


PRASA PROJECT


APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

CONFIDENTIAL INFORMATION

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


APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ? 	
				TC1	MA	M1	M2	M3	TC2			
<input type="checkbox"/>	OTR31374497/3	AAD0001413323	CARBODYSHELL M2 ASSEMBLY	cb2210				X			PRA.cb2210.DTR313744 97/3.V25	YES
<input type="checkbox"/>												

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018
			CHECKER	Nosizo Pindela	10/01/2018
			COMPILER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motama	2018/05/18
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230	APPROVER	Itumeleng Modiba	2018/07/04
			CHECKER	Nosizo Pindela	2018/07/04
			REVISED BY	Ramokone Motama	2018/07/04
3	2018/12/12	Added dimensional check points to cb2210	APPROVER	Itumeleng Modiba	12/12/2018
			CHECKER	Nosizo Pindela	12/12/2018
			REVISED BY	Ramokone Motama	12/12/2018
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	22/01/2019
			CHECKER	Nosizo Pindela	22/01/2019
			REVISED BY	Vanessa Ntuli	22/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	21/08/2019
			CHECKER	Nosizo Pindela	21/08/2019
			REVISED BY	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			REVISED BY	Bongane Masina	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISED BY	Mpho Mulaudzi	17/08/2021
25	21/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	21/02/2022
			CHECKER	Andani Muthelo	21/02/2022
			REVISED BY	Andani Muthelo	21/02/2022
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlampe Amogelang	14/04/2023
			REVISED BY	Mohlampe Amogelang	14/04/2023
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023
			CHECKER	Zwane Ntokozo	27/07/2023
			REVISED BY	Mohlampe Amogelang	27/07/2023
28	07/11/2023	Addition of welder traceability	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Andani Muthelo	07/11/2023
			REVISED BY	Ntokozo Zwane	07/11/2023

TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
231	M2	GERALD / 628951	05/06/24	SI.CB2210.247.V28	17

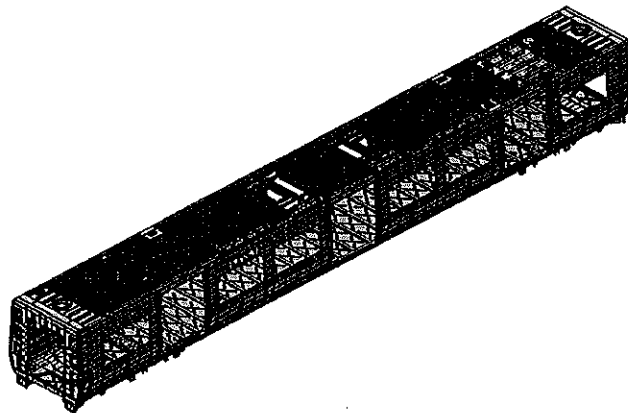
APPROVED
 21-08-2019
 13-03-2019
 10-01-2018

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
		Date 07/11/2023	

Car: M2	NCR:	Work station: CB2210
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Safety Related



I - Documentation and Instruments Control

1.1 - Documentation Control

Document	Type of car						Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
	D	M	S	E	E	D						
DTR31374497/3			X				28		✓		N/A 07/11/2023	07/11/2023

1.2 - Instruments Control

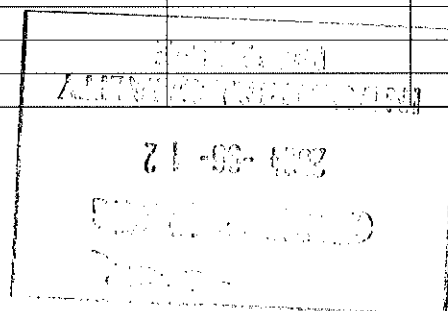
Monitoring and Measuring Instrument Control - Used for Special Process



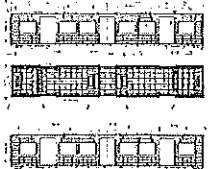
Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
Tubular	32823-2	15/03/25	✓		07/11/2023	07/11/2023
laser tape	1254-25924	08/01/25	✓		07/11/2023	07/11/2023
30 m tape	GIBTP0102	18/11/24	✓		07/11/2023	07/11/2023

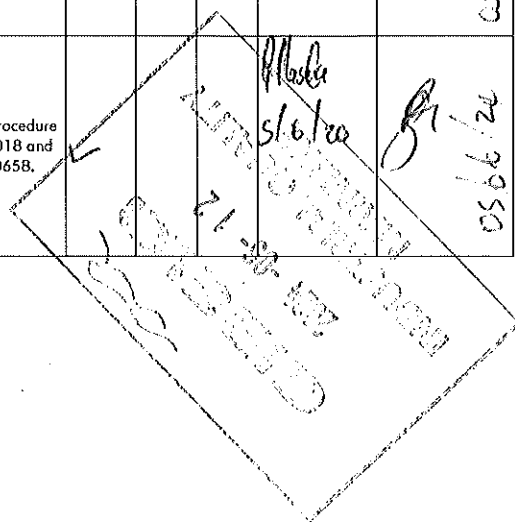
1.3 - Consumables


Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSi	314018-74097	Mig	✓		07/11/2023	07/11/2023
ER 308L	294 687 70322	Tig	✓		07/11/2023	07/11/2023

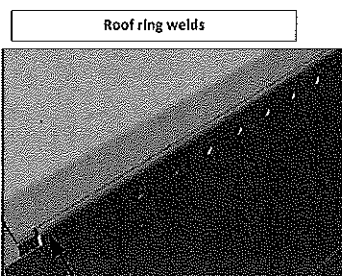





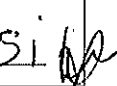
		CARBODYSHELL M2 ASSEMBLY DTR31374497/3		Rev. 28 Date 07/11/2023	Project: PRA5A SI.CB2210.247.V28		
II - Self Inspection - Items to Check							
II.1 - Items to check							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls, Endframes, Roof and Underframe)	AA00001375051	✓		P. Mascher 5/6/24	P. Mascher 05/06/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		P. Mascher 5/6/24	P. Mascher 05/06/24
03	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓		P. Mascher 5/6/24	P. Mascher 05/06/24
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		P. Mascher 5/6/24	P. Mascher 05/06/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		P. Mascher 5/6/24	P. Mascher 05/06/24
06		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓		P. Mascher 5/6/24	P. Mascher 05/06/24
07	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓		P. Mascher 5/6/24	P. Mascher 05/06/24




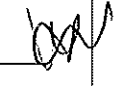


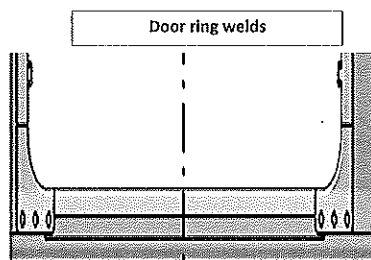
	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
		Date 07/11/2023	


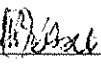
Welder traceability


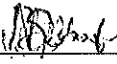


LHS		END 1
Boiler maker (Name & Sign):	Welder (Name & Sign):	
GERALD 	MITOKOISI 	
RHS		
Boiler maker (Name & Sign):	Welder (Name & Sign):	
TEROCCI 	MITOKOISI 	


LHS		END 2
Boiler maker (Name & Sign):	Welder (Name & Sign):	
GERALD 	MITOKOISI 	
RHS		
Boiler maker (Name & Sign):	Welder (Name & Sign):	
TEROCCI 	MITOKOISI 	



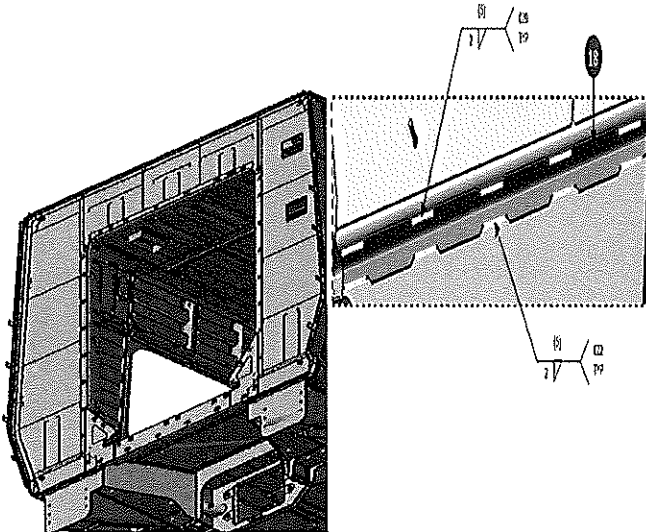
LHS	
Boiler maker (Name & Sign): TEROCCI 	
Welder (Name & Sign): Bobbert 	

RHS	
Boiler maker (Name & Sign): GERALD 	
Welder (Name & Sign): Bobbert 	

RECEIVED
11/11/2023
11/11/2023
11/11/2023
11/11/2023

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
		Date 07/11/2023	

EUFR Reinforcement Plates

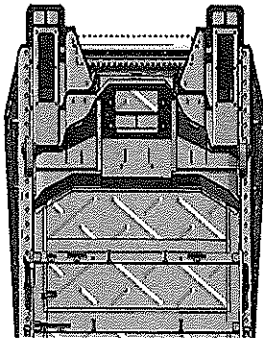


END 1

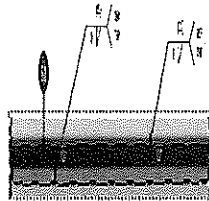
Boiler maker (Name & Sign): LAURENCE Selzer

Welder (Name & Sign): G177

END 2



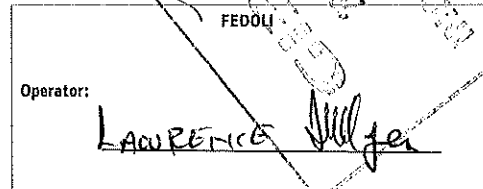
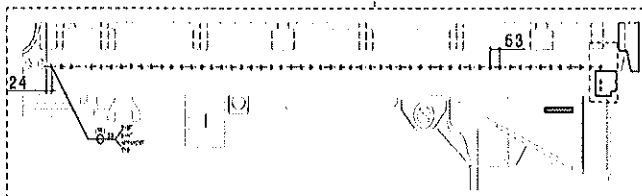
Underneath the CAR



END 2


Boiler maker (Name & Sign): MAHATI

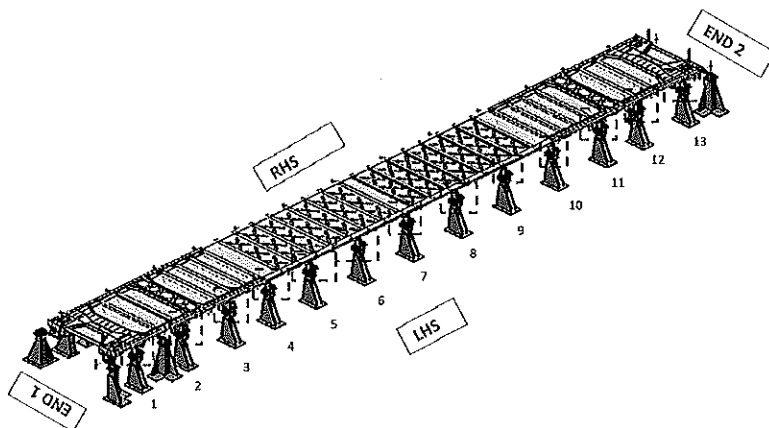
Welder (Name & Sign): KETUMETSE



Operator:

LAURENCE Selzer

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		Date 07/11/2023	
Specifications of Details for CBS measurement			



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

After loading and clamping

Fill in the gap 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	@				N/A								
Right Hand Side													

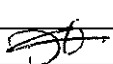
Signature Operations: 

Date: 31/6/24

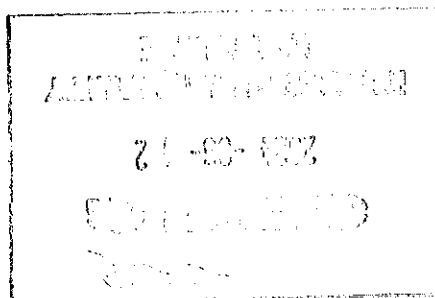
After Welding.

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					N/A								
Right Hand Side													

Signature Industrial Quality: 

Date: 06/06/24





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28

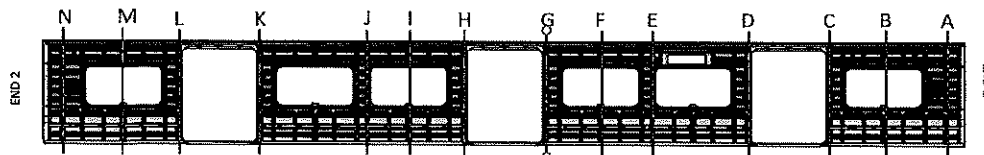
Date

07/11/2023

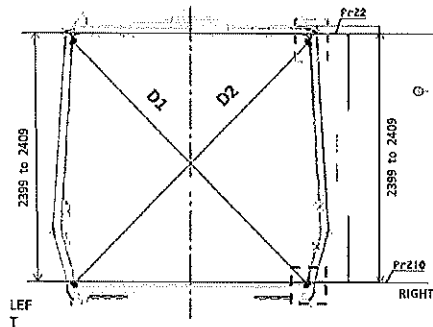
Project: PRASA

Sl.CB2210.247.V28

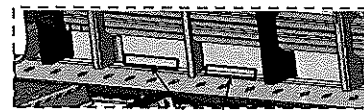
Specifications of Details for CBS measurement



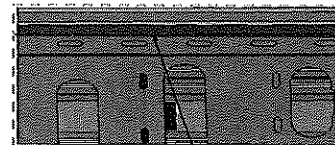
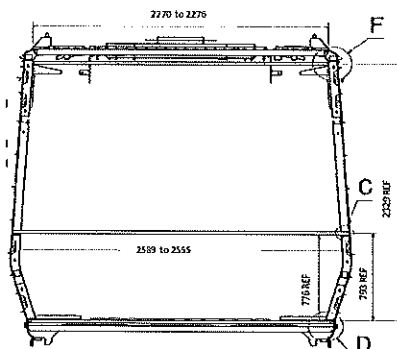
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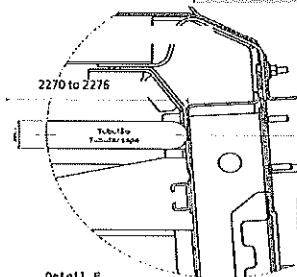
Measurement positions on roof rail and sidewall omega corner.



Measurement positions on sidewall and side sill corner.

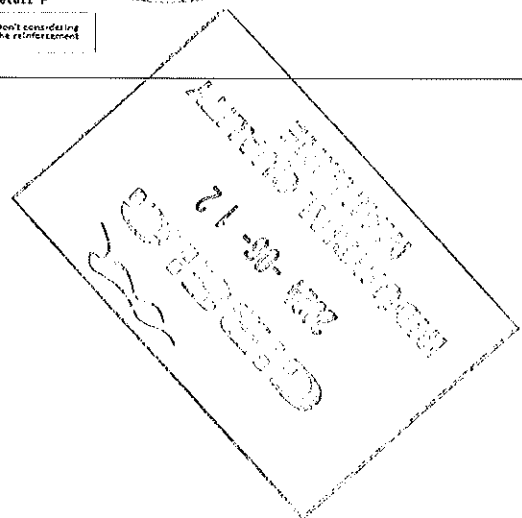


Reinforcement area measurement positions on roof reinforcement area.



Detail P

Don't considering the reinforcement





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Project: PRASA

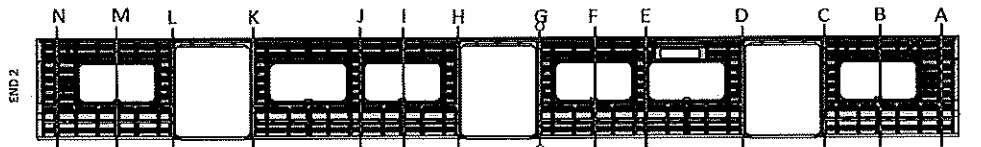
SI.CB2210.247.V28

Date

07/11/2023

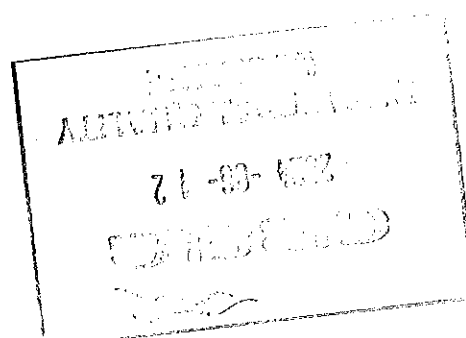
Specifications of Details for CBS measurement

BEFORE WELDING



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

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3266	3266	0	2405	2406	1
B	3266	3265	1	2406	2406	0
C	3268	3266	2	2405	2405	0
D	3265	3265	0	2406	2405	1
E	3267	3266	1	2404	2404	0
F	3266	3266	0	2405	2405	0
G	3266	3265	1	2405	2404	1
H	3266	3266	0	2405	2405	0
I	3266	3265	1	2405	2404	1
J	3266	3268	2	2405	2405	0
K	3268	3268	0	2406	2406	0
L	3266	3266	0	2405	2405	0
M	3266	3265	1	2406	2406	0
N	3266	3266	0	2405	2405	0



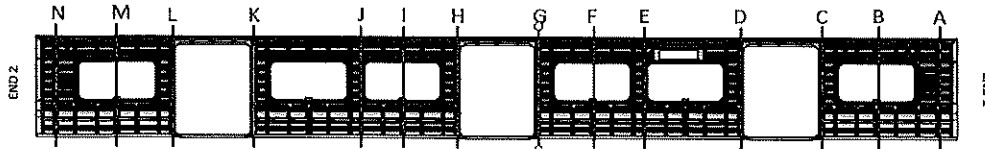


CARBODYSHELL M2 ASSEMBLY DTR31374497/3

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28Date
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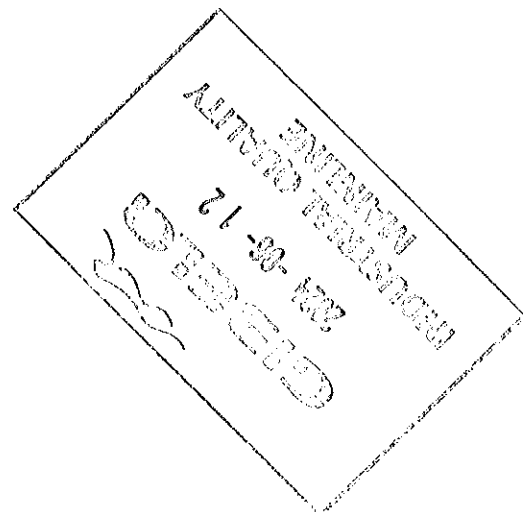
Specifications of Details for CBS measurement


AFTER WELDING



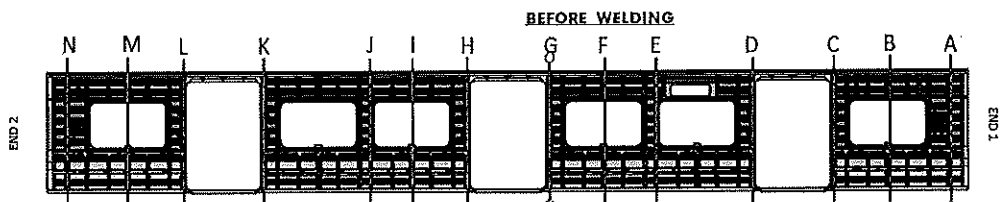
Note: The difference in Height values measured on the LHS and RHS should be $\leq 2\text{MM}$ on each point.

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3295	3295	0	2406	2406	0
B	3266	3265	1	2406	2405	1
C	3296	3296	0	2406	2406	0
D	3295	3295	0	2404	2405	1
E	3266	3266	0	2405	2405	0
F	3268	3266	2	2405	2404	1
G	3298	3295	0	2405	2405	0
H	3296	3295	1	2406	2406	0
I	3267	3267	0	2406	2405	1
J	3267	3266	1	2405	2405	0
K	3296	3296	0	2406	2405	1
L	3298	3296	2	2405	2405	0
M	3268	3268	0	2406	2405	1
N	3296	3296	0	2406	2406	0



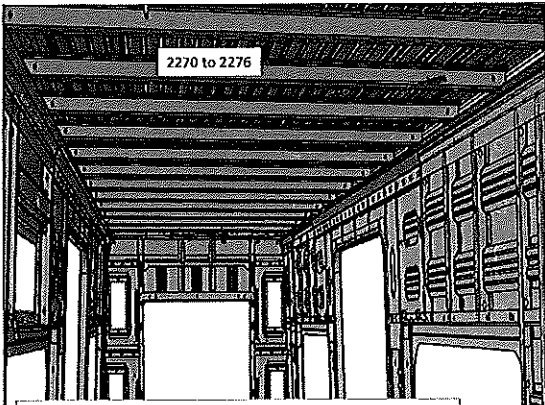
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CBS measurement

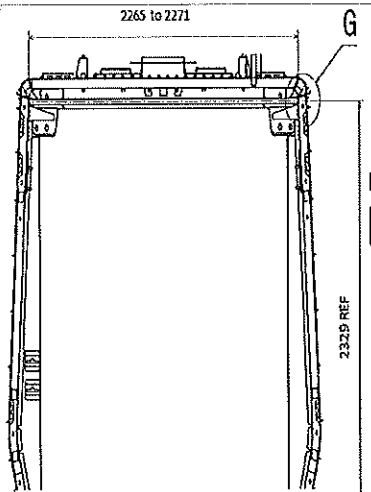


2270 to 2276

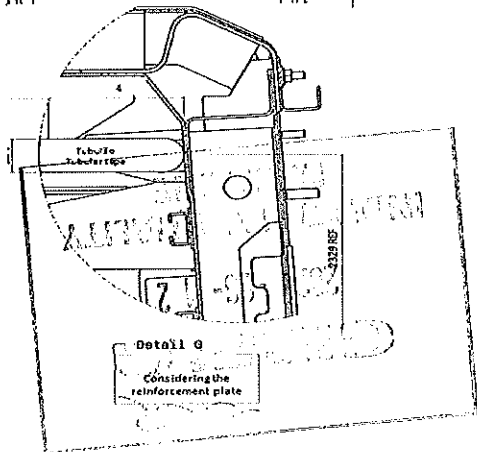
A	2274
B	2276
C	2272
D	2273
E	2275
F	2273
G	2272
H	2275
I	2274
J	2275
K	2276
L	2272
M	2273
N	2274




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

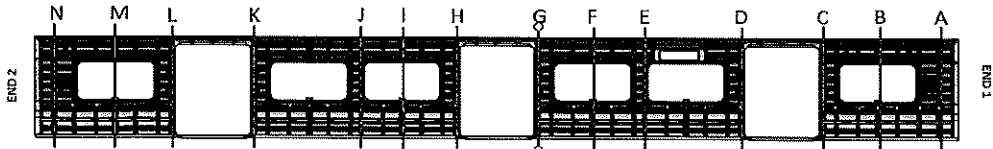


2265 to 2271

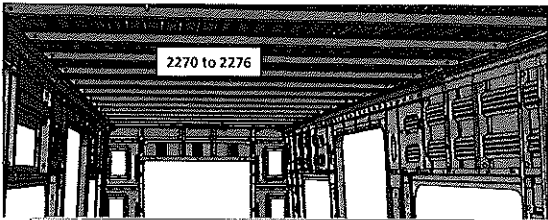


	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
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CBS measurement			

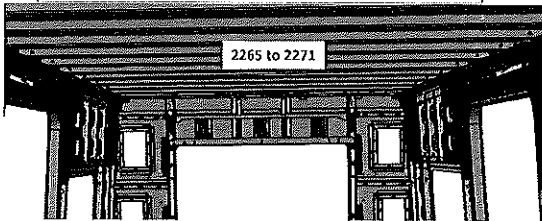
AFTER WELDING



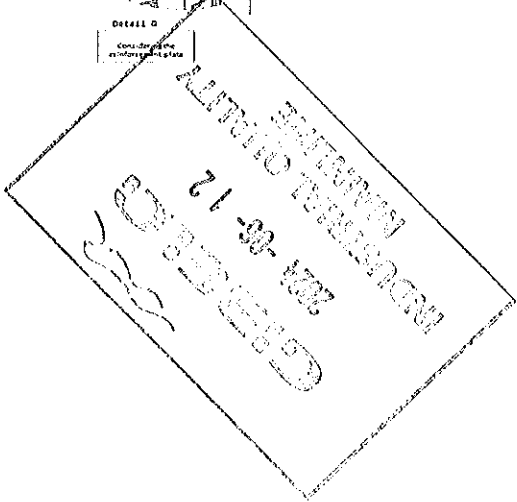
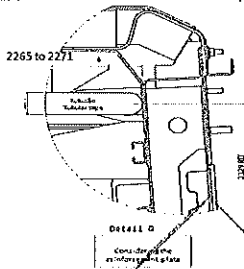
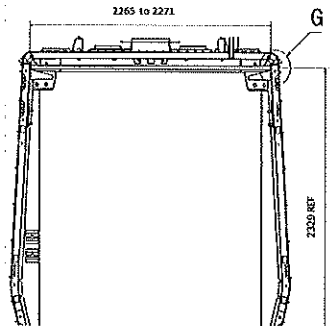
	2265 to 2271	2270 to 2276
A	2269	N/A
B	N/A	2275
C	2270	N/A
D	2271	N/A
E	N/A	2275
F	N/A	2276
G	2270	N/A
H	2271	N/A
I	N/A	2273
J	N/A	2274
K	2269	N/A
L	2270	N/A
M	N/A	2275
N	2269	N/A



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



Take measurement close to radius (considering reinforcement)





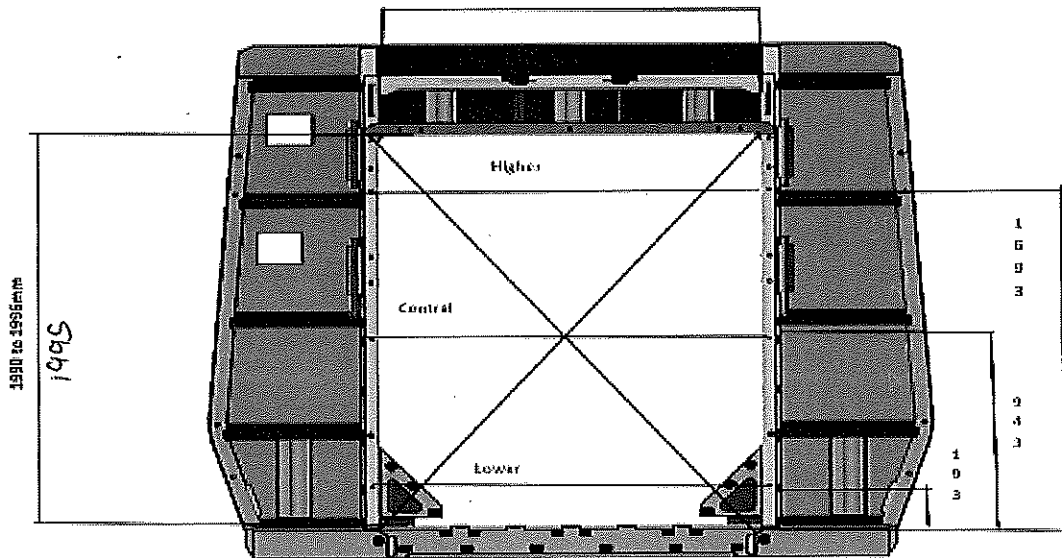
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07/11/2023Project: PRA5A
SI.CB2210.247.V28

CBS measurement

End frame 1

1380 to 1382 mm



Higher Dimension

1381

Central Dimension

1380

Lower Dimension

1381

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

D1

2416

D2

2414

D1-D2

0

ALFA ROMEO
21-03-2023

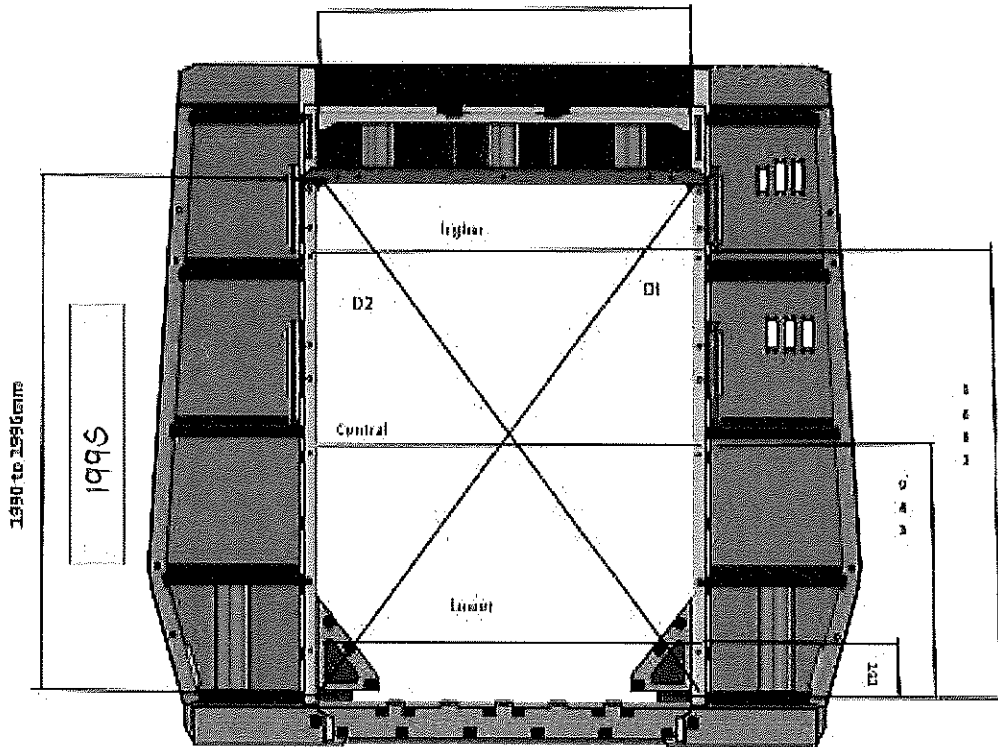


CARBODYSHELL M2 ASSEMBLY DTR31374497/3

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28
Date
07/11/2023

Project: PRASA
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End frame 2



1380 to 1382 mm

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

Higher Dimension

1381

D1

2415

Central Dimension

1380

D2

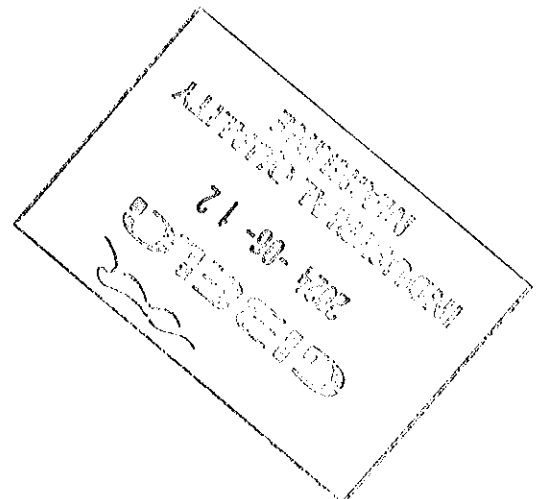
2415

Lower Dimension

1380

D1-D2

0





CARBODYSHELL M2 ASSEMBLY DTR31374497/3

Rev.

28

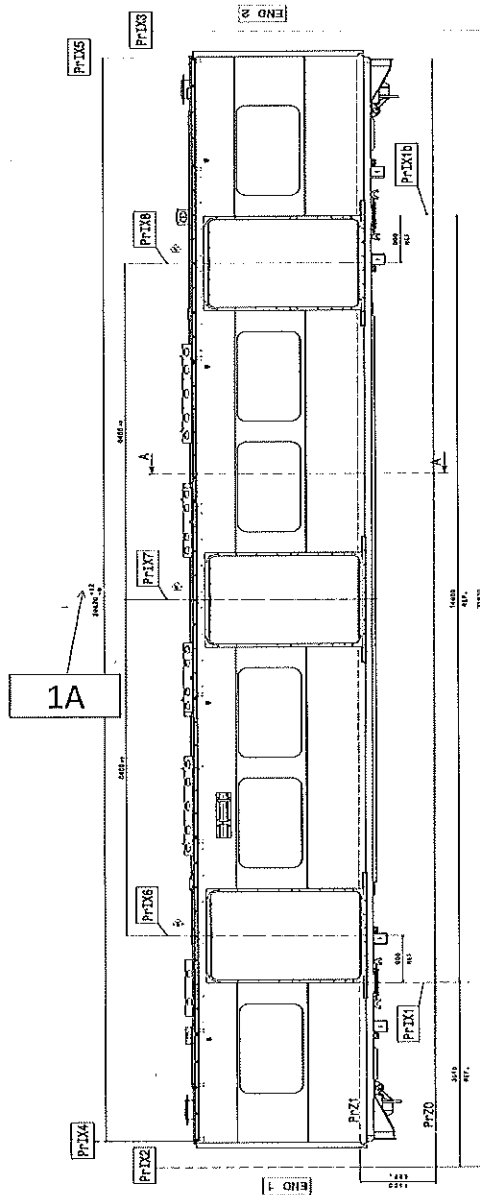
Date

07/11/2023

Project: PRA5A

SI.CB2210.247.V28

Specifications of Details for CBS measurement

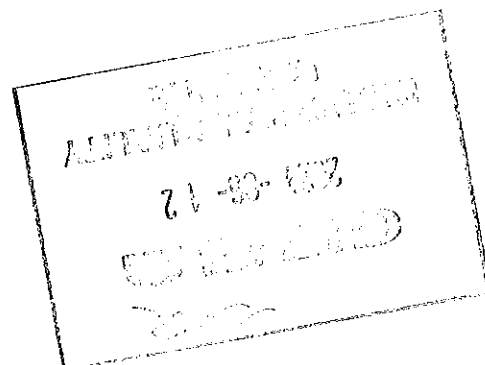



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20613

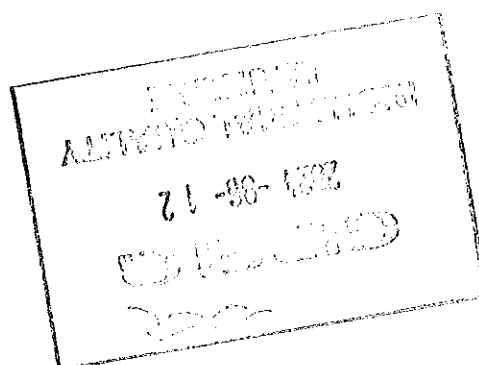
RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20612


Dye penetrant test


Dye-penetration test to be performed by quality personnel




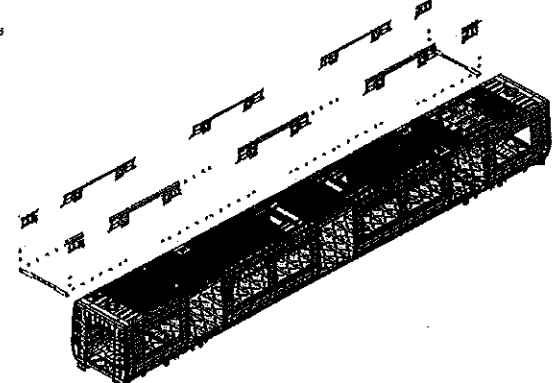
		CARBODYSHELL M2 ASSEMBLY DTR31374497/3		Rev. 28 Date 07/11/2023	Project: PRASA SI.CB2210.247.V28	
Self Inspection - Final Result						
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)			DATE	NAME	SIGNATURE	
HOLD POINT	GO	(if activities are not complete, the missing activities must not impact the next stage!)	5/6/24	GERALD Operations	[Signature]	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.	05/06/24	Ntokozo Industrial Quality	[Signature]	
	NO GO	There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)			Operations	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet!			Industrial Quality	
In case of "NO GO", describe blocking problems :						
In case of "NO GO", the operations manager must define below action plan to ensure "GO":						
Item	Description		Responsible	Due date	Status	
Operations			Quality			



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												
ROUTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY	
				TC4	MA	M3	M2	M3	TC2			
<input type="checkbox"/>	DTR3000257465	A/D0001413329	CARBODYSHELL M2 ASSEMBLY	EB2220				X			PRA.CB2220.DTR3137 4487/2.V21	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
REV	DATE	MODIFICATION CONTENT		RESPONSIBLE	NAME	DATE						
0	01/02/2018	GIBELA NEW CREATION		APPROVER	Itumeleng Modiba	01/02/2018						
				CHECKER	Nosizo Pindela	01/02/2018						
				COMPILER	Thanyani Mathegu	01/02/2018						
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager		APPROVER	Itumeleng Modiba	18/05/2018						
				CHECKER	Nosizo Pindela	18/05/2018						
				REVISED BY	Ramokone Motama	18/05/2018						
2	2018/07/05	Certain dimensional checks added and others moved to CB1210		APPROVER	Itumeleng Modiba	2018/07/05						
				CHECKER	Nosizo Pindela	2018/07/05						
				REVISED BY	Ramokone Motama	2018/07/05						
3	2018/06/12	Width tolerance as per DT0000336600		APPROVER	Itumeleng Modiba	2018/06/12						
				CHECKER	Nosizo Pindela	2018/06/12						
				REVISED BY	Nosizo Pindela	2018/06/12						
5	24/01/2019	As per Baseline 10.2		APPROVER	Itumeleng Modiba	24/01/2019						
				CHECKER	Nosizo Pindela	24/01/2019						
				REVISED BY	Vanessa Ntuli	24/01/2019						
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements Remove		APPROVER	Itumeleng Modiba	13/03/2019						
				CHECKER	Nosizo Pindela	13/03/2019						
				REVISED BY	Nosizo Pindela	13/03/2019						
7	27/05/2019	Removed measurement positions on the display windows		APPROVER	Itumeleng Modiba	27/05/2019						
				CHECKER	Nosizo Pindela	27/05/2019						
				REVISED BY	Nosizo Pindela	27/05/2019						
10	22/08/2019	New Baseline 10.2.5		APPROVER	Itumeleng Modiba	22/08/2019						
				CHECKER	Nosizo Pindela	22/08/2019						
				REVISED BY	Nosizo Pindela	22/08/2019						
15	06/08/2020	New Baseline 10.2.6		APPROVER	Timothy Maimela	06/08/2020						
				CHECKER	Bongane Masina	06/08/2020						
				REVISED BY	Bongane Masina	06/08/2020						
20	19/04/2021	New Baseline change 10.3		APPROVER	Timothy Maimela	19/04/2021						
				CHECKER	Bongane Masina	19/04/2021						
				REVISED BY	Bongane Masina	19/04/2021						
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING		APPROVER	Mbhombi Collins	17/08/2021						
				CHECKER	Mpho Mulaudzi	17/08/2021						
				REVISED BY	Mpho Mulaudzi	17/08/2021						
25	20/02/2022	New Baseline change 10.3.1		APPROVER	Mbhombi Collins	20/02/2022						
				CHECKER	Andani Muthelo	20/02/2022						
				REVISED BY	Andani Muthelo	20/02/2022						
26	14/06/2022	Update minimum temperature requirement for sealant application		APPROVER	Mbhombi Collins	14/06/2022						
				CHECKER	Andani Muthelo	14/06/2022						
				REVISED BY	Andani Muthelo	14/06/2022						
27	17/10/2022	Addition of traceability for sealant application and welding.		APPROVER	Mbhombi Collins	17/10/2022						
				CHECKER	Ntokozo Zwane	17/10/2022						
				REVISED BY	Amogelang Mohlampe	17/10/2022						
28	14/04/2023	Added sealant batch number & welding consumables traceability		APPROVER	Vanessa Ntuli	14/04/2023						
				CHECKER	Ntokozo Zwane	14/04/2023						
				REVISED BY	Amogelang Mohlampe	14/04/2023						
29	28/10/2023	Addition of bracket quantity		APPROVER	Ngobeni Tyson	28/10/2023						
				CHECKER	Mathapo Kelebone	28/10/2023						
				REVISED BY	Mohlampe Amogelang	28/10/2023						
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES							
231	M2	Levi 483008	06/06/24	SI.CB2220.276.V29	15							

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB2220.276.V29	
		29		
		Date		
Car: M2	NGR:	Work station:	CB2220	

 Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

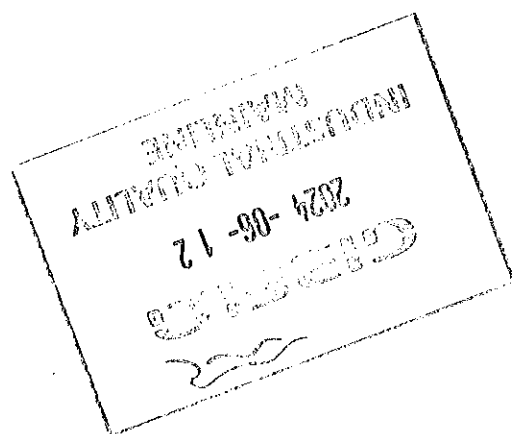
Document	Type of car					Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)	
	T1	T2	T3	T4	T5							
DTR31374497/2						29	28/10/2023	X		N/A	06/06/24	06/06/24


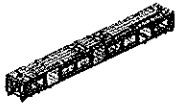
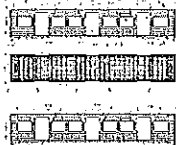
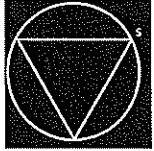
I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process						
Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
Measuring Tape	5587A CBL	17/04/2024 - 17/04/2025	X		06/06/24	06/06/24
Tubular						

I.3 Consumables

Welding Consumable Control - Used for Special Process						
Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
Welding 308LSi	B221880	Mig	X		06/06/24	06/06/24



	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev. 28	Project: PRASA SI.CB2220.276.V29											
		Date 28/10/2023												
II - Self Inspection - Items to Check														
II.1 - Items to check														
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. DTR31374497/2 Verification of fillet for all reinforcement brackets.	PRA CB2220. DTR31374497/2	✓	06/06/24 L. B. B.	06/06/24 M. K.								
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	06/06/24 L. B. B.	06/06/24 M. K.								
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	06/06/24 L. B. B.	06/06/24 M. K.								
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	06/06/24 L. B. B.	06/06/24 M. K.								
05		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓	06/06/24 L. B. B.	06/06/24 M. K.								
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.	✓	06/06/24 L. B. B.	06/06/24 M. K.								
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 <table border="1" style="font-size: small;"> <tr> <td colspan="2">Specified</td> </tr> <tr> <td>Temperature Min - Max (°C)</td> <td>10°C - 35°C</td> </tr> <tr> <td>Relative humidity Max (%)</td> <td>25%</td> </tr> <tr> <td>Max (g)</td> <td>60%</td> </tr> </table>	Specified		Temperature Min - Max (°C)	10°C - 35°C	Relative humidity Max (%)	25%	Max (g)	60%	Sealant Batch No: B3412/03/4 Exp Date: 15/06/24 Actuals Temperature: 23°C Humidity: 50%	✓	06/06/24 L. B. B.	06/06/24 M. K.
Specified														
Temperature Min - Max (°C)	10°C - 35°C													
Relative humidity Max (%)	25%													
Max (g)	60%													
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001613329	✓	06/06/24 L. B. B.	06/06/24 M. K.								



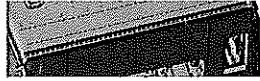
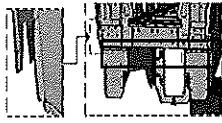
CARBODYSHELL M2 ASSEMBLY DTR31374497/2

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SEALANT APPLICATION



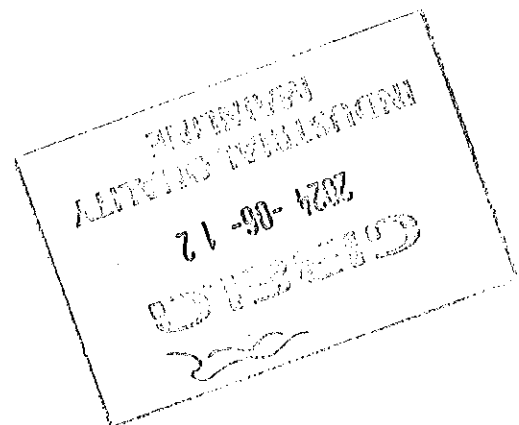
AREA 1 & 2 END 1


Operator (Name & sign):

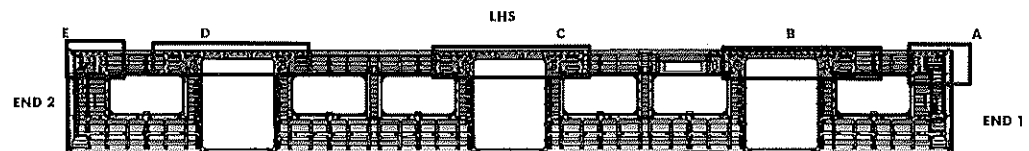
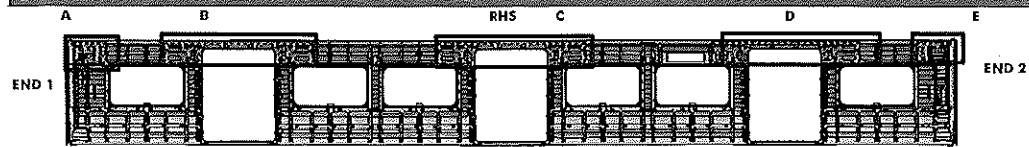
Priscilla
Coir

Operator (Name & sign):





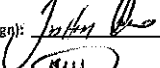

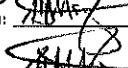
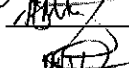
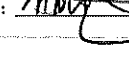
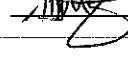
Priscilla
Coir

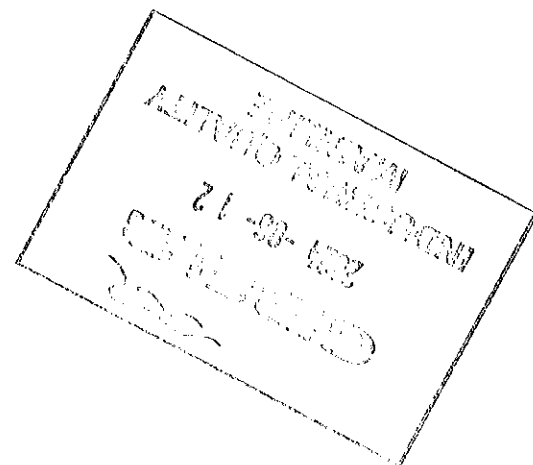


	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev. 29	Project PRASA SI.CB2220.276.V29
		Date 28/10/2023	
	II - Self Inspection - Items to Check		

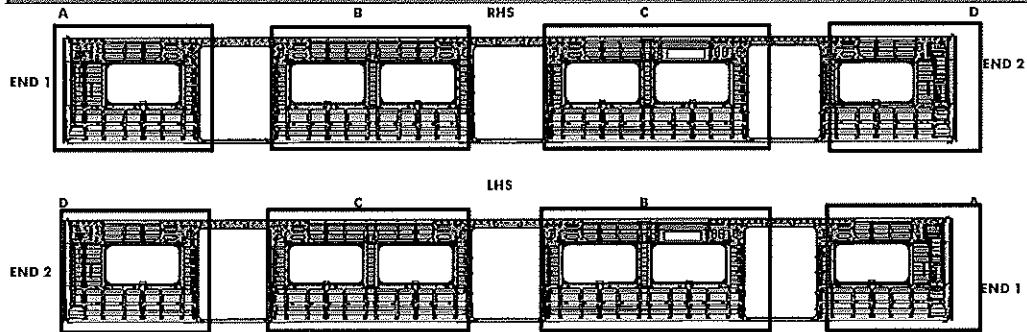


REINFORCEMENT WELDING

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



	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA
		29	
		Date	SI.CB2220.276.V29
		28/10/2023	
II - Self Inspection - Items to Check			

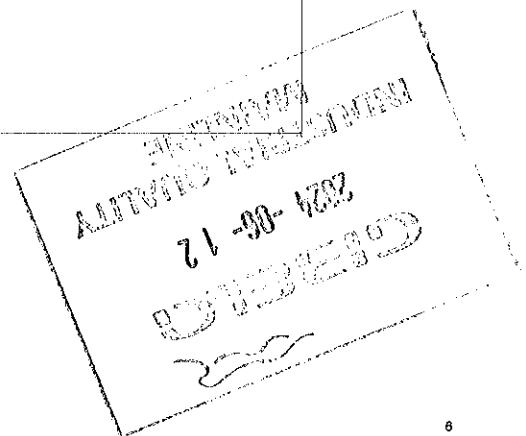



BRACKETING

INSTALLATION	
C-RAILS:	Operator: <u>Priscilla</u>
	Operator: _____
DOOR MECHANISMS:	Operator: <u>Tetelo</u>
	Operator: _____
TAPPING PADS	Operator: <u>Levi</u>
	Operator: <u>Tetelo</u>
INSTALLATION & VERIFICATION	
SEAT & LUGGAGE BRACKETS:	Operator: _____
	Operator: _____
SEAT BRACKETS VERIFICATION:	Operator: <u>Levi</u>
	Operator: _____

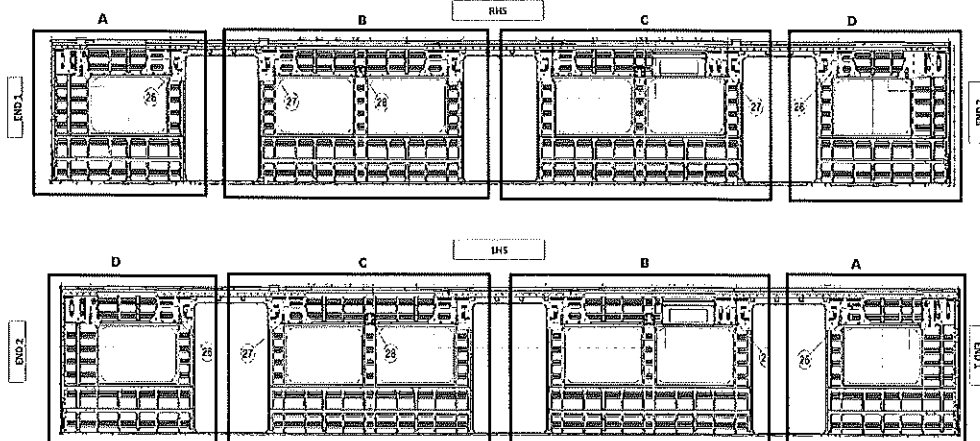
WELDING

AREA	LHS	RHS
A (Seat brackets)	: Operator (Name&sign): <u>Nkulungwa</u>	<u>Nkulungwa</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Nkulungwa</u>	<u>S. M. M. M.</u>
B (Seat brackets)	: Operator (Name&sign): <u>Musoke</u>	<u>S. M. M. M.</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Musoke</u>	<u>K. M. M. M.</u>
C (Seat brackets)	: Operator (Name&sign): <u>K. M. M. M.</u>	<u>THULANI</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Musoke</u>	<u>K. M. M. M.</u>
D (Seat brackets)	: Operator (Name&sign): <u>S. M. M. M.</u>	<u>S. M. M. M.</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>S. M. M. M.</u>	<u>THULANI</u>
ENDS		
END 1 TAPPING PADS WELDING:	Operator (Name&sign): <u>S. M. M. M.</u>	
END 1 TAPPING PADS WELDING:	Operator (Name&sign): <u>THULANI</u>	



	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev. 29	Project: PRASA SI.CB2220.276.V29
		Date 28/10/2023	

M2 BRACKET INSTALLATION



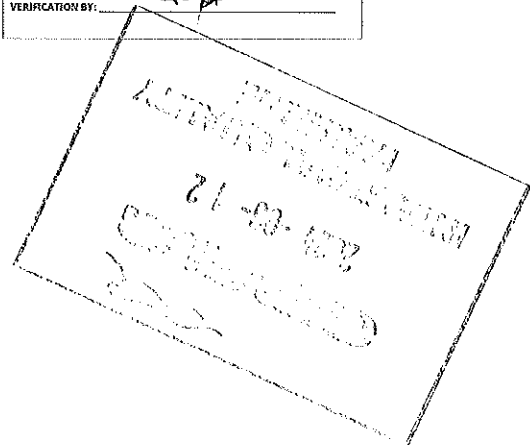
QUANTITIES (M2)

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

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

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

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



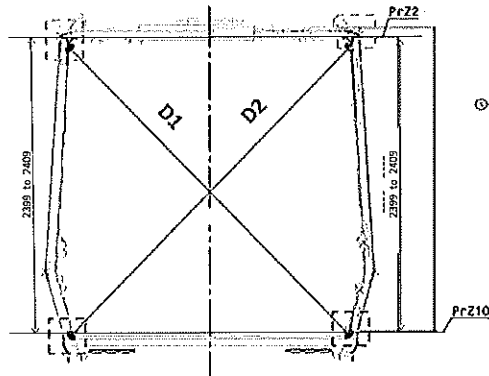


CARBODYSHELL M2 ASSEMBLY DTR31374497/2

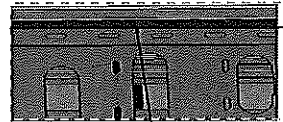
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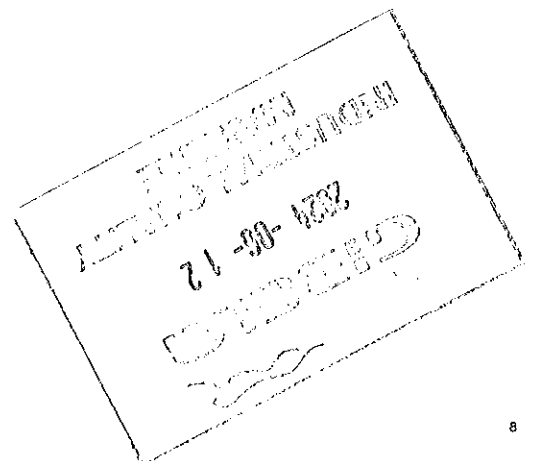
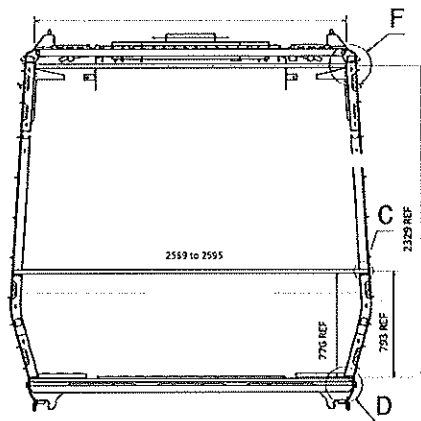
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



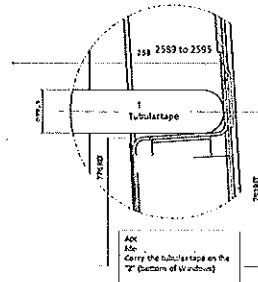
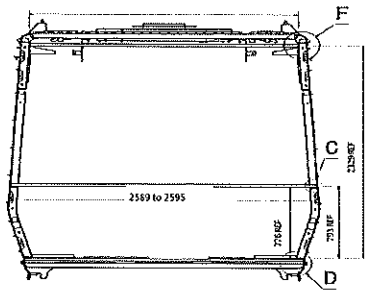


CARBODYSHELL M2 ASSEMBLY DTR31374497/2

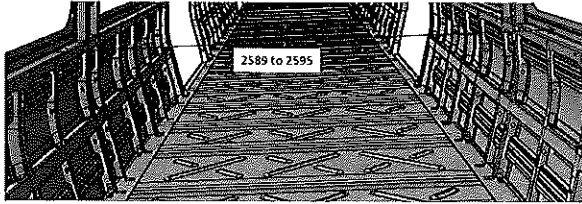
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28/10/2023

Project: PRASA

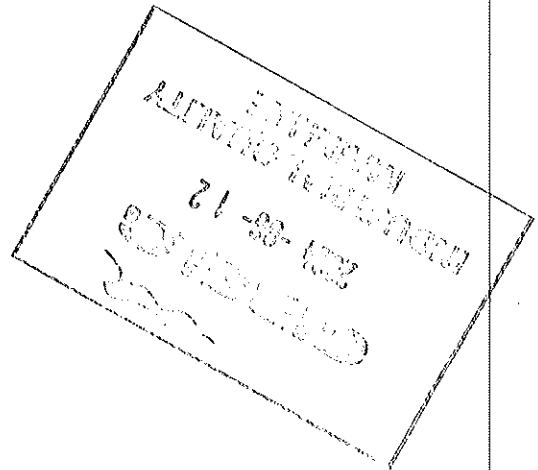
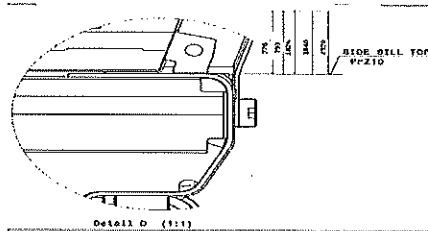
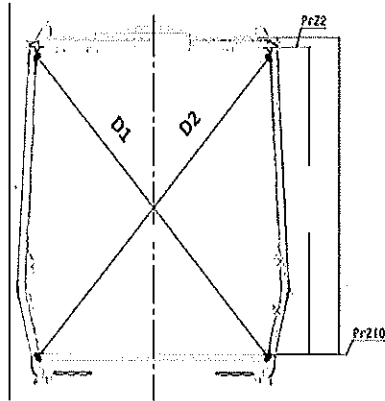
SI.CB2220.276.V29




Detail C

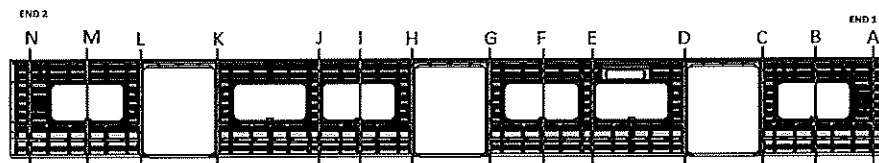


Take measurement close to
radius



	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB2220.276.V29
		29	
		Date	
		28/10/2023	


CBS measurement



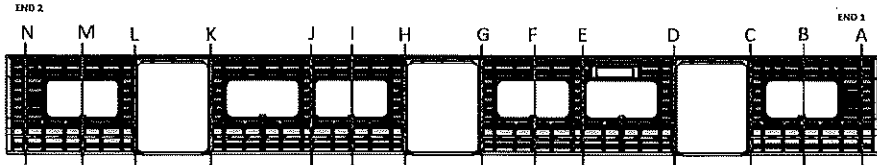
BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3298	3292	3	-
B	3265	3261	3	-
C	3296	3294	2	-
D	3299	3294	5	-
E	3264	3263	1	-
F	3261	3263	2	-
G	3294	3291	3	-
H	3294	3294	0	-
I	3264	3264	0	-
J	3264	3266	2	-
K	3295	3293	2	-
L	3293	3298	0	-
M	3265	3265	0	-
N	3293	3291	2	-

21-08-2022
 12:13:00
 21-08-2022
 12:13:00

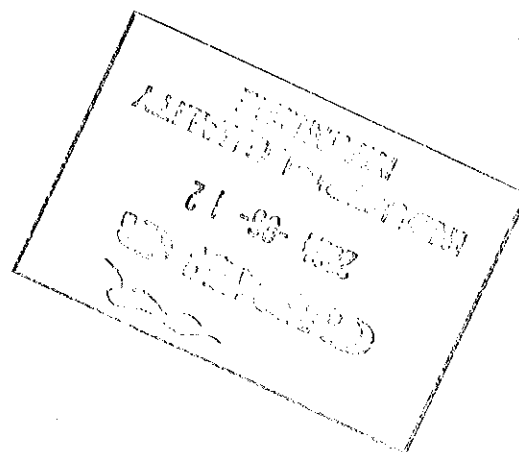
	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB2220.276.V29
		26	
		Date	
		28/10/2023	

CBS measurement

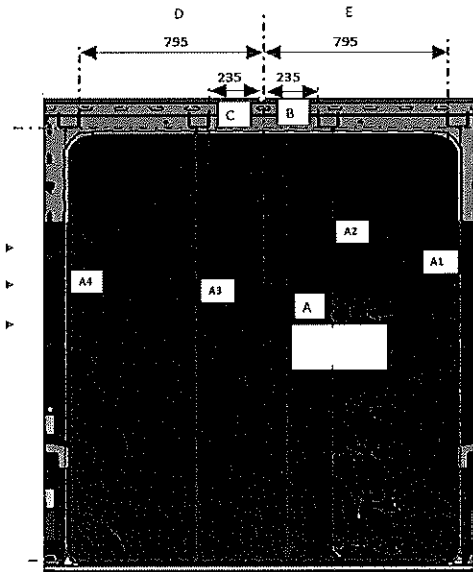


AFTER WELDING

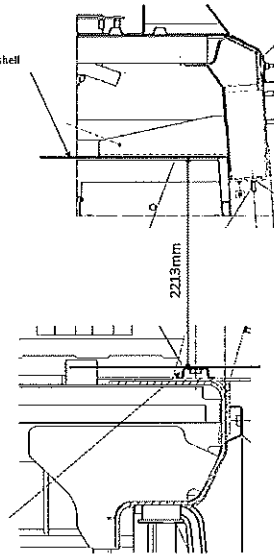
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3295	3298	2	2593
B	3263	3262	1	2593
C	3296	3295	5	2590
D	3300	3298	2	2589
E	3265	3262	3	2594
F	3265	3262	3	2595
G	3295	3294	1	2593
H	3292	3295	3	2594
I	3265	3264	1	2595
J	3264	3266	2	2595
K	3295	3297	2	2590
L	3293	3293	2	2593
M	3265	3264	1	2591
N	3292	3291	1	2590



Specifications of Details for CBS measurement CB1220



Brackets Carbodyshell
U Type Supports

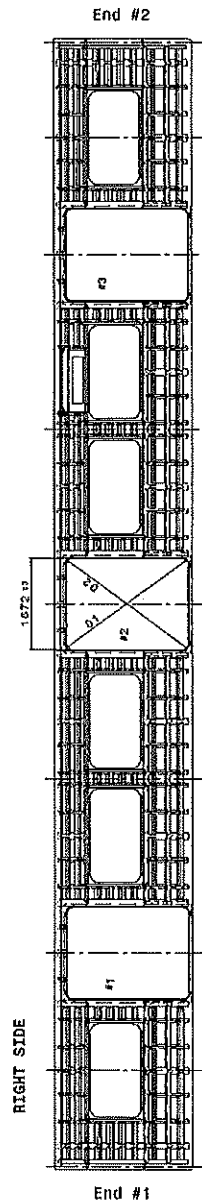


DOOR 1 - LHS			DOOR 2 - LHS			DOOR 3 - LHS		
	VALUE	ACTUAL		VALUE	ACTUAL		VALUE	ACTUAL
A1	2230 to 2232	2231	A1	2230 to 2232	2232	A1	2230 to 2232	2230
A2	2230 to 2232	2232	A2	2230 to 2232	2231	A2	2230 to 2232	2231
A3	2230 to 2232	2231	A3	2230 to 2232	2232	A3	2230 to 2232	2230
A4	2230 to 2232	2231	A4	2230 to 2232	2231	A4	2230 to 2232	2231
B	234 to 236	235	B	234 to 236	235	B	234 to 236	234
C	234 to 236	235	C	234 to 236	235	C	234 to 236	235
D	794 to 796	795	D	794 to 796	795	D	794 to 796	795
E	794 to 796	795	E	794 to 796	795	E	794 to 796	795

DOOR 1 - RHS			DOOR 2 - RHS			DOOR 3 - RHS		
	VALUE	ACTUAL		VALUE	ACTUAL		VALUE	ACTUAL
A1	2230 to 2232	2230	A1	2230 to 2232	2231	A1	2230 to 2232	2231
A2	2230 to 2232	2231	A2	2230 to 2232	2230	A2	2230 to 2232	2231
A3	2230 to 2232	2230	A3	2230 to 2232	2231	A3	2230 to 2232	2230
A4	2230 to 2232	2231	A4	2230 to 2232	2231	A4	2230 to 2232	2230
B	234 to 236	235	B	234 to 236	235	B	234 to 236	235
C	234 to 236	235	C	234 to 236	235	C	234 to 236	234
D	794 to 796	795	D	794 to 796	795	D	794 to 796	794
E	794 to 796	795	E	794 to 796	795	E	794 to 796	796

21-08-2023
21-08-2023
21-08-2023

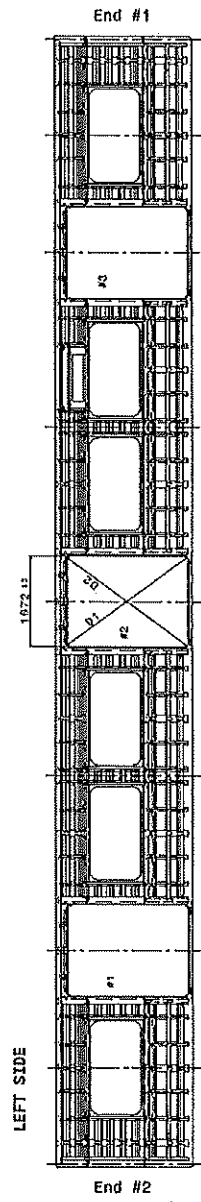
Specifications of Details for CBS measurement CB1220



Doors diagonal D1-D2 maximum difference ≤4mm

	#1	#2	#3
D1	2147	2149	2149
D2	2149	2149	2148
D1-D2	2	2	1

Doors Length - 1672 ±3mm			
	#1	#2	#3
HIGHER DIMENSION	1671	1672	1672
CENTRAL DIMENSION	1672	1672	1672
LOWER DIMENSION	1671	1671	1671

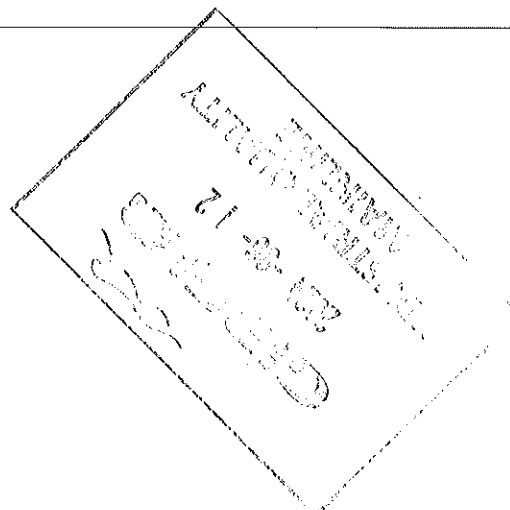



4mm


	#1	#2	#3
D1	2149	2148	2141
D2	2147	2146	2148
D1-D2	2	2	1

Vão de Portas - 1672 ±3mm

DIMENSÃO SUPERIOR HIGHER DIMENSION			
	#1	#2	#3
	1671	1672	1671
CENTRAL DIMENSION			
	#1	#2	#3
	1672	1671	1672
LOWER DIMENSION			
	#1	#2	#3
	1671	1672	1671




	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA		
		20			
		Date	SI.CB2220.276.V29		
		28/10/2023			

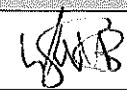

CBS measurement (Manufacturing)				
Dye penetrant test				
Dye-penetration test to be performed by quality personnel				
				

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

B.2 - Check List REX							
Check List Items							
Item	Picture/Drawing	Description	Critical Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)	
01	N/A	To complete REX	Refer to REX. New defects must be added on it's REX				

RECEIVED
21-08-2023
GIBELQ

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev. 20	Project: PRASA SI.CB2220.276.V29	
		Date 28/10/2023		
		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)		06/06/24	Lena Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party		06/06/24	Edmond Industrial Quality	
		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				

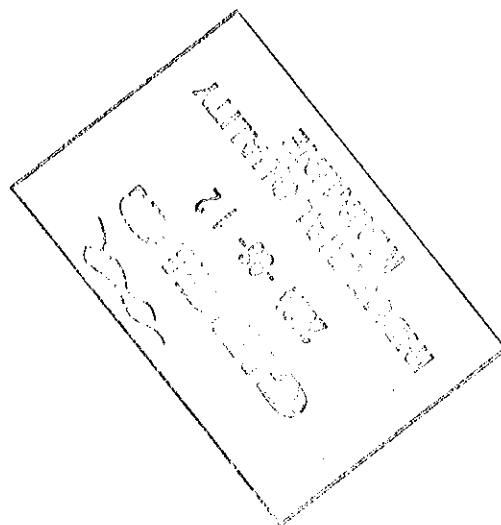
In case of "NO GO", describe blocking problems


In case of "NO GO", the operations manager must define below action plan to ensure "GO":

Item	Description	Responsible	Due date	Status

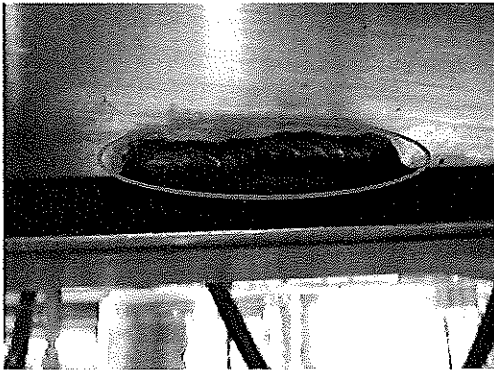
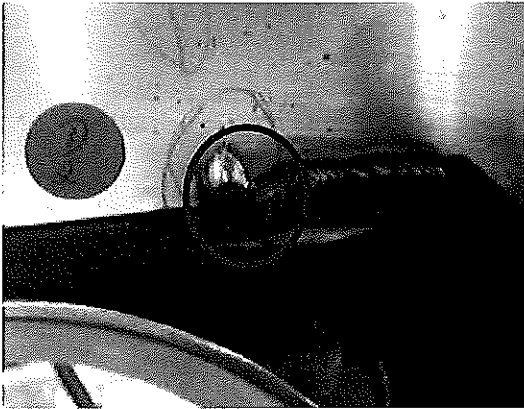
Operations

Quality



	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB2220.276.V29
		29	
		Date	
		28/10/2023	

ANNEXURE A: Arc Welding Quality Acceptance Standard




APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

CONFIDENTIAL INFORMATION

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

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY? 
				TC1	M1	M2	M3	TC2			
<input type="checkbox"/>	DTR3000152710	AAD0001413329	CARBODYSHELL M2 ASSEMBLY				X			PRA.CB2230.AA000013 74497.V20	YES
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
V	DATE	MODIFICATION CONTENT		RESPONSIBLE	NAME	DATE					
0	2018/08/02	GIBELA NEW CREATION		APPROVER	Philippe Marques	2018/08/02					
				CHECKER	Nosizo Pindela	2018/08/02					
				COMPILER	Nosizo Pindela	2018/08/02					
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager		APPROVER	Itumeleng Modiba	30/5/2018					
				CHECKER	Nosizo Pindela	30/5/2018					
				REVISED BY	Nosizo Pindela	30/5/2018					
2	2018/05/07	Certain dimensional checks moved to CB1220		APPROVER	Itumeleng Modiba	2018/05/07					
				CHECKER	Nosizo Pindela	2018/05/07					
				REVISED BY	Ramokone Motama	2018/05/07					
5	24/01/2019	As per Baseline 10.2		APPROVER	Itumeleng Modiba	24/01/2019					
				CHECKER	Nosizo Pindela	24/01/2019					
				REVISED BY	Vanessa Ntuli	24/01/2019					
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements		APPROVER	Itumeleng Modiba	13/03/2019					
				CHECKER	Nosizo Pindela	13/03/2019					
				REVISED BY	Vanessa Ntuli	13/03/2019					
10	23/03/2019	New Baseline 10.2.5		APPROVER	Itumeleng Modiba	23/08/2019					
				CHECKER	Nosizo Pindela	23/08/2019					
				REVISED BY	Nosizo Pindela	23/08/2019					
15	06/08/2020	New Baseline 10.2.6		APPROVER	Timothy Maimela	06/08/2020					
				CHECKER	Bongane Masina						
				REVISED BY	Bongane Masina						
20	19/04/2021	New Baseline change 10.3		APPROVER	Timothy Maimela	19/04/2021					
				CHECKER	Bongane Masina						
				REVISED BY	Bongane Masina						
25	20/02/2022	New Baseline change 10.3.1		APPROVER	Collins 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 measurement addition		APPROVER	Collins Mbombhni	27/07/2022					
				CHECKER	Andani Muthelo						
				REVISED BY	Andani Muthelo						
28	17/10/2022	Addition of traceability for 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 thresholds traceability for boiler makers and welders		APPROVER	Tyson Ngobeni	06/11/2023					
				CHECKER	Andani Muthelo						
				REVISED BY	Ntokozo Zwane						
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES						
231	1102	Siule 426965	07/11/2023	SI.CB2230.277.V29	11						

	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA SI.CB2230.277.V29	
		Date 06/11/2023		
Car:	NCR:	Work station: CB2230		


Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control







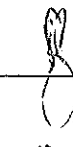
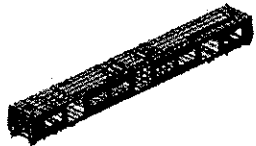


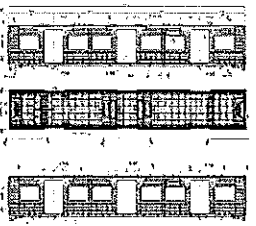


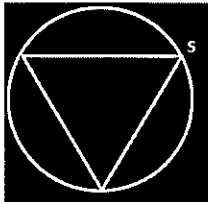






Document	Type of car						Revision	Observation	OK		Signature/Date (Operations)	Signature/Date (Quality)	
	TS	ME	SE	MS	SE	TS							
PRA.CB2230.AA00001374497			X				30		OK		N/A	07/06/24	07/06/24

I.2 - Instruments Control

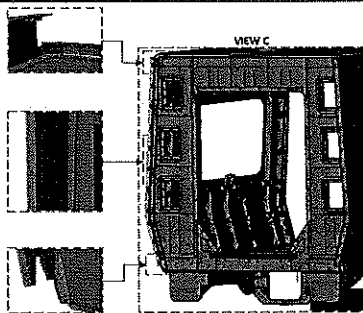
Monitoring and Measuring Instrument Control - Used for Special Process						
Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Operations)	Signature/Date (Quality)
Tubular	22713	20/06/25	OK		07/06/24	07/06/24
Measuring tape	GIB 0794	25/04/25	OK		07/06/24	07/06/24
Combination Square	GIB 0072	27/07/24	OK		07/06/24	07/06/24

1.3 Consumables

Welding Consumable Control - Used for Special Process						
Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSI	180130	Mig welding	OK		07/06/24	07/06/24

		CARBODYSHELL M2 ASSEMBLY AA00001374497		Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.277.V29								
II - Self Inspection - Items to Check													
II.1 - Items to check													
Nº	Picture/Drawing	Description	Acceptance criteria / Record	OK		Signature/Date (Operations)	Signature/Date (Quality)						
01	N/A	Assembly according to Instruction Engineering nº PRA.CB1230.AA00001374497 Verification of fitment for all brackets.	PRA.CB1230.AA00001374497	OK		 07/06/24	 07/06/24						
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	OK		 07/06/24	 07/06/24						
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	OK		 07/06/24	 07/06/24						
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	OK		 07/06/24	 07/06/24						
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	OK		 07/06/24	 07/06/24						
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS 018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	OK		 07/06/24	 07/06/24						
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: <table border="1" data-bbox="422 1758 742 1870"> <tr> <td>Temperature Min - Max (1)</td> <td>Min-Max</td> <td>10°C - 35°C</td> </tr> <tr> <td>Relative humidity Min - Max (1)</td> <td>Min-Max</td> <td>25% - 80%</td> </tr> </table>	Temperature Min - Max (1)	Min-Max	10°C - 35°C	Relative humidity Min - Max (1)	Min-Max	25% - 80%	Sealant Batch No: <u>15270.03</u> Exp Date: <u>06/08/24</u> Actuals Temperature: <u>13,3°C</u> Humidity: <u>54%</u>	OK		 07/06/24	 07/06/24
Temperature Min - Max (1)	Min-Max	10°C - 35°C											
Relative humidity Min - Max (1)	Min-Max	25% - 80%											
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.	OK		 07/06/24	 07/06/24						

II - Self Inspection - Items to Check



VIEW C END 2

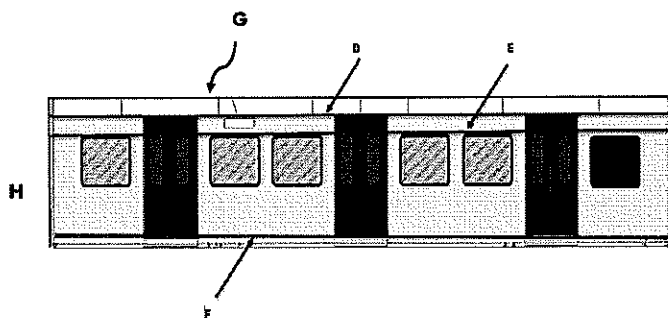
Operator: Zanele

Operator: Zanele



Operator: Zanele

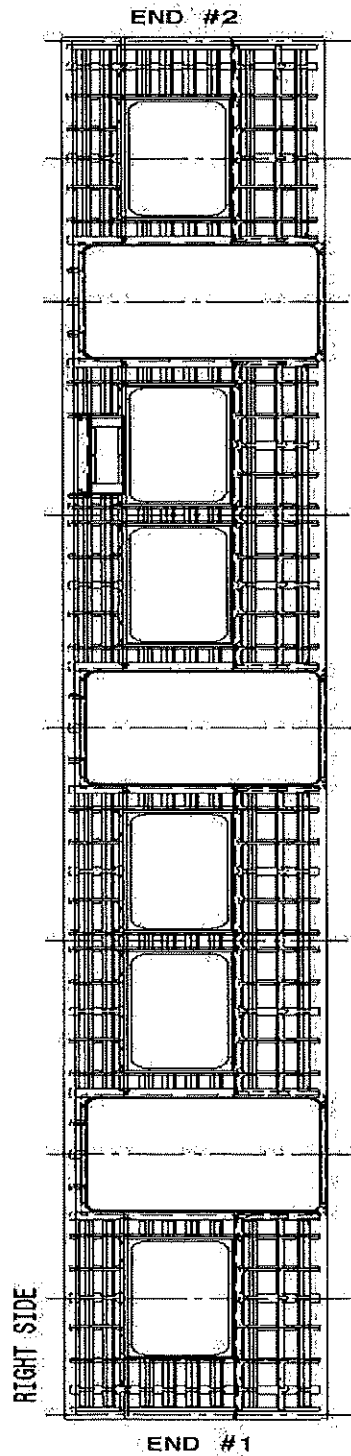
SEALANT APPLICATION



Area D,E,F,G,H,I	LHS	RHS
Operator (Name & sign) :	<u>D.E.G.H.I</u>	<u>D.E.G.H.I</u>
Operator (Name & sign) :	<u>Simle</u>	<u>Simle</u>
Operator (Name & sign) :	<u>Tshenoto</u>	<u>Tshenoto</u>
Operator (Name & sign) :	<u>Knosy</u>	<u>Knosy</u>
Operator (Name & sign) :	_____	_____
Operator (Name & sign) :	_____	_____

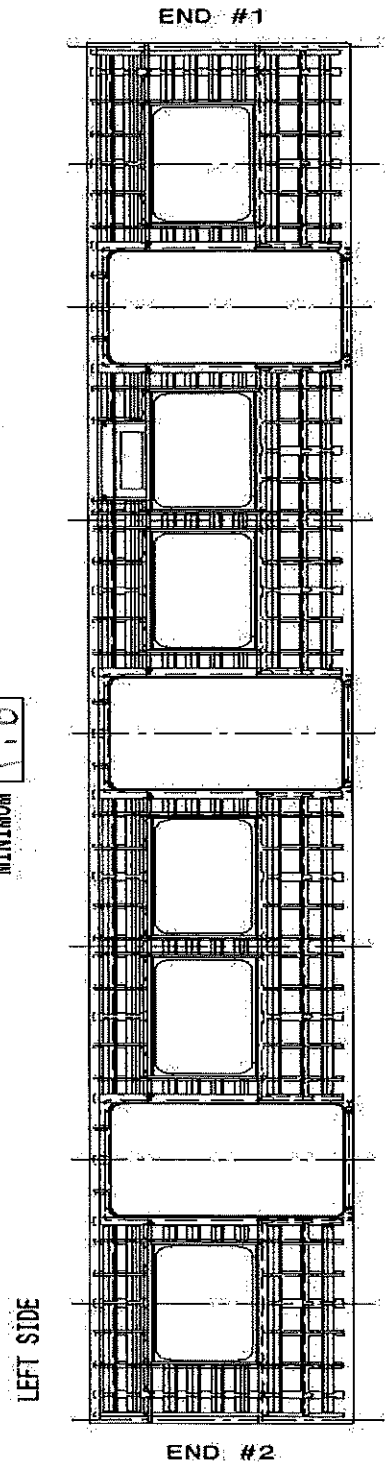
Specifications of Details for CBS measurement CB1230

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.



MAXIMUM 1.9

MINIMUM 1.6

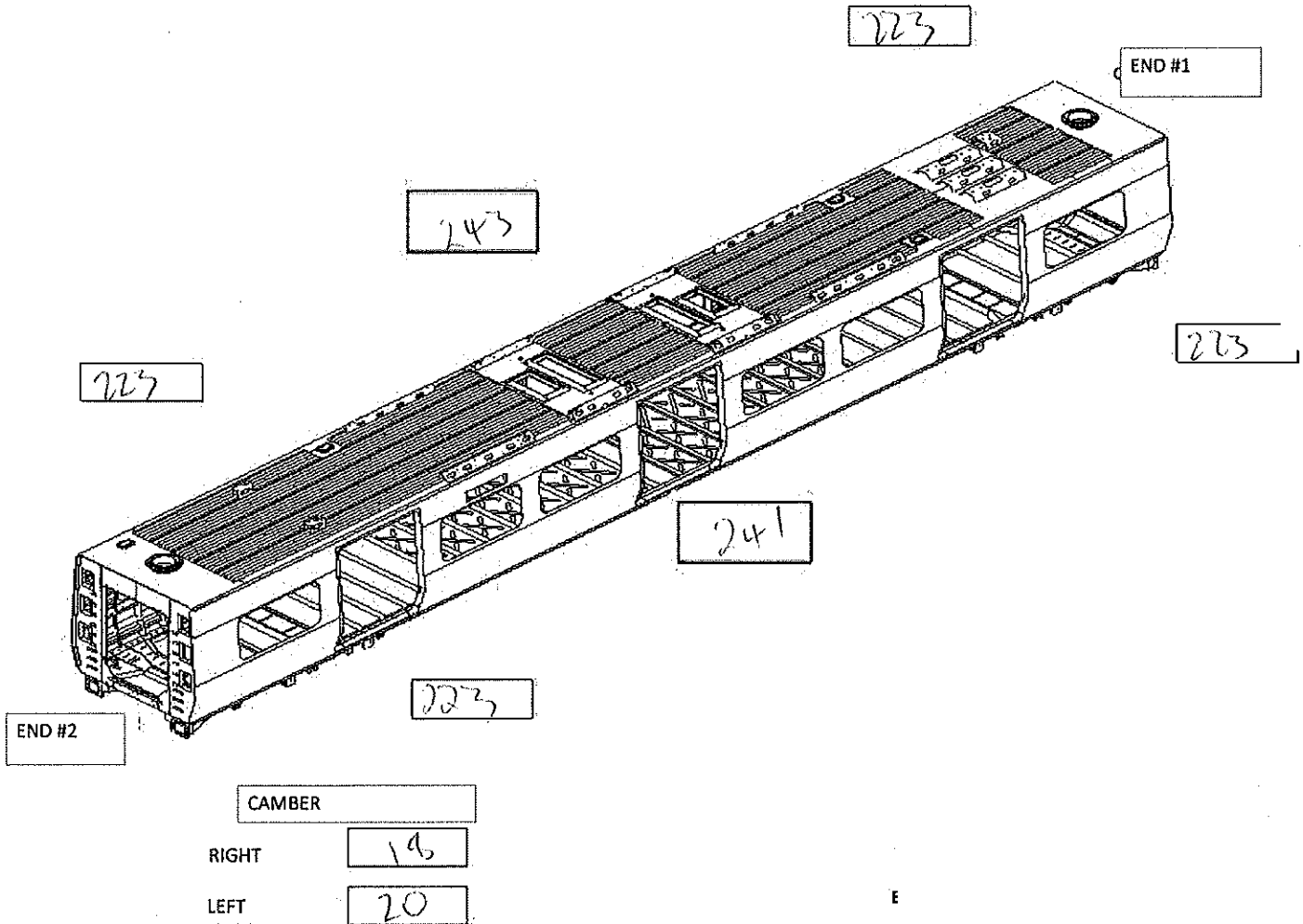


MAXIMUM 1.5

MINIMUM 1.3

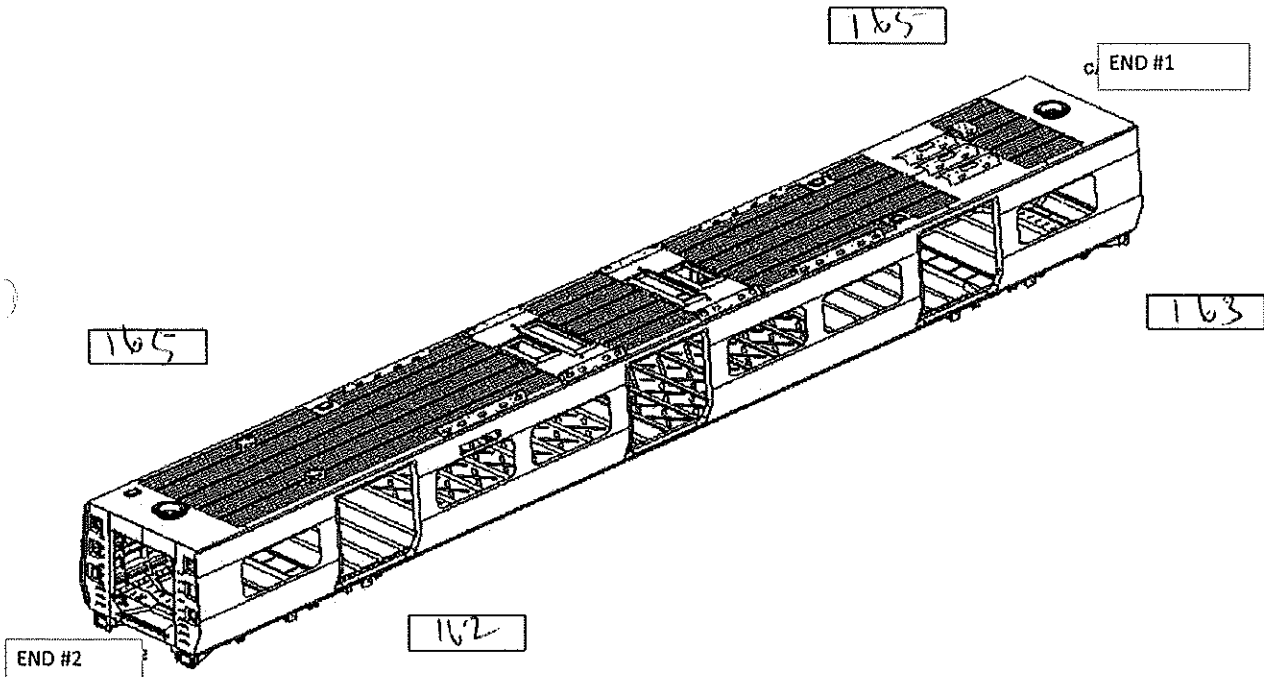
Specifications of Details for CBS measurement CB1230

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



Specifications of Details for CBS measurement CB1230

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



TWIST FOUND ON END 1

TRANVERSE

2

LONGITUDINAL

1

TWIST FOUND ON END 2

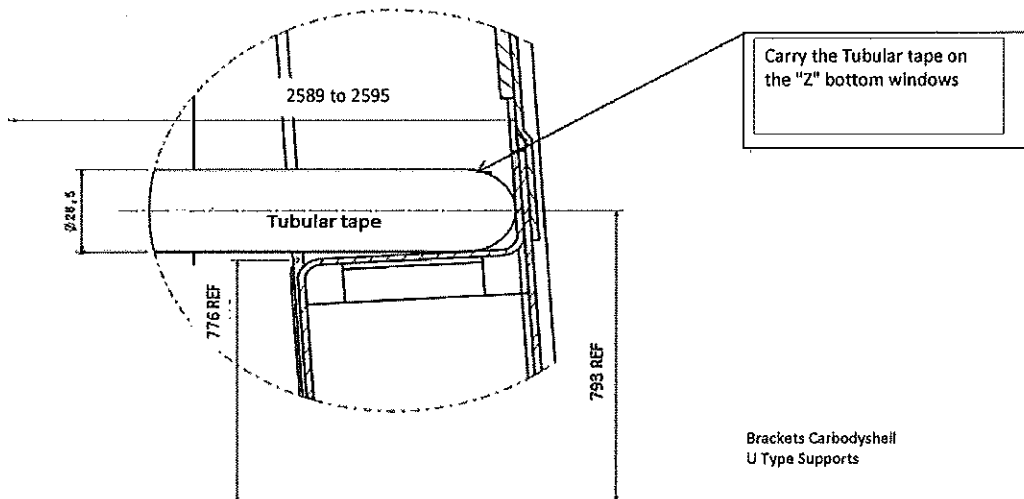
TRANVERSE

3

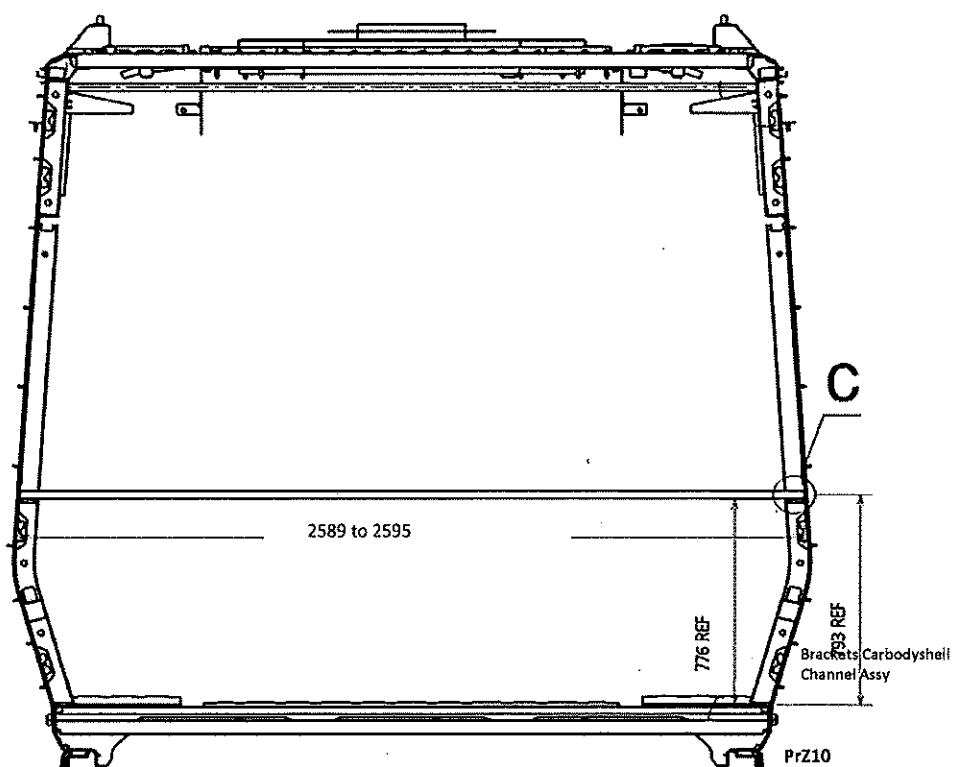
LONGITUDINAL

0

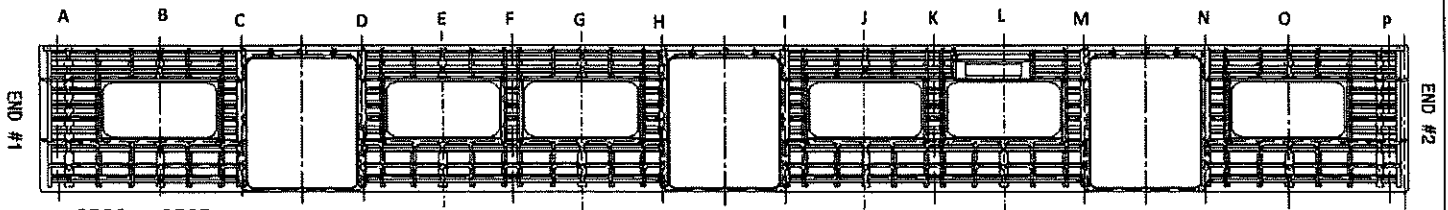
Specifications of Details for CBS measurement CB1230



Detail C

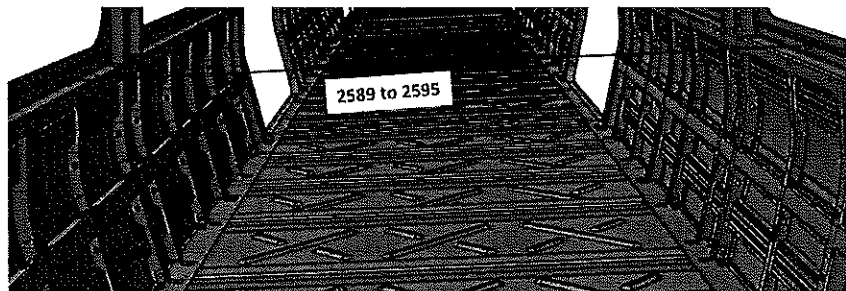


Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	2590
B	2592
C	2593
D	2593
E	2593
F	2590
G	2592
H	2591
I	2590
J	2590
K	2594
L	2593
M	2591
N	2592
O	2592
P	2590



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:

Lerato




X

WELDER:

Inmathapelo

Musa




	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA SI.CB2230.277.V29
		Date 06/11/2023	

Dye penetrant test

Dye-penetration test to be performed by quality personnel





	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA SI.CB2230.277.V29		
		Date 06/11/2023			
Self Inspection - Final Result					
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)		DATE	NAME	SIGNATURE	
HOLD POINT	<input checked="" type="checkbox"/> NO <small>(If activities are not complete, the missing activities must not impact the next stage)</small>	07/06/24	Sime Operations Manager		
		07/06/24	Ntokozo Industrial Quality		
	<input type="checkbox"/> YES	There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)		Operations Manager	
		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

ANNEXURE A: Arc Welding Quality Acceptance Standard

