

CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 4 5 9 _

WEIGHT: 1 4 8 3 Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	05/02/2024	178247 104625 01	LP49402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	11/02/2024	178820 104640 01	F205272	
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegasus	28/02/2024	128488 104640 01	P80091	
RCS 355	20 mm					

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

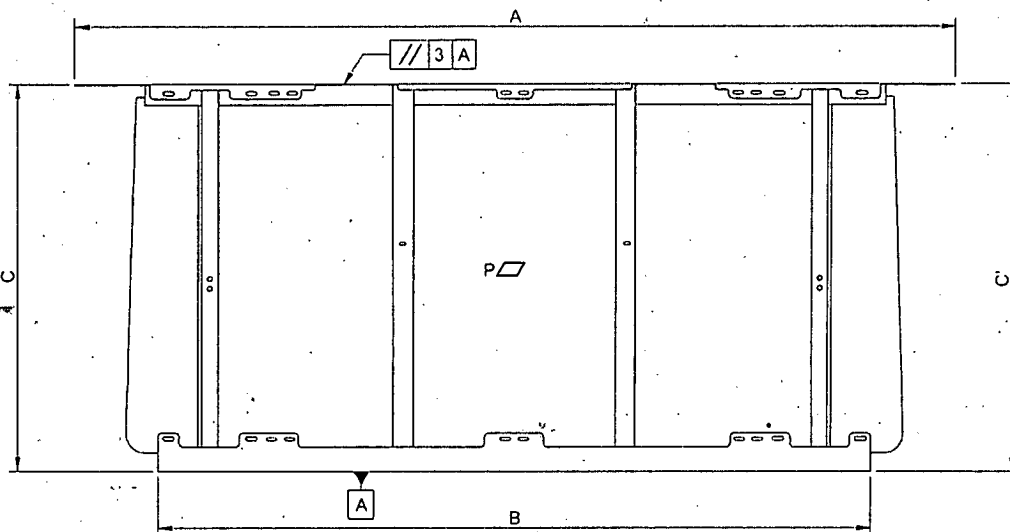
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	08/02/2024	178489 104640 01	VHC3558	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	14/02/2024	178865 104640 01	F207905 VHC28402	
RCS 450	6 mm					
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	22/11/2024	175569 102206 01	F207906 VHS58432	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

Cabin Roof Assembly: GN002839

Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	① YLAN ① AVIDS	Assembly Date:	2024/03/26		
Sign:		Wire Batch No.:	107238201		



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	Riccardo	Sign:		Date:	2024/03/26

Dimensional Control

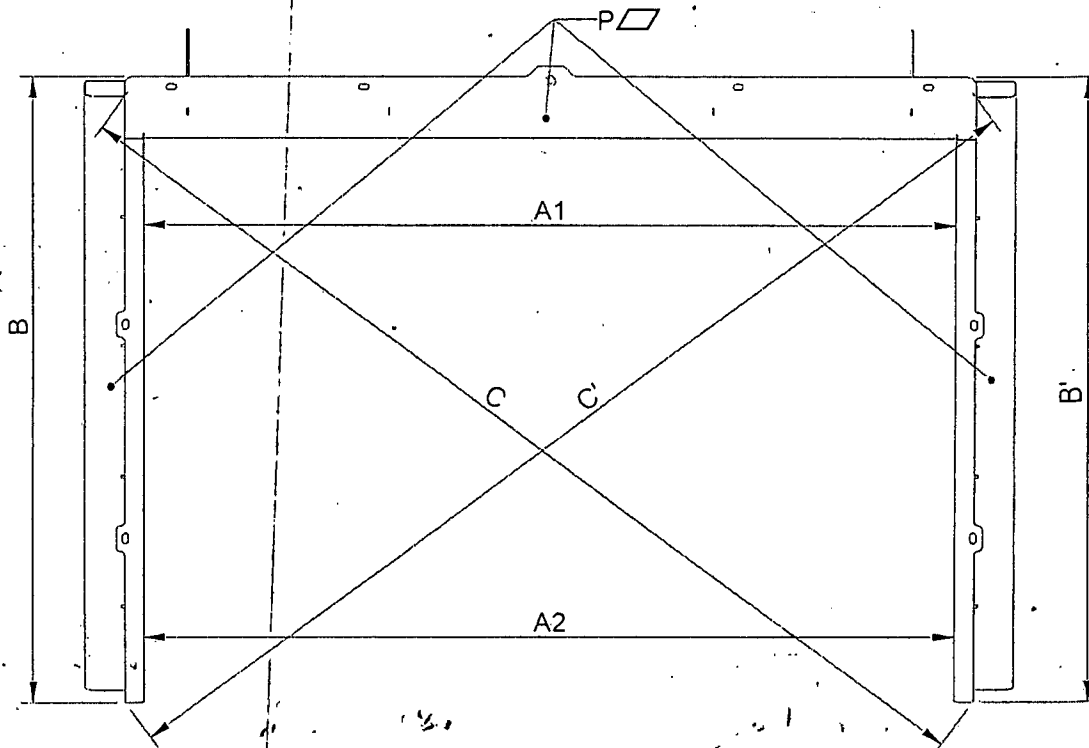
Rep	Toler.	Dimension measured	Measuring Equipment	Observations	
A	2216	+5/-0	Tape Measure	acceptable	
B	1800	± 4		acceptable	
C	976	+2/-3		acceptable	
QC Inspector:	Riccardo	Sign:		Date:	2024/03/26

Geometrical Control

Nature of Checks	Dimension Measured	Measuring Equipment	Observations		
Planity P	6 mm	Ruler	acceptable		
// 3 A	Passed	Set Square	acceptable		
QC Inspector:	Riccardo	Sign:		Date:	2024/03/26

Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator: <u>Bambelo Gcinah</u>	Assembly Date: <u>2024/03/19</u>				
Sign: <u>[Signature]</u>	Wire Batch No.: <u>SS2033</u>				



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector: <u>Leon</u>	Sign: <u>[Signature]</u>	Date: <u>2024/03/19</u>			

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	1910	± 2	1912		Tape Measure	Acceptable	
A2	1910		1910			Acceptable	
B	1475	± 1	1474	1474		Acceptable	
C	Diagonals C - C' ≤ 3		2476	2478		Acceptable	
QC Inspector:		Leon		Sign:		QA	Date:

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P : Planeity	4 mm	Ruler	Acceptable
QC Inspector: <u>Leon</u>	Sign: <u>[Signature]</u>	Date: <u>2024/03/19</u>	

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

Assembly Completed as per WI/SOS MD_0068_0073	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator: <i>Xen</i>	Assembly Date:	2024/03/19			
Sign: <i>[Signature]</i>	Wire Batch No.:	552033			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

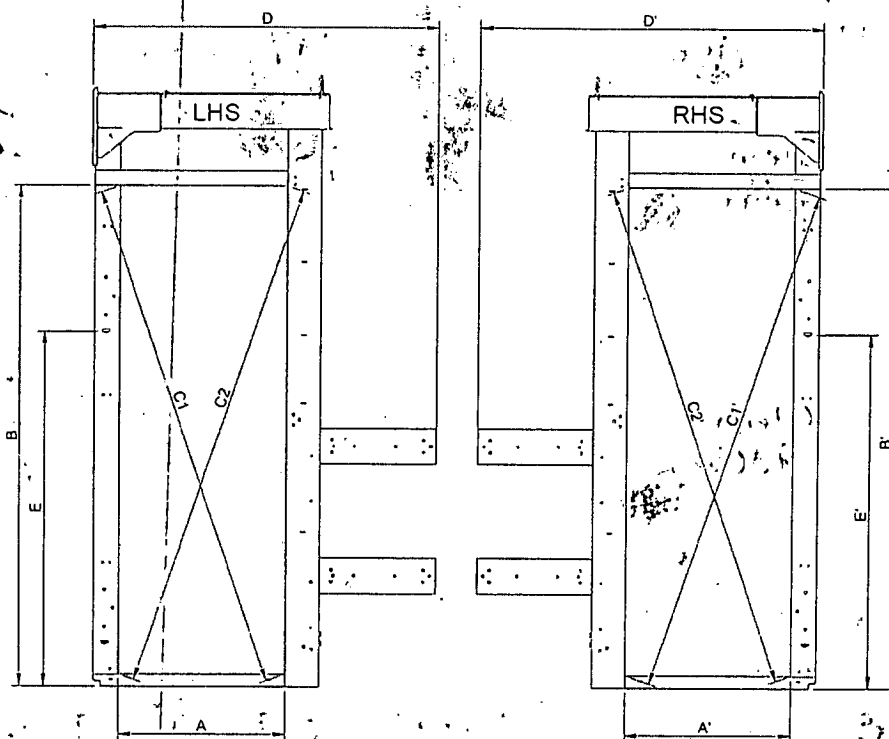
Assembly Completed as per WI/SOS MD_0065_0066	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator: Glenn	Assembly Date:	2024/03/14			
Sign: <i>[Signature]</i>	Wire Batch No.:	552033			

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator: Glenn	Assembly Date:	2024/03/14			
Sign: <i>[Signature]</i>	Wire Batch No.:	552033			

Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Glenn	Assembly Date:	2024/03/15			
Sign:	<i>Glenn</i>	Wire Batch No.:	552033			



Welding Control

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

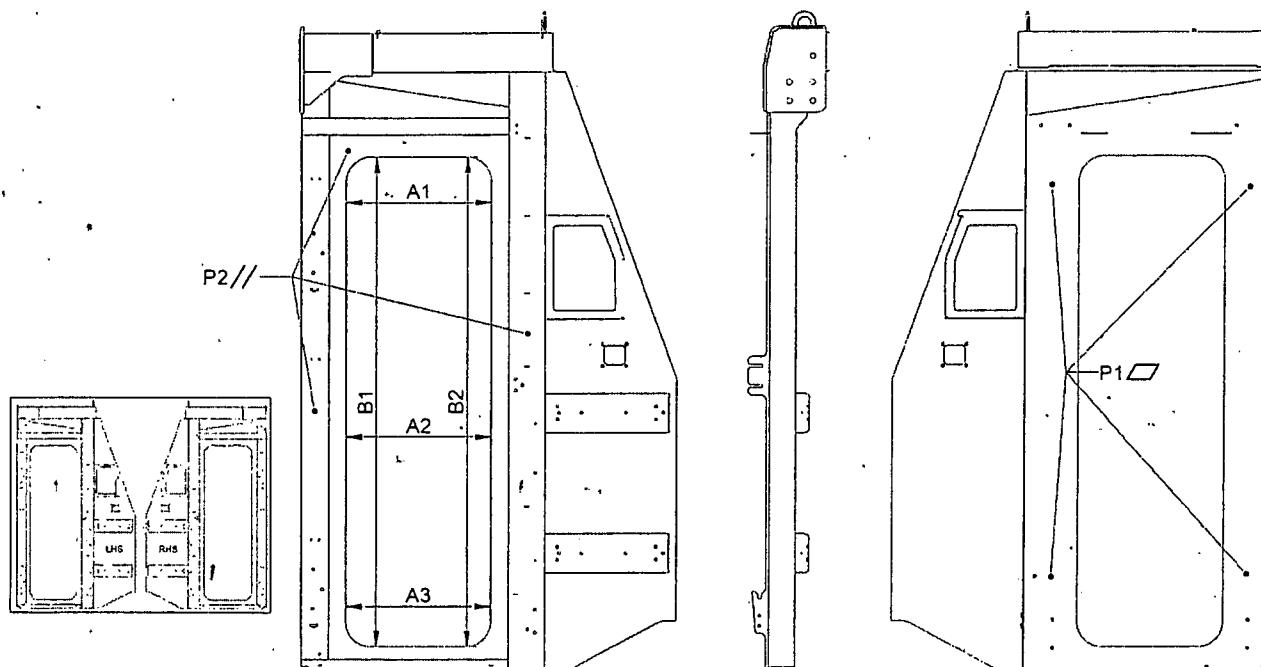
Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	697	696	Tape Measure	<i>Aug 16</i>
B	2086	+1/-3	2085	2086		<i>Aug 16</i>
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2153	2154		<i>Aug 16</i>
C1 - C2			2152	2153		<i>Aug 16</i>
D	1438	+2/-3	1437	1437		<i>Aug 16</i>
E						
QC Inspector:		<i>Low</i>	Sign:	<i>Q</i>	Date:	2024/03/16

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations	
P1 : planeity of 2 edges	4 mm	Pass	Ruler	Aug 16	
QC Inspector:	Low	Sign:	B	Date:	2024/08/16

Cabin LHS/RHS Side Assembly: GN002838/GN002837				
Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes <input checked="" type="checkbox"/>	No <input type="checkbox"/>
Operator:	<i>Xander R-H-S</i>	Assembly Date:	2024/03/19	
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033	



Welding Control				
Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes <input checked="" type="checkbox"/>	No <input type="checkbox"/>
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date: 2024/03/26

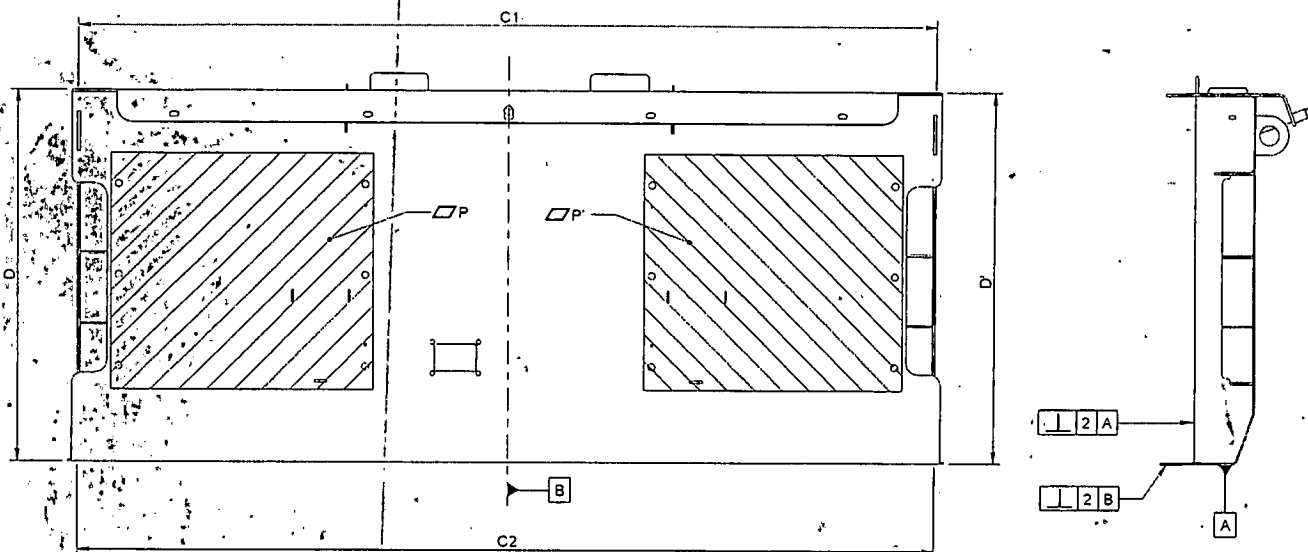
Dimensional Control					
Rep	Theoretical Dim.	Toler.	Dimension Measured		Observations
A1	560	±2	558	558	acceptable
A2			560	559	acceptable
A3			559	559	acceptable
B1	1900	±2	1898	1898	acceptable
B2			1898	1898	acceptable

QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date: 2024/03/26
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Geometrical Control				
Nature of checks	Dimension Measured	Measuring Equipment	Observations	
P1 : Planeity	4 mm	<i>Passo</i>	Ruler	acceptable
P2 : Planeity	2 mm	<i>Passo</i>	Ruler	acceptable
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date: 2024/03/26

Cabin Shield Assembly: GN002836


Assembly Completed as per WI/SOS MD_0043	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator: <u>Bambelo Ganan</u>	Assembly Date:	20 <u>24</u> / <u>03</u> / <u>25</u>			
Sign: <u>[Signature]</u>	Wire Batch No.:	SS <u>2035</u>			



Welding Control

Assembly Completed as per WI/SOS MD_0043	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector: <u>Leon</u>	Sign: <u>[Signature]</u>	Date:	20 <u>24</u> / <u>03</u> / <u>25</u>		

Dimensional Control

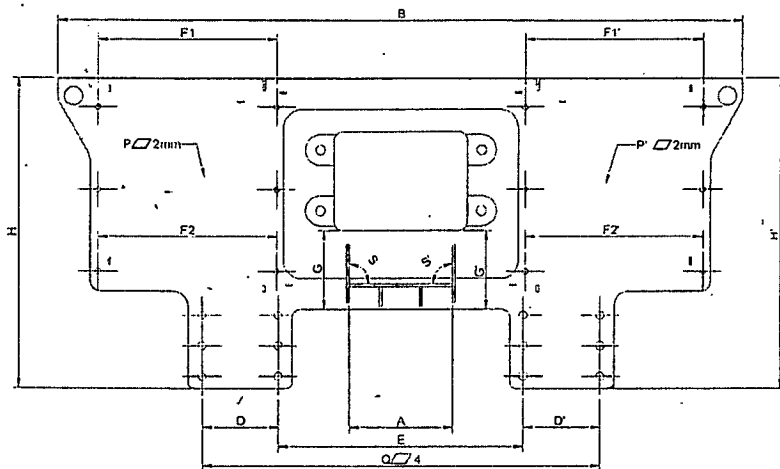
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2212	2213	Tape Measure	Acceptable
D / D'	956	± 2	955	958		Acceptable
QC Inspector:		Leon		Sign:		Date: 2024/03/25

Geometrical Control

Nature of Checks		Dimension Measured	Measuring Equipment	Observations
Planarity P / P'	2 mm	Pass	Ruler	Acceptable
Perpendicularity	2 A	Pass	Set Square	Acceptable
	2 B	Pass	Set Square	Acceptable
QC Inspector: <u>Leon</u>	Sign: <u>[Signature]</u>	Date:	20 <u>24</u> / <u>03</u> / <u>25</u>	

Cabin Front Headstock Assembly: GN002841


Assembly Completed as per WI/SOS MD_0019	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator: <i>TK Booru</i>	Assembly Date:	2024/03/19			
Sign: <i>[Signature]</i>	Wire Batch No.:	F52033			



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector: <i>Riccardo</i>	Sign: <i>[Signature]</i>	2273	Date:	2024/03/19	

Dimensional Control

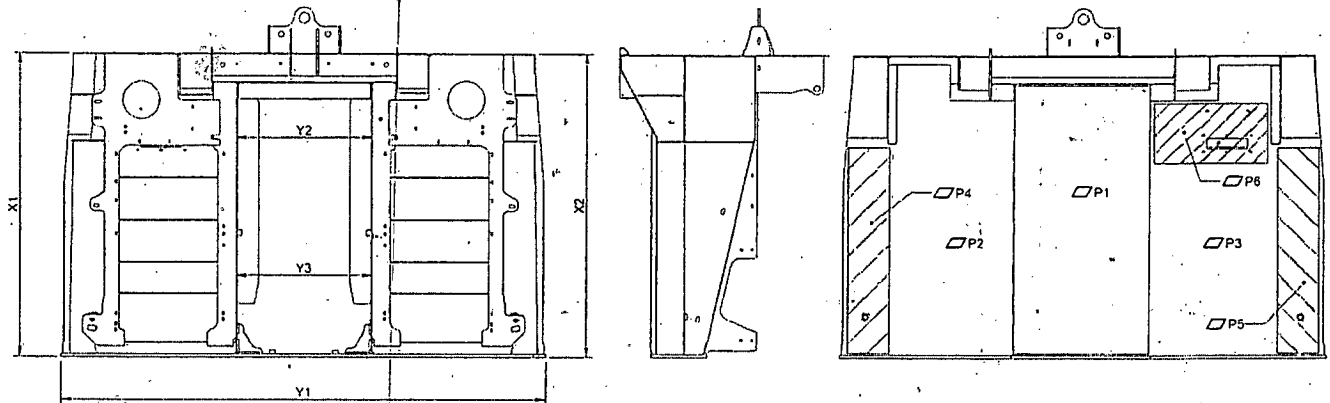
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	340	± 1	340		Tape Measure	acceptable	
B	2240	± 4	2244			acceptable	
D / D'	250	± 1	251	251		acceptable	
E	808	± 2	808			acceptable	
F1 / F1'	580	± 1	581	581		acceptable	
F2 / F2'			581	581		acceptable	
G / G'	258	± 1	259	259		acceptable	
H / H'	1019	± 2	1020	1020		acceptable	
QC Inspector:		Riccardo		Sign:		Date:	2024/03/19

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
O: Planeity of global assembly	4 mm	Ruler	acceptable
P / P': Planeity	2 mm	Ruler	acceptable
Q: Planeity Surface of Supports	4 mm	Ruler	acceptable
R: Planeity Coupler Support	2 mm	Ruler	acceptable
S: Perpendicularity coupler	1mm	Square	acceptable
QC Inspector: <i>Riccardo</i>	Sign: <i>[Signature]</i>	Date:	2024/03/19

Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	Michael Wood	Assembly Date:	2024/03/14	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152	




Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	Leon	Sign:	<i>[Signature]</i>	Date: 2024/03/14


Dimensional Control

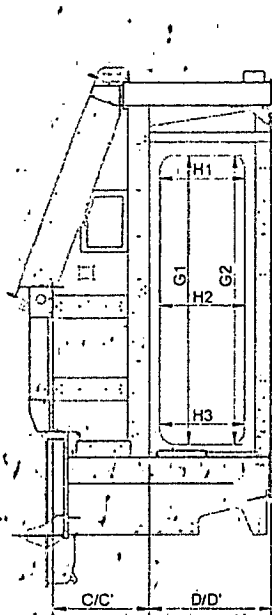
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1485	1486	Tape Measure	<i>[Signature]</i>
Y1	2354	±3	2352			<i>[Signature]</i>
Y2 / Y3	666	±1	664	664		<i>[Signature]</i>
QC Inspector:		Leon	Sign:	<i>[Signature]</i>	Date:	2024/03/15

Geometrical Control

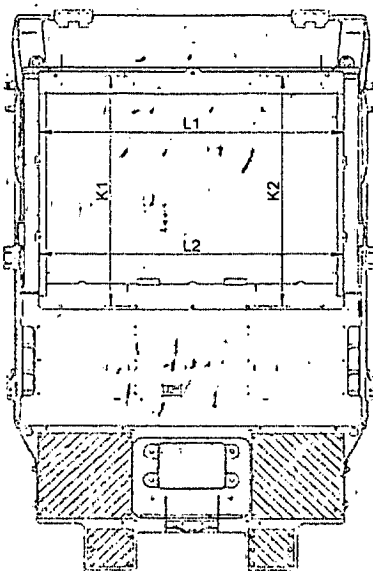
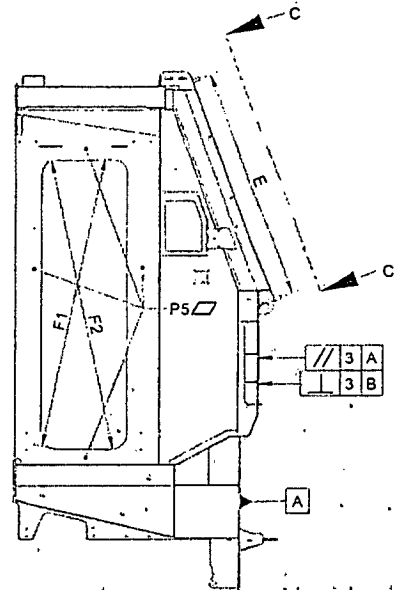
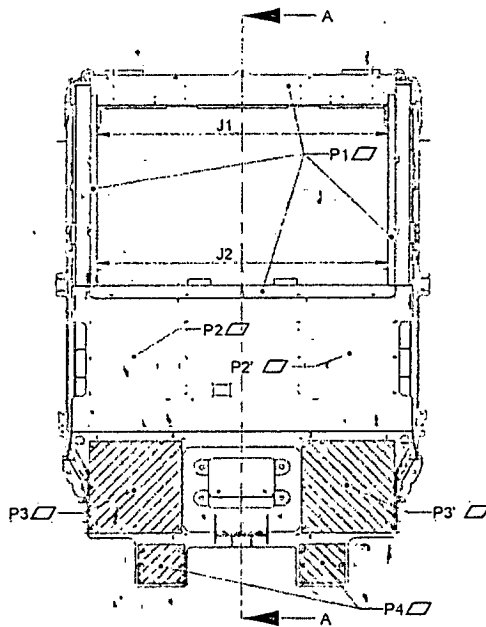
Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Pass	Ruler	Accepted
P2 / P3 : Planeity	4 mm	Pass	Ruler	Accepted
P4 / P5 : Planeity	2 mm	Pass	Ruler	Accepted
P6 : Planeity	2 mm	Pass	Ruler	Accepted
QC Inspector:	Leon	Sign:		Date: 2024/03/15

Cabin Structure Assembly: GN002834

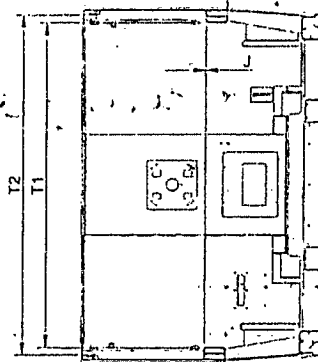
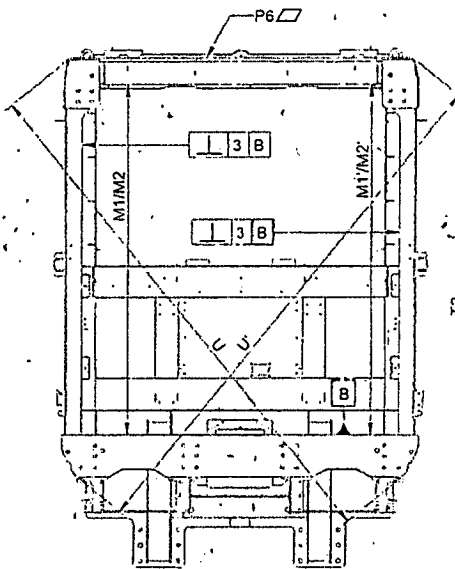
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLOOM	Assembly Date:	20 24 03 / 28			
Sign:		Wire Batch No.:	5602033			



SECTION A-A



AUX VIEW: C

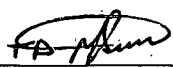
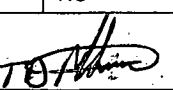
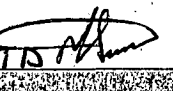



SECTION B-B


Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed		Yes		No
QC Inspector:		Riccardo		Sign:		Dina		Date: 2024/04/02	
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	625	625	acceptable				
D / D'	813	± 2,5	813	813	acceptable				
E	1531.5	± 3	1530		acceptable				
G1 / G'1	Height 1900	+1	1897	1897	acceptable				
G2 / G'2		-3	1898	1898	acceptable				
H1 / H'1	Width 560	+1	559	558	acceptable				
H2 / H'2		-3	560	559	acceptable				
H3 / H'3			560	560	acceptable				
F1 / F'1	Diagonals 1939		1936	1936	acceptable				
F2 / F'2			1935	1935	acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	1	1	acceptable				
J	Gap of Doors	± 1,5	1	1	acceptable				
K1 / K2	1515	± 3	1513	1515	acceptable				
L1 / L2	1996	± 3	1998	1993	acceptable				
M1 / M'1	2308	± 3	2467	2466	acceptable				
M2 / M'2			2477	2476	acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2128	2129	acceptable				
T2 / T'2	2230 Top/Bottom		2230	2230	acceptable				
Difference	U - U' (3522)	≤ 4mm	3522	3524	acceptable				
QC Inspector:		Riccardo		Sign:		Dina		Date: 2024/04/02	
Geometrical Control									
Nature of checks				Toler.	LHS / Dimension Measured / RHS				
P1 / P'1	Planeity			2 mm	Passed		acceptable		
P2 / P'2	Planeity			2 mm	Passed		acceptable		
P3 / P'3	Planeity			4 mm	Passed		acceptable		
P4 / P'4	Planeity			4 mm	Passed		acceptable		
P5 / P'5	Planeity			4 mm	Passed		acceptable		
P6 Roof	Planeity			6 With 2m Ruler	Passed		acceptable		
Shield	//	3	A	3	Passed		acceptable		
Shield	⊥	3	A	3	Passed		acceptable		
Door Post	⊥	3	A	Front	Passed		acceptable		
				Back	Passed		acceptable		
QC Inspector:		Riccardo		Sign:		Dina		Date: 2024/04/02	

Cabin Bracket Assembly: GN002833				
Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>Daniel</i>	Assembly Date:	20 <i>24</i> / <i>09</i> / <i>02</i>	
Sign:	<i>[Signature]</i>	Wire Batch No.:	<i>5502033</i>	

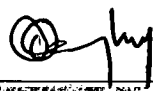

Cabin Rivnut Assembly: GN002832				
Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>Seung</i>	Assembly Date:	20 __ / __ / __	
Sign:	<i>[Signature]</i>	Wire Batch No.:		

Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Fasteners positioned in all Rivnuts and Bosses		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Masked as per GMS-SOS-GIBELA-CABIN-001		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:	DAVID	Sign:			
Date:	2024/04/22				
Record of Shot Blasting					
Operator:		Date:	2024/04/19		
Start Time:	11:15	End Time:	13:05		
Temperature ($\geq 15^\circ$):	20-02 °C	Humidity ($\leq 75\%$):	49-03		
Shot Blasting Self-Inspection					
Interior of Cabin: Sa 1 - Light Stripping		Confirmed	Yes	<input checked="" type="checkbox"/> No	
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping		Confirmed	Yes	<input checked="" type="checkbox"/> No	
		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:	DAVID	Sign:			
Date:	2024/04/19				
Shot Blasting Cleaning					
Cabin free of all sand		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:		Sign:			
Date:	2024/04/19				
Shot Blasting Control					
Temperature $\geq 15^\circ$:	21-02 °C	Humidity $\leq 75\%$:	46-09 %		
Internal Roughness $3.2 \leq Ra \leq 12.5$	10.532	External Roughness $3.2 \leq Ra \leq 12.5$	11.528		
QC Inspector:	LEON	Sign:			
Date:	19/04/24				

Record of Priming							
Start Time:		02:00		End Time:		04:00	
Temperature $\geq 15^{\circ}$:		31 $^{\circ}$ C		Humidity $\leq 75\%$:		59%	
Paint Batch No.:		7978267		Paint Expiry Date:		06/25	
Hardener Batch No.:		733119		Hardener Expiry Date:		01/11/24	
Desolvation Start Time:		04:00		Desolvation End Time:		04:15	
Stoving Start Time:		04:15		Stoving End Time:		05:15	
Stoving Temp:		60 $^{\circ}$ C					
Operator:		Intutuhko		Sign:			
Date:		20/04/23				Intutuhko	
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 43	5: 58	1: 41	5: 77	1: 64	5: 81	1: 62	5: 71
2: 61	6: 49	2: 45	6: 52	2: 72	6: 73	2: 56	6: 78
3: 74	7: 55	3: 68	7: 61	3: 50	7: 44	3: 74	7: 64
4: 62	8: 62	4: 57	8: 78	4: 62	8: 58	4: 65	8: 80
Min:	43	Min:	41	Min:	44	Min:	56
Max:	74	Max:	78	Max:	81	Max:	80
Average:	58	Average:	59	Average:	62	Average:	68
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 61	5: 70	1: 75	5: 51	1: 48	5: 78	1: 63	5: 74
2: 81	6: 53	2: 65	6: 60	2: 45	6: 64	2: 52	6: 68
3: 48	7: 83	3: 79	7: 74	3: 63	7: 57	3: 61	7: 77
4: 72	8: 47	4: 54	8: 69	4: 79	8: 56	4: 44	8: 80
Min:	48	Min:	51	Min:	45	Min:	44
Max:	83	Max:	79	Max:	79	Max:	86
Average:	65	Average:	65	Average:	62	Average:	65
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DET. Machined Top RHS/LHS	
1: 41	5: 71	1: 58	5: 42	1: 62	5: 67	1: 63	5: 41
2: 59	6: 80	2: 79	6: 46	2: 62	6: 55	2: 68	6: 43
3: 52	7: 51	3: 85	7: 37	3: 73	7: 78	3: 57	7: 72
4: 66	8: 46	4: 76	8: 49	4: 40	8: 74	4: 50	8: 62
Min:	41	Min:	37	Min:	40	Min:	41
Max:	80	Max:	85	Max:	78	Max:	72
Average:	60.5	Average:	61	Average:	59	Average:	56
Primer has been inspected and is free of defects				Confirmed		Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>	
QC Inspector:		Zankle		Sign:			
Date:		21/04/2024					

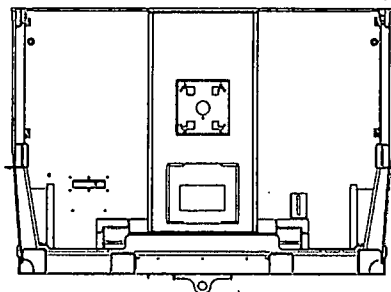
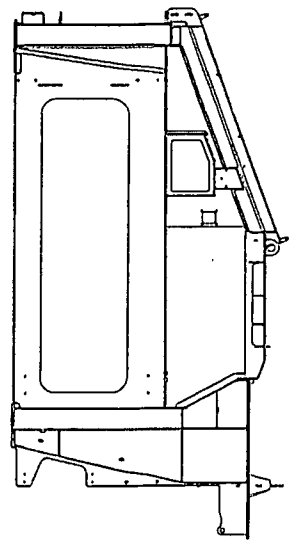
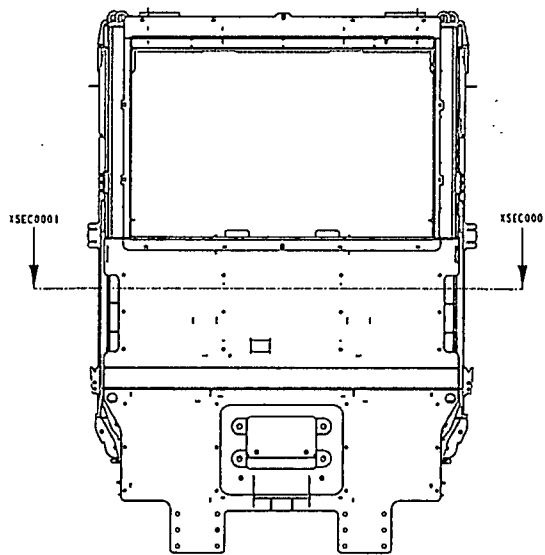
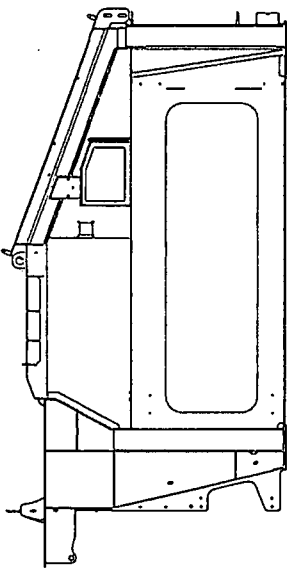
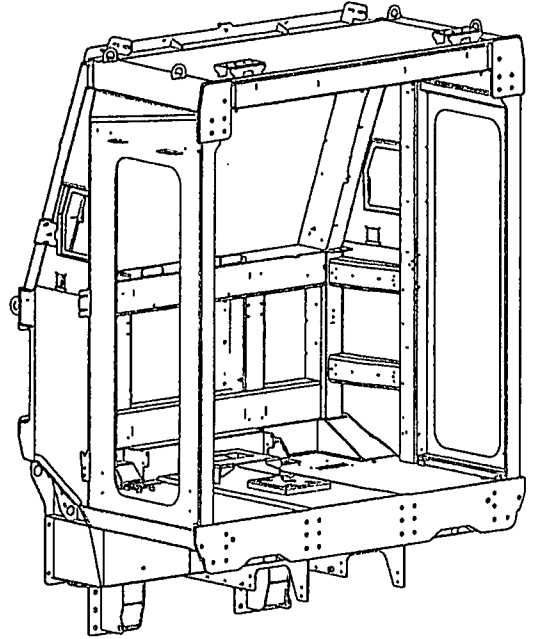
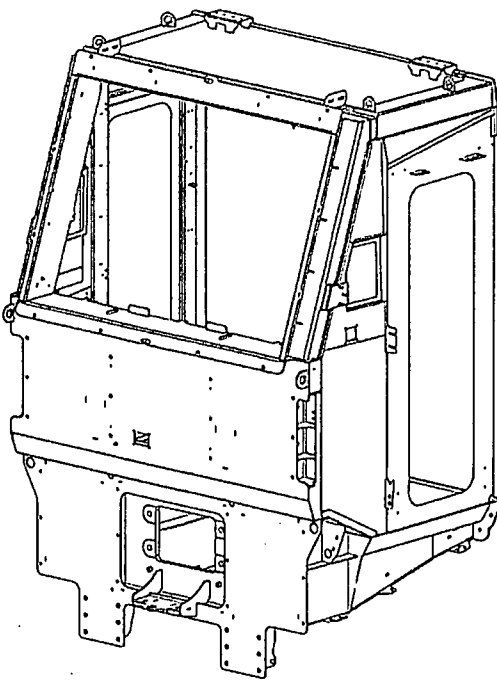
Record of Painting NCSS3010 R90B			
Start Time:	09:00	End Time:	10:00
Temperature $\geq 15^{\circ}$:	29°C	Humidity $\leq 75\%$:	42%
Paint Batch No.:	8196598	Paint Expiry Date:	23-02-2025
Hardener Batch No.:	8138195113	Hardener Expiry Date:	11/26
Desolvation Start Time:	10:00	Desolvation End Time:	10:15
Stoving Start Time:	10:15	Stoving End Time:	11:15
Stoving Temp:	60°C		
Operator:	msa	Sign:	msa
Date:	2024/04/25		
Painting NCSS3010 R90B Control			
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS	
GMS-SOS-GIBELA-PS-001 Adhesion Test, (attach test tape)			
1: 140	5: 143	1: 176	5: 909
2: 58	6: 122	2: 162	6: 158
3: 124	7: 106	3: 116	7: 109
4: 185	8: 137	4: 132	8: 126
Min:	106	Min:	909
Max:	158	Max:	176
Average:	133	Average:	133
Painting NCSS3010 R90B has been inspected and is free of defects		Confirmed	Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	348
QC Inspector:	Carmen	Sign:	
Date:	26/04/24		

Record of Painting Blue NCSS1565 B			
Start Time:	18:30	End Time:	19:00
Temperature $\geq 15^{\circ}$:	26 $^{\circ}$ C	Humidity $\leq 75\%$:	61%
Paint Batch No.:	8196598	Paint Expiry Date:	23-02-2025
Hardener Batch No.:	8138195113	Hardener Expiry Date:	11/26
Desolvation Start Time:	19:00	Desolvation End Time:	19:15
Stoving Start Time:	19:15	Stoving End Time:	20:15
Stoving Temp:	60 $^{\circ}$ C		
Operator:	NEUTKJCO	Sign:	[Signature]
Date:	20/04/25		
Painting Blue NCSS1565 B Control			
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS	
1: 141	5: 108	1: 119	5: 97.5
2: 96	6: 89.8	2: 121	6: 98.1
3: 124	7: 119	3: 107	7: 102
4: 133	8: 110.7	4: 115	8: 81.3
Min: 89.8		Min: 81.3	
Max: 141		Max: 121	
Average: 114		Average: 105	
Painting NCSS3010 R90B has been inspected and is free of defects		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)	
		Confirmed	Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test		Value 92.2	
QC Inspector:	CAEMCH	Sign:	[Signature]
Date:	26/4/24		

Record of RAL7012									
Start Time:		15:00		End Time:		17:00			
Temperature $\geq 15^{\circ}$:		31 ^o C		Humidity $\leq 75\%$:		57%			
Paint Batch No.:		8196593		Paint Expiry Date:		16-02-2025			
Hardener Batch No.:		8138198113		Hardener Expiry Date:		11/26			
Desolvation Start Time:		17:00		Desolvation End Time:		17:15			
Stoving Start Time:		17:15		Stoving End Time:		18:15			
Stoving Temp:		60 ^o C							
Operator:		Musa		Sign:					
Date:		20/04/24							
RAL7012 Control									
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front			
1: 170	5: 175	1: 198	5: 76,3	1: 120	5: 132	1: 132	5: 114		
2: 101	6: 132	2: 92,4	6: 167	2: 140	6: 93,4	2: 84,3	6: 93,4		
3: 150	7: 83,8	3: 106	7: 86,3	3: 133	7: 104	3: 90,4	7: 123		
4: 139	8: 72,8	4: 187	8: 115	4: 162	8: 138	4: 116	8: 105		
Min:	72,8	Min:	76,3	Min:	93,4	Min:	84,3		
Max:	175	Max:	198	Max:	152	Max:	132		
Average:	127	Average:	128	Average:	126	Average:	107		
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside			
1: 121	5: 100	1: 147	5: 64,0	1: 139	5: 171	1: 84,3	5: 79,3		
2: 126	6: 104	2: 102	6: 132	2: 123	6: 148	2: 105	6: 106		
3: 198	7: 178	3: 125	7: 112	3: 121	7: 153	3: 116	7: 80,1		
4: 119	8: 174	4: 121	8: 132	4: 112	8: 135	4: 130	8: 121		
Min:	100	Min:	64,0	Min:	112	Min:	79,3		
Max:	198	Max:	147	Max:	153	Max:	130		
Average:	140	Average:	118	Average:	137	Average:	102		
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test					
1: 109	5: 81,3	1: 112	5: 88,9						
2: 198	6: 156	2: 149	6: 107						
3: 152	7: 102	3: 80,3	7: 125						
4: 132	8: 143	4: 105	8: 137						
Min:	81,3	Min:	80,3						
Max:	198	Max:	149						
Average:	134	Average:	113						
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>	
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	408				
QC Inspector:		CARMEL		Sign:					
Date:		26/4/24							
SEALING OF CABIN									
All areas where there is no welding has been sealed with SIKA						Confirmed	YES	<input checked="" type="checkbox"/>	NO
All sealants have been neatly applied along joints						Confirmed	YES	<input checked="" type="checkbox"/>	NO
SIGN OFF:									
CLOCK No:	2400		OPERATOR SIGN:			DATE:	26/04/2024		

REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)



[illegible][illegible]



CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	0459	Checks Updated:	2022/08/26

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

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

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