

## CABIN STRUCTURE QUALITY CARD

CAB No.: CAB \_ 4 5 2

WEIGHT: 1 4 8 5 Kg

# RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	05/02/24	178847 104825 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	14/02/24	178820 104640 01	F265272	
RCS 355	3 mm					
RCS 355	3 mm					

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

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegasus	12/02/24			
RCS 355	30 mm					

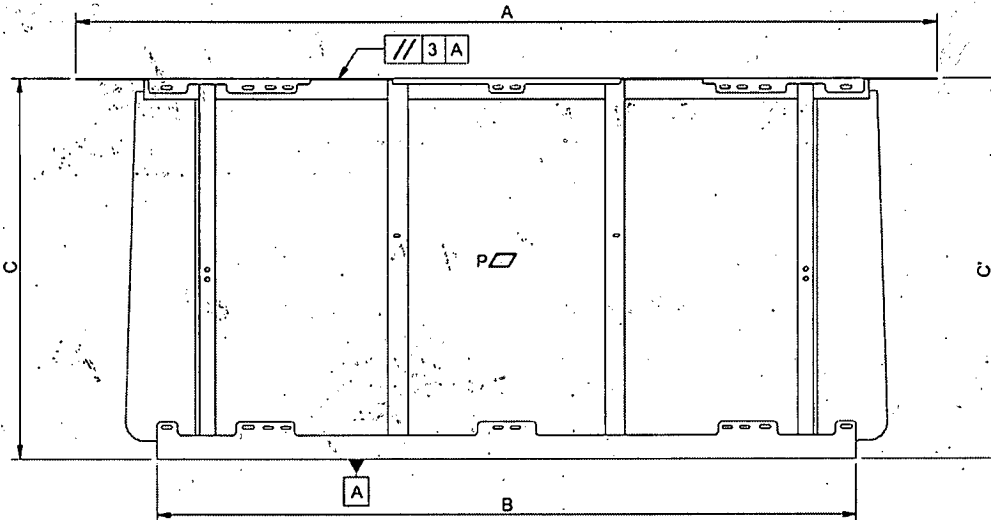
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	08/02/24	178489 104640	VHC35578	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	14/02/24	178815 104640 01	F269905	
RCS 450	6 mm				VHC28402	
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	22/11/23	175569 172206 01	F207906	
RCS 450	8 mm				VHS98432	
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	<input type="checkbox"/>
Operator:	DYLAN DAVIDS	Assembly Date:	20__/__/__			
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

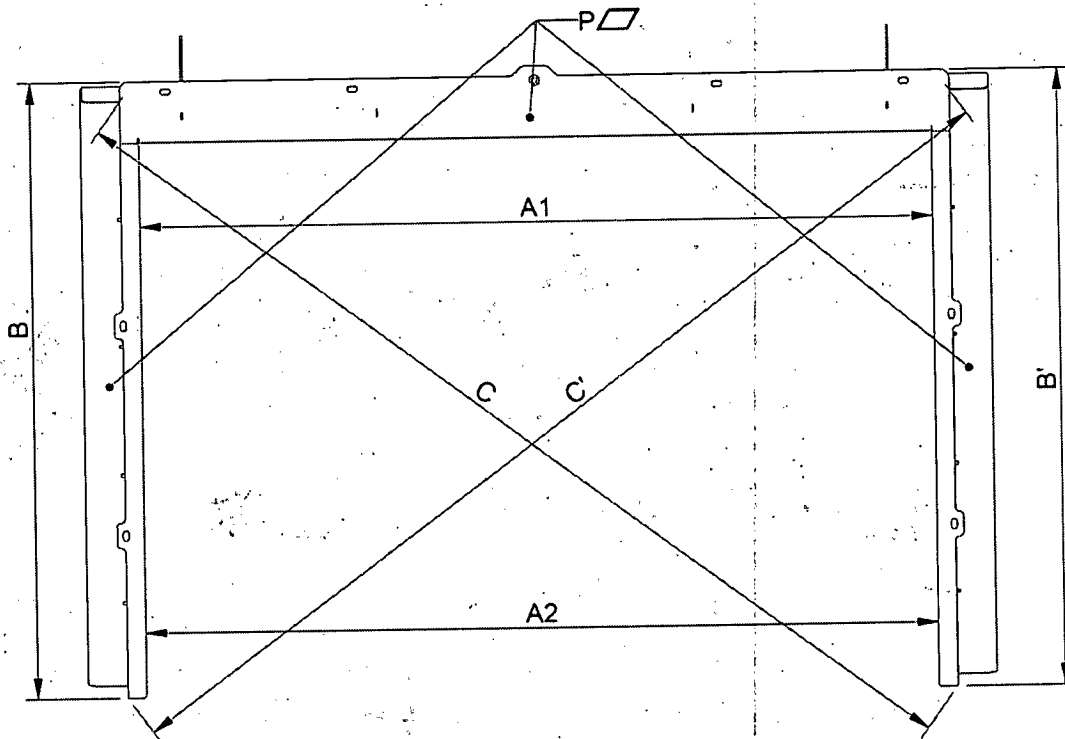
QC Inspector:	SBonele	Sign:		Date:	2024/02/24
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Dimensional Control						
Rep		Toler.	Dimension measured		Measuring Equipment	Observations
A	2216	+5/-0	2216.		Tape Measure	Acceptable
B	1800	± 4	1801			Acceptable
C	976	+2/-3	975	976.		Acceptable
QC Inspector:	SBonele	Sign:		Date:	2024/03/24	

Geometrical Control						
Nature of Checks		Dimension Measured		Measuring Equipment	Observations	
Planarity P	6 mm	Pass		Ruler	Acceptable	
//	3	A		Set Square	Acceptable	
QC Inspector:	SBonele	Sign:		Date:	2024/03/24	

## Cabin Front Frame Assembly: GN002840


Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	Bambelo G. C. N. A.	Assembly Date:	2024/02/25		
Sign:		Wire Batch No.:	2202152		



### 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:	SBonelo	Sign:		Date:	2024/03/07

### Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	1910	± 2	1912.		Tape Measure	Acceptable	
A2	1910		1911			Acceptable	
B	1475	± 1	1474	1474		Acceptable	
C	Diagonals   C - C'  ≤ 3		2475	2476.		Acceptable	
QC Inspector:		S Bonelo		Sign:		Date:	2024/03/07

### Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P: Planeity	4 mm		Ruler	Acceptable
QC Inspector:	SBonelo	Sign:		Date: 2024/03/07

**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:	<i>Xander</i>	Assembly Date:	2024/02/28			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

**Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907**

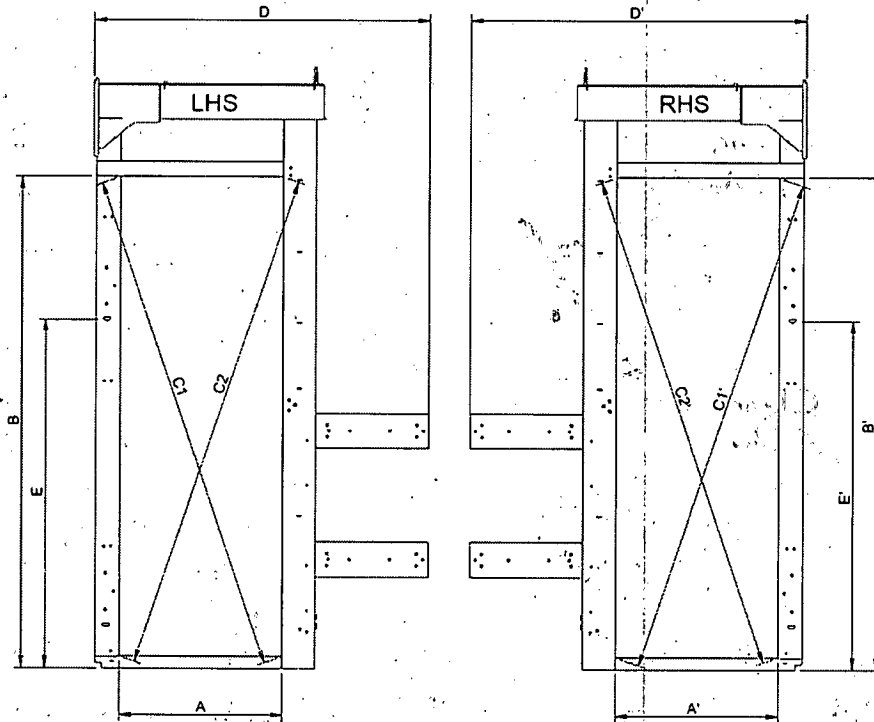
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>Glenn</i>	Assembly Date:	2024/02/26			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

**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:	<i>Glenn</i>	Assembly Date:	2024/02/26			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

## 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:	2024/02/28		
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152		



### 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:	Leon	Sign:	<i>[Signature]</i>	Date:	2024/03/04

### Dimensional Control

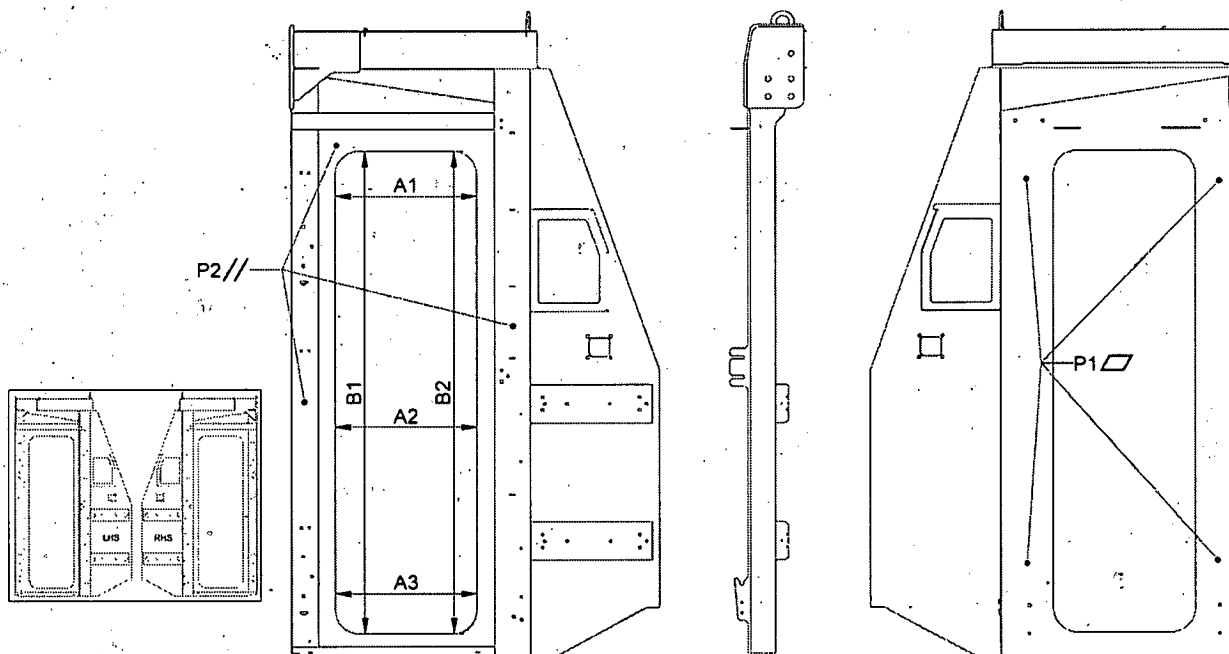
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	695.5	Tape Measure	Acceptable
B	2086	+1/-3	2085	2086		Acceptable
C1 / C2	Difference of diagonals $ C1 - C2  \leq 3$		2152	2152		Acceptable
C1 - C2			2150	2150.5		Acceptable
D	1438	+2/-3	1438	1440		Acceptable
E			1486	1486		Acceptable
QC Inspector:		Leon	Sign:	<i>[Signature]</i>	Date:	2024/03/04

### Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	Passes	Ruler	Acceptable
QC Inspector:		Leon	Sign:	<i>[Signature]</i>
		Date:	2024/03/04	



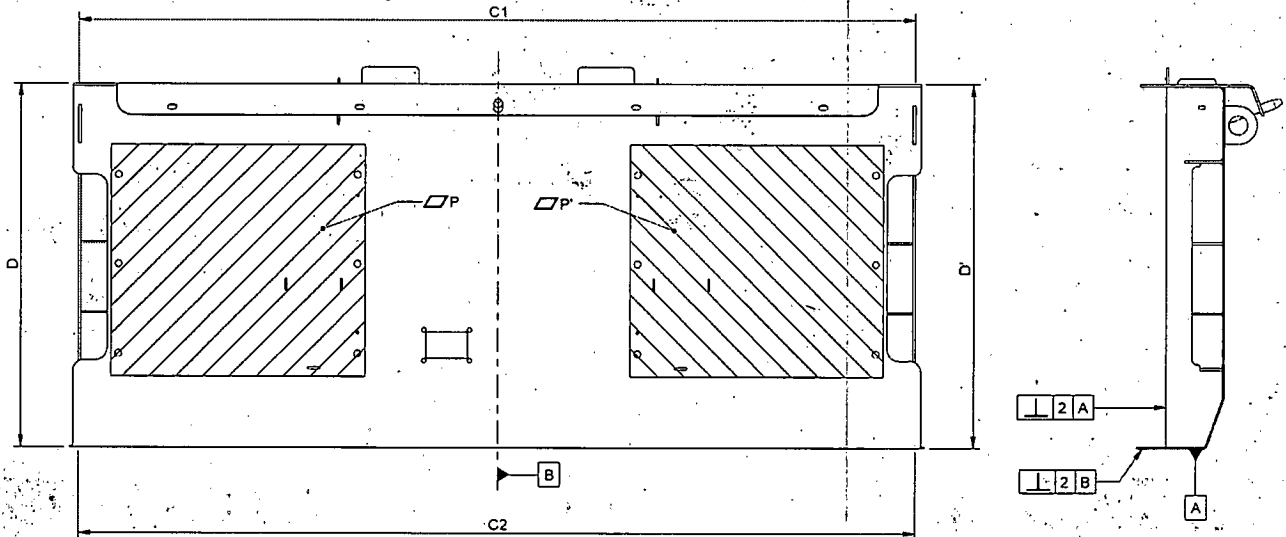
Cabin LHS/RHS Side Assembly: GN002838/GN002837					
Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	<i>Ramde</i>	Assembly Date:	2024/03/05		
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152		



Welding Control						
Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
QC Inspector:	<i>S Bonelo</i>	Sign:	<i>[Signature]</i>	Date:	20__/__/__	
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1			559	558	Tape Measure	Acceptable
A2	560	±2	560	559		Acceptable
A3			560	559		Acceptable
B1	1900	±2	1898	1898		Acceptable
B2			1898	1898		Acceptable
QC Inspector:	<i>S Bonelo</i>	Sign:	<i>[Signature]</i>	Date:	2024/03/07	
Geometrical Control						
Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P1: Planeity		4 mm	<i>Pass</i>	Ruler	<i>Acceptable</i>	
P2: Planeity		2 mm	<i>Pass</i>	Ruler	<i>Acceptable</i>	
QC Inspector:	<i>S Bonelo</i>	Sign:	<i>[Signature]</i>	Date:	2024/03/07	

# Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD 0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	BEVAN JAVENHILL	Assembly Date:	2024/03/07		
Sign:		Wire Batch No.	552088		



## Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	SBonelo	Sign:		Date:	2024/03/07

## Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2212	2213	Tape Measure	ACCEPTABLE
D / D'	956	± 2	956	956		ACCEPTABLE
QC Inspector:	SBonelo		Sign:		Date:	2024/03/07

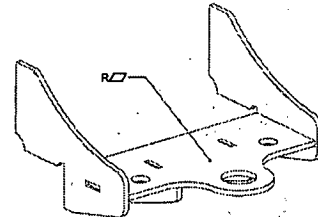
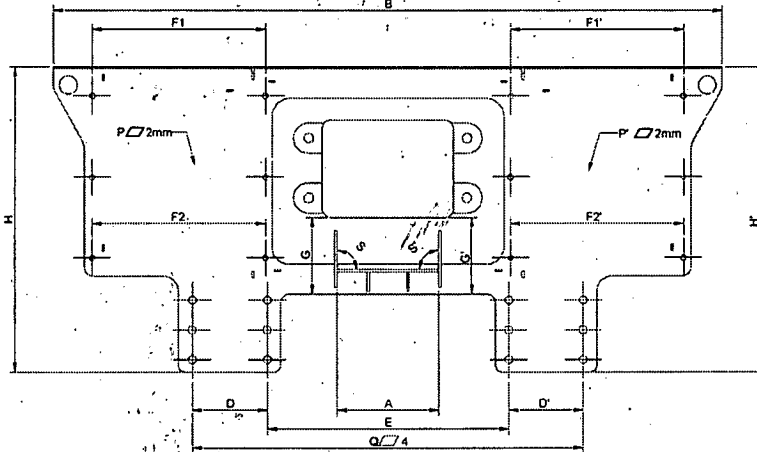
## Geometrical Control

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:	SBonelo		Sign:		Date:	2024/03/07



# Cabin Front Headstock Assembly: GN002841

Assembly Completed as per WI/SOS MD_0019	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator: <u>TK BOOTH</u>	Assembly Date:	2024/03/04			
Sign: <u>Booth</u>	Wire Batch No.:	2202152			



## 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:	2024/03/05		

## Dimensional Control

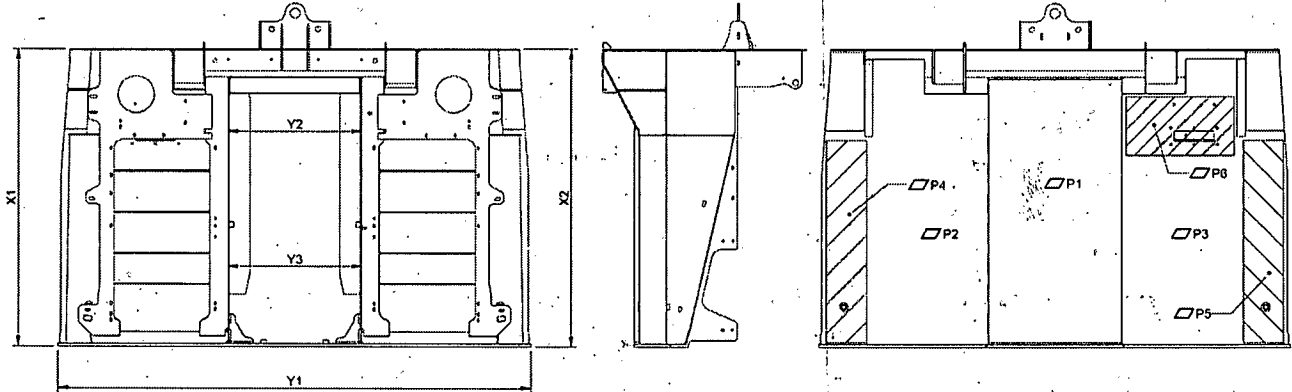
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	±1	440	340	Tape Measure	Acceptable
B	2240	±4	2244			Acceptable
D / D'	250	±1	250	250		Acceptable
E	808	±2	808			Acceptable
F1 / F1'	580	±1	580	580		Acceptable
F2 / F2'			580	580		Acceptable
G / G'	258	±1	259	259		Acceptable
H / H'	1019	±2	1020	1020		Acceptable
QC Inspector: <u>Leon</u>	Sign: <u>[Signature]</u>	Date:	2024/03/05			

## Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
O: Planicity of global assembly	4 mm	Ruler	Acceptable
P / P': Planicity	2 mm	Ruler	Acceptable
Q: Planicity Surface of Supports	4 mm	Ruler	Acceptable
R: Planicity Coupler Support	2 mm	Ruler	Acceptable
S: Perpendicularity coupler	1mm	Square	Acceptable
QC Inspector: <u>Leon</u>	Sign: <u>[Signature]</u>	Date:	2024/03/04

# Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	2024/03/08	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2302152	




## Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date: 2024/03/08


## Dimensional Control

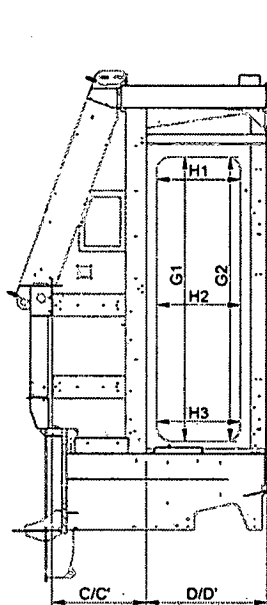
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1484	1489	Tape Measure	Acceptable
Y1	2354	± 3	2352			Acceptable
Y2 / Y3	666	± 1	668	666		Acceptable
QC Inspector:	<i>Leon</i>		Sign:	<i>[Signature]</i>	Date:	2024/03/08

## Geometrical Control

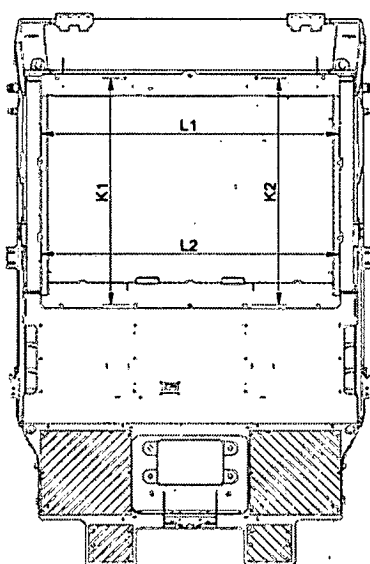
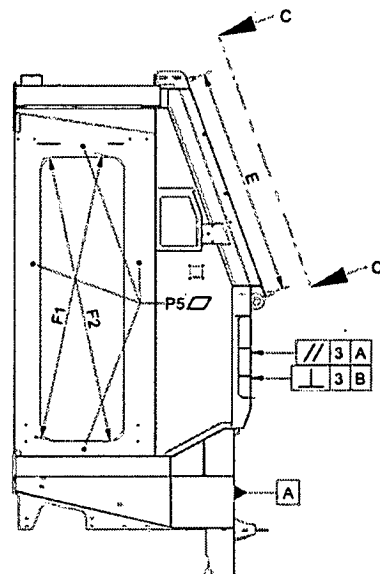
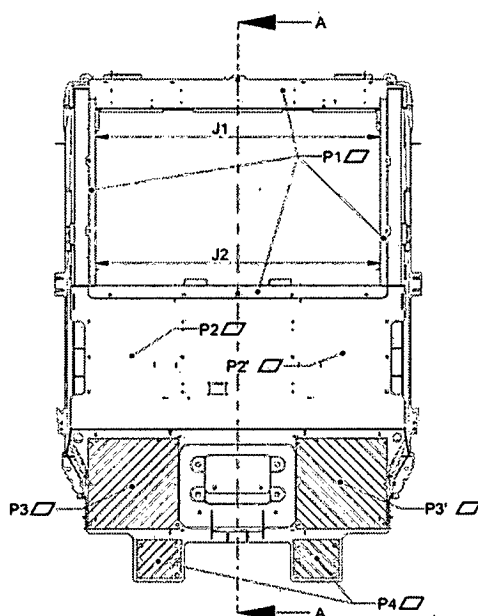
Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Passo	Ruler	Acceptable
P2 / P3 : Planeity	4 mm	Passo	Ruler	Acceptable
P4 / P5 : Planeity	2 mm	Passo	Ruler	Acceptable
P6 : Planeity	2 mm	Passo	Ruler	Acceptable
QC Inspector:	LEON	Sign:		Date: 2024/03/08

# Cabin Structure Assembly: GN002834

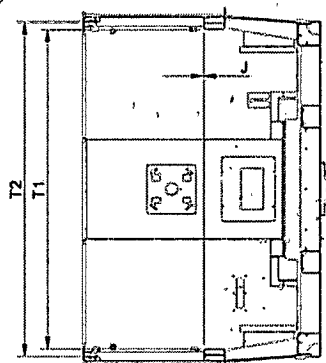
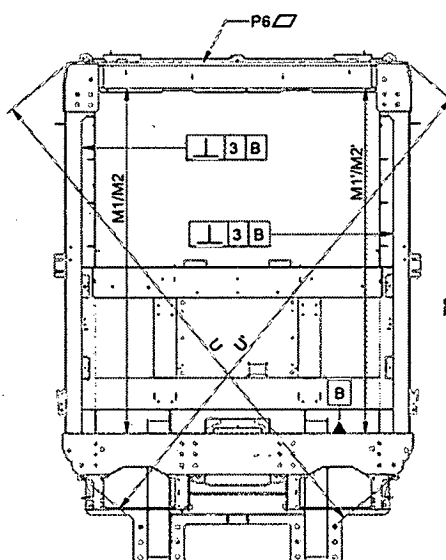
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLOEM	Assembly Date:	2024/03/12			
Sign:		Wire Batch No.:	2202152			



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:		Lea		Sign:		A		Date: 2023/03/12	
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	626	624	Acceptable				
D / D'	813	± 2,5	813	812	Acceptable				
E	1531.5	± 3	1530		Acceptable				
G1 / G'1	Height	+1	1897	1898	Acceptable				
G2 / G'2	1900	-3	1899	1898	Acceptable				
H1 / H'1	Width 560	+1 -3	558	558	Acceptable				
H2 / H'2			558	558	Acceptable				
H3 / H'3			558	559	Acceptable				
F1 / F'1	Diagonals 1939		1936	1937	Acceptable				
F2 / F'2			1936	1935	Acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	0	2	Acceptable				
J	Gap of Doors	± 1,5	1		Acceptable				
K1 / K2	1515	± 3	1514	1513	Acceptable				
L1 / L2	1996	± 3	1998	1996	Acceptable				
M1 / M'1	2306	± 3	2468	2468	Acceptable				
M2 / M'2			2478	2478	Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2127	2127	Acceptable				
T2 / T'2	2230 Top/Bottom		2232	2230	Acceptable				
Difference	U - U' (3522)	≤ 4mm	3519	3519	Acceptable				
QC Inspector:		Lea		Sign:		A		Date: 2024/03/12	
Geometrical Control									
Nature of checks		Toler.	LHS / Dimension Measured / RHS		Observations				
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				
Shield	⊥	3 A	3		PASSED				
Door Post	⊥	3 A	Front		PASSED				
			Back		PASSED				
QC Inspector:		Lea		Sign:		A		Date: 2023/03/12	

Cabin Bracket Assembly: GN002833				
Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>Dum:en</i>	Assembly Date:	2024/04/03	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152	

Cabin Rivnut Assembly: GN002832				
Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>DELWIN</i>	Assembly Date:	2024/04/03	
Sign:	<i>[Signature]</i>	Wire Batch No.:	N/A	

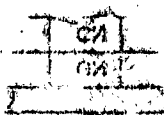
Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Fasteners positioned in all Rivnuts and Bosses		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Masked as per GMS-SOS-GIBELA-CABIN-001		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DAVID	Sign:		TOM	
Date:	2024/04/04				
Record of Shot Blasting					
Operator:		Date:	2024/04/04		
Start Time:	09 H59	End Time:	16 H05		
Temperature ( $\geq 15^\circ$ ):	20-05 °C	Humidity ( $\leq 75\%$ ):	63-04 %		
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:		TOM	
Date:	2024/04/04				
Shot Blasting Cleaning					
Cabin free of all sand		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DAVID	Sign:		TOM	
Date:	2024/04/04				
Shot Blasting Control					
Temperature $\geq 15^\circ$ :	22-07 °C	Humidity $\leq 75\%$ :	67-02 %		
Internal Roughness $3.2 \leq Ra \leq 12.5$	10.572	External Roughness $3.2 \leq Ra \leq 12.5$	9.773		
QC Inspector:	SPONELLO	Sign:		A	
Date:	04/04/24				




Record of Priming							
Start Time:		03:00		End Time:		05:00	
Temperature $\geq 15^{\circ}$ :		29°C		Humidity $\leq 75\%$ :		57%	
Paint Batch No.:		7978267		Paint Expiry Date:		06/25	
Hardener Batch No.:		7331119		Hardener Expiry Date:		01-11-24	
Desolvation Start Time:		05:00		Desolvation End Time:		05:15	
Stoving Start Time:		05:15		Stoving End Time:		06:15	
Stoving Temp:		160°C					
Operator:		Ntuthuko		Sign:		mstamps	
Date:		2024/04/05					
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 78.1	5: 64.6	1: 66	5: 60.4	1: 60.3	5: 87.9	1: 90	5: 50.6
2: 38.1	6: 77.3	2: 60.9	6: 76.0	2: 59.1	6: 66.5	2: 52.6	6: 57.1
3: 97.6	7: 86.5	3: 88.5	7: 92.0	3: 68.1	7: 61.8	3: 57.4	7: 48.1
4: 65.5	8: 59.8	4: 54.9	8: 52.8	4: 82.1	8: 46.1	4: 56.0	8: 44.0
Min:	38.1	Min:	52.8	Min:	46.1	Min:	44.0
Max:	97.6	Max:	92.0	Max:	87.9	Max:	90
Average:	65.1	Average:	76.4	Average:	61.3	Average:	68.3
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 52.4	5: 54.6	1: 66.9	5: 74.0	1: 69.2	5: 39.	1: 74.9	5: 46.5
2: 68.1	6: 65.3	2: 75	6: 66.4	2: 67.9	6: 45	2: 73.5	6: 59.0
3: 58.3	7: 52.9	3: 66.1	7: 57	3: 72.0	7: 73.2	3: 85.9	7: 49.8
4: 58.9	8: 64.9	4: 95	8: 89.4	4: 63.5	8: 74.5	4: 65.0	8: 68.9
Min:	52.4	Min:	57	Min:	39	Min:	46.5
Max:	68.1	Max:	89.4	Max:	74.5	Max:	85.9
Average:	59.4	Average:	63.8	Average:	51.0	Average:	62.7
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 66.5	5: 73	1: 84.3	5: 73.9	1: 52	5: 60.3	1: 77.4	5: 88.0
2: 52.7	6: 76	2: 81.6	6: 63.5	2: 86.	6: 39.6	2: 72.4	6: 88.5
3: 64.4	7: 81	3: 75.9	7: 84.6	3: 45.1	7: 59.1	3: 69.1	7: 97
4: 77.1	8: 97	4: 62.7	8: 76.1	4: 58.3	8: 49.1	4: 71.3	8: 43.
Min:	52.7	Min:	63.5	Min:	39.6	Min:	43.
Max:	97.	Max:	84.6	Max:	86.	Max:	88.5
Average:	78.8	Average:	72.2	Average:		Average:	63.9
Primer has been inspected and is free of defects				Confirmed		Yes	<input checked="" type="checkbox"/> No
QC Inspector:		Zothile		Sign:		H. Ruel	
Date:		05/04/2024					

Record of Painting NCSS3010 R90B			
Start Time:	19:00	End Time:	19:30
Temperature $\geq 15^{\circ}$ :	25°C	Humidity $\leq 75\%$ :	61%
Paint Batch No.:	8156903	Paint Expiry Date:	23-01-25
Hardener Batch No.:	75202115/21	Hardener Expiry Date:	12-24
Desolvation Start Time:	19:30	Desolvation End Time:	19:45
Stoving Start Time:	19:45	Stoving End Time:	20:45
Stoving Temp:	60°C		
Operator:	Ntuthuko	Sign:	[Signature]
Date:	20 24/04/08		
Painting NCSS3010 R90B Control			
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS	
1: 137	5: 134	1: 129	5: 112
2: 124	6: 107	2: 167	6: 937
3: 109	7: 118	3: 114	7: 148
4: 126	8: 122	4: 155	8: 123
Min:	107	Min:	93.2
Max:	134	Max:	167
Average:	122	Average:	131
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	32.8
QC Inspector:	Zothile	Sign:	[Signature]
Date:	06 Apr 2024		

Record of Painting Blue NCSS1565 B			
Start Time:	22:00	End Time:	23:30
Temperature $\geq 15^{\circ}$ :	29 $^{\circ}$ C	Humidity $\leq 75\%$ :	59%
Paint Batch No.:	81763138	Paint Expiry Date:	02-01-25
Hardener Batch No.:	750215121	Hardener Expiry Date:	12/24
Desolvation Start Time:	22:30	Desolvation End Time:	22:45
Stoving Start Time:	22:45	Stoving End Time:	23:45
Stoving Temp:	60 $^{\circ}$ C		
Operator:	Ntuthuko	Sign:	[Signature]
Date:	2024/04/05		
Painting Blue NCSS1565 B Control			
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS	
1: 128	5: 113	1: 115	5: 127
2: 90.8	6: 117	2: 106	6: 158
3: 117	7: 124	3: 156	7: 104
4: 102	8: 130	4: 147	8: 90.3
Min:	90.8	Min:	90.3
Max:	130	Max:	158
Average:	112	Average:	128
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	92.8
QC Inspector:	Zothile	Sign:	[Signature]
Date:	06 Apr 2024		

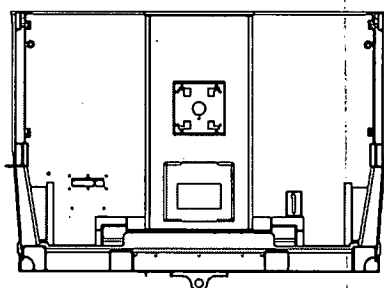
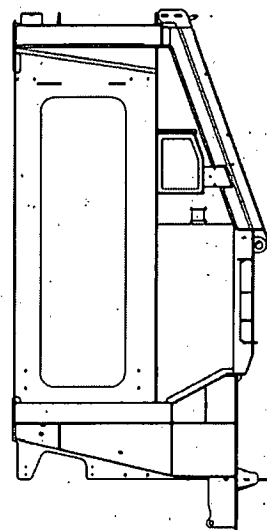
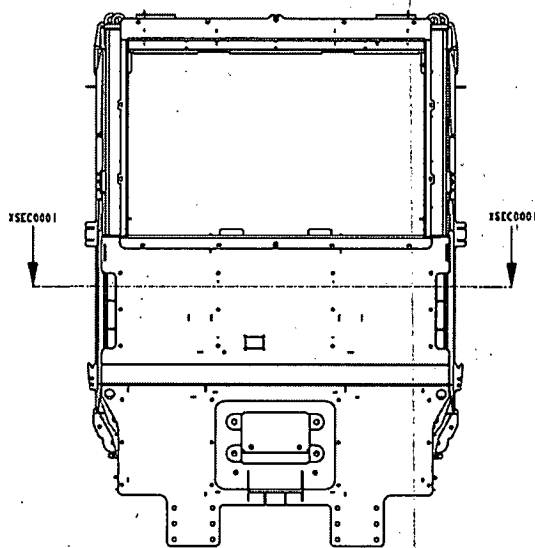
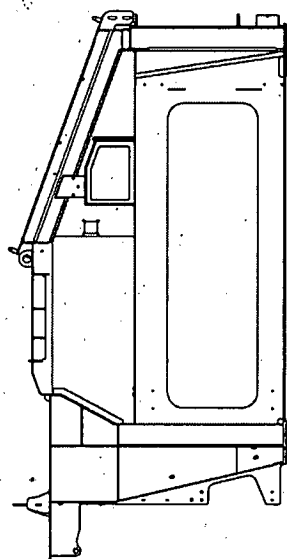
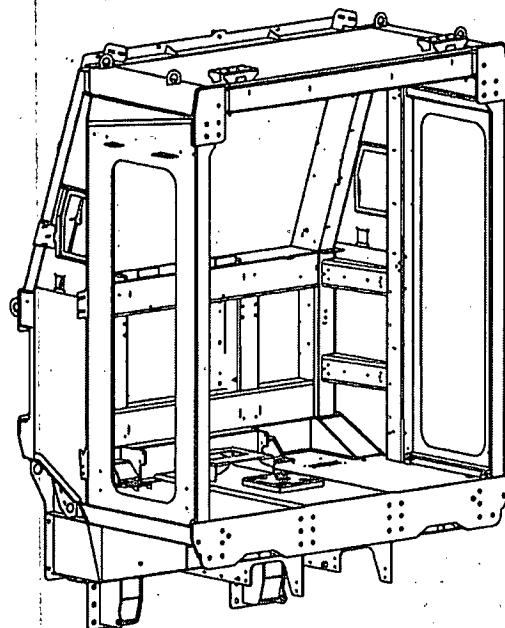
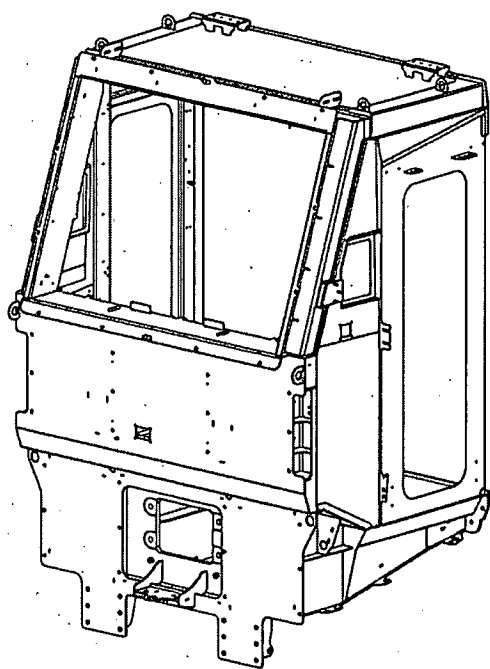


Record of RAL 7012							
Start Time:		03:00		End Time:		05:00	
Temperature $\geq 15^{\circ}$ :		31 $^{\circ}$ C		Humidity $\leq 75\%$ :		52%	
Paint Batch No.:		8156853		Paint Expiry Date:		06-02-25	
Hardener Batch No.:		7502115/21		Hardener Expiry Date:		12/24	
Desolvation Start Time:		05:00		Desolvation End Time:		05:15	
Stoving Start Time:		05:15		Stoving End Time:		06:15	
Stoving Temp:		60 $^{\circ}$ C					
Operator:		Neutuko		Sign:		nustangas	
Date:		20/04/06					
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 116	5: 142	1: 129	5: 124	1: 119	5: 164	1: 147	5: 120
2: 127	6: 137	2: 138	6: 126	2: 104	6: 188	2: 129	6: 144
3: 114	7: 128	3: 142	7: 131	3: 127	7: 141	3: 131	7: 100
4: 121	8: 119	4: 90.6	8: 128	4: 129	8: 143	4: 130	8: 102
Min:	114	Min:	90.6	Min:	104	Min:	100
Max:	142	Max:	142	Max:	164	Max:	147
Average:	128	Average:	116	Average:	134	Average:	123
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 136	5: 136	1: 114	5: 128	1: 98.2	5: 90.7	1: 115	5: 140
2: 137	6: 158	2: 109	6: 93.0	2: 113	6: 104	2: 81.2	6: 90.6
3: 120	7: 119	3: 158	7: 112	3: 169	7: 139	3: 125	7: 121
4: 121	8: 124	4: 162	8: 100	4: 105	8: 113	4: 124	8: 154
Min:	119	Min:	93.0	Min:	90.7	Min:	81.2
Max:	158	Max:	162	Max:	169	Max:	154
Average:	131	Average:	122	Average:	129	Average:	118
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 132	5: 93.3	1: 106	5: 147				
2: 169	6: 96.0	2: 107	6: 102				
3: 157	7: 135	3: 165	7: 146				
4: 151	8: 136	4: 143	8: 110				
Min:	86.0	Min:	101				
Max:	169	Max:	165				
Average:	124	Average:	138				
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		40.4	
QC Inspector:		Totrule		Sign:			
Date:		06.04.2024					
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	2400		OPERATOR SIGN	Aphile		DATE	06/4/24

[illegible]

## REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)





## FAULT TRACKING

[illegible]

## REMINDERS / COMMENTS

[illegible]

11/24/20

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## CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	452	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"><li>JOINTS ARE CLOSED</li><li>NO BREAKS IN THE SEALANT</li><li>CORRECT BEAD</li></ul>	0			
4	RIVET NUTS ARE PROPERLY CRIMPED <ul style="list-style-type: none"><li>RIVETS ARE MARKED</li><li>CORRECT GRIP RANGE USED</li></ul>	0			
5	NO MISS WELDS PRESENT AFTER SANDBLASTING	0			
6	NO VISUAL MISS WELDS (INSPECTION AFTER SEALING)	0			
7					
8					
9					
10					
11					
12					
13					
14					

Quality approval for release Signature	CO. NO.	DATE
	2291	12/04/24