

GIBELA

PRASA PROJECT

APPLICABLE FROM TRAINSET 190+ AS PER BASELINE 10.4

## 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"/> DTR3000152644	AAD0001278566	CARBODYSHELL M3,M4 ASSEMBLY	CB2210		X			X		PRA.CB2210.DTR30225 487/3.V30	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 CB2210	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	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	19/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	19/02/2022						
			CHECKER	Andani Muthelo	19/02/2022						
			REVISED BY	Andani Muthelo	19/02/2022						
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						
28	07/11/2023	Added traceability for welding sections	APPROVER	Ngobeni Tyson	07/11/2023						
			CHECKER	Mohlampe Amogelang	07/11/2023						
			REVISED BY	Ntokozo Zwane	07/11/2023						
TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES						
B228	M3	Imneno 41008	20.05.24	SI.CB2210.254.V30	17						

2024-05-20

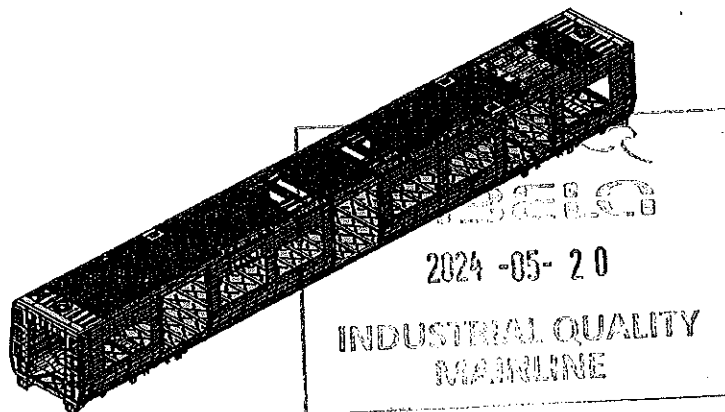
TRIAL QUALITY  
MAINLINE

	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	

Car: M3 & M4	NCR:	Work station: CB2210
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Safety Related



## I - Documentation and Instruments Control

### I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	1	2	3	4	5	6						
DTR30225487/3							28		✓		20.05.24	

### I.2 - Instruments Control


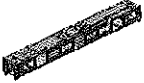
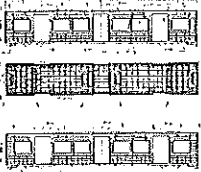
#### Monitoring and Measuring Instrument Control - Used for Special Process

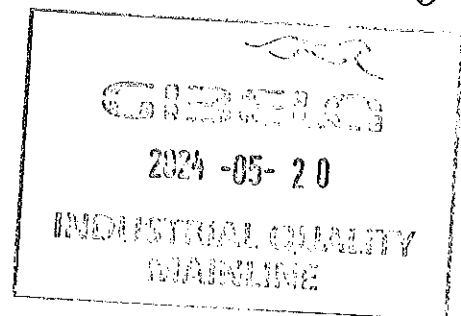
Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
THICKNESS	828228-2	15/03/25	OK		20.05.24	
LOSSY TAPES	125425924	08/09/25	OK		20.05.24	
(80mm) TAPES	41870102	18/11/24	OK		20.05.24	


### 1.3 Consumables

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

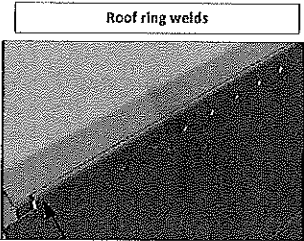
Fiber Material	Real Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
EC 308 081	31408-74097	MIG	OK		20.05.24	
	29968-70822	TIG	OK		20.05.24	

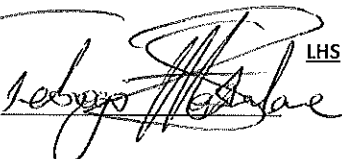
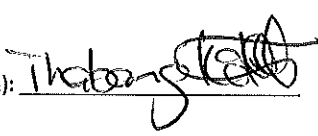
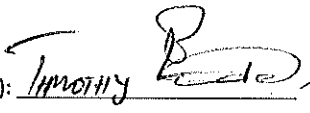
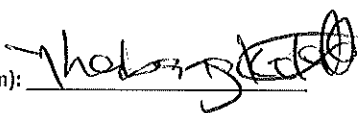
		Rev. 28	Project: PRASA SI.CB2210.254.V30			
		Date 07/11/2023				
<b>II - Self Inspection - Items to Check</b>						
<b>II.1 - Items to check</b>						
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	/	<i>P. B. S.</i> 20.05.24	<i>[Signature]</i> 20/05/24
02	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	/	<i>P. B. S.</i> 20.05.24	<i>[Signature]</i> 20/05/24
03	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	/	<i>P. B. S.</i> 20.05.24	<i>[Signature]</i> 20/05/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	/	<i>P. B. S.</i> 20.05.24	<i>[Signature]</i> 20/05/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	/	<i>P. B. S.</i> 20.05.24	<i>[Signature]</i> 20/05/24
06	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.	/	<i>P. B. S.</i> 20.05.24	<i>[Signature]</i> 20/05/24

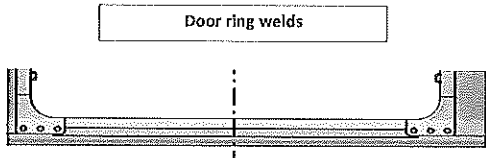


	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRA5A SI.CB2210.254.V30
		Date 07/11/2023	

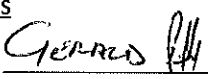
**Welding Traceability**

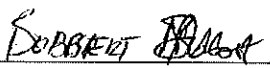


<div style="text-align: right; margin-bottom: 10px;"> <u>LHS</u> </div> Boiler maker (Name & Sign): <u></u>	<div style="text-align: right; margin-bottom: 10px;"> <u>LHS</u> </div> Welder (Name & Sign): <u></u>
<div style="text-align: right; margin-bottom: 10px;"> <u>RHS</u> </div> Boiler maker (Name & Sign): <u></u>	<div style="text-align: right; margin-bottom: 10px;"> <u>RHS</u> </div> Welder (Name & Sign): <u></u>

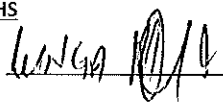


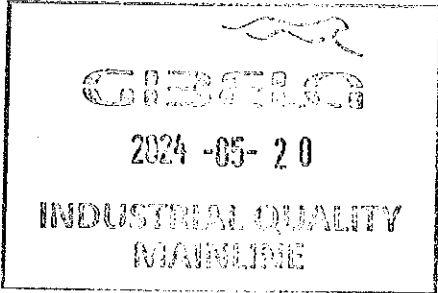
LHS

Boiler maker (Name & Sign): 

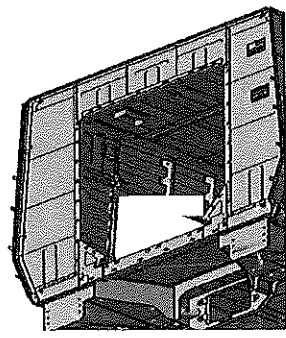
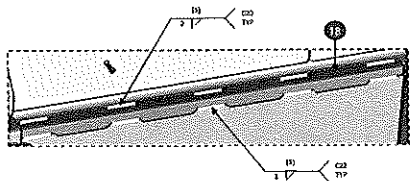
Welder (Name & Sign): 

RHS

Boiler maker (Name & Sign): 

Welder (Name & Sign): 


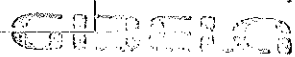
EUF Reinforcement Plates

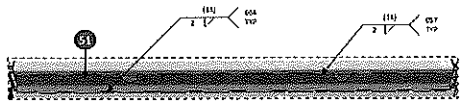


END 1

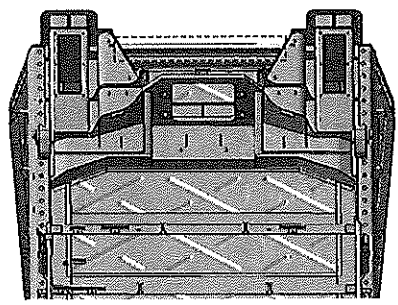
Boiler maker (Name & Sign): Lunga

Welder (Name & Sign): SITHOKAZI


  
2024 -05- 20
  
INDUSTRIAL QUALITY
  
MAINTENANCE



END 2

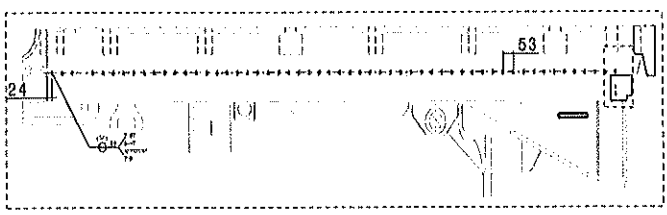


Underneath the CAR

END 2


Boiler maker (Name & Sign): GERALD

Welder (Name & Sign): Dobbert

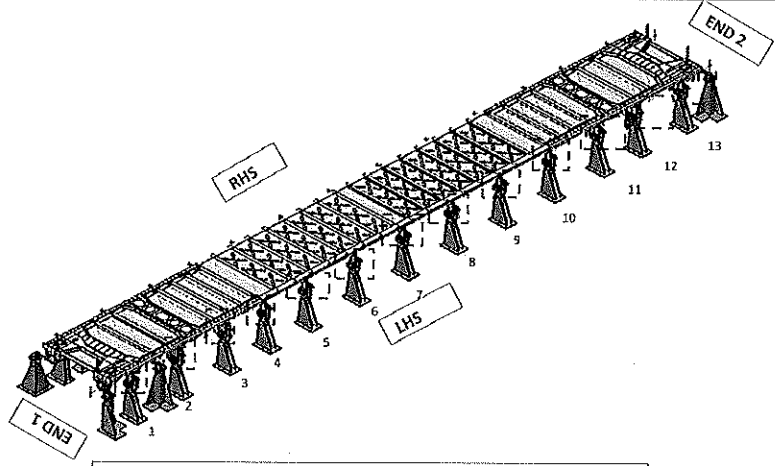


FEDOLI

Operator: Fedoli

	CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3	Rev. 28	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	

Specifications of Details for CBS measurement



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

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	00	00	00	00	00	00	00	00	00	00	00	00
Right Hand Side	00	00	00	00	00	00	00	00	00	00	00	00	00

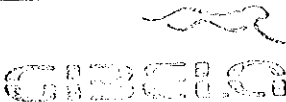
Signature Operations: *[Signature]* Date: 20.05.24

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	00	00	00	00	00	00	00	00	00	00	00	00	00
Right Hand Side	00	00	00	00	00	00	00	00	00	00	00	00	00

Signature Industrial Quality: *[Signature]* Date: 20/05/24



2024-05-20

INDUSTRIAL QUALITY  
MAINLINE



CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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28

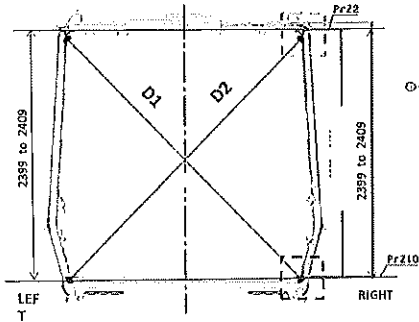
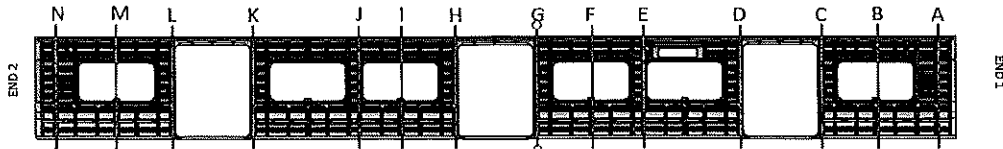
Date

07/11/2023

Project: PRASA

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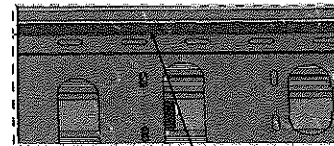
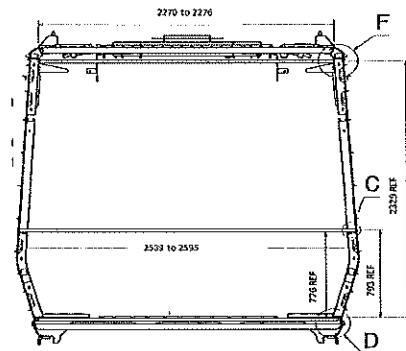
### Specifications of Details for CBS measurement



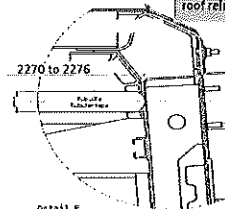
Measurement positions on roof rail and sidewall omega corner.



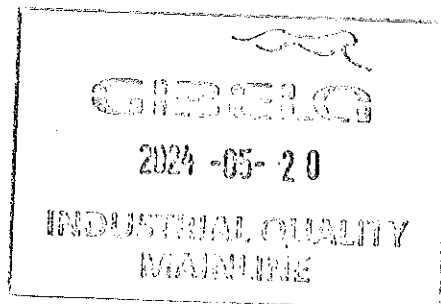
Measurement positions on sidewall and side sill corner.




Reinforcement area measurement positions on roof reinforcement area.

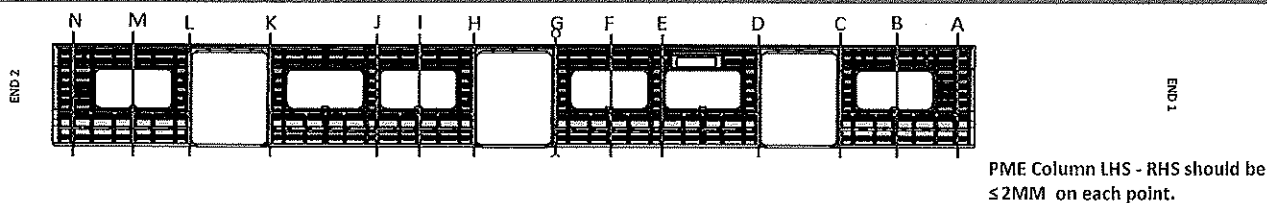


Detail F  
Don't considering the reinforcement



	CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3	Rev. 28	Project: PRASA SI.CB2210.254.V30
		Date	
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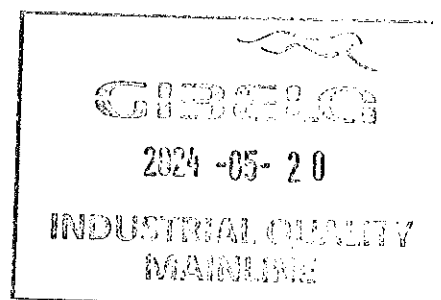
Specifications of Details for CBS measurement



BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3268	3268	0	2407	2406	1
B	3270	3270	0	2406	2406	0
C	3265	3267	2	2408	2406	2
D	3266	3266	0	2406	2406	0
E	3275	3274	1	2407	2406	1
F	3273	3271	2	2406	2407	1
G	3265	3265	0	2406	2406	0
H	3266	3266	0	2405	2406	1
I	3264	3266	1	2407	2406	1
J	3274	3272	2	2408	2406	2
K	3268	3268	0	2406	2406	0
L	3265	3265	0	2405	2406	1
M	3269	3267	2	2407	2406	1
N	3264	3265	1	2406	2406	0

*Boles*  
20.05.24







CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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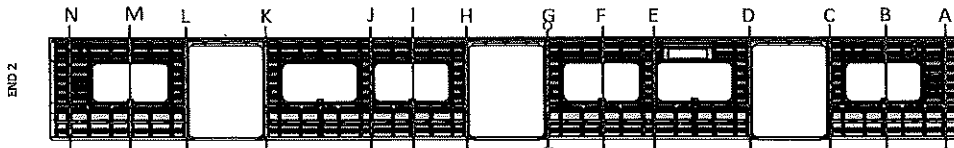
Date

07/11/2023

Project: PRASA

SI.CB2210.254.V30

## 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	3294	3294	0	2407	3206	1
B	3267	3268	2	2406	2405	1
C	3295	3298	0	2406	2406	0
D	3294	3294	0	2405	2406	1
E	3272	3272	0	2406	2406	0
F	3270	3271	1	2407	2406	1
G	3294	3294	0	2406	2406	0
H	3295	3294	1	2402	2408	0
I	3269	3268	1	2408	2406	2
J	3272	3272	0	2407	2406	1
K	3298	3278	0	2406	2406	0
L	3294	3294	0	2406	2408	1
M	3267	3269	2	2406	2406	0
N	3295	3295	0	2406	2407	1

GIBELQ

2024-05-20

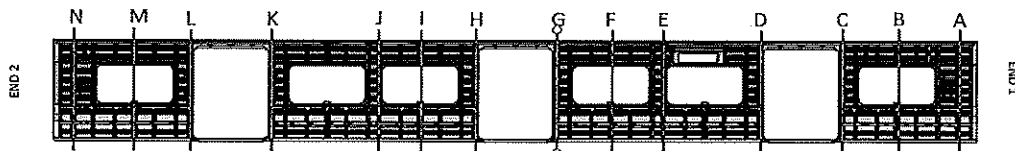
INDUSTRIAL QUALITY  
MAINLINE

20.05.24

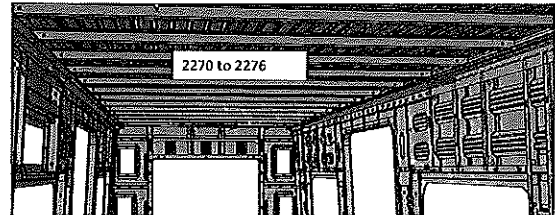
	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	

### CBS measurement

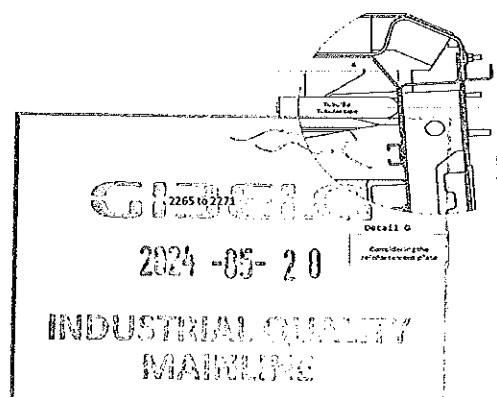
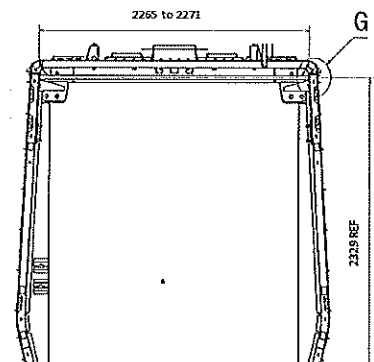
#### BEFORE WELDING




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



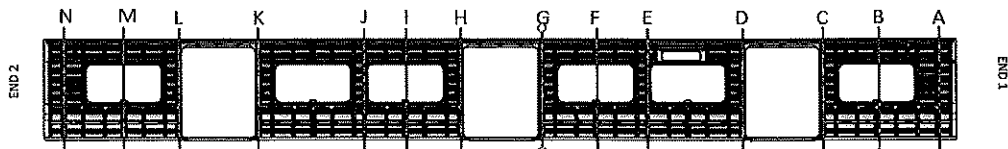
Do not consider reinforcement ( Take measurements top area of zee profile



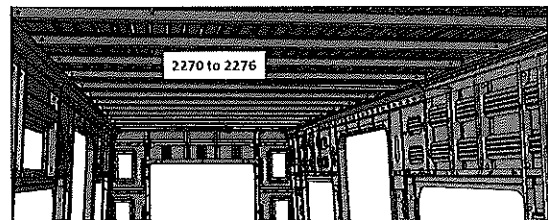
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	CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3	Rev. 28	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	
CBS measurement			

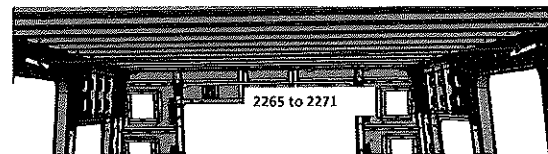
AFTER WELDING



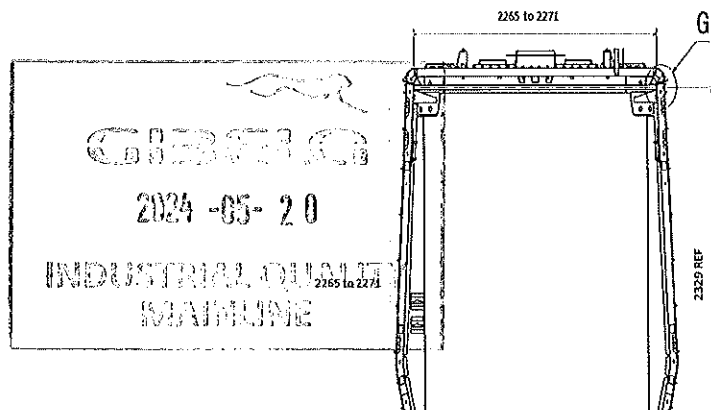
	2265 to 2271	2270 to 2276
A	2268	
B		2270
C	2267	
D	2268	
E		2274
F		2275
G	2266	
H	2268	
I		2274
J		2275
K	2267	
L	2268	
M		2273
N	2267	



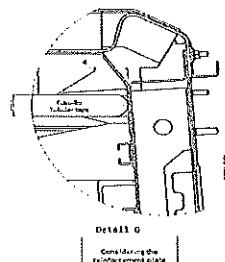
Do not consider reinforcement ( Take measurements top area of zee profile




Take measurement close to radius ( considering reinforcement)



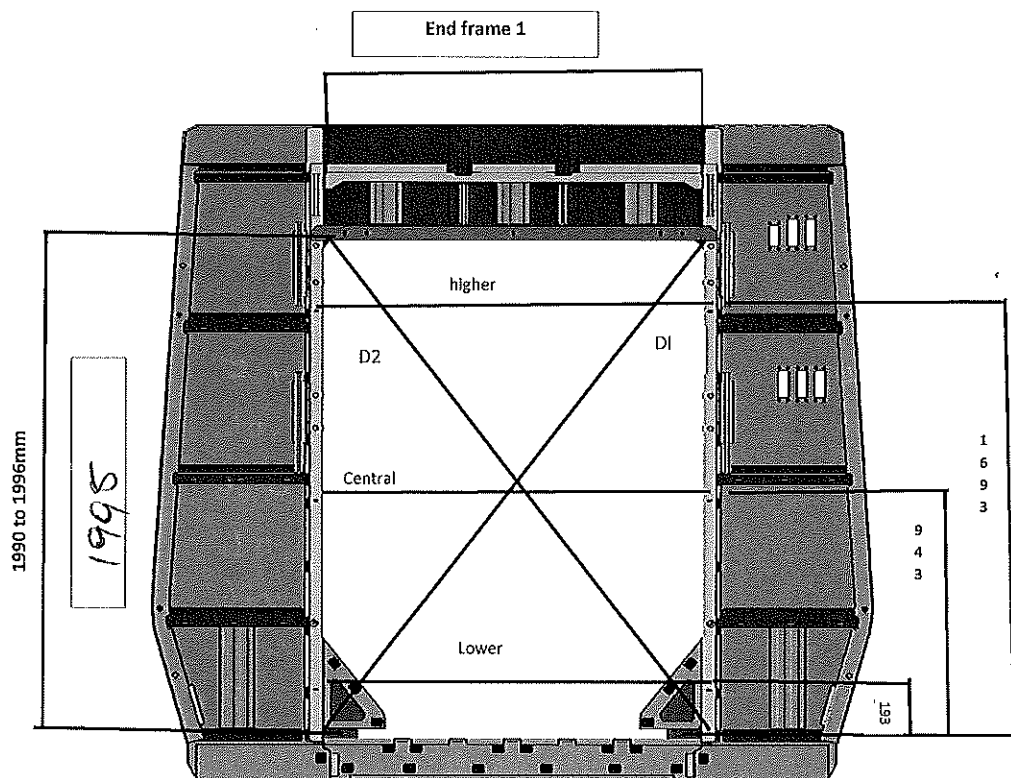
2265 to 2271



20.05.24

	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRA5A SI.CB2210.254.V30
		Date 07/11/2023	

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE  $D1-D2 \leq 3mm$

Higher Dimention

1381

D1

2415

Central Dimension

1381

D2

2417

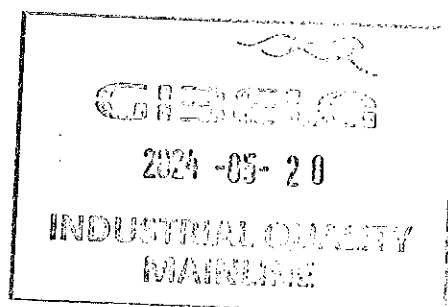
Lower Dimension

1380

D1-D2

2

20.05.24





CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

Rev.

28

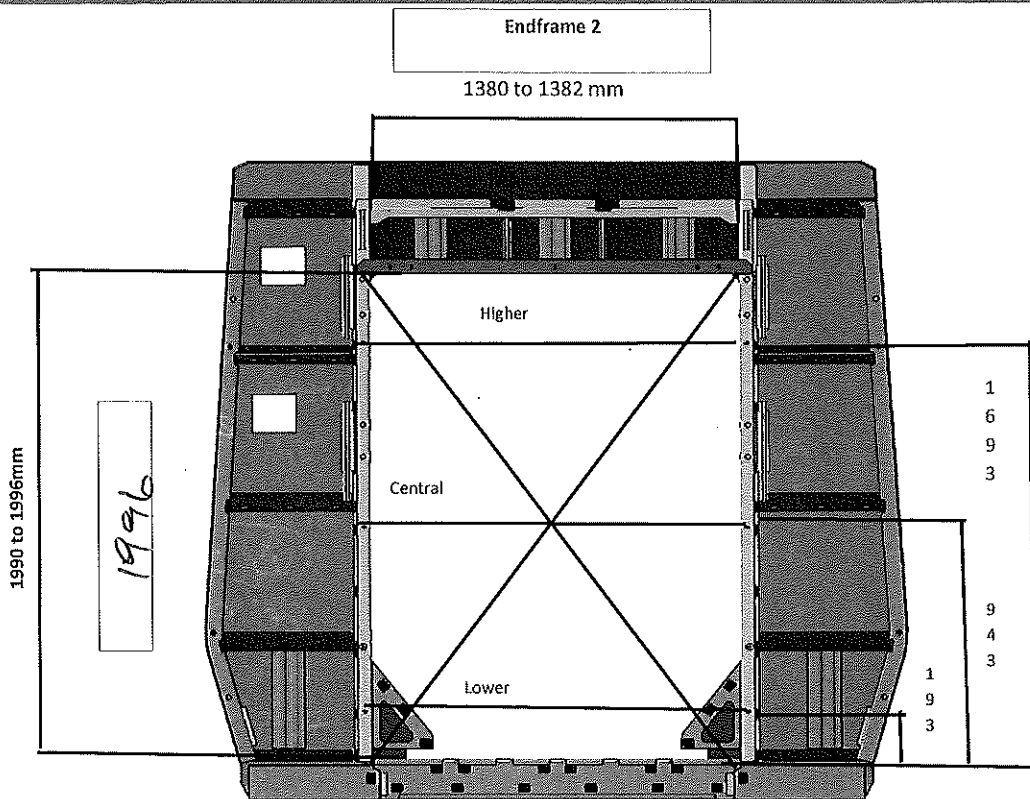
Project: PRASA

SI.CB2210.254.V30

Date

07/11/2023

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE  $D1-D2 \leq 3\text{mm}$

Higher Dimension

1380

D1

2417

Central Dimension

1381

D2

2406

Lower Dimension

1380

D1-D2

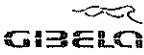
3

GIBELQ

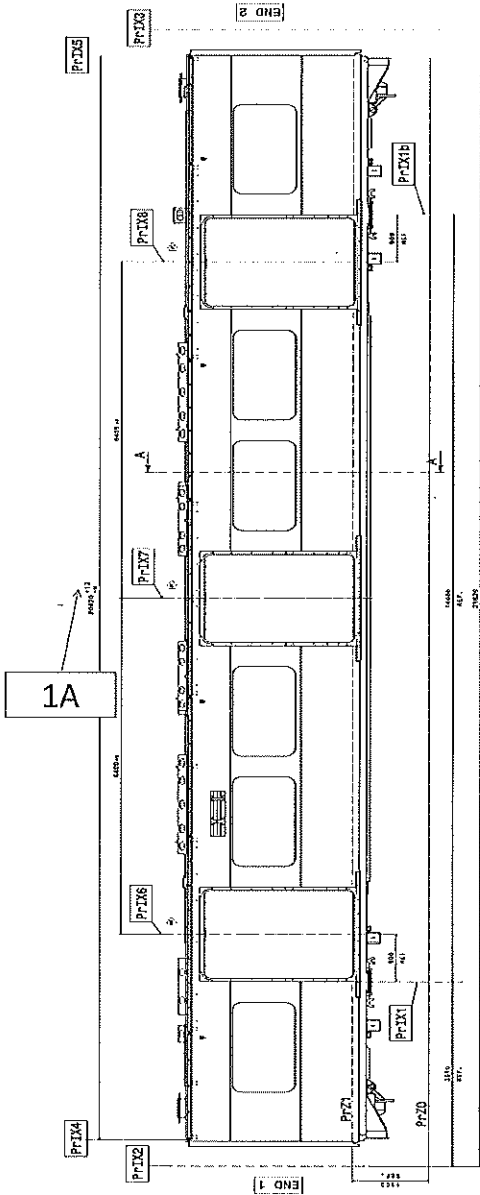
2024-05-20

INDUSTRIAL QUALITY  
WARRANTY

20.05.24

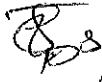
	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB2210.254.V30
		Date	
		07/11/2023	

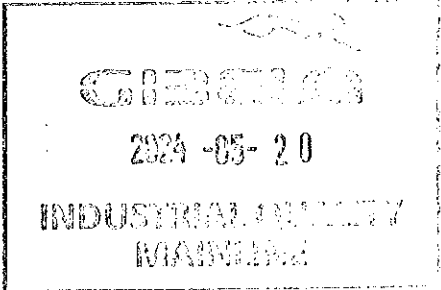
Specifications of Details for CBS measurement



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20680

RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20629


  
 20.05.24



Dye penetrant test

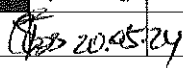
Dye-penetration test to be performed by quality personnel

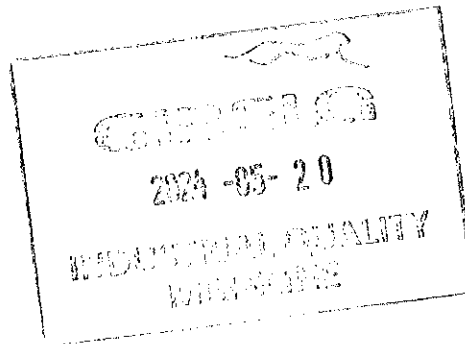



	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	

Item	Description of the Issue	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)


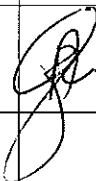
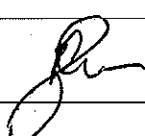
II.2 - Check List REX

Check List Items							
Item	Picture/Drawing	Description	Criteria /Record	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	I/A	To complete REX	Refer to REX. New defects must be added on the REX			 20.05.24	



	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB2210.254.V30
		Date 07/11/2023	

Self Inspection - Final Result

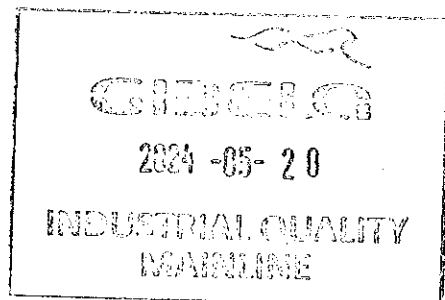
				DATE	NAME	SIGNATURE
HOLD POINT		GO	(If activities are not complete, the missing activities must not impact the next stage)	20.8.24	Tumelo Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	23/05/24	Ntokoero 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)	20/05/24	Ntokoero 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



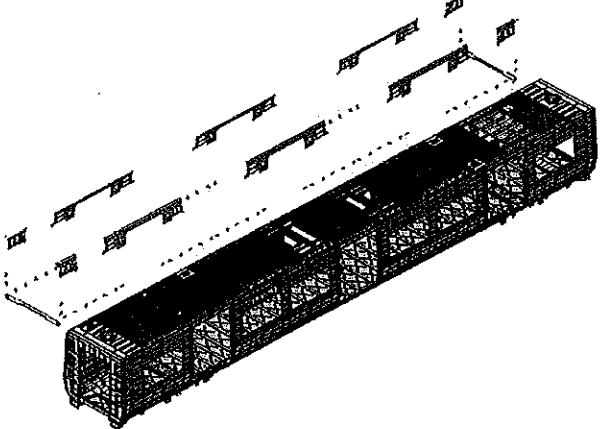
Operations

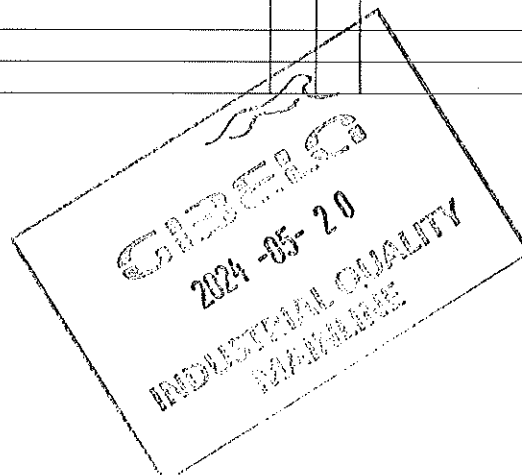
Quality

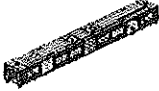
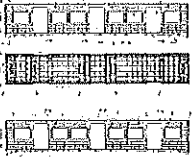




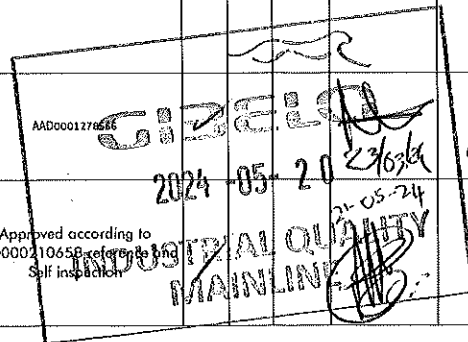



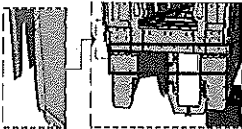
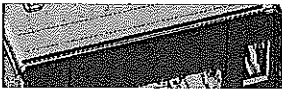
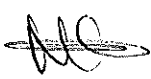
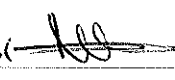


	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DTR30225487/2	Rev.	Project: PRASA																					
		29																						
		Date	SI.CB2220.250.V29																					
28/10/2023																								
Car: M1,M3&M4	NCR:	Work station:	CB2220																					
 Safety Related																								
																								
<b>I - Documentation and Instruments Control</b>																								
<b>I.1 - Documentation Control</b>																								
	<table border="1"> <tr> <th colspan="6">Type of car</th> </tr> <tr> <th>M1</th> <th>M3</th> <th>M4</th> <th>M5</th> <th>M6</th> <th>M7</th> </tr> <tr> <td></td> <td></td> <td>X</td> <td></td> <td></td> <td></td> </tr> </table>	Type of car						M1	M3	M4	M5	M6	M7			X				Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Type of car																								
M1	M3	M4	M5	M6	M7																			
		X																						
DTR30225487/2		2a	28/10/2023	X	N/A																			
					21-05-24																			
<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)																			
measuring tape	CHITHA0521	16/04/2025	X	21-05-24																				
Tubular	32823	15/03/2025	X	21-05-24																				
<b>I.3 Consumables</b>																								
Welding Consumable Control - Used for Special Process																								
Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)																			
308	373779	MIG	X	21-05-24																				




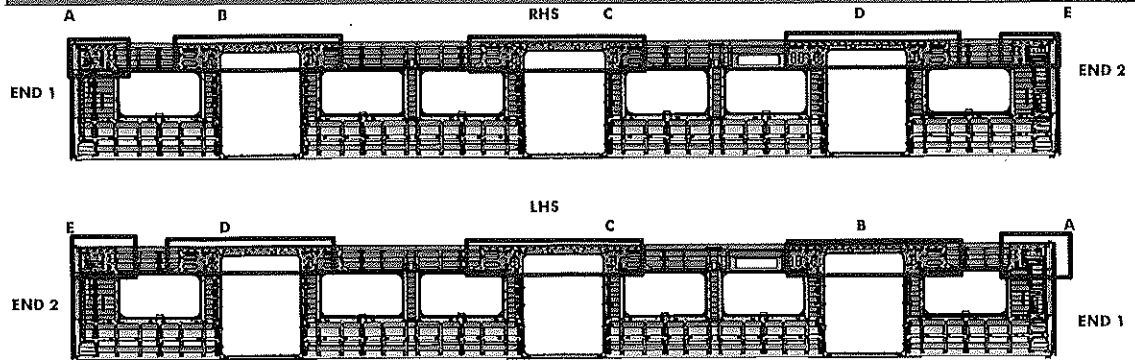
GIBELQ		CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29			
<b>II - Self Inspection - Items to Check</b>							
<b>II.1 - Items to check</b>							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)	
01	N/A	Assembly according to Instruction Engineering n° PRA CB2220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA CB2220.DTR30225487/2	✓	21-05-24	21/05/24	
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	21-05-24	21/05/24	
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	21-05-24	21/05/24	
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	21-05-24	21/05/24	
05		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓	21-05-24	21/05/24	
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.	✓	21-05-24	21/05/24	
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) Min Max 10°C - 35°C Relative humidity Min - Max (%) Min Max 25% - 60%	Sealant Batch No: 5287 Exp Date: 05/06/24 Actuals Temperature: 16 Humidity: 37	✓	21/05/24	21/05/24	
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001270686		21/05/24	21/05/24	
09		Verification of safety welds	Approved according to DTD000210658 and Self inspection		21-05-24	21/05/24	



	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA  SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	
II - Self Inspection - Items to Check			
SEALANT APPLICATION			
		AREA 1 & 2 END 1	
		Operator (Name & sign): Mtchkozi: 	
		Operator (Name & sign): Mtchkozi: 	




	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DTR30225487/2	Rev.	<b>Project: PRASA</b>  <b>SI.CB2220.250.V29</b>
		29	
		Date	
		28/10/2023	
<b>II - Self Inspection - Items to Check</b>			

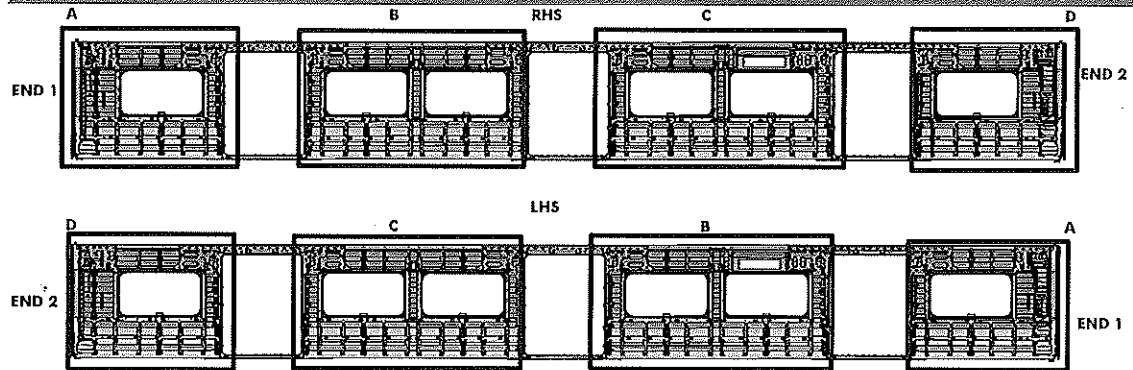


**REINFORCEMENT WELDING**

AREA	LHS	RHS
A	Operator (Name&sign): <u>THULANI</u>	<u>LINDO</u>
B	Operator (Name&sign): <u>THULANI</u>	<u>LINDO</u>
C	Operator (Name&sign): <u>Mkhize</u>	<u>Mkhize</u>
D	Operator (Name&sign): <u>Mkhize</u>	<u>Mkhize</u>
E	Operator (Name&sign): <u>Mkhize</u>	<u>Mkhize</u>

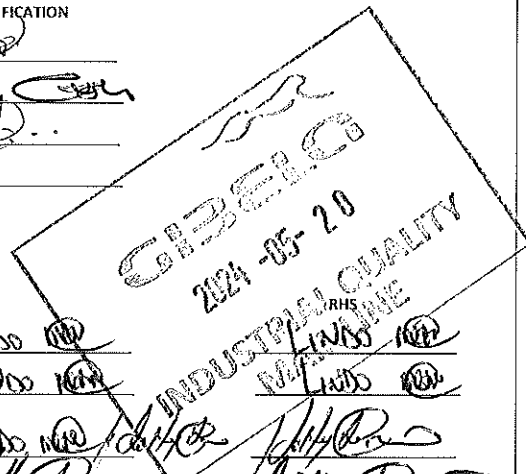



	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29	Project: PRASA SI.CB2220.250.V29
		Date 28/10/2023	
		II - Self Inspection - Items to Check	



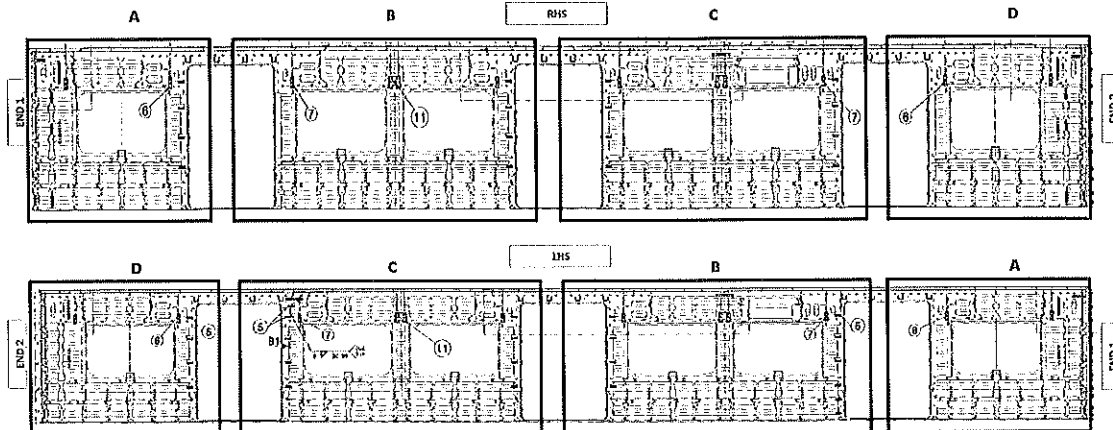
### BRACKETING

INSTALLATION	
C-RAILS:	Operator: <u>mkho</u>
	Operator: _____
DOOR MECHANISMS:	Operator: <u>Tekele</u>
	Operator: _____
TAPPING PADS	Operator: <u>Jonny</u>
	Operator: <u>Mkhize</u>
INSTALLATION & VERIFICATION	
SEAT & LUGGAGE BRACKETS:	Operator: <u>ASANDI</u>
	Operator: <u>Priscilla</u>
SEAT BRACKETS VERIFICATION:	Operator: <u>ASANDI</u>
	Operator: _____
WELDING	
AREA	LHS
A (Seat brackets)	: Operator (Name&sign): <u>LINDO</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>LINDO</u>
B (Seat brackets)	: Operator (Name&sign): <u>LINDO</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Tekele</u>
C (Seat brackets)	: Operator (Name&sign): <u>Mmasuwa</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Tekele</u>
D (Seat brackets)	Operator (Name&sign): <u>Mmasuwa</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Mmasuwa</u>
ENDS	
END 1 TAPPING PADS WELDING:	Operator (Name&sign): <u>Tekele</u>
END 2 TAPPING PADS WELDING:	Operator (Name&sign): <u>Mkhize</u>



	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DTR30226487/2	Rev.	<b>Project: PRASA</b>  <b>SI.CB2220.250.V29</b>
		29	
		Date	
		28/10/2023	
<b>II - Self Inspection - Items to Check</b>			

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

RHS				
	SECTION	QUANTITY	OK	NGK
C-RAILS	A	7		
	B	4		
	C	8		
	D	6		
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: *ASA-DA* *[Signature]*

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	8		
	C	11		
	D	6		
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: *ASA-DA* *[Signature]*

QUANTITIES (M1)

RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7		
	B	8		
	C	8		
	D	6		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	2		
	B	4		
	C	5		
	D	3		

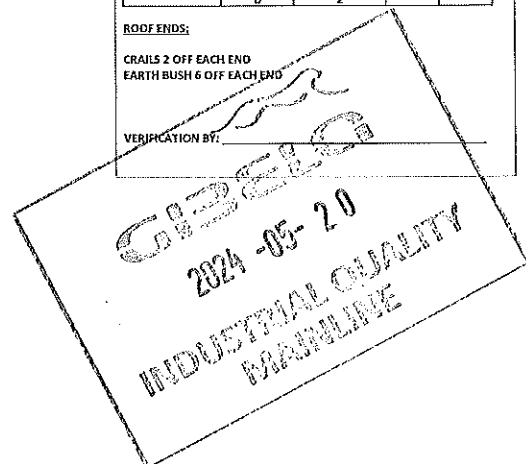
ROOF ENDS:  
 CRAILS 2 OFF EACH END  
 EARTH BUSH 6 OFF EACH END

VERIFICATION BY: \_\_\_\_\_

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	10		
	C	11		
	D	6		
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: *[Signature]*



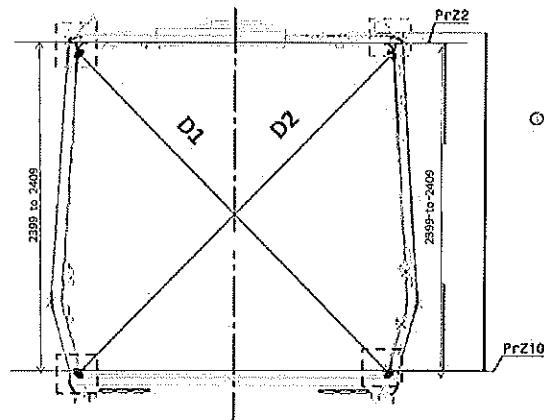


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2

Rev.  
29  
Date  
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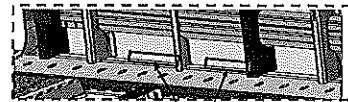
Specifications of Details for CBS measurement



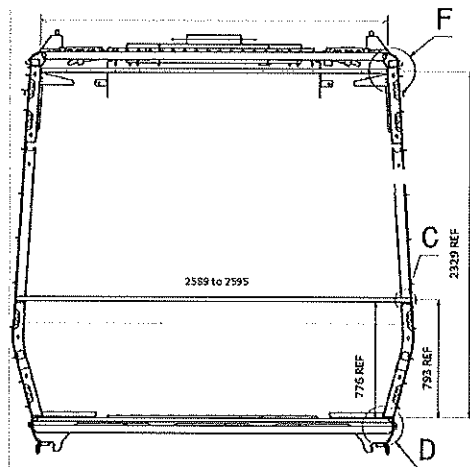
Measurement positions on roof rail and sidewall omega corner.




Reinforcement area measurement positions on roof reinforcement area.

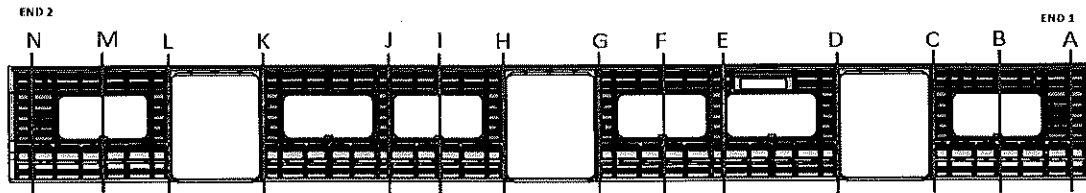


Measurement positions on sidewall and side sill corner.





	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	
CBS measurement			



BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3295	3295	0	—
B	3265	3265	0	—
C	3298	3295	3	—
D	3290	3294	4	—
E	3265	3263	2	—
F	3268	3263	5	—
G	3296	3294	2	—
H	3294	3293	1	—
I	3260	3268	8	—
J	3270	3270	0	—
K	3293	3297	4	—
L	3294	3294	0	—
M	3264	3264	0	—
N	3293	3292	1	—

2 -05-24



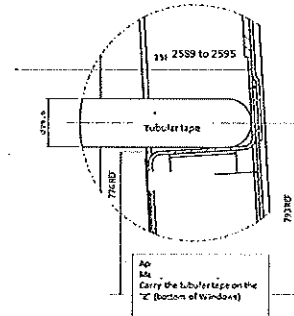
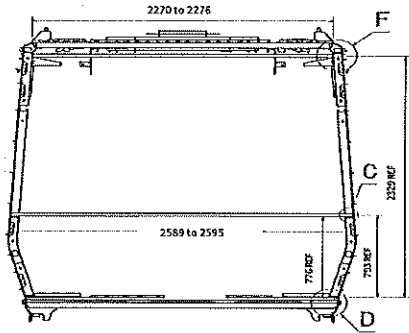


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30226487/2

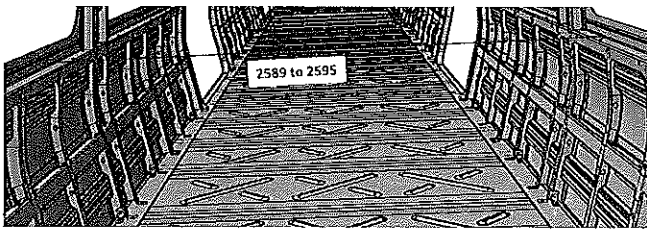
Rev.  
29  
Date  
28/10/2023

Project: PRASA  
SI.CB2220.250.V29

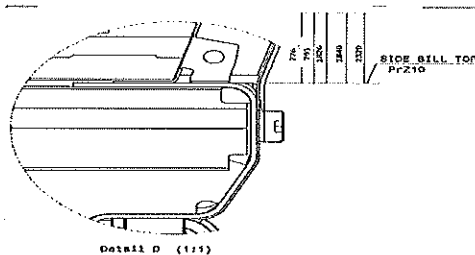
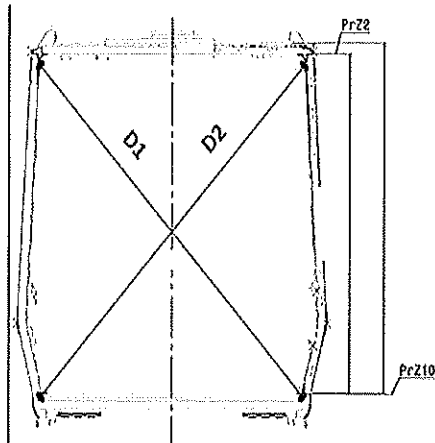
### CBS measurement



Detail C


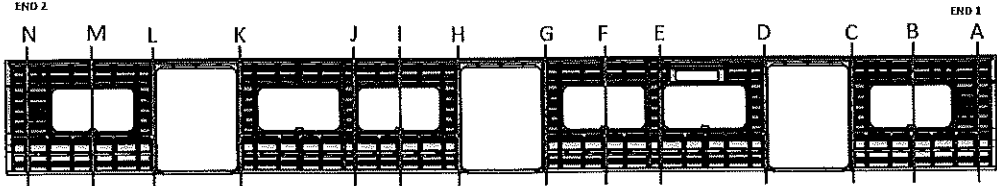


Take measurement close to  
radius



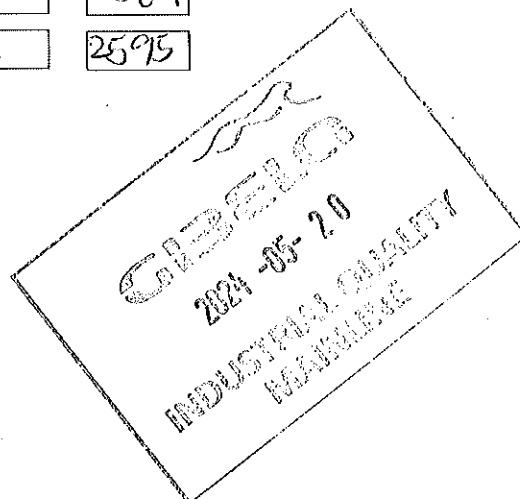
Detail D (1:1)




	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA  SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	
CBS measurement			
			

**AFTER WELDING**

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3293	3297	4	2595
B	3267	3266	1	2589
C	3293	3299	6	2589
D	3299	3299	0	2593
E	3266	3268	2	2593
F	3266	3265	1	2589
G	3295	3293	2	2590
H	3294	3299	5	2593
I	3264	3266	2	2593
J	3269	3268	1	2592
K	3297	3294	3	2592
L	3300	3290	10	2589 *
M	3266	3264	2	2589
N	3293	3291	2	2595



  
21-05-24

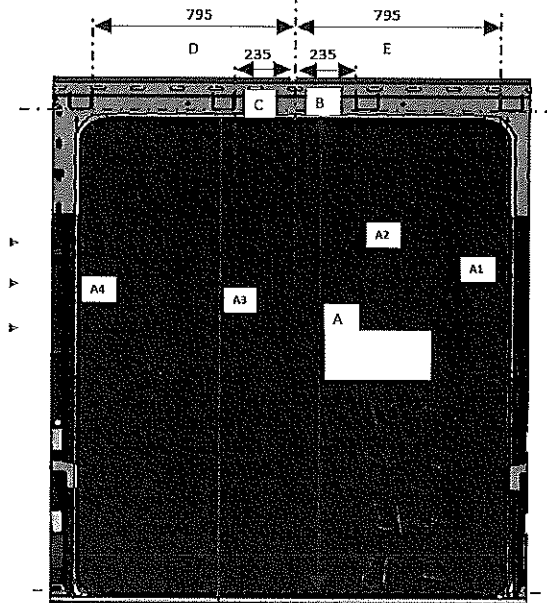


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30226487/2

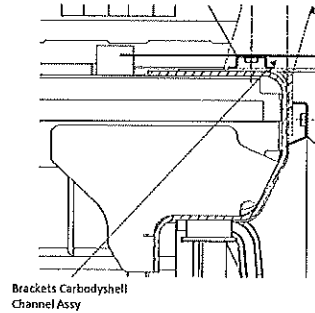
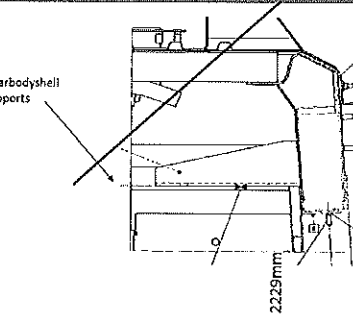
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29  
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28/10/2023

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SI.CB2220.250.V29

Specifications of Details for CBS measurement CB1220



Brackets Carbodyshell  
U Type Supports



DOOR 1 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2232
A3	2230 to 2232	2231
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 - LHS

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

DOOR 2 - RHS

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

DOOR 1 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2232
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 2 - RHS

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

DOOR 3 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2232
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

21-05-24

GIBEL  
2024-05-20  
INDUSTRIAL QUALITY  
MAINLINE



CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2

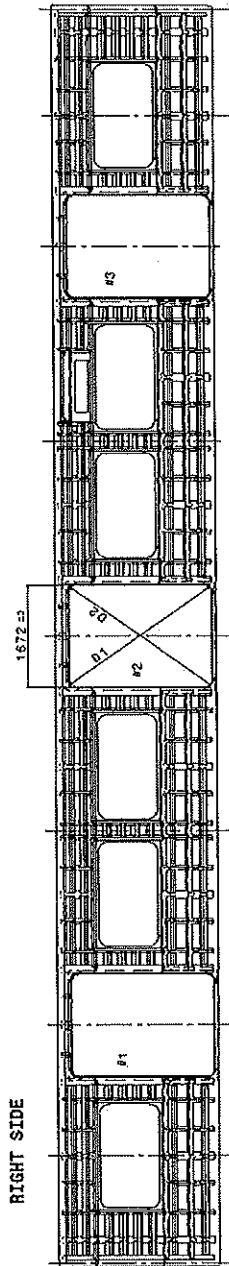
Rev.  
29  
Date  
28/10/2023

Project: PRASA

SI.CB2220.250.V29

Specifications of Details for CBS measurement CB1220

End #2



RIGHT SIDE

End #1

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

	#1	#2	#3
D1	2748	2746	2747
D2	2747	2744	2745
D1-D2	1	2	2

HIGHER DIMENSION

CENTRAL DIMENSION

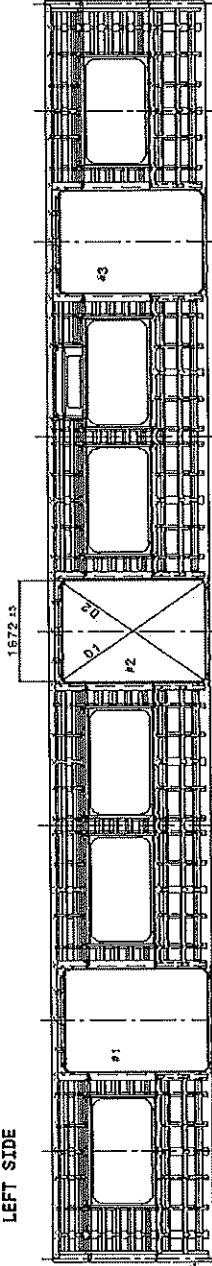
LOWER DIMENSION

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

	#1	#2	#3
HIGHER DIMENSION	1674	1673	1673
CENTRAL DIMENSION	1673	1672	1672
LOWER DIMENSION	1671	1672	1671

LEFT SIDE

End #1



End #2

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

	#1	#2	#3
D1	2747	2746	2745
D2	2746	2745	2747
D1-D2	1	1	2

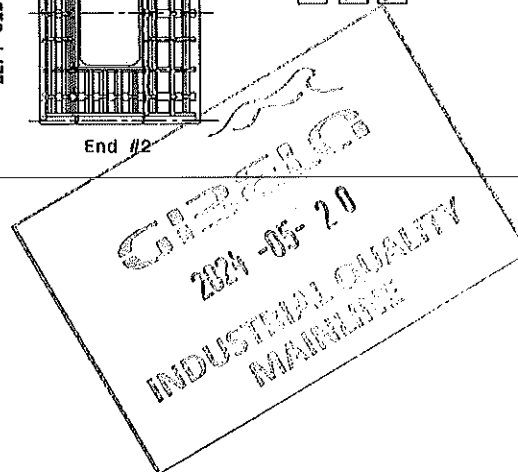
HIGHER DIMENSION

CENTRAL DIMENSION

LOWER DIMENSION



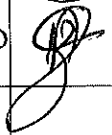
Doors length - 1672  $\pm 3\text{mm}$

	#1	#2	#3
HIGHER DIMENSION	1674	1673	1673
CENTRAL DIMENSION	1673	1672	1672
LOWER DIMENSION	1671	1672	1671



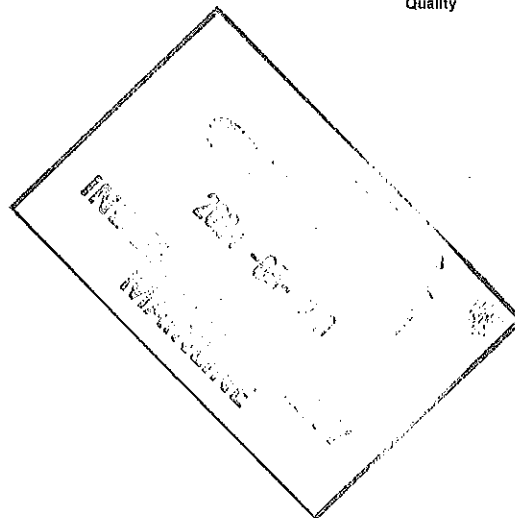
24-05-20




	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225407/2		Rev.	Project: PRA5A  SI.CB2220.250.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)	21-05-24	A. SANDA Operations		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party	21/05/24	N. O. Koro Industrial Quality		
		There are activities pending 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

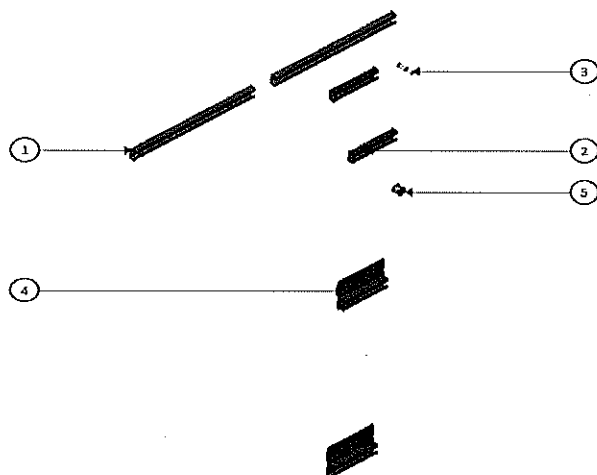


	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	

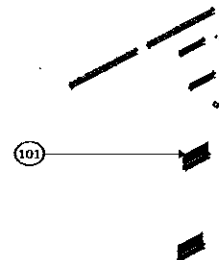
### ANNEXURE A: Arc Welding Quality Acceptance Standard



Station: CB1220-004- U108 & U107



PART NO.	ITEM NO.	QTY	DESCRIPTION	AMSS (60)
DTR0000074263	5	6	EARTH STUD 6	0.035
AAC0003201613	4	6	ASSEMBLY SUPPORT	0.271
DTF0000948305	3	12	WELDING STUD ISO13918 PT--A/SD20--SS1	0.007
AAC0003180424	2	12	ASSEMBLY SUPPORT	0.191
AAC0003184418	1	14	ASSEMBLY SUPPORT	0.522
AAC0003161080	101	6	CARBODYSHELL BRACKETS CARBODYSHELL M1/M3/M4 CAR(SIDE FRAME MODULE END--099)	12.132





GIBELA

PRASA PROJECT

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

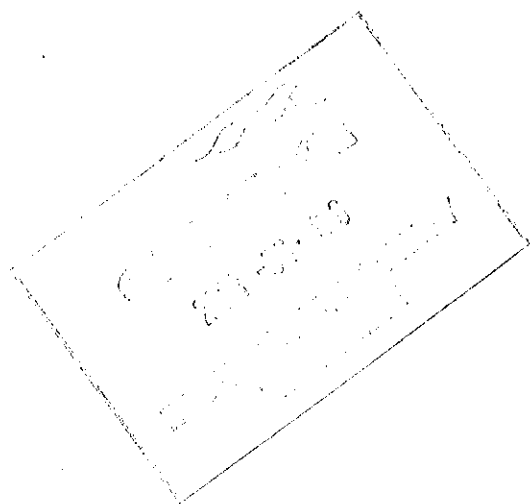
## SELF INSPECTION SHEET

## 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.

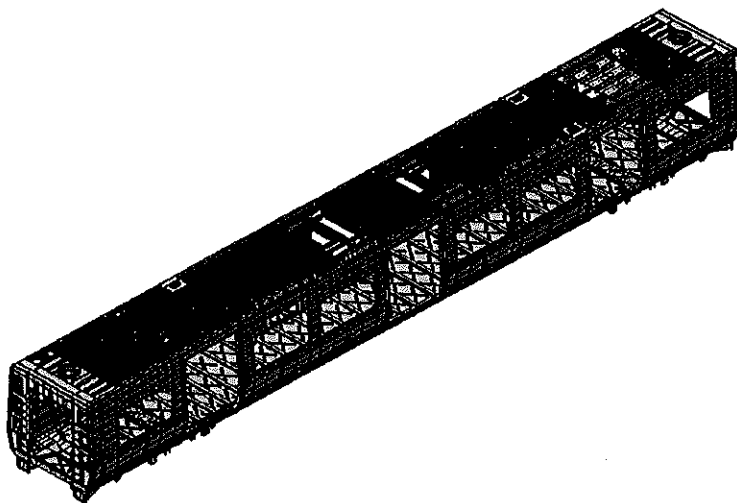
## APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY 1	
				TC1	M4	M1	M2	M3	TC2			
<input type="checkbox"/>	DT00000225487	AAD0001276566	CARBODYSHELL M1,M3,M4 ASSEMBLY	CB2230		X	X		X		PRA.CB2230.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								
15	06/08/2020	New Baseline 10.2.6	APPROVER Timothy Mainela	06/08/2020								
			CHECKER Bongane Masina									
			REVISED BY Bongane Masina									
20	19/04/2021	New Baseline change 10.3	APPROVER Timothy Mainela	19/04/2021								
			CHECKER Bongane Masina									
			REVISED BY Bongane Masina									
25	20/02/2022	New Baseline change 10.3.1	APPROVER Collins Mbombhni	20/02/2022								
			CHECKER Andani Muthelo									
			REVISED BY Andani Muthelo									
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER Collins Mbombhni	14/06/2022								
			CHECKER Andani Muthelo									
			REVISED BY Andani Muthelo									
27	26/07/2022	Threshold measurements addition	APPROVER Collins Mbombhni	26/07/2022								
			CHECKER Andani Muthelo									
			REVISED BY Andani Muthelo									
28	17/10/2022	Added traceability of sealant application	APPROVER Collins Mbombhni	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 threshold traceability for boiler makers and welders	APPROVER Ngobeni Tyson	06/11/2023								
			CHECKER Andani Muthelo									
			REVISED BY Ntokozo Zwane									
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES							
22-8	M3	KHOSI 417401	20.05.24	SI.CB2230.256.V29	12							





	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DT00000225487	Rev. 30	<b>Project: PRASA</b>  <b>SI.CB2230.256.V29</b>
		Date 06/11/2023	
Cart:	NCR:	Work station: CB2230	



### I - Documentation and Instruments Control

#### I.1 - Documentation Control

Document	Type of car					Revision	Observation	OK	NOK	Rework	Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4	TC2							
PRA.CB2230.DT00000225487			X			V30		OK		N/A	<i>[Signature]</i>	<i>[Signature]</i>

#### 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)
MEASURING TAPE	C180194	25/04/25	OK		<i>[Signature]</i>	<i>[Signature]</i>
TUBULAR	22713	26/06/25	OK		<i>[Signature]</i>	<i>[Signature]</i>
COMBINATION SQUARE	4180072	27/07/24	OK		<i>[Signature]</i>	<i>[Signature]</i>

#### 1.3 Consumables

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

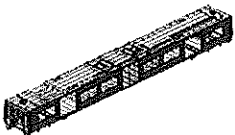
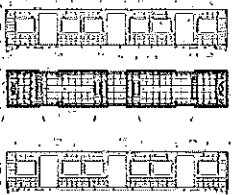
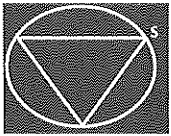
Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
AUTROD 306LS1	E001880	MIG	OK		<i>[Signature]</i>	<i>[Signature]</i>



	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DT00000225487	Rev. 30	<b>Project: PRASA</b>  <b>SI.CB2230.256.V29</b>
		Date	
		06/11/2023	

## II - Self Inspection - Items to Check

### II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOX	REWORK	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	<i>a</i>			<i>[Signature]</i> 02/05/24	<i>[Signature]</i> 29/03/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	<i>a</i>			<i>[Signature]</i> 02/05/24	<i>[Signature]</i> 29/03/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	<i>a</i>			<i>[Signature]</i> 02/05/24	<i>[Signature]</i> 29/03/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	<i>a</i>			<i>[Signature]</i> 02/05/24	<i>[Signature]</i> 29/03/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	<i>a</i>			<i>[Signature]</i> 02/05/24	<i>[Signature]</i> 29/03/24
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.	<i>a</i>			<i>[Signature]</i> 02/05/24	<i>[Signature]</i> 29/03/24
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) Min-Max 10°C - 35°C Relative humidity Min - Max (%) Min-Max 25% - 60%	Sealant Batch No: <u>SL70-03</u> Exp Date: <u>12/12/24</u> Actuals Temperature: <u>20,6°C</u> Humidity: <u>48%</u>	<i>a</i>			<i>[Signature]</i> 02/05/24	<i>[Signature]</i> 29/03/24
08	N/A	Verification of sealant application on the roof and sidewall finishers.	Sealant must be: - Applied straight and even - Free of gaps, cracks, damage and debris (flashes, dirt, dust)  Refer to Annexure B	<i>a</i>			<i>[Signature]</i> 02/05/24	<i>[Signature]</i> 29/03/24
09	N/A	Verification of sealant application in certain regions in the drawing.	AAD0001278566	<i>a</i>			<i>[Signature]</i> 02/05/24	<i>[Signature]</i> 29/03/24





CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.  
30

Date

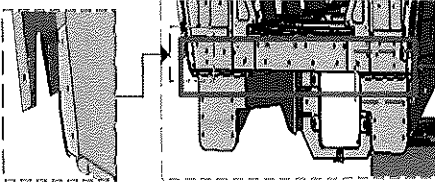
06/11/2023

Project: PRASA

SI.CB2230.256.V29

## II - Self Inspection - Items to Check

AREA 1



### END 2 SEALANT

OPERATOR  
(Name & sign):

LEROY

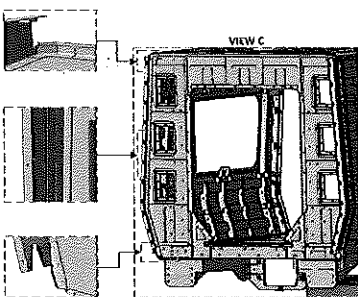
OPERATOR  
(Name & sign):

LEROY

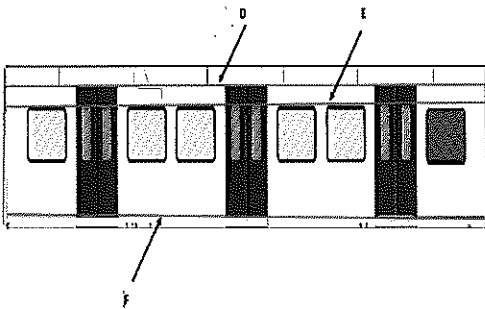
OPERATOR  
(Name & sign):

LEROY

AREA 2 (VIEW C)



H



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

Operator (Name & sign):

LHS

DEG(HI)

Boile

Buhle

F(HI)

Shenolo

Shenolo

Shenolo

Shenolo

Shenolo

Shenolo

Shenolo

Shenolo

Shenolo

Shenolo

Shenolo

Shenolo

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Shenolo

Shenolo

Shenolo

RHS

D,E,F,G,H,I

Shenolo

Shenolo

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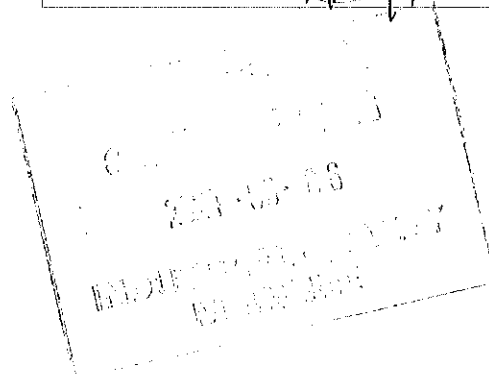
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CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.

30

Date

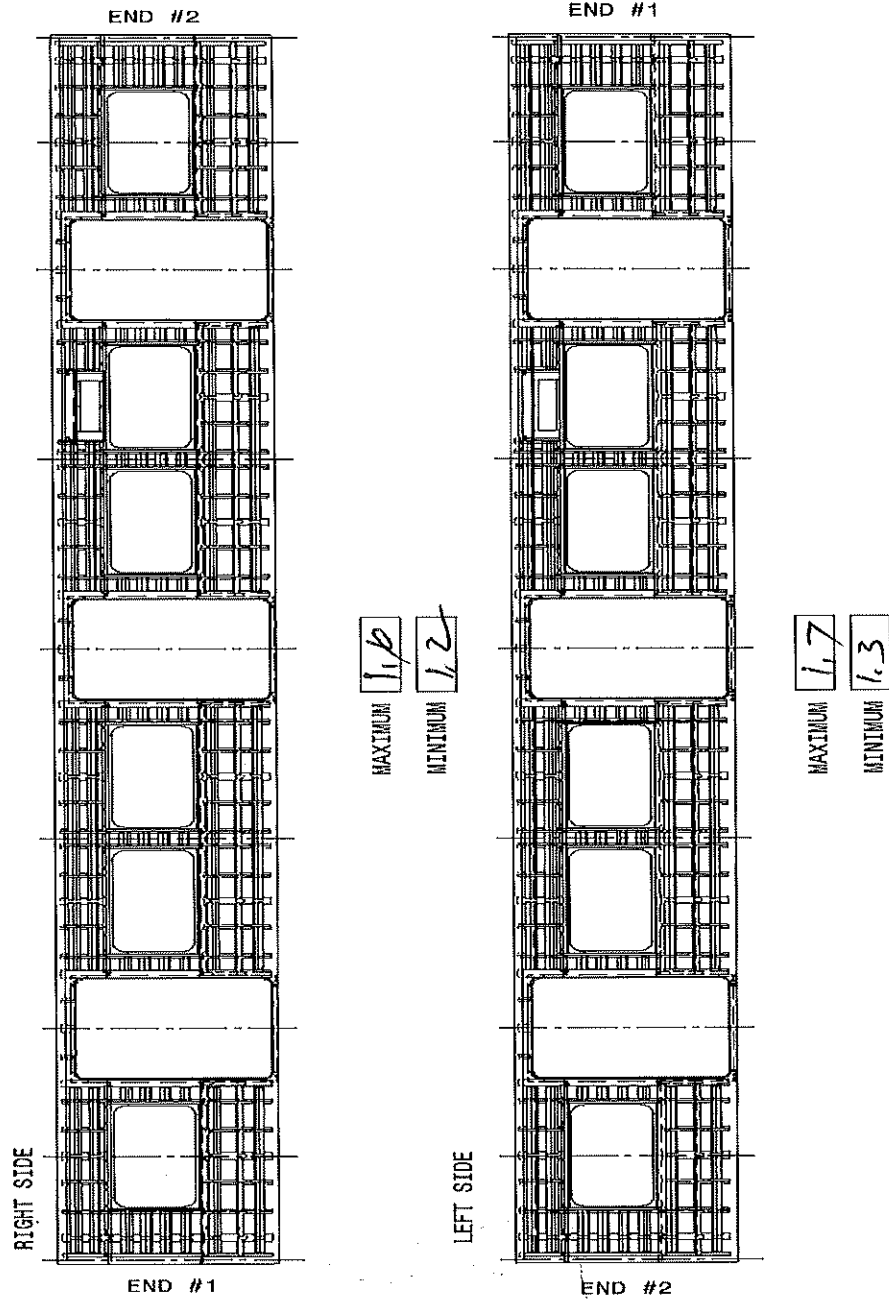
06/11/2023

Project: PRASA

SI.CB2230.256.V29

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.

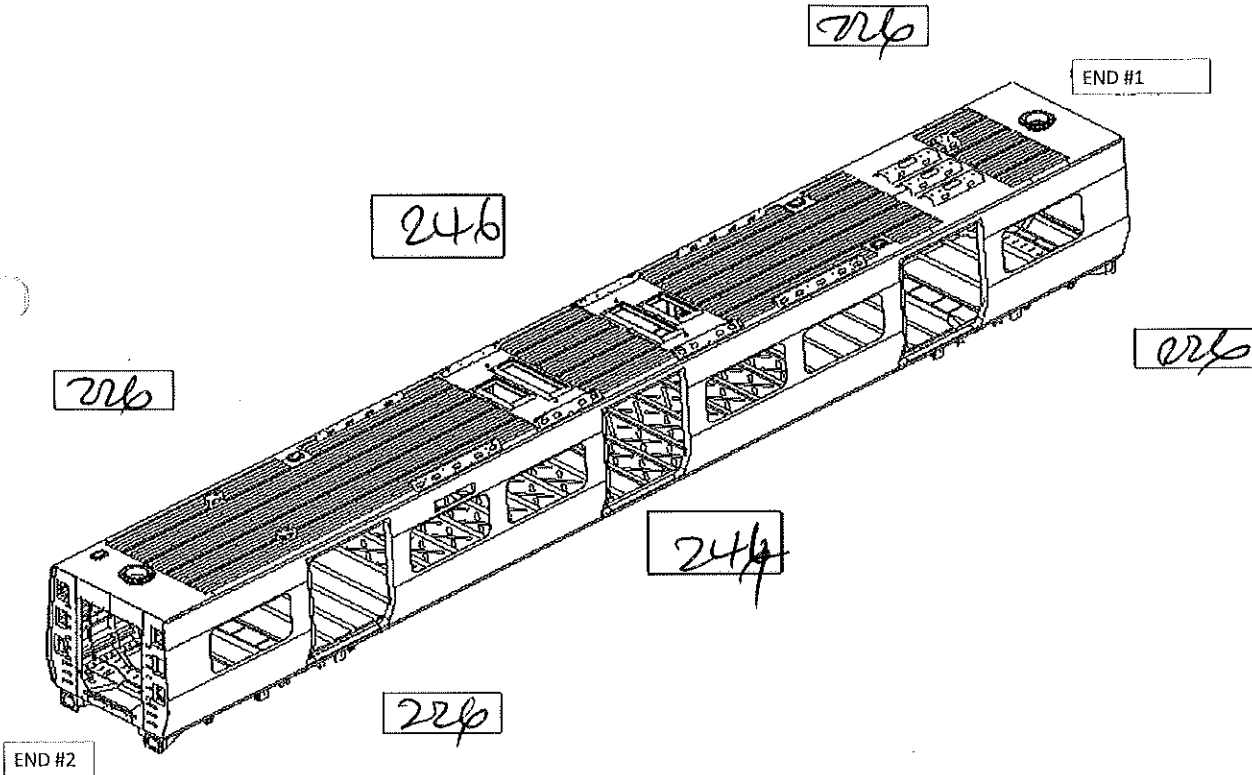


80-03-13  
INDUSTRIAL  
FURNITURE



Specifications of Details for CBS measurement CB1230

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



MEASURED CAMBER VALUES

RIGHT 1 18  
LEFT 'a1 20

Handwritten notes and stamps at the bottom of the page, including a date stamp '06/11/2023' and a signature.





CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

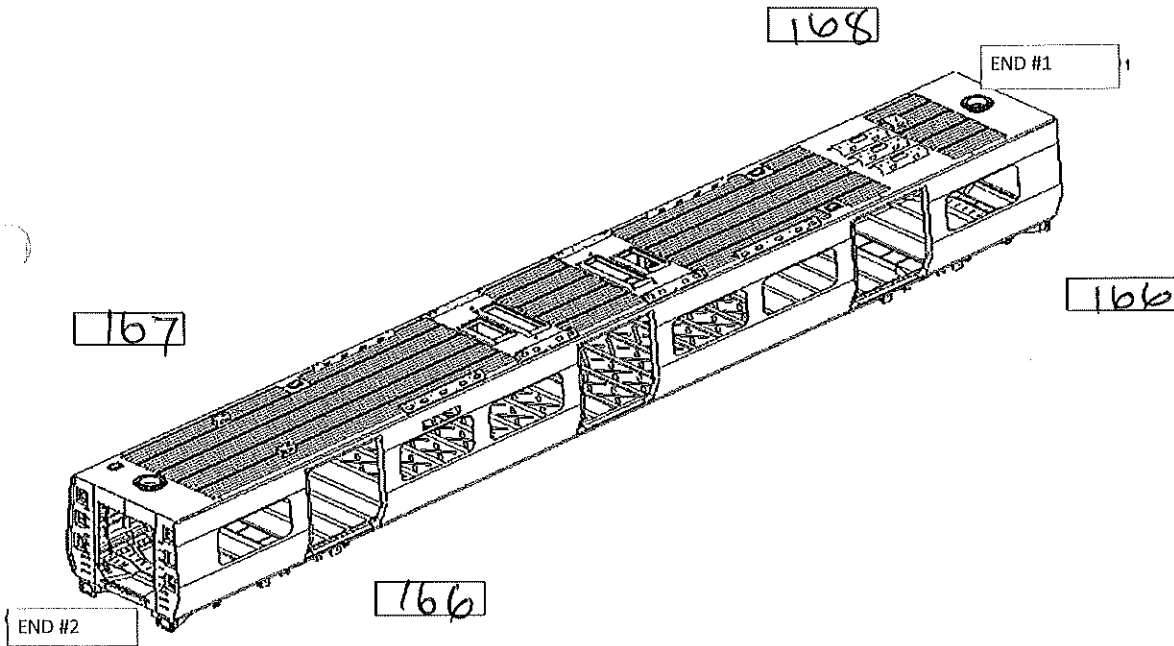
Rev.  
30  
Date  
06/11/2023

Project: PRASA

SI.CB2230.256.V29

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

1

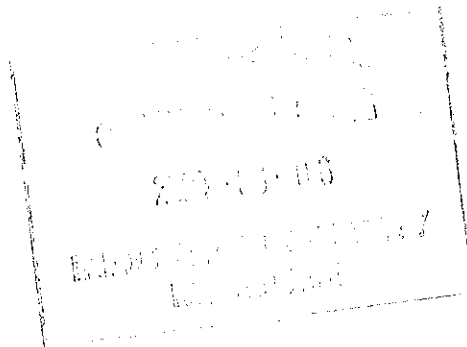
TWIST FOUND ON END 2

TRANVERSE

2

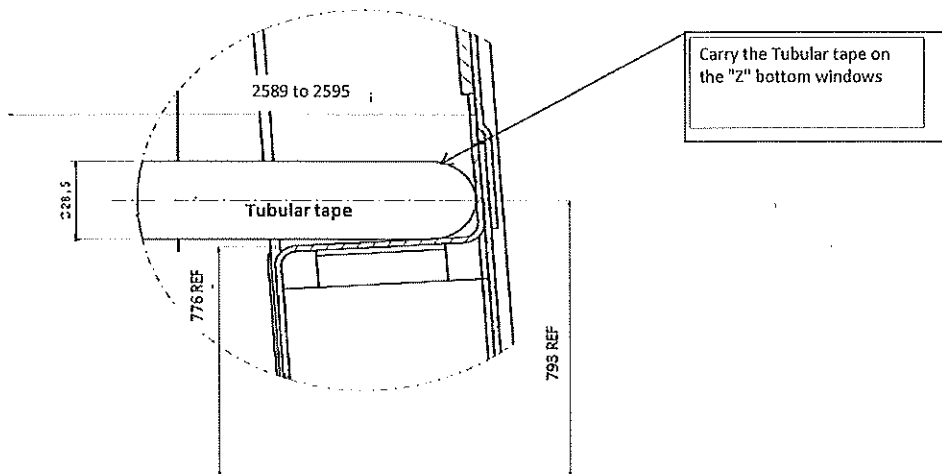
LONGITUDINAL

0

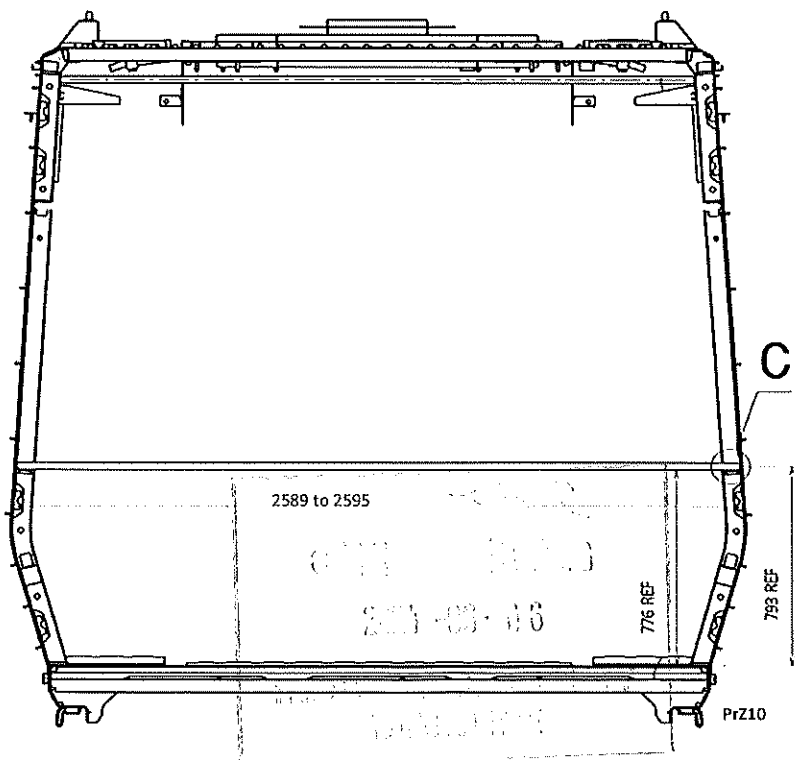




Specifications of Details for CBS measurement CB1230



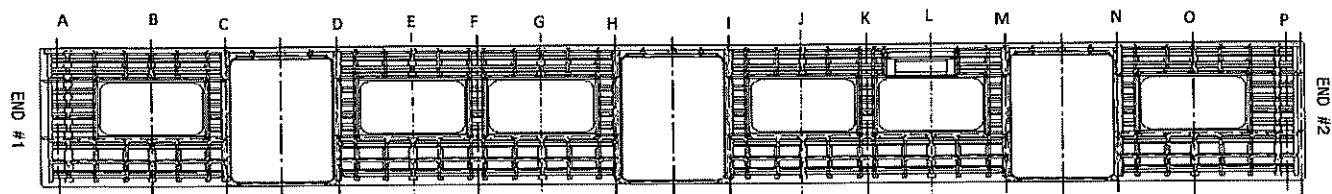
Detail C







Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	25 00
B	25 89
C	25 90
D	25 92
E	25 92
F	25 94
G	25 81
H	25 90
I	25 93
J	25 93
K	25 92
L	25 90
M	25 92
N	25 89
O	25 90
P	25 95



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: MMA TIAPELO Mda.  
WELDER: ZANGLER

Dye penetrant test


Dye-penetration test to be performed by quality personnel




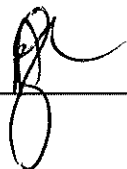






	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DT00000225487	Rev. 30	<b>Project: PRASA</b>  <b>SI.CB2230.256.V29</b>
		Date	
		06/11/2023	

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!)	20.05.24	EMOST	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	20/05/24	Nikola	
	NO GO	There are activities pending 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

