V29



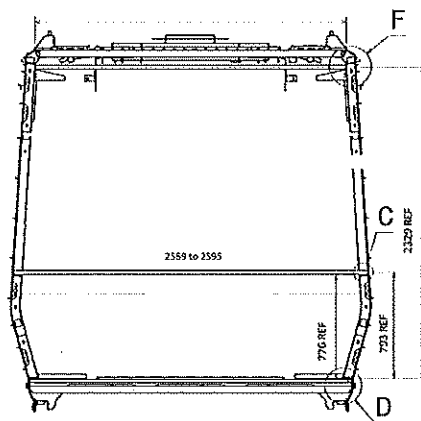
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.





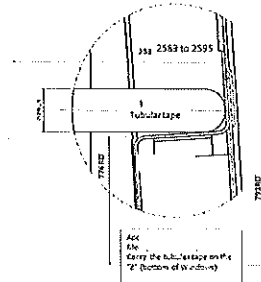
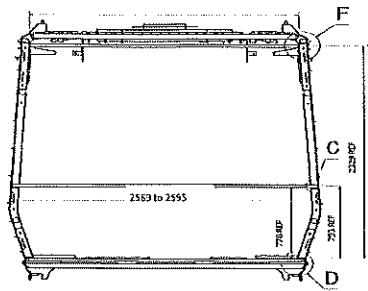


CARBODYSHELL M2 ASSEMBLY DTR31374497/2

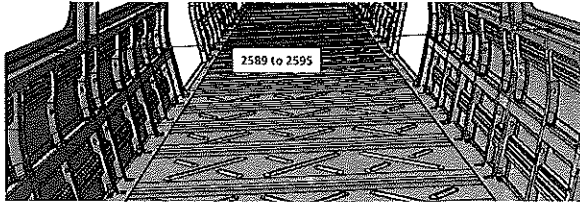
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28/10/2023

Project: PRASA

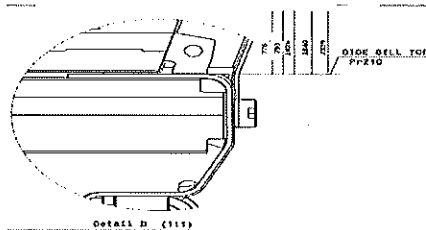
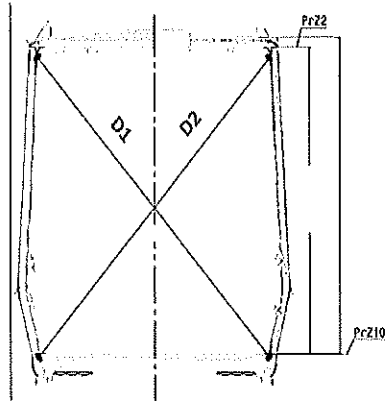
SI.CB1220.276.V29



Detail C

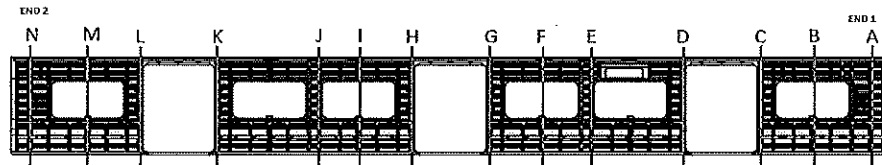


Take measurement close to  
radius



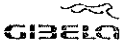
Detail D (111)

## GBS measurement

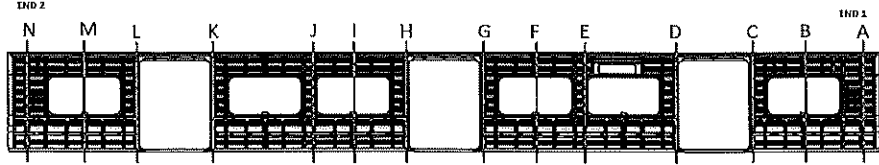


## BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3299	3297	2	-
B	3265	3264	2	-
C	3292	3297	5	-
D	3295	3292	3	-
E	3264	3263	1	-
F	3263	3264	1	-
G	3294	3296	2	-
H	3298	3294	4	-
I	3262	3262	0	-
J	3264	3266	2	-
K	3297	3295	2	-
L	3295	3295	0	-
M	3265	3267	2	-
N	3297	3294	3	-

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB1220.276.V29
		29	
		Date	
		28/10/2023	

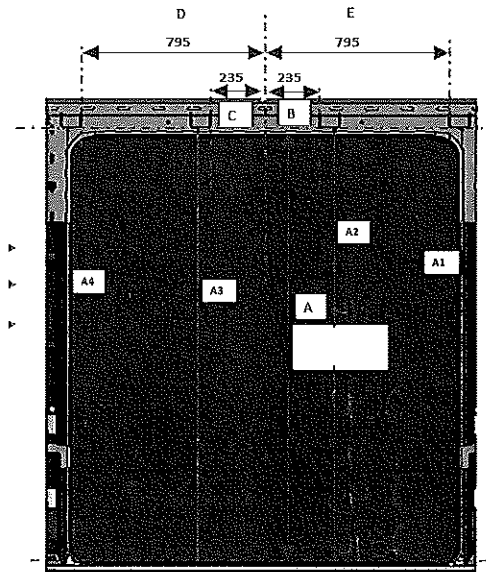
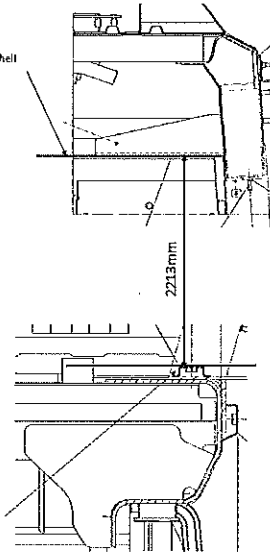
**CBS measurement**



**AFTER WELDING**

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3298	3299	1	2594
B	3264	3266	2	2593
C	3294	3297	3	2590
D	3293	3295	2	2593
E	3264	3264	0	2595
F	3264	3265	1	2594
G	3297	3295	2	2589
H	3298	3296	2	2591
I	3262	3262	0	2590
J	3268	3266	2	2591
K	3298	3296	2	2592
L	3296	3295	1	2594
M	3265	3266	1	2593
N	3297	3295	2	2594

## Specifications of Details for CBS measurement CB1220


Brackets Carbodyshell  
U Type Supports

Brackets Carbodyshell  
Channel Assy

## DOOR 1 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2233
A2	2230 to 2232	2231
A3	2230 to 2232	2232
A4	2230 to 2232	2231
B	234 to 236	235
C	234 to 236	235
D	794 to 796	795
E	794 to 796	796

## DOOR 2 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2234
A2	2230 to 2232	2232
A3	2230 to 2232	2232
A4	2230 to 2232	2233
B	234 to 236	235
C	234 to 236	235
D	794 to 796	796
E	794 to 796	796

## DOOR 3 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2233
A2	2230 to 2232	2232
A3	2230 to 2232	2231
A4	2230 to 2232	2233
B	234 to 236	235
C	234 to 236	234
D	794 to 796	795
E	794 to 796	796

## DOOR 1 - RHS

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

## DOOR 2 - RHS

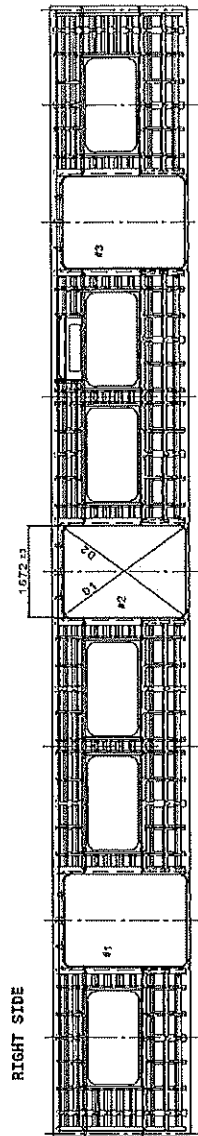
	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2230
A3	2230 to 2232	2231
A4	2230 to 2232	2231
B	234 to 236	235
C	234 to 236	235
D	794 to 796	795
E	794 to 796	795

## DOOR 3 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2232
A3	2230 to 2232	2232
A4	2230 to 2232	2233
B	234 to 236	234
C	234 to 236	236
D	794 to 796	795
E	794 to 796	795

Specifications of Details for CBS measurement CB1220

End #2



End #1

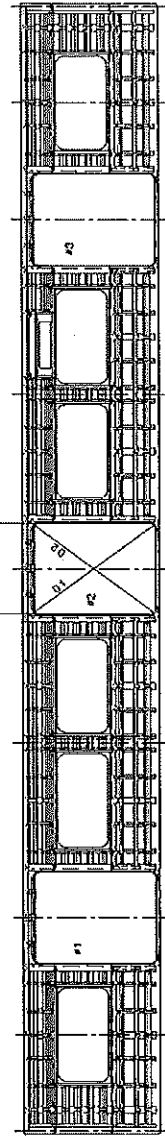
Doors diagonal D1-D2 maximum difference  $\leq 4\text{mm}$

	#1	#2	#3
D1	2169	2169	2169
D2	2169	2169	2169
D1-D2	2	1	1

Doors length - 1672  $\pm 3\text{mm}$

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

End #1



End #2


4mm


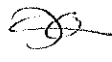
	#1	#2	#3
D1	2169	2169	2169
D2	2169	2169	2169
D1-D2	2	1	1

Vão de Portas - 1672  $\pm 3\text{mm}$

	#1	#2	#3
DIMENSÃO SUPERIOR	1672	1673	1673
HIGHER DIMENSION	1673	1673	1673
CENTRAL DIMENSION	1673	1672	1672
LOWER DIMENSION	1673	1672	1672



	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev. 29	Project: PRASA	
		Date 28/10/2023	SI.CB1220.276.V29	
		Self Inspection - Final Result		


Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)			DATE	NAME	SIGNATURE	
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)	16/05/2024	Mashah Operations		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party	16/05/24	Arakuni Industrial Quality		
		There are activities pending that impact 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	

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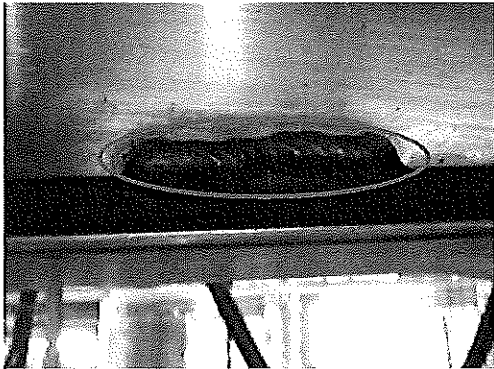
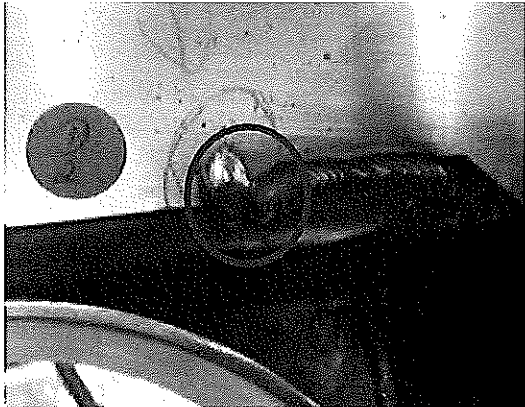
Operations

---

Quality

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA
		29	
		Date	
		28/10/2023	
		SI.CB1220.276.V29	

ANNEXURE A: Arc Welding Quality Acceptance Standard





GIBELA

PRASA PROJECT

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

## SELF INSPECTION SHEET

## CONFIDENTIAL INFORMATION

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

## APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?
				TCL	MA	M1	M2	M3	TCL		
<input type="checkbox"/>	AA00001374497	AA00001413329	CARBOODYSHELL M2 ASSEMBLY	CB2230						PRA.CB1230.AA00001374497.V20	YES
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											


RE	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	Vanessa Ntuli	13/03/2019
10	23/03/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	23/03/2019
			CHECKER	Nosizo Pindela	23/03/2019
			REVISED BY	Nosizo Pindela	23/03/2019
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	
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbombhi	20/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbombhi	14/06/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
27	26/07/2022	Threshold measurement addition	APPROVER	Collins Mbombhi	27/07/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
28	17/10/2022	Addition of traceability for sealant application	APPROVER	Collins Mbombhi	17/10/2022
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
29	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
30	06/11/2023	Added traceability on thresholds for boiler makers and welders	APPROVER	Ngobeni Tyson	06/11/2023
			CHECKER	Andani Muthelo	
			REVISED BY	Ntokozo Zwane	

GIBELA

2024-05-16

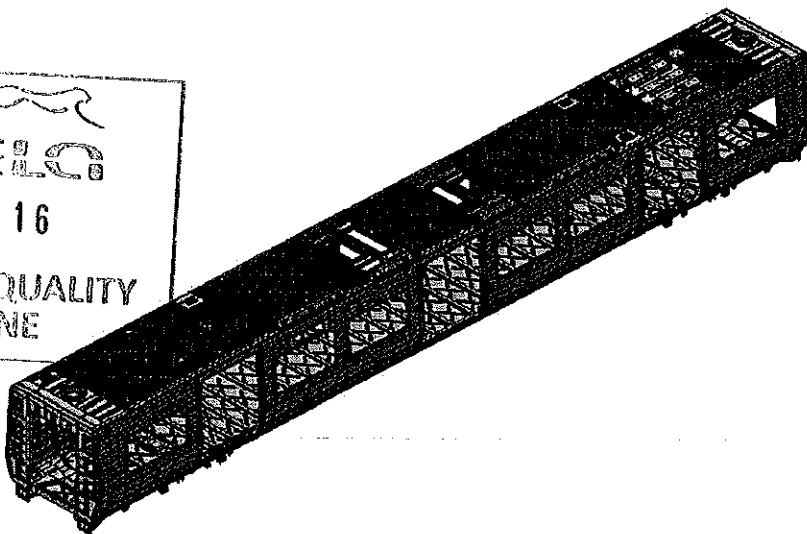
INDUSTRIAL QUALITY  
MAINLINE

TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
327	M02	KHOSE 417409	17 05 24	SI.CB1230.277.V29	11

	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA  SI.CB1230.277.V29
		Date 06/11/2023	
		Car: <span style="border: 1px solid black; display: inline-block; width: 150px; height: 20px;"></span> NCR: <span style="border: 1px solid black; display: inline-block; width: 100px; height: 20px;"></span>	
		Work station:	CB1230



Safety Related



## I - Documentation and Instruments Control

### I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK		Signature/Date (Operations)	Signature/Date (Quality)
	TC	M1	M2	M3	M4	TC2						
PRA.CB1230.AA00001374497			X				V30		OK		N/A	E 17.05.24 / 17/05/24

### I.2 - Instruments Control

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

Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Operations)	Signature/Date (Quality)
MEASURING TAPE	GIB 0194	25/04/23	OK		E 17.05.24	17/05/24
TURBILAC	32713	27/01/24	OK		E 17.05.24	17/05/24
COMBINATION SQUARE	GIB0052	26/06/23	OK		E 17.05.24	17/05/24


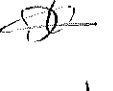

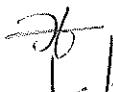
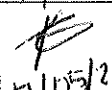
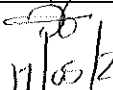
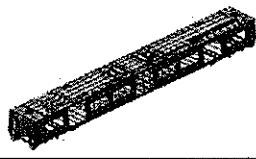

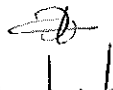
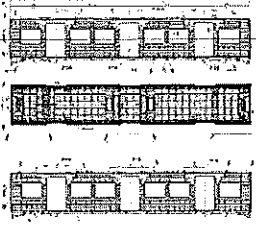

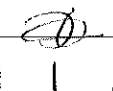
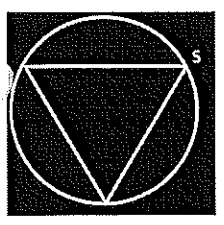
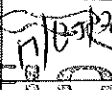



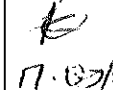

### 1.3 Consumables

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

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
AUTROD 308 LSi	E021886	MIG	OK		E 17.05.24	17/05/24

## II - Self Inspection - Items to Check

### II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK			Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.AA00001374497 Verification of fitment for all brackets.	PRA.CB1230.AA00001374497	OK			 17/05/24	 17/05/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	OK			 17/05/24	 17/05/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	OK			 17/05/24	 17/05/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	OK			 17/05/24	 17/05/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	OK			 17/05/24	 17/05/24
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.	OK			 17/05/24	 17/05/24
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 (1) Min-Max 10°C - 35°C Relative humidity Min - Max (1) Min-Max 25% - 80%	Sealant Batch No: 15R TO 8 Exp Date: 1/06/24 Actuals Temperature: 22°C Humidity: 51%	OK			 17/05/24	 17/05/24
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.	OK			 17/05/24	 17/05/24



CARBODYSHELL M2 ASSEMBLY AA00001374497

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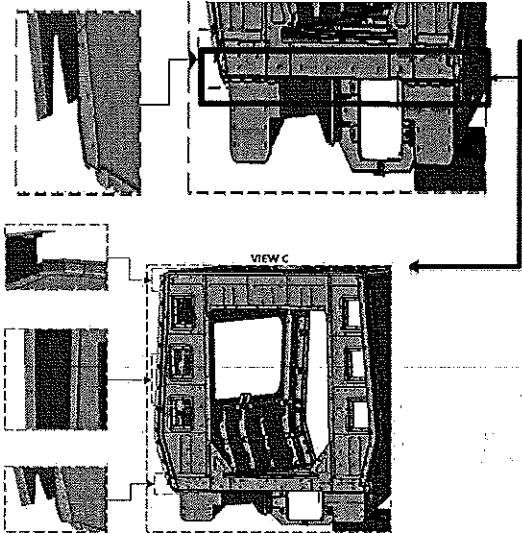
Date

06/11/2023

Project: PRASA

SI.CB1230.277.V29

AREA 1



END 2 SEALANT

OPERATOR  
(Name & sign):

Levy

OPERATOR  
(Name & sign):

Levy

OPERATOR  
(Name & sign):

Levy

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

Operator (Name & sign):

(-F) LHS (CN) RHS

Operator (Name & sign):

Bunie

Bunie

Operator (Name & sign):

Bunie

Bunie

Operator (Name & sign):

\_\_\_\_\_

\_\_\_\_\_

Operator (Name & sign):

\_\_\_\_\_

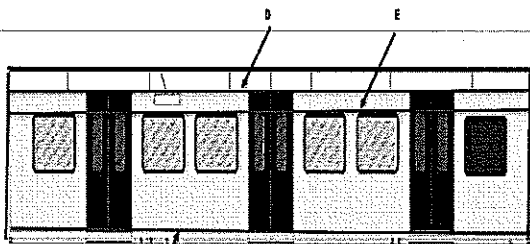
\_\_\_\_\_

Operator (Name & sign):

\_\_\_\_\_

\_\_\_\_\_

H



GIBELQ

2024 -05- 16

INDUSTRIAL QUALITY  
REVENUE



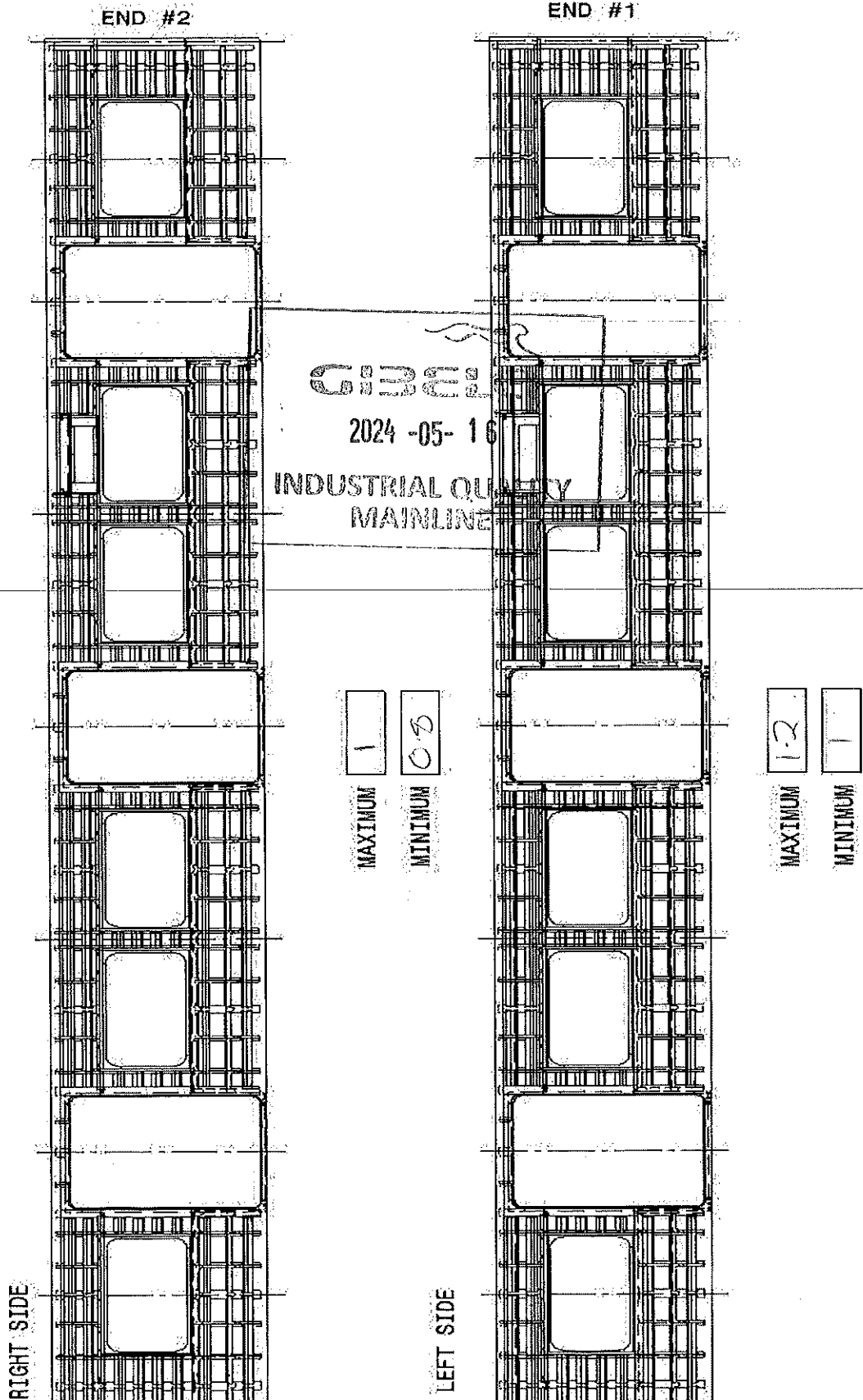
CARBODYSHELL M2 ASSEMBLY AA00001374497

Rev.  
30  
Date  
06/11/2023

Project: PRASA  
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Specifications of Details for CBS measurement CB1230

latness side left and right maximum of 2mm in the valley to peak measured in 900mm. Record the maximum and minimum value and indicate the corresponding location.







CARBODYSHELL M2 ASSEMBLY AA00001374497

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Date

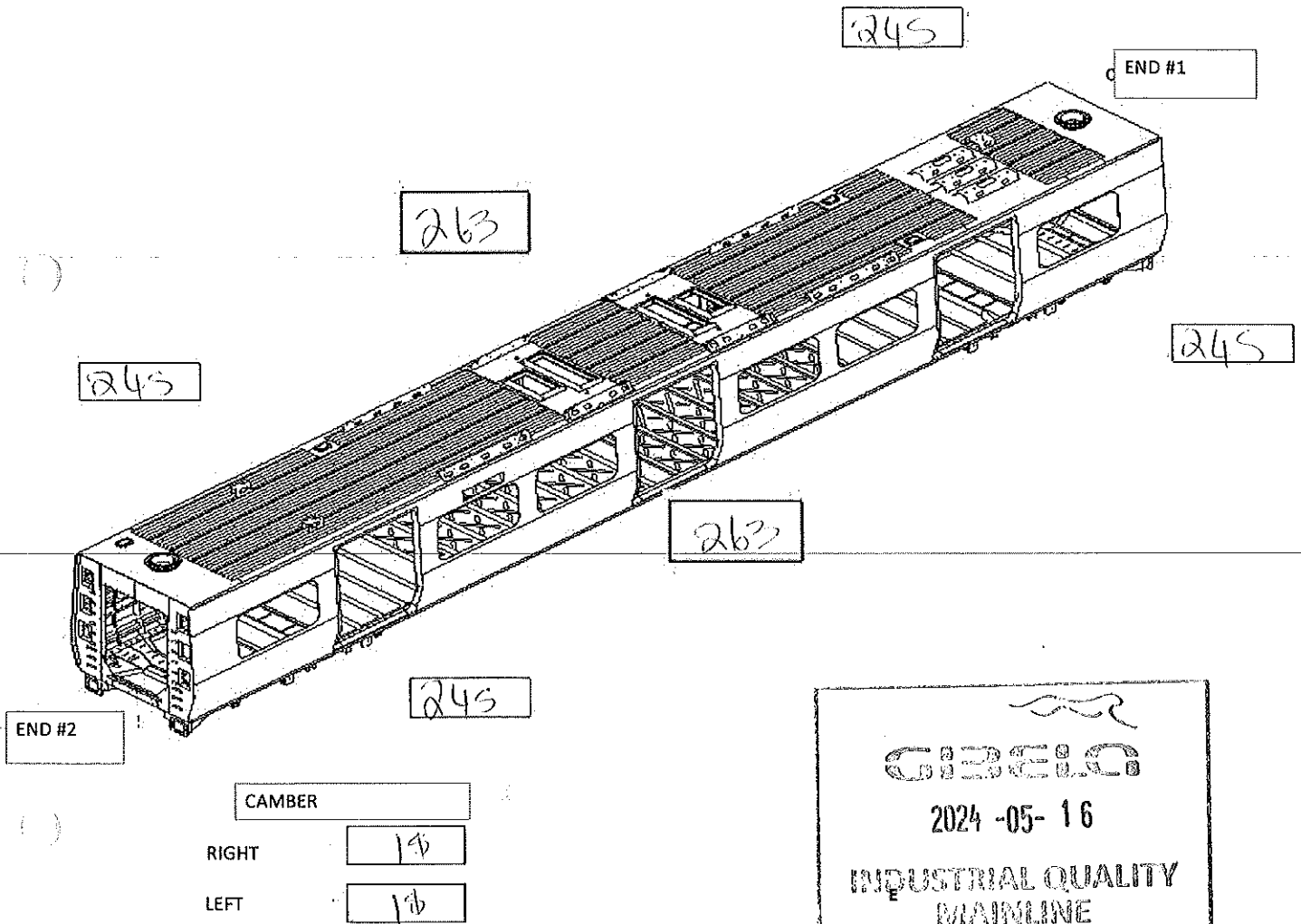
06/11/2023

Project: PRASA

SI.CB1230.277.V29

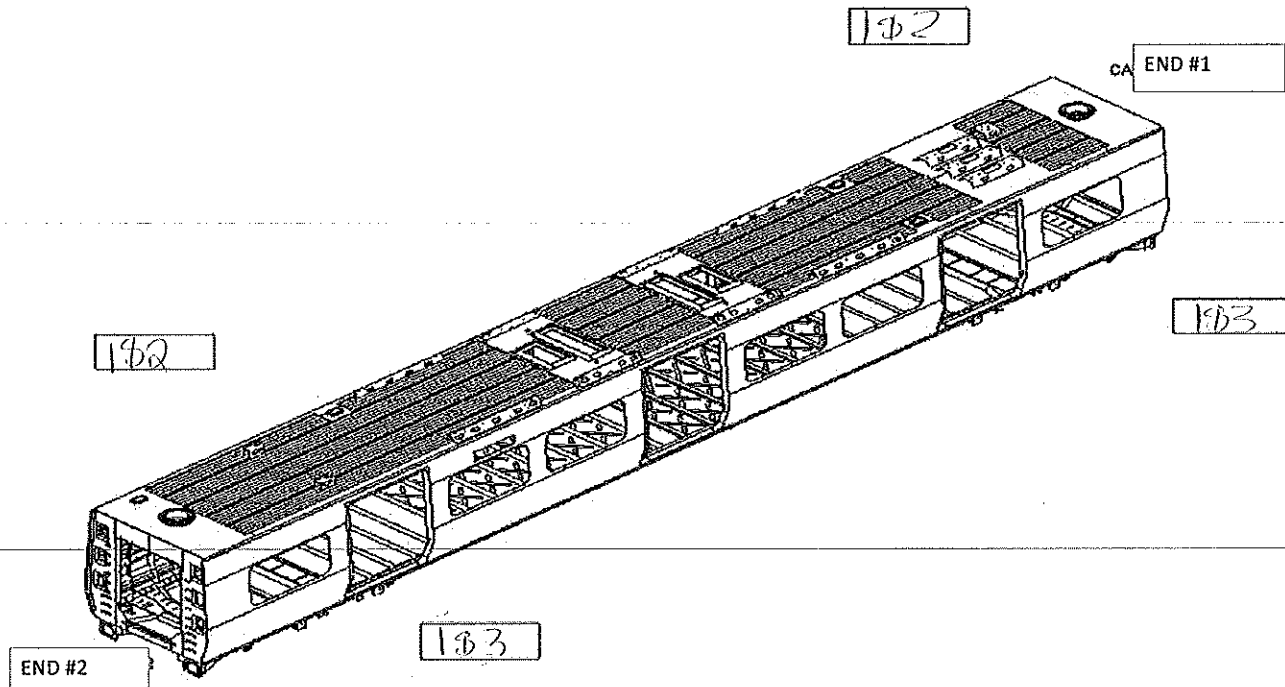
### Specifications of Details for CBS measurement CB1230

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



### Specifications of Details for CBS measurement CB1230

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



TWIST FOUND ON END 1

TRANVERSE

1

LONGITUDINAL

0

TWIST FOUND ON END 2

TRANVERSE

1

LONGITUDINAL

0

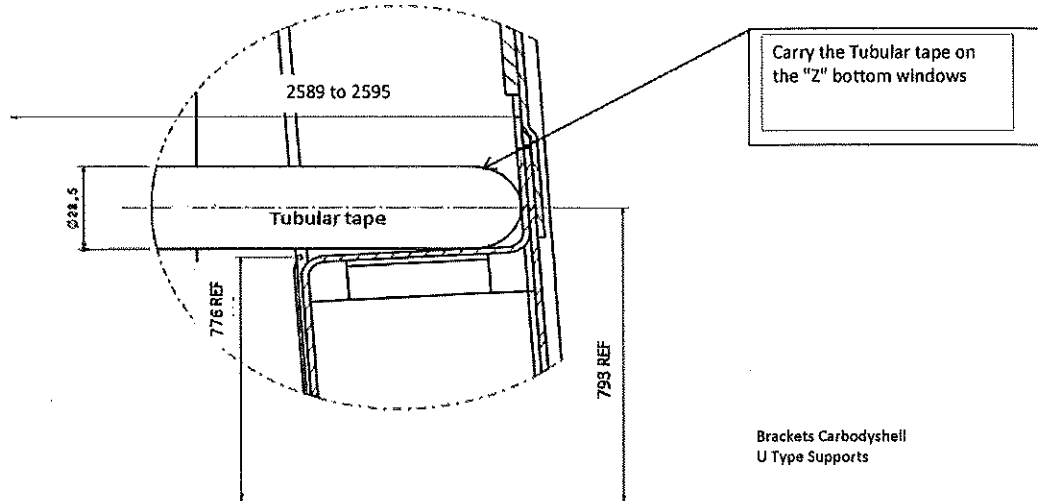


2024-05-16

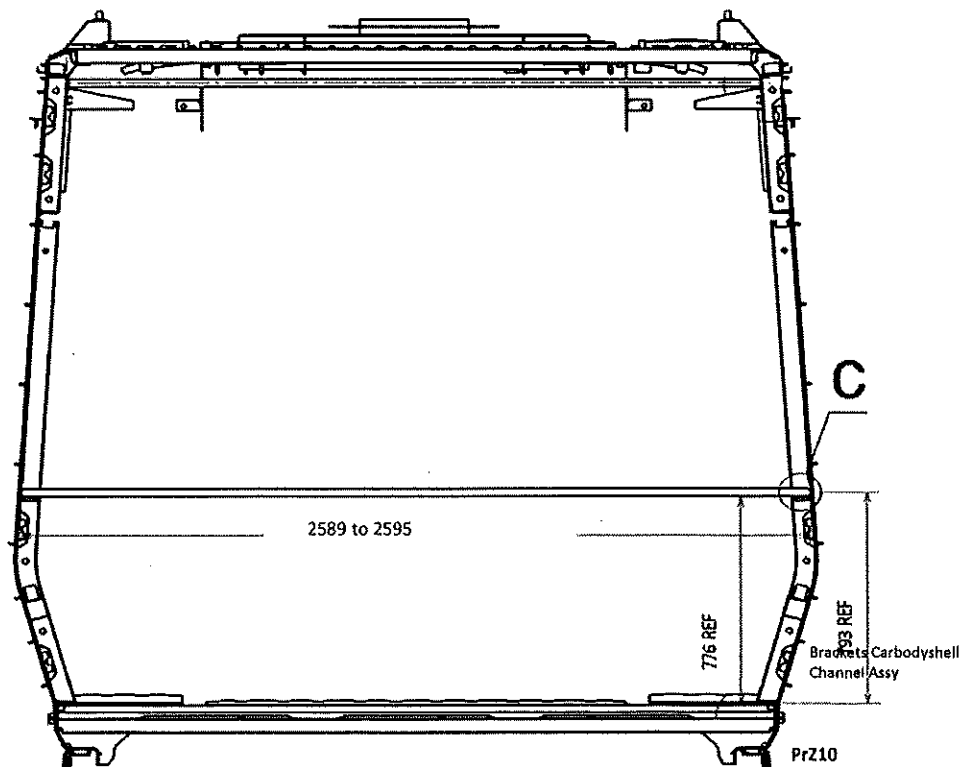
INDUSTRIAL QUALITY  
MANUFACTURE



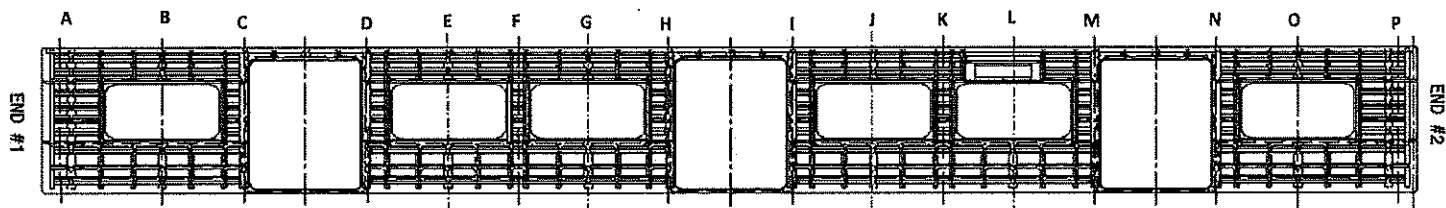
## Specifications of Details for CBS measurement CB1230



Detail C



## Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	2595
B	2592
C	2597
D	2595
E	2595
F	2595
G	2592
H	2594
I	2594
J	2596
K	2590
L	2590
M	2597
N	2594
O	2594
P	2595



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

BOILER MAKER: mmathapeio

Mada

WELDER: rhianha

Cm.



CARBODYSHELL M2 ASSEMBLY AA00001374497

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Date


06/11/2023

Project: PRASA

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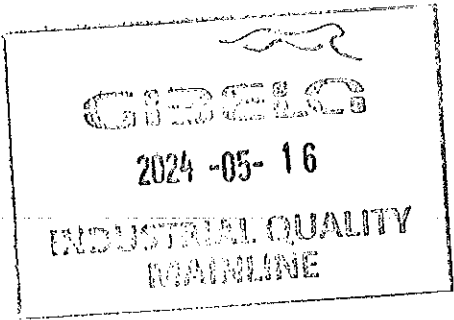
2024 -05- 16

INDUSTRIAL QUALITY  
MAINLINE

	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA  SI.CB1230.277.V29
		Date	
		06/11/2023	

Dye penetrant test


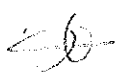
Dye-penetration test to be performed by quality personnel





	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA  SI.CB1230.277.V29
		Date	
		06/11/2023	

Self Inspection - Final Result

Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)		17.05.24	KHOSI Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)		17/05/2024	Amkani Industrial Quality	
		There are activities pendings 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

