

CABIN STRUCTURE
QUALITY CARD

CAB No.: CAB₄₆₄

WEIGHT: 1489 Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	08/02/2024	178247 104825 01	LP499102	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	14/02/24	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	08/02/2024	178488 104640 01	P300091	
RCS 355	20 mm					

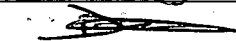
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegasus	12/02/2024			
RCS 355	30 mm					

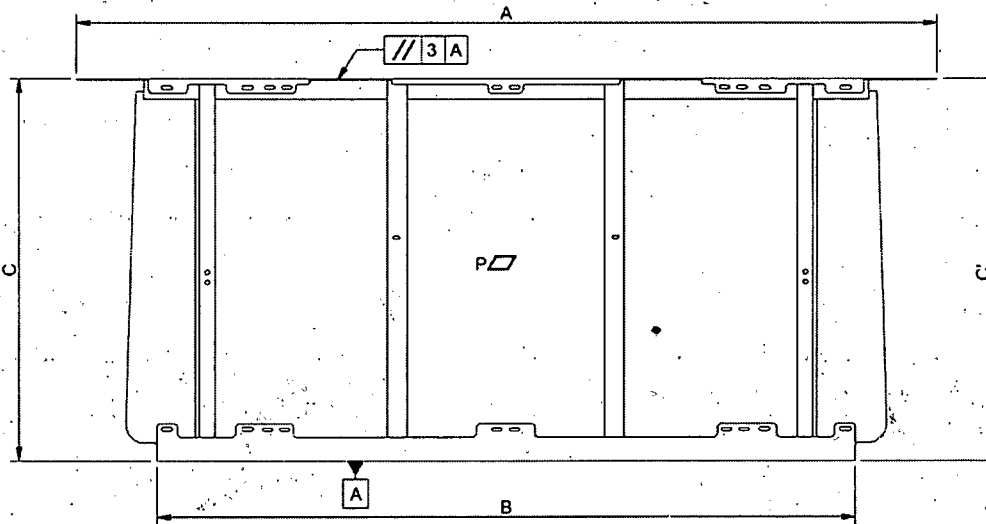
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	08/02/2024	178489 104640 01	VHC35578	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

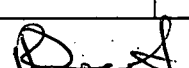
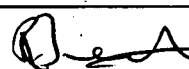
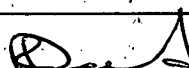
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	14/02/2024	178515 104640 01	F207905 VHC28402	
RCS 450	6 mm					
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	22/11/23	175564 102206 01	F209106 VHS58432	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

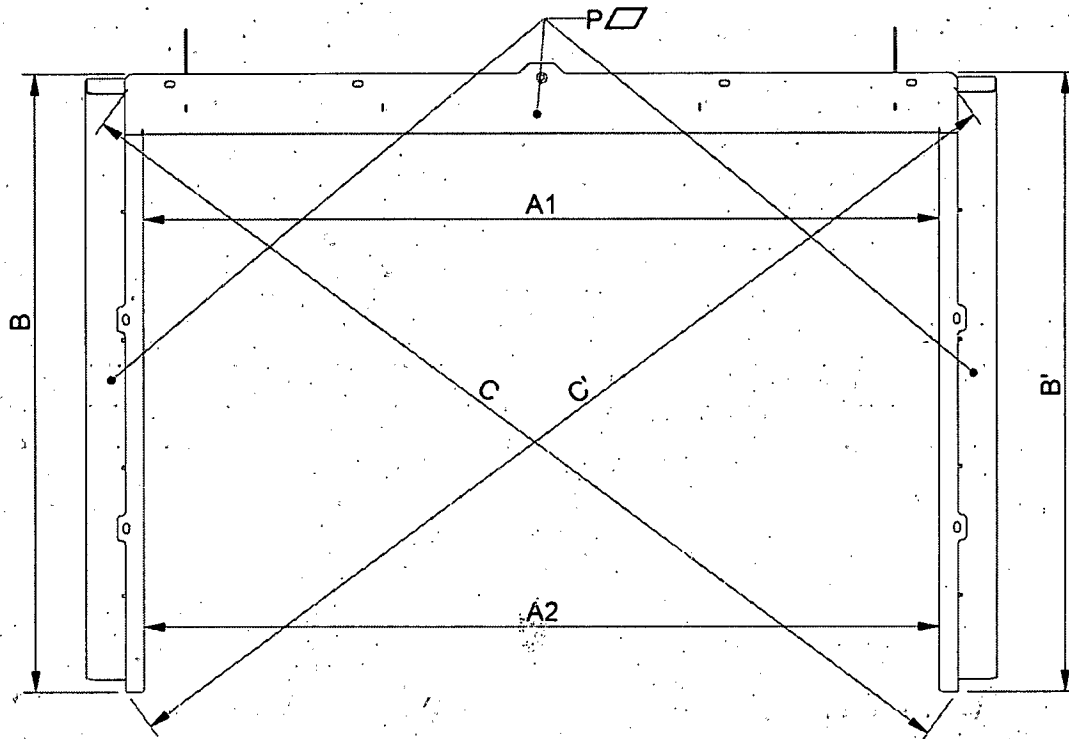
Cabin Roof Assembly: GN002839

Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	DYLAN DAVIDS	Assembly Date:	2024/04/04	
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:	2024/04/04	
Dimensional Control						
Rep	Toler.	Dimension measured		Measuring Equipment	Observations	
A	2216	+5/-0	2216	Tape Measure	acceptable	
B	1800	± 4	1801		acceptable	
C	976	+2/-3	976		acceptable	
QC Inspector:	Riccardo	Sign:		Date:	2024/04/04	
Geometrical Control						
Nature of Checks		Dimension Measured		Measuring Equipment	Observations	
Planarity P	6 mm	PASSED		Ruler	acceptable	
//	3	PASSED		Set Square	acceptable	
QC Inspector:	Riccardo	Sign:		Date:	2024/04/04	

Cabin Front Frame Assembly: GN002840				
Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	Raimondo G. Cuman.	Assembly Date:	2024/04/09	
Sign:		Wire Batch No.:	9582033	




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:	2024/04/09
Dimensional Control					
Rep	Theoretical Dim	Toler.	Dimension Measured		Observations
A1	1910	± 2	1912		Tape Measure acceptable acceptable acceptable
A2	1910		1911		
B	1475	± 1	1475	1474	
C	Diagonals C - C' ≤ 3		2476	2475	
QC Inspector:	Riccardo	Sign:		Date:	2024/04/09
Geometrical Control					
Nature of checks		Dimension Measured		Measuring Equipment	Observations
P : Planeity		4 mm	Passed		Ruler
QC Inspector:	Riccardo	Sign:		Date:	2024/04/09


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	
Operator:	Xander	Assembly Date:	2024/04/03			
Sign:		Wire Batch No.:	552033			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

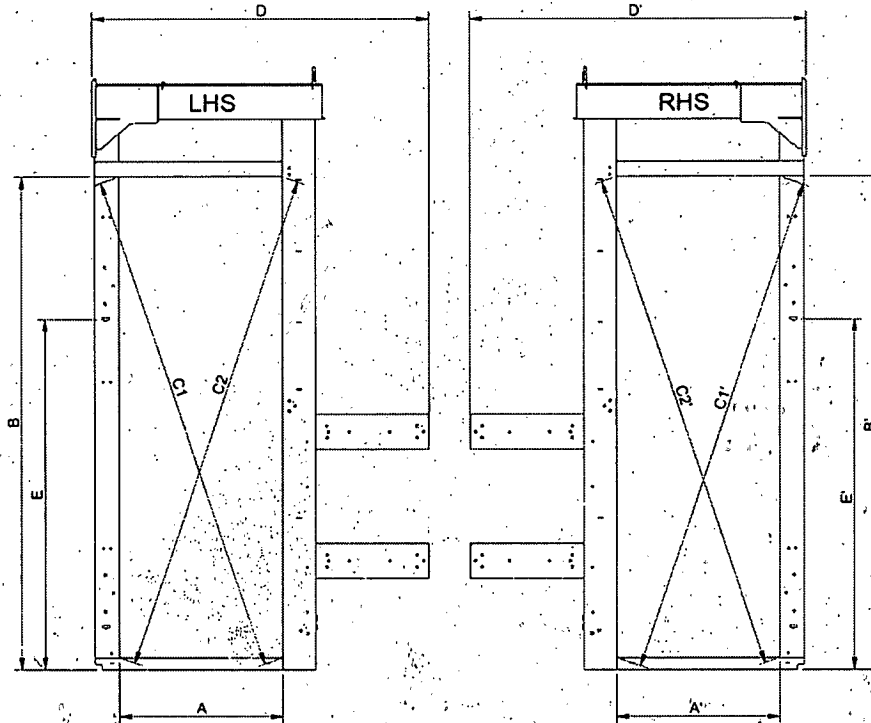
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	2024/03/28			
Sign:		Wire Batch No.:	552033			

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	2024/03/27			
Sign:		Wire Batch No.:	552033			

Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	Glenn	Assembly Date:	2024/03/28	
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 checked="" type="checkbox"/> No
QC Inspector:	Riccardo	Sign:	<i>Riccardo</i>	Date: 2024/04/02

Dimensional Control

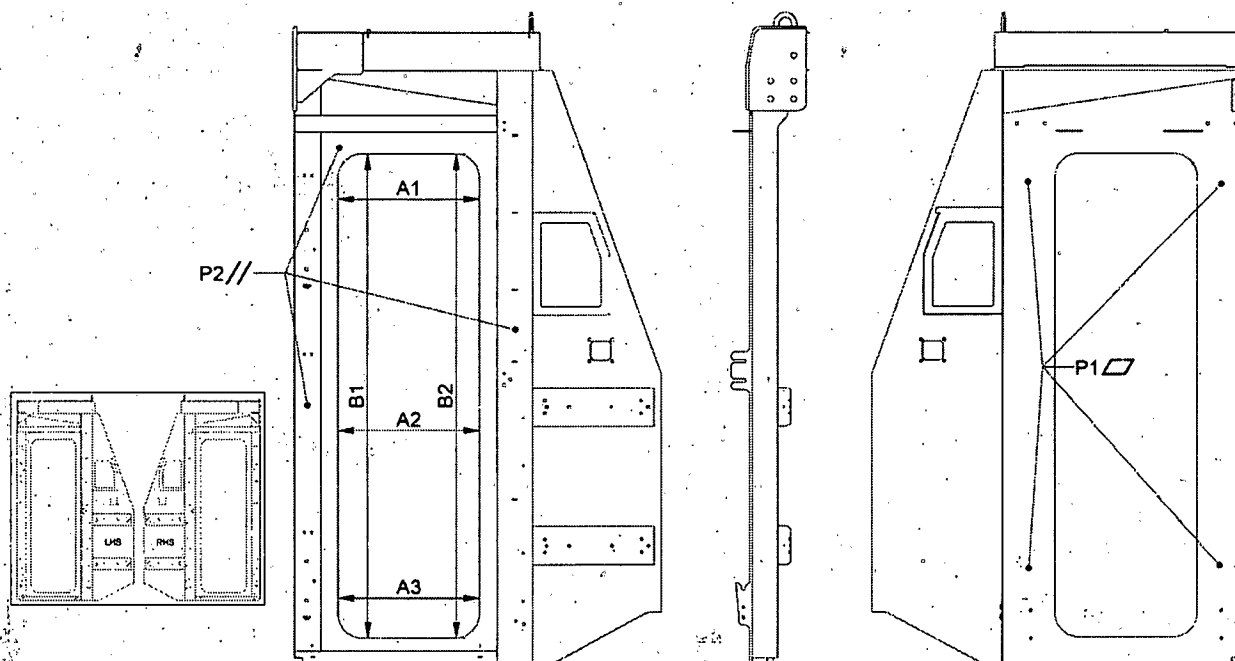
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	696	Tape Measure	acceptable
B	2086	+1/-3	2085	2086		acceptable
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2153	2152		acceptable
$ C1 - C2 $			2151	2151		acceptable
D	1438	+2/-3	1438	1438		acceptable
E			1484	1483		acceptable
QC Inspector:	Riccardo	Sign:	<i>Riccardo</i>	Date:	2024/04/02	

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	Pass	Ruler	acceptable
QC Inspector:	Riccardo	Sign:	<i>Riccardo</i>	Date: 2024/04/02

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>Xonder</i>	Assembly Date:	2024/04/03			
Sign:	<i>[Signature]</i>	Wire Batch No.:	55 2033			



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:	2024/04/04	

Dimensional Control

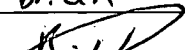
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	558	558	Tape Measure	acceptable
A2			560	560		acceptable
A3			559	560		acceptable
B1	1900	± 2	1898	1898		acceptable
B2			1898	1898		acceptable

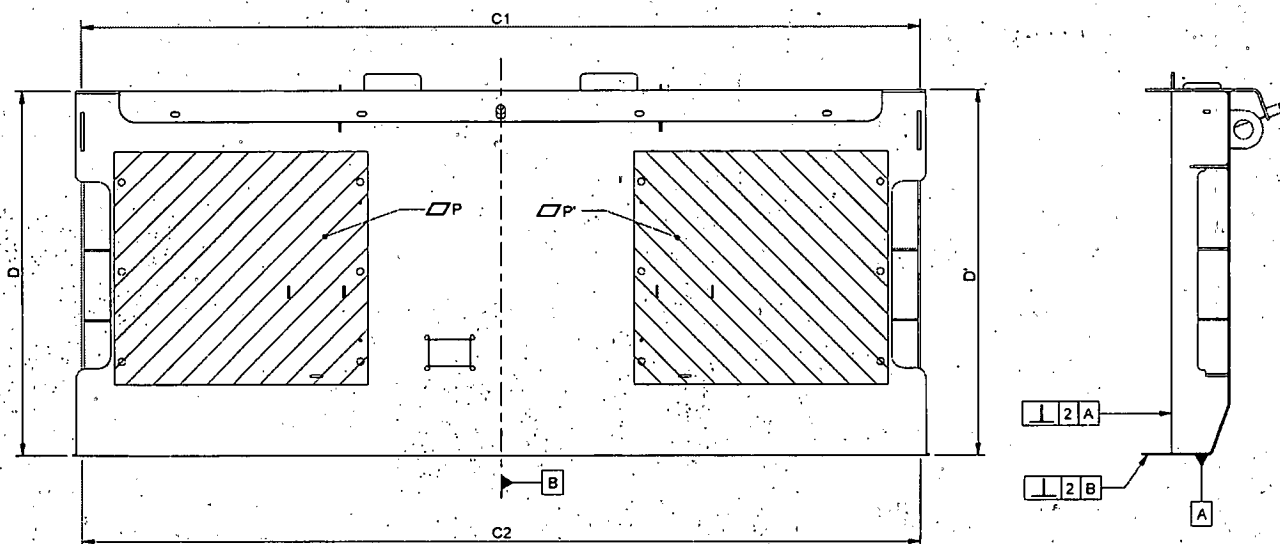
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/04/04	
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Geometrical Control


Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P1 : Planeity	4 mm	Passed		Ruler	acceptable	
P2 : Planeity	2 mm	Passed		Ruler	acceptable	
QC Inspector:	Riccardo	Sign:		Date:	2024/04/04	

Cabin Shield Assembly: GN002836

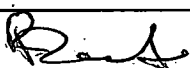
Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Brian	Assembly Date:	20 24 04 09			
Sign:		Wire Batch No.:	55 2033			



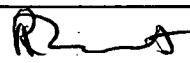
Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Riccardo	Sign:		Date:	20 24 04 09	

Dimensional Control

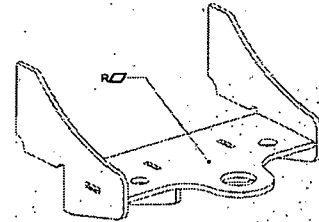
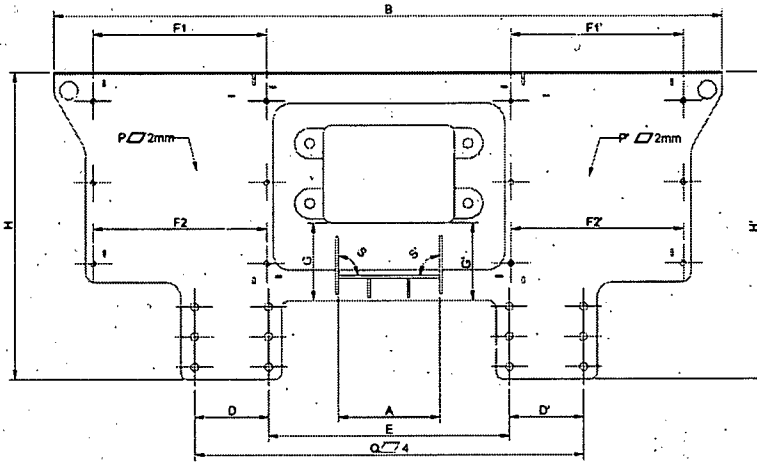
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2212	2213	Tape Measure	acceptable
D / D'	956	± 2	953	957		acceptable
QC Inspector:	Riccardo		Sign:		Date:	20 24 04 09

Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planarity P / P'		2 mm	PASSED		Ruler	acceptable
Perpendicularity		2	PASSED		Set Square	acceptable
		2	PASSED		Set Square	acceptable
QC Inspector:	Riccardo		Sign:		Date:	20 24 04 09

Cabin Front Headstock Assembly: GN002841


Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	<i>TK Bootu</i>	Assembly Date:	2024/02/26		
Sign:	<i>TK</i>	Wire Batch No.:	552033		



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>Riccardo</i>	Sign:	<i>Riccardo</i>	Date:	2024/04/04

Dimensional Control

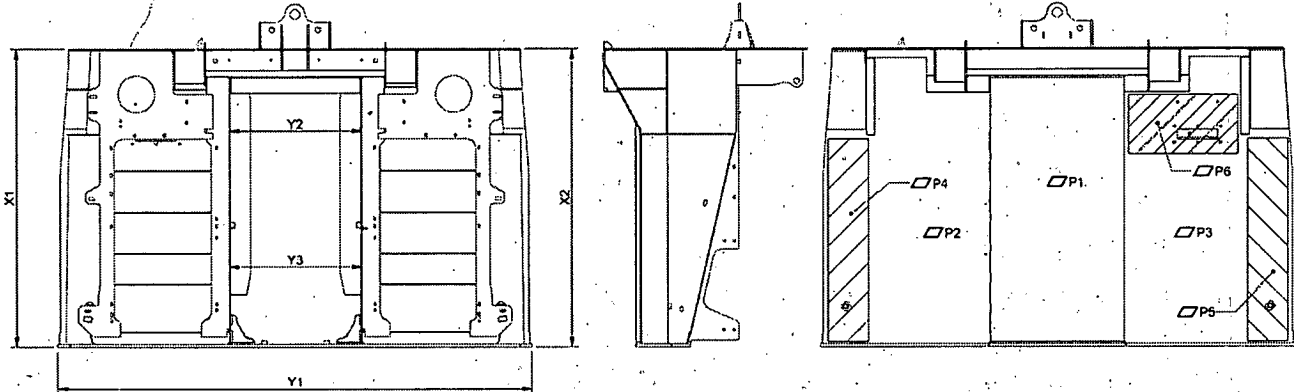
Rep	Thèorical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	340	±1	340		Tape Measure	acceptable	
B	2240	±4	2244			acceptable	
D / D'	250	±1	250	250		acceptable	
E	808	±2	808			acceptable	
F1 / F1'	580	±1	581	581		acceptable	
F2 / F2'			581	581		acceptable	
G / G'	258	±1	258	258		acceptable	
H / H'	1019	±2	1020	1020		acceptable	
QC Inspector:		Riccardo		Sign:		Date:	2024/04/04

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>Riccardo</i>
Date:	2024/04/04		

Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator: <i>Michael Wood</i>	Assembly Date:		20 24 / 04 / 08	
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: <i>Riccardo</i>	Sign: <i>[Signature]</i>	Date:	2024/04/08	


Dimensional Control

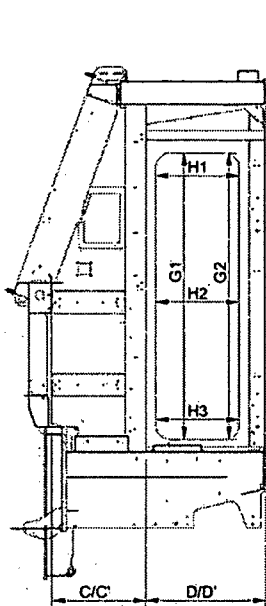
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1486	1487	Tape Measure	acceptable
Y 1	2354	± 3	2352			
Y2 / Y3	666	± 1	667	668		acceptable
QC Inspector: <i>Riccardo</i>		Sign: <i>[Signature]</i>		Date:		2024/04/08

Geometrical Control

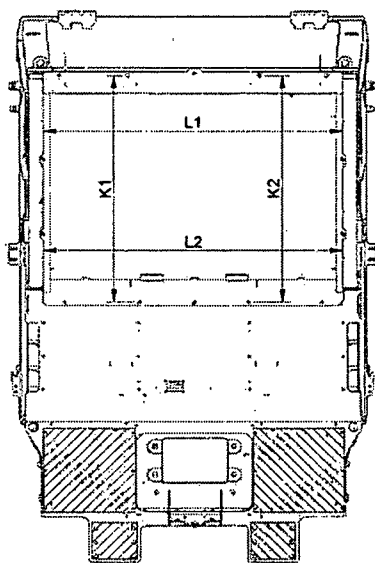
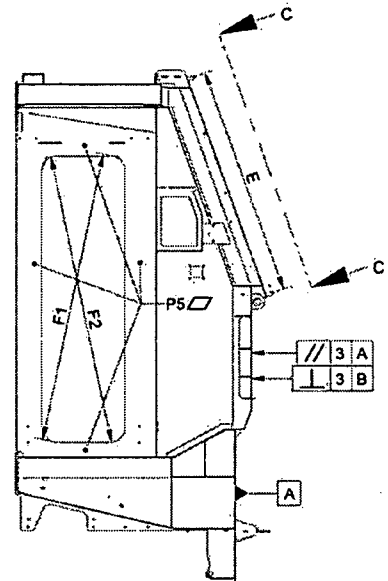
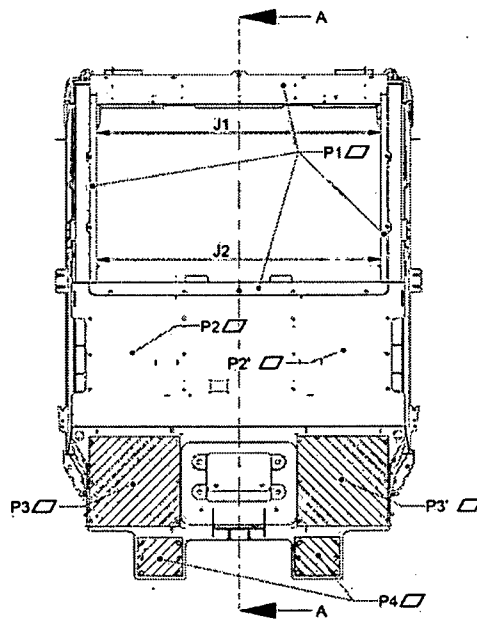
Nature of checks	Dimension Measured	Measuring Equipment	Observations		
P1 : Planeity	4 mm	Passed	Ruler	acceptable	
P2 / P3 : Planeity	4 mm	Passed	Ruler	acceptable	
P4 / P5 : Planeity	2 mm	Passed	Ruler	acceptable	
P6 : Planeity	2 mm	Passed	Ruler	acceptable	
QC Inspector: <i>Riccardo</i>		Sign: <i>[Signature]</i>		Date:	2024/04/12

Cabin Structure Assembly: GN002834

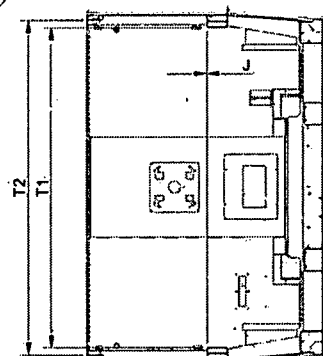
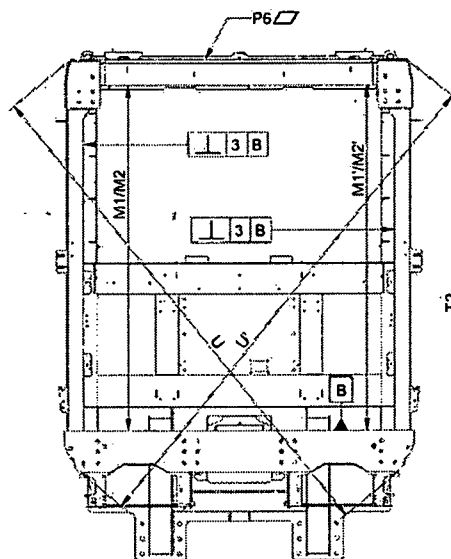
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:	CHAZE BLOU	Assembly Date:	20 24/04/08		
Sign:		Wire Batch No.:	880 65034		



SECTION A-A




AUX VIEW: C



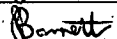
SECTION B-B

Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed		Yes	<input checked="" type="checkbox"/>	No
QC Inspector:		Riccardo		Sign:		R. A.		Date: 2024/04/12	
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	1529		acceptable				
G1 / G'1	Height 1900	+1	1897	1897	acceptable				
G2 / G'2		-3	1898	1897	acceptable				
H1 / H'1	Width 560	+1 -3	558	558	acceptable				
H2 / H'2			558	559	acceptable				
H3 / H'3			560	560	acceptable				
F1 / F'1	Diagonals 1939		1937	1937	acceptable				
F2 / F'2			1938	1937	acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	1	0	acceptable				
J	Gap of Doors	± 1,5	1	1	acceptable				
K1 / K'2	1515	± 3	1514	1514	acceptable				
L1 / L'2	1996	± 3	1997	1995	acceptable				
M1 / M'1	2306	± 3	2479	2479	acceptable				
M2 / M'2			2469	2469	acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2128	2128	acceptable				
T2 / T'2	2230 Top/Bottom		2232	2233	acceptable				
Difference	U - U' (3522)	≤ 4mm	3524	3522	acceptable				
QC Inspector:		Riccardo		Sign:		R. A.		Date: 2024/04/12	
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:		R. A.		Date: 2024/04/12	

Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLOEM	Assembly Date:	20 24 / 04 / 12		
Sign:		Wire Batch No.:	552033		

Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092	Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
Operator:	SEMMIN	Assembly Date:	20 24 / 04 / 16		
Sign:		Wire Batch No.:			

Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Fasteners positioned in all Rivnuts and Bosses	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Masked as per GMS-SOS-GIBELA-CABIN-001	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	DAVID	Sign:		T. D. [Signature]	
Date:	2024/04/26				
Record of Shot Blasting					
Operator:		Date:	2024/04/26		
Start Time:	08 ^h 41	End Time:	13 ^h 12		
Temperature ($\geq 15^\circ$):	20-02 °C	Humidity ($\leq 75\%$):	67-02 %		
Shot Blasting Self-Inspection					
Interior of Cabin: Sa 1 - Light Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
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	<input type="checkbox"/>
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	DAVID	Sign:		T. D. [Signature]	
Date:	2024/04/26				
Shot Blasting Cleaning					
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:		Sign:		T. D. [Signature]	
Date:	2024/04/26				
Shot Blasting Control					
Temperature $\geq 15^\circ$:	19-03 °C	Humidity $\leq 75\%$:	68-01 %		
Internal Roughness 3.2 $\leq Ra \leq 12.5$		External Roughness 3.2 $\leq Ra \leq 12.5$			
QC Inspector:	Jur3	Sign:		[Signature]	
Date:	26/4/24				

Internal

Ra 6,356 RZ 36,329

Ra 5.943

RZ 36.970

6.445

39.288

5.827

33.558

6.462

36.733

5.251

30.661

6.051

42.044

4.930

28.435

5.269

30.411

5.964

38.621

External

Ra 6.524

RZ 35.127

6.831

40.125

5.580

31.818

7.594

44.812

6.755

36.478

5.455

33.305

6.212

36.974

6.838

43.971

7.008

41.232

5.819

32.703

Record of Priming							
Start Time:		08:00		End Time:		10:00	
Temperature $\geq 15^{\circ}$:		27 $^{\circ}$ C		Humidity $\leq 75\%$:		62%	
Paint Batch No.:		8016059		Paint Expiry Date:		08/25	
Hardener Batch No.:		7331119		Hardener Expiry Date:		01/11/24	
Desolvation Start Time:		10:00		Desolvation End Time:		10:15	
Stoving Start Time:		10:15		Stoving End Time:		11:15	
Stoving Temp:		60 $^{\circ}$ C					
Operator:		musa		Sign:		musa	
Date:		20/04/26					
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 58.8	5: 44.8	1: 70.6	5: 72.4	1: 43.2	5: 60.2	1: 40.3	5: 31.6
2: 56.9	6: 43.2	2: 86.9	6: 60.6	2: 77.8	6: 70.6	2: 60.8	6: 70.2
3: 74.3	7: 90.4	3: 90.4	7: 69.8	3: 69.4	7: 44.9	3: 74.3	7: 81.3
4: 80.6	8: 93.4	4: 74.2	8: 50.4	4: 56.8	8: 59.8	4: 40.6	8: 87.6
Min:	43.2	Min:	80.4	Min:	43.2	Min:	31.6
Max:	93.4	Max:	90.4	Max:	77.8	Max:	87.6
Average:	68.3	Average:	71.9	Average:	60.5	Average:	59.7
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 74.2	5: 70.8	1: 41.3	5: 44.3	1: 39	5: 60.9	1: 59.6	5: 108.2
2: 66.7	6: 83.2	2: 38.6	6: 37.6	2: 48.6	6: 76.8	2: 40.8	6: 113.8
3: 60.8	7: 83.4	3: 40.9	7: 39.8	3: 41.3	7: 56.9	3: 37.8	7: 104.8
4: 58.2	8: 56.9	4: 45.3	8: 45.6	4: 67.9	8: 66.8	4: 44.8	8: 93.2
Min:	56.9	Min:	37.6	Min:	39	Min:	39.6
Max:	83.4	Max:	45.6	Max:	76.8	Max:	113
Average:	70.1	Average:	41.6	Average:	57.9	Average:	76.6
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 39.6	5: 50.0	1: 71.8	5: 90.8	1: 62.6	5: 60.8	1: 72.6	5: 60.7
2: 40.8	6: 49.8	2: 40.8	6: 71.6	2: 99.8	6: 86.3	2: 43.2	6: 89.8
3: 31.2	7: 43.9	3: 90.8	7: 72	3: 93.6	7: 62.9	3: 40.8	7: 44.3
4: 58.6	8: 59.8	4: 99.8	8: 70.1	4: 82.4	8: 163.4	4: 59.6	8: 66.8
Min:	31.2	Min:	70.8	Min:	62.9	Min:	40.8
Max:	49.8	Max:	99.8	Max:	99.8	Max:	72.6
Average:	43.5	Average:	82.0	Average:	76.7	Average:	56.7
Primer has been inspected and is free of defects				Confirmed		Yes	No
QC Inspector:		Reel		Sign:		Reel	
Date:		20/04/26					

Record of Painting NCSS3010 R90B			
Start Time:	02:30	End Time:	05:00
Temperature $\geq 15^{\circ}$:	31°C	Humidity $\leq 75\%$:	89%
Paint Batch No.:	8196598	Paint Expiry Date:	23-02-25
Hardener Batch No.:	8138195 113	Hardener Expiry Date:	11/26
Desolvation Start Time:	05:00	Desolvation End Time:	05:15
Stoving Start Time:	05:15	Stoving End Time:	06:15
Stoving Temp:	60°C		
Operator:	Musa	Sign:	Musa
Date:	2024/05/02		
Painting NCSS3010 R90B Control			
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS	
1: 148	5: 111	1: 127	5: 135
2: 104	6: 126	2: 118	6: 121
3: 100	7: 135	3: 128	7: 102
4: 108	8: 127	4: 136	8: 101
Min:	100	Min:	101
Max:	148	Max:	136
Average:	119	Average:	121
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	89.2
QC Inspector:	Zottile	Sign:	APaw
Date:	08 May 2024		

Record of Painting Blue NCSS1565 B			
Start Time:	09:00	End Time:	10:00
Temperature $\geq 15^{\circ}$:	30°C	Humidity $\leq 75\%$:	37%
Paint Batch No.:	18216288	Paint Expiry Date:	27-03-25
Hardener Batch No.:	8138195 113	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:	Murda	Sign:	
Date:	2024/05/02		Murda
Painting Blue NCSS1565 B Control			
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS	
1: 104	5: 151	1: 148	5: 129
2: 88.2	6: 97.3	2: 122	6: 115
3: 133	7: 112	3: 105	7: 106
4: 119	8: 140	4: 136	8: 153
Min: 88.2	Min: 105		
Max: 151	Max: 153		
Average: 118	Average: 129		
Painting NCSS3010 R90B has been inspected and is free of defects			
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	
QC Inspector:	Zothile	Sign:	
Date:	06 May 2024		

Record of RAL 7012							
Start Time:		02:30		End Time:		05:00	
Temperature $\geq 15^{\circ}$:		29°C		Humidity $\leq 75\%$:		59%	
Paint Batch No.:		8216273		Paint Expiry Date:		13.03.2025	
Hardener Batch No.:		813819S 113		Hardener Expiry Date:		11/26	
Desolvation Start Time:		05:00		Desolvation End Time:		05:15	
Stoving Start Time:		05:15		Stoving End Time:		06:15	
Stoving Temp:		60°C					
Operator:		M. V. K. K.		Sign:		na shahar	
Date:		20/05/23					
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 133	5: 134	1: 103	5: 126	1: 96.9	5: 117	1: 125	5: 113
2: 126	6: 117	2: 112	6: 115	2: 111	6: 109	2: 92.0	6: 108
3: 147	7: 101	3: 106	7: 122	3: 114	7: 102	3: 110	7: 81.1
4: 154	8: 125	4: 118	8: 131	4: 129	8: 134	4: 98.6	8: 108
Min:	101	Min:	103	Min:	96.9	Min:	81.1
Max:	154	Max:	131	Max:	134	Max:	125
Average:	127	Average:	117	Average:	115	Average:	103
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 97.3	5: 118	1: 101	5: 124	1: 133	5: 107	1: 143	5: 139
2: 114	6: 101	2: 127	6: 115	2: 93.2	6: 119	2: 129	6: 126
3: 128	7: 111	3: 104	7: 130	3: 149	7: 159	3: 123	7: 116
4: 145	8: 137	4: 120	8: 112	4: 95.9	8: 153	4: 136	8: 100
Min:	97.3	Min:	104	Min:	93.2	Min:	100
Max:	145	Max:	130	Max:	159	Max:	143
Average:	121	Average:	117	Average:	126	Average:	121
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 81.6	5: 97.4	1: 110	5: 122				
2: 131	6: 132	2: 135	6: 109				
3: 128	7: 138	3: 103	7: 113				
4: 117	8: 144	4: 106	8: 128				
Min:	81.6	Min:	103				
Max:	144	Max:	135				
Average:	112	Average:	119				
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	41.8		
QC Inspector:		Zothile		Sign:		[Signature]	
Date:		06 May 2024					
SEALING OF CABIN							
All areas where there is no welding has been sealed with SIKA				Confirmed	YES	<input checked="" type="checkbox"/>	NO
All sealants have been neatly applied along joints				Confirmed	YES	<input checked="" type="checkbox"/>	NO
SIGN OFF							
CLOCK No	24.58	OPERATOR SIGN	[Signature]	DATE	06 May 2024		

CABIN WAXING									
CABIN IS WAXED							Confirmed	YES	NO
SIGN OFF									
CLOCK No.	2458	OPERATOR SIGN	[Signature]				DATE	06 May 2024	

Confirmed

YES

NO

SIGN OFF

CLOCK No.

2458

OPERATOR SIGN

~~MS. 11.1.1.1~~

DATE:

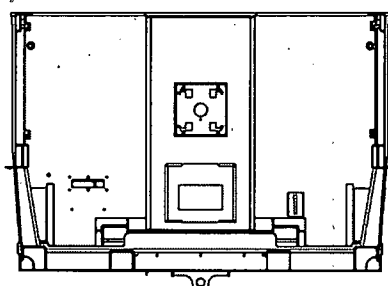
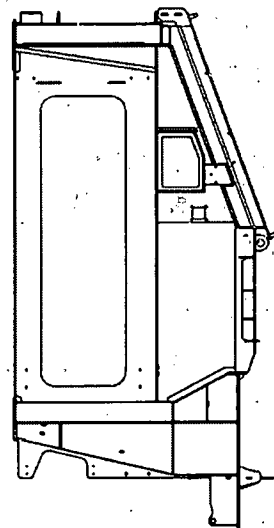
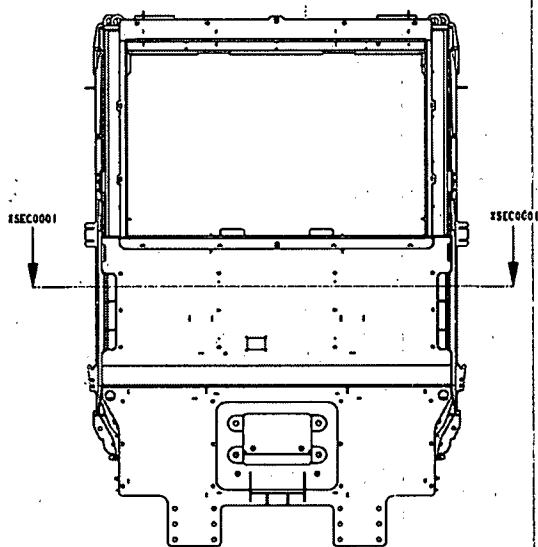
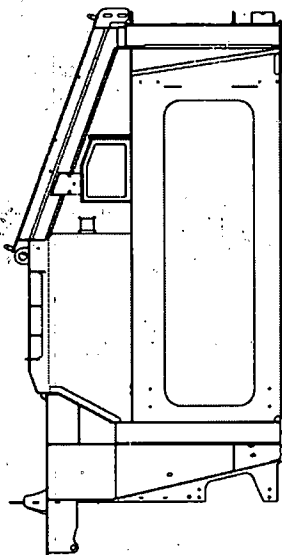
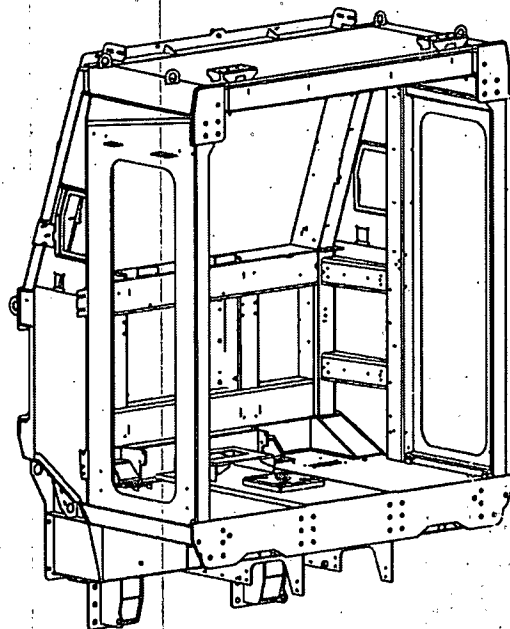
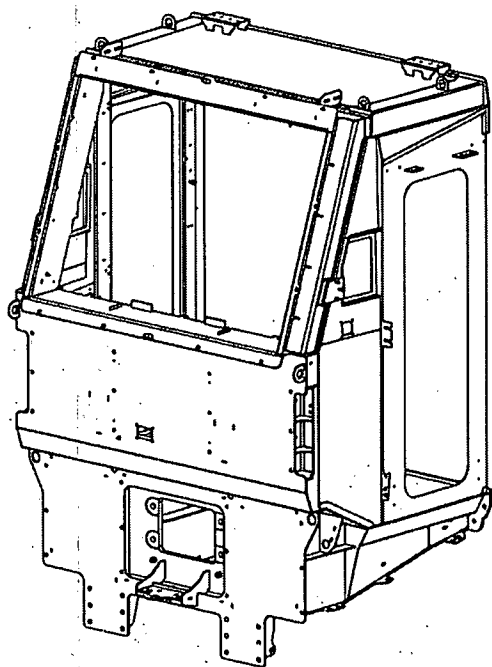
06 May 2024

Request for Weld Repair

[illegible]

REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)



FAULT TRACKING

[illegible]

REMINDERS / COMMENTS

[illegible]



CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	0464	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	○			
2	NO PIN HOLES ON CAB STRUCTURE	○			
3	SEALANT IS APPLIED CORRECTLY <ul style="list-style-type: none">JOINTS ARE CLOSEDNO BREAKS IN THE SEALANTCORRECT BEAD	○			
4	RIVET NUTS ARE PROPERLY CRIMPED <ul style="list-style-type: none">RIVETS ARE MARKEDCORRECT GRIP RANGE USED	○			
5	NO MISS WELDS PRESENT AFTER SANDBLASTING	○			
6	NO VISUAL MISS WELDS (INSPECTION AFTER SEALING)	○			
7	NO PAINT IN THREADS	○			
8					
9					
10					
11					
12					
13					
14					

Quality approval for release Signature	CO. NO:	DATE
	2285	08 May 2024