

## CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 4 7 0 \_  
WEIGHT: 14 88 Kg

# RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	24/05/24	178247 104895 01	F305031	
RCS 355	2 mm				Y1-E99055	
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	24/05/24	183653 107087 01	F207906	
RCS 355	3 mm				VHE 73062	
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegasus	24/05/24	178488 104640 01	P310156	
RCS 355	20 mm				VPL63542	

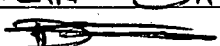
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegasus	26/05/24			
RCS 355	30 mm					

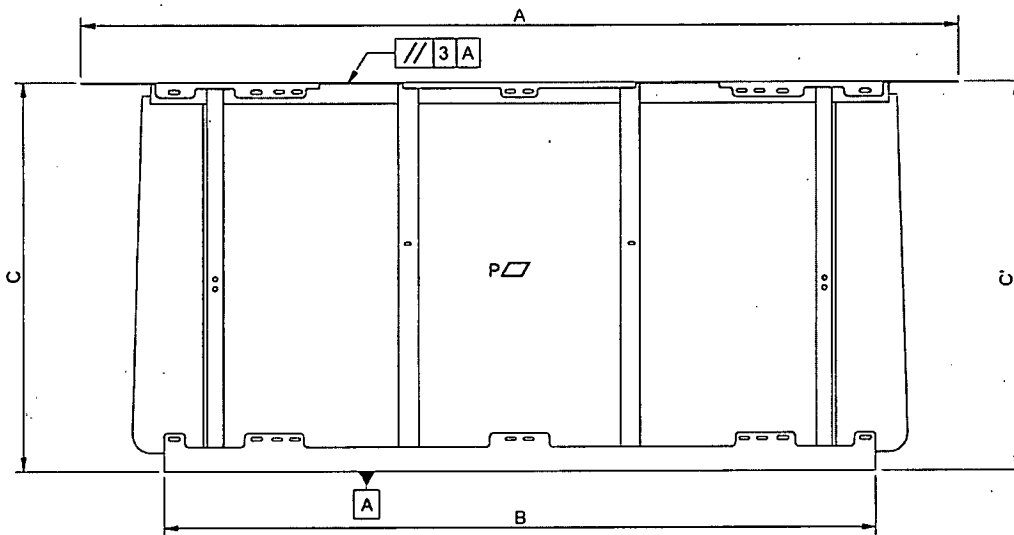
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	24/05/24	182739 107087 01	F207906	
RCS 450	4 mm				VH447403	
RCS 450	4 mm					
RCS 450	4 mm					


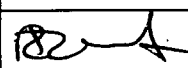

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	24/05/24	183446 107087 01	F207907	
RCS 450	6 mm				VHS6236	
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	24/05/24	188451 107087 01	F305031	
RCS 450	8 mm				VHS62365	
RCS 450	8 mm					
RCS 450	8 mm					

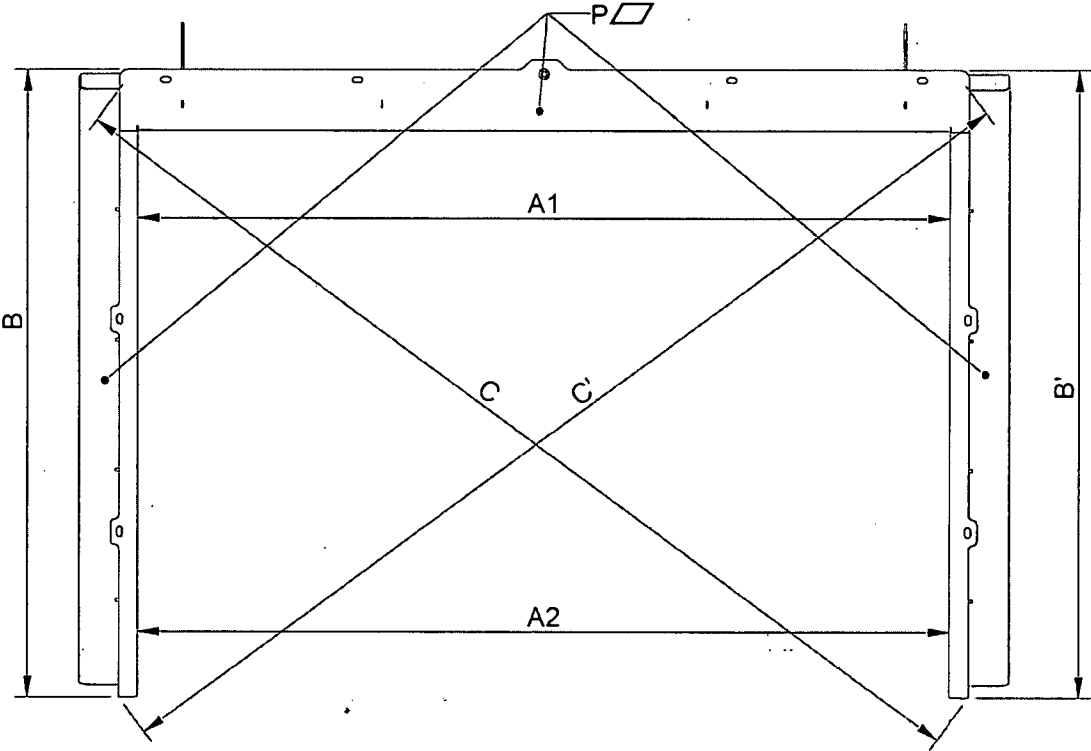
## Cabin Roof Assembly: GN002839

Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	DYLAN DAVIDS	Assembly Date:	20 <u>24</u> / <u>04</u> / <u>22</u>			
Sign:		Wire Batch No.:	107238201			



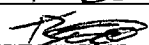
Welding Control							
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042				Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	Riccardo		Sign:			Date:	20__/__/__
Dimensional Control							
Rep		Toler.	Dimension measured		Measuring Equipment	Observations	
A	2216	+5/-0	2216		Tape Measure	acceptable	
B	1800	± 4	1800			acceptable	
C	976	+2/-3	976	976		acceptable	
QC Inspector:	Riccardo		Sign:			Date:	20 <u>24</u> / <u>04</u> / <u>22</u>
Geometrical Control							
Nature of Checks		Dimension Measured		Measuring Equipment		Observations	
Planéité P		6 mm	PASSED		Ruler	acceptable	
//	3	A	PASSED		Set Square	acceptable	
QC Inspector:	Riccardo		Sign:			Date:	20 <u>24</u> / <u>04</u> / <u>22</u>

Cabin Front Frame Assembly: GN002840				
Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	No
Operator:	Bambela Genon	Assembly Date:	2024/04/22	
Sign:	[Signature]	Wire Batch No.:	SS2032	




Welding Control					
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042			Confirmed	Yes	No
QC Inspector:		Sign:		Date:	20__/__/__
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		acceptable
C	Diagonals  C - C'  ≤ 3		2475		2475
QC Inspector:	Riccardo	Sign:	[Signature]	Date:	2024/04/22
Geometrical Control					
Nature of checks		Dimension Measured		Measuring Equipment	Observations
P : Planeity	4 mm	Passed		Ruler	acceptable
QC Inspector:	Riccardo	Sign:	[Signature]	Date:	2024/04/22


**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:	TBDO CL	Assembly Date:	20 <del>24/04/12</del>			
Sign:		Wire Batch No.:	552033			

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

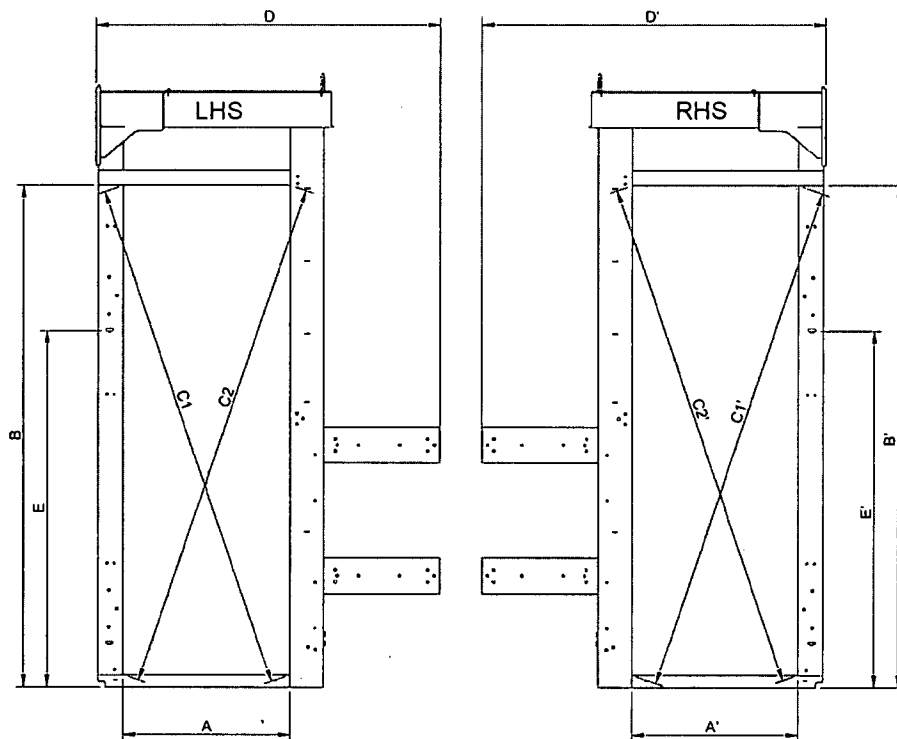
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	20 <del>24/04/12</del>			
Sign:		Wire Batch No.:	552033			

**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:	20 <del>24/04/12</del>			
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:	2024/04/13	
Sign:	<i>[Signature]</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>[Signature]</i>	Date: 2024/04/18

### Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	696	Tape Measure	acceptable
B	2086	+1/-3	2085	2085		acceptable
C1 / C2	Difference of diagonals $ C1 - C2  \leq 3$		2153	2154		acceptable
$ C1 - C2 $			2153	2151		acceptable
D	1438	+2/-3	1438	1438		acceptable
E			1484			

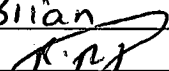
QC Inspector:	Riccardo	Sign:	<i>[Signature]</i>	Date:	2024/04/18
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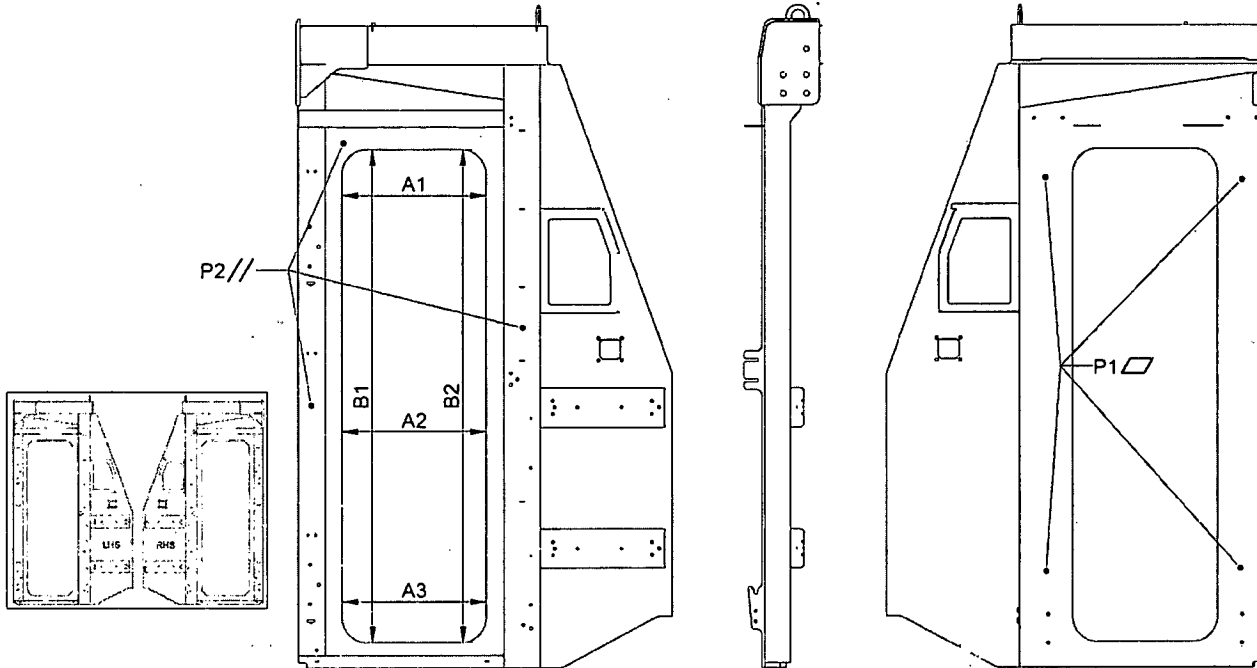
### Geometrical Control




Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	Passed	Ruler	acceptable

QC Inspector:	Riccardo	Sign:	<i>[Signature]</i>	Date:	2024/04/22
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## Cabin LHS/RHS Side Assembly: GN002838/GN002837

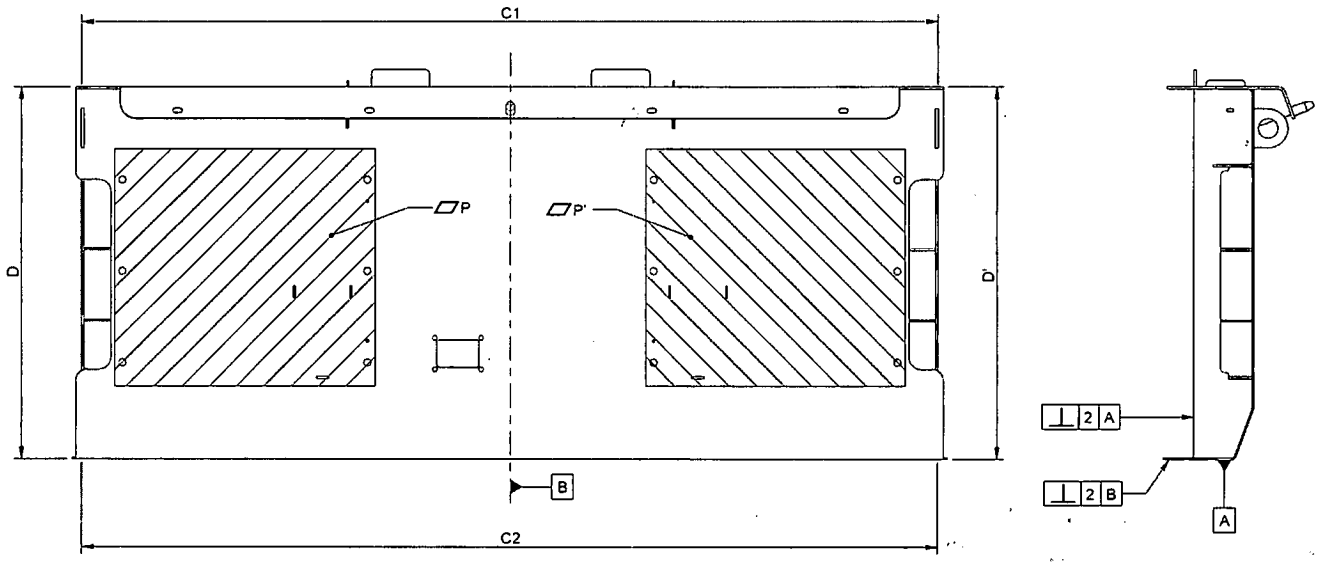
Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Brian	Assembly Date:	20 24/04/23			
Sign:		Wire Batch No.:	552033			

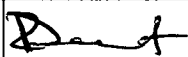
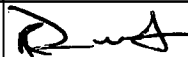
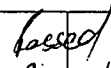
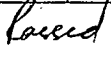



Welding Control						
Assembly Completed as per WI/SOS MD_0044_0045			Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	Riccardo	Sign:		Date:	20 24/04/23	
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	558	559	Tape Measure	acceptable
A2			560	559		acceptable
A3			560	559		acceptable
B1	1900	± 2	1898	1898		acceptable
B2			1898	1898		acceptable
QC Inspector:	Riccardo	Sign:		Date:	20 24/04/23	
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:	20 24/04/23	

## Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Bambelo Giman	Assembly Date:	2024/04/22			
Sign:		Wire Batch No.:	SS 2033			

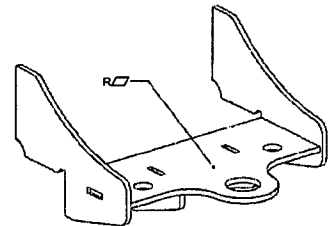
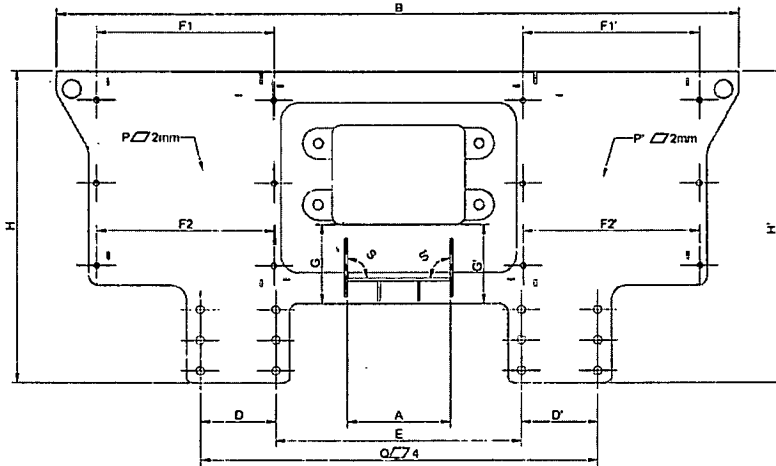


Welding Control							
Assembly Completed as per WI/SOS MD_0043				Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	Riccardo		Sign:			Date:	2024/04/22
Dimensional Control							
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations	
C1 / C2	2210	± 4	2213	2213	Tape Measure	acceptable	
D / D'	956	± 2	955	955		acceptable	
QC Inspector:	Riccardo		Sign:			Date:	2024/04/22
Geometrical Control							
Nature of Checks			Dimension Measured		Measuring Equipment	Observations	
Planeity P / P'		2 mm			Ruler		
Perpendicularity		2	A		Set Square	Acceptable	
		2	B		Set Square	Acceptable	
QC Inspector:			Sign:			Date:	2024/04/22



## Cabin Front Headstock Assembly: GN002841

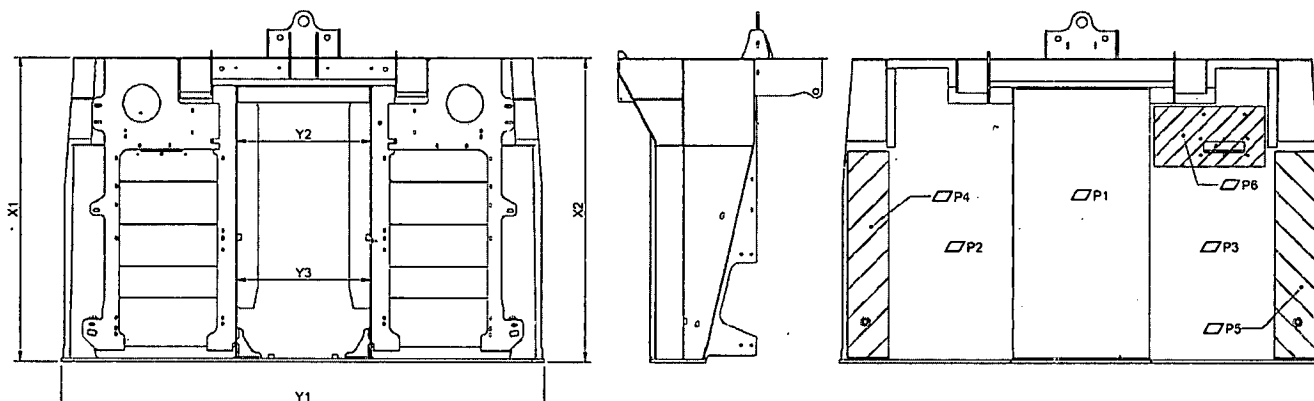
Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	TK Booken	Assembly Date:	2024/04/16	
Sign:		Wire Batch No.:	552033	



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:		Date:	2024/04/17
Dimensional Control					
Rep	Theoretical Dim	Toler.	Dimension Measured		Observations
A	340	± 1	539		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	259	259	acceptable
H / H'	1019	± 2	1020	1020	acceptable
QC Inspector:	Riccardo	Sign:		Date:	2024/04/17
Geometrical Control					
Nature of checks		Dimension Measured	Measuring Equipment		Observations
O: Planeity of global assembly	4 mm	Passed	Ruler		acceptable
P / P': Planeity	2 mm	Passed	Ruler		acceptable
Q: Planeity Surface of Supports	4 mm	Passed	Ruler		acceptable
R: Planeity Coupler Support	2 mm	Passed	Ruler		acceptable
S: Perpendicularity coupler	1mm	Passed	Square		acceptable
QC Inspector:	Riccardo	Sign:		Date:	2024/04/17

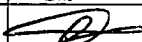
## Cabin Underframe Assembly: GN002835

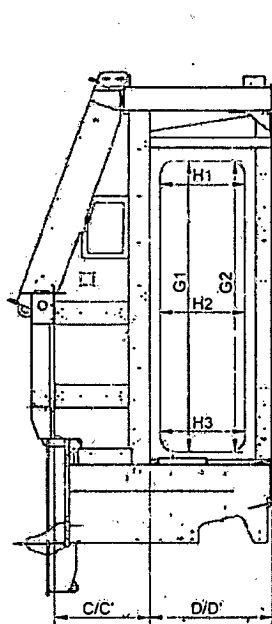
Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	20 <u>24/04/20</u>	
Sign:	<i>[Signature]</i>	Wire Batch No.:	<u>2202162</u>	



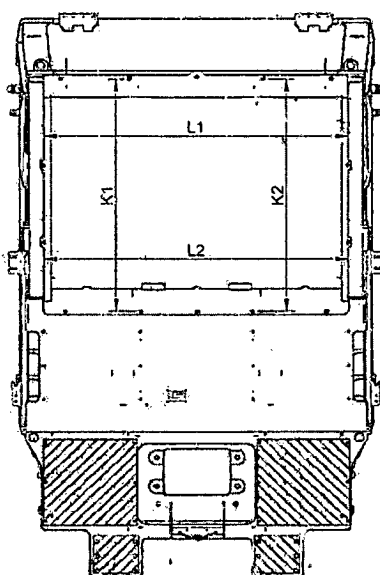
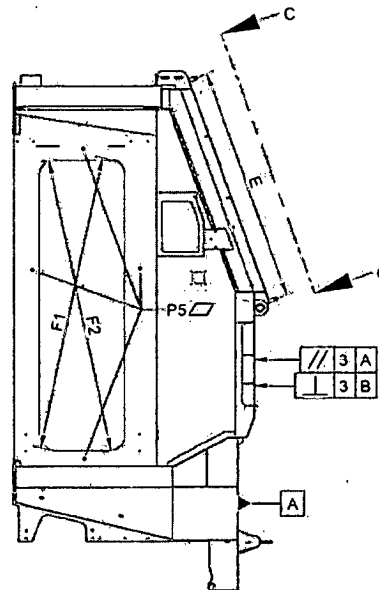
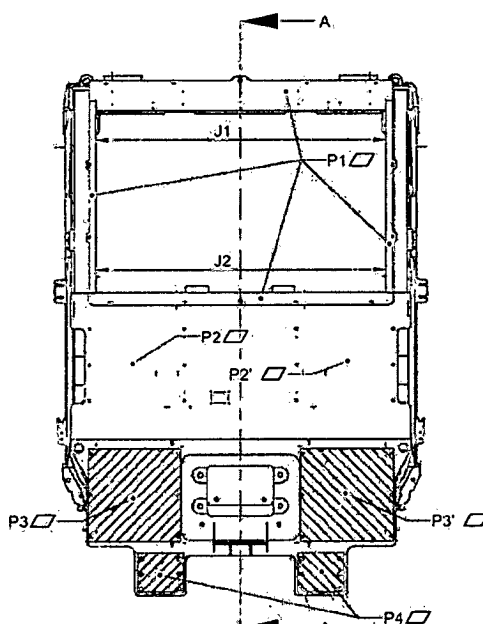
Welding Control					
Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No	
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	<u>2024/04/20</u>
Dimensional Control					
Rep	Theoretical Dim	Toler.	Dimension Measured		Observations
X1 / X2	1485	+5 / -2	<u>1486</u>	<u>1468</u>	Tape Measure <i>acceptable</i> <i>acceptable</i> <i>acceptable</i>
Y 1	2354	± 3	<u>2351</u>		
Y2 / Y3	666	± 1	<u>666</u>	<u>666</u>	
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	<u>2024/04/20</u>
Geometrical Control					
Nature of checks		Dimension Measured		Measuring Equipment	Observations
P1 : Planeity		4 mm	<u>Passed</u>	Ruler	<i>acceptable</i>
P2 / P3 : Planeity		4 mm	<u>Passed</u>	Ruler	<i>acceptable</i>
P4 / P5 : Planeity		2 mm	<u>Passed</u>	Ruler	<i>acceptable</i>
P6 : Planeity		2 mm	<u>Passed</u>	Ruler	<i>acceptable</i>
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	<u>2024/04/20</u>

# Cabin Structure Assembly: GN002834

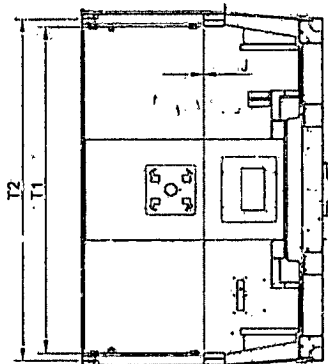
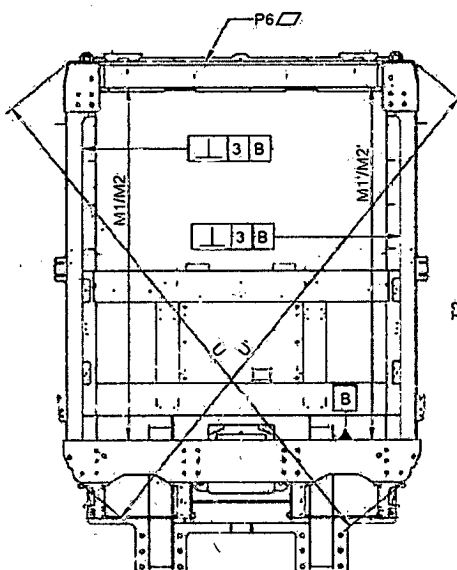
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:	CHARL BLOEM	Assembly Date:	20 24/04/20		
Sign:		Wire Batch No.:	552053		



SECTION A-A



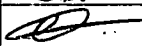
AUX VIEW: C



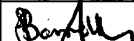
SECTION B-B

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:		Leon		Sign:		A		Date:	2024/04/27
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	627	628	Acceptable				
D / D'	813	± 2,5	812	812	Acceptable				
E	1531.5	± 3	1530		Acceptable				
G1 / G'1	Height 1900	+1	1897	1897	Acceptable				
G2 / G'2		-3	1898	1899	Acceptable				
H1 / H'1	Width 560	+1	557	557	Acceptable				
H2 / H'2		-3	558	558	Acceptable				
H3 / H'3			560	558	Acceptable				
F1 / F'1	Diagonals 1939		1987	1938	Acceptable				
F2 / F'2			1987	1936	Acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	0	2	Acceptable				
J	Gap of Doors	± 1,5	0		Acceptable				
K1 / K2	1515	± 3	1515	1513	Acceptable				
L1 / L2	1996	± 3	1997.5	1995	Acceptable				
M1 / M'1	2306	± 3	2461	2461	Acceptable				
M2 / M'2			2471	2471	Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2128	2128	Acceptable				
T2 / T'2	2230 Top/Bottom		2230	2231	Acceptable				
Difference	U - U' (3522)	≤ 4mm	3518	3518	Acceptable				
QC Inspector:		Leon		Sign:		A		Date:	2024/04/27
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:		Leon		Sign:		A		Date:	2024/04/27

### Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL ELLER	Assembly Date:	20 __ / __ / __			
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:	SELWYN	Assembly Date:	20 24 / 04 / 27			
Sign:		Wire Batch No.:				

Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Fasteners positioned in all Rivnuts and Bosses	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Masked as per GMS-SOS-GIBELA-CABIN-001	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Johnson	Sign:			
Date:	2024/05/17				
Record of Shot Blasting					
Operator:	Johnson	Date:	2024/05/17		
Start Time:	11:00 am	End Time:	12:00 pm		
Temperature ( $\geq 15^\circ$ ):	29.9 $^\circ$ C	Humidity ( $\leq 75\%$ ):	60-9%		
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:	Johnson	Sign:			
Date:	2024/05/17				
Shot Blasting Cleaning					
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Johnson	Sign:			
Date:	2024/05/17				
Shot Blasting Control					
Temperature $\geq 15^\circ$ :		Humidity $\leq 75\%$ :			
Internal Roughness $3.2 \leq Ra \leq 12.5$	Ra 7,086 Rz 43,680	External Roughness $3.2 \leq Ra \leq 12.5$	Ra 8,822 Rz 51,410		
QC Inspector:	2473	Sign:			
Date:	17/5/24				

Ra 6,817  
 7,086  
 7,121  
 6,993  
 6,105  
 5,690  
 5,227  
 5,057  
 6,386  
 4,484

Rz 37,986  
 43,680  
 40,389  
 43,353  
 38,457  
 33,035  
 35,060  
 30,822  
 35,725  
 31,654

Ra 6,215  
 6,287  
 6,449  
 5,384  
 4,989  
 8,822  
 8,071  
 6,830  
 6,673  
 6,595

Rz 42,067  
 39,876  
 36,406  
 32,187  
 31,955  
 54,410  
 47,671  
 39,971  
 40,305  
 40,102

Record of Priming									
Start Time:		19:00		End Time:		21:00			
Temperature $\geq 15^{\circ}$ :				Humidity $\leq 75\%$ :					
Paint Batch No.:		8016059		Paint Expiry Date:		08/25			
Hardener Batch No.:		7331119		Hardener Expiry Date:		01/11/2024			
Desolvation Start Time:		21:00		Desolvation End Time:		21:15			
Stoving Start Time:		21:15		Stoving End Time:		22:15			
Stoving Temp:		60°C							
Operator:		Ntuthuko		Sign:		Ntuthuko			
Date:		20/24/2017							
Priming Control									
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front			
1: 61.6	5: 46.4	1: 52.5	5: 77.1	1: 46.2	5: 46.2	1: 49.6	5: 87.7		
2: 68.8	6: 81.0	2: 52.5	6: 57.4	2: 83.4	6: 47.0	2: 49.1	6: 68.2		
3: 44.2	7: 80.4	3: 65.6	7: 52.9	3: 57.0	7: 83.4	3: 48.2	7: 68.2		
4: 50.6	8: 68.6	4: 12.1	8: 82.4	4: 47.5	8: 47.5	4: 71.9	8: 68.2		
Min:	44.2	Min:	52.5	Min:	46.2	Min:	48.2		
Max:	80.4	Max:	82.4	Max:	83.4	Max:	87.7		
Average:	58.9	Average:	64.0	Average:	57.2	Average:	68.8		
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside			
1: 53.9	5: 66.1	1: 73.6	5: 71.4	1: 52.3	5: 83.3	1: 47.2	5: 45.4		
2: 76.4	6: 70.6	2: 47.0	6: 52.2	2: 72.1	6: 69.9	2: 57.0	6: 51.5		
3: 77.1	7: 79.3	3: 47.6	7: 47.6	3: 89.5	7: 82.8	3: 56.3	7: 62.7		
4: 89.7	8: 71.5	4: 66.6	8: 73.6	4: 77.0	8: 57.2	4: 82.6	8: 50.5		
Min:	53.9	Min:	47.0	Min:	52.3	Min:	45.4		
Max:	89.7	Max:	73.6	Max:	89.5	Max:	82.6		
Average:	72.9	Average:	57.3	Average:	73.0	Average:	55.3		
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS			
1: 78.1	5: 68.7	1: 62.7	5: 60.6	1: 63.2	5: 81.4	1: 62.5	5: 49.0		
2: 35.7	6: 100	2: 73.9	6: 60.2	2: 68.3	6: 72.5	2: 82.6	6: 66.4		
3: 92.9	7: 72.7	3: 51.4	7: 75.9	3: 71.8	7: 100	3: 66.0	7: 70.2		
4: 92.8	8: 68.0	4: 61.6	8: 70.1	4: 62.5	8: 64.9	4: 80.2	8: 47.2		
Min:	35.7	Min:	51.4	Min:	62.5	Min:	47.2		
Max:	100	Max:	75.9	Max:	109	Max:	82.6		
Average:	76.1	Average:	64.1	Average:	74.2	Average:	66.2		
Primer has been inspected and is free of defects				Confirmed		Yes		No	
QC Inspector:		Zothile		Sign:		Hou			
Date:		21 May 2014							

Record of Painting NCSS3010 R90B				
Start Time:	09:00		End Time:	10:00
Temperature $\geq 15^{\circ}$ :			Humidity $\leq 75\%$ :	
Paint Batch No.:	8216294		Paint Expiry Date:	04-04-23
Hardener Batch No.:	8187506 024		Hardener Expiry Date:	02-27
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:	musa		Sign:	musa
Date:	2024/03/25			
Painting NCSS3010 R90B Control				
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)
1: 117	5: 121	1: 982	5: 124	
2: 142	6: 124	2: 104	6: 137	
3: 138	7: 119	3: 889	7: 100	
4: 120	8: 106	4: 118	8: 128	
Min:	106	Min:	889	
Max:	142	Max:	137	
Average:	124	Average:	111	
Painting NCSS3010 R90B has been inspected and is free of defects		Confirmed	Yes	
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	33.8	
QC Inspector:	Zotwile		Sign:	Hou
Date:	26 June 2024			



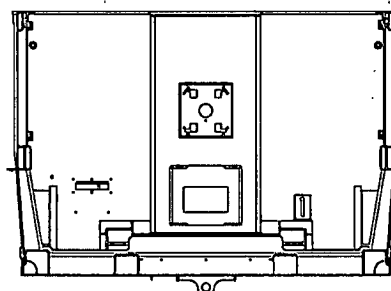
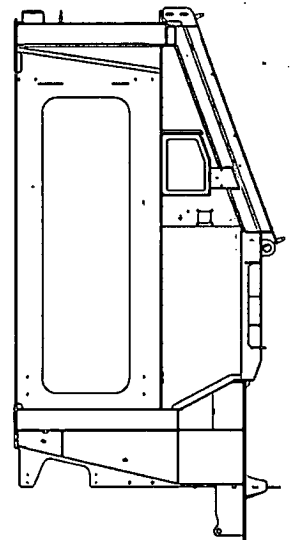
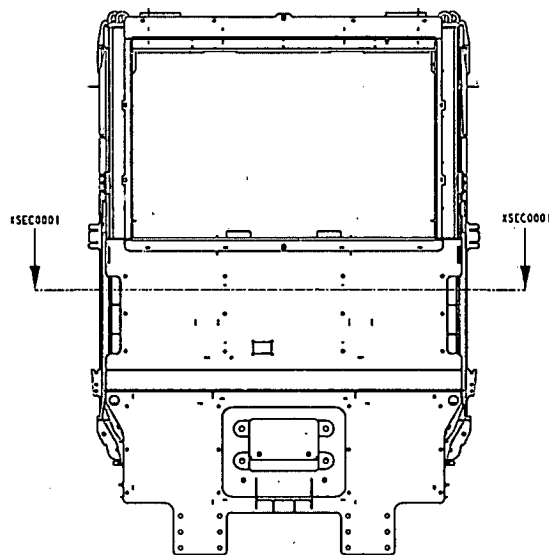
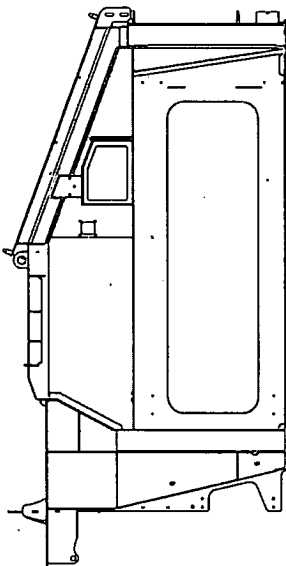
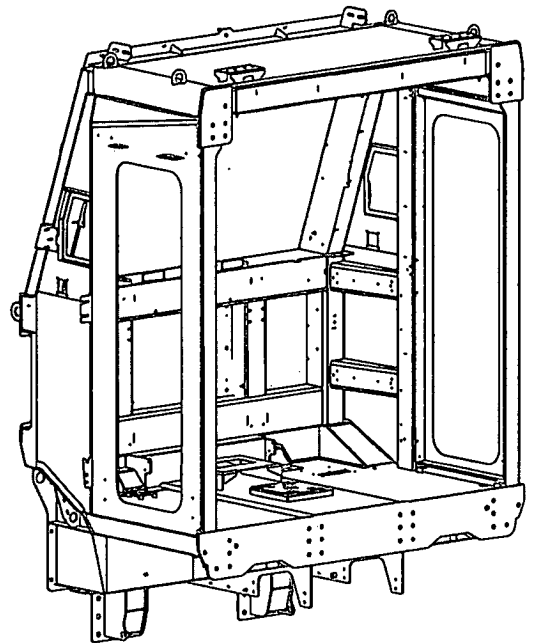
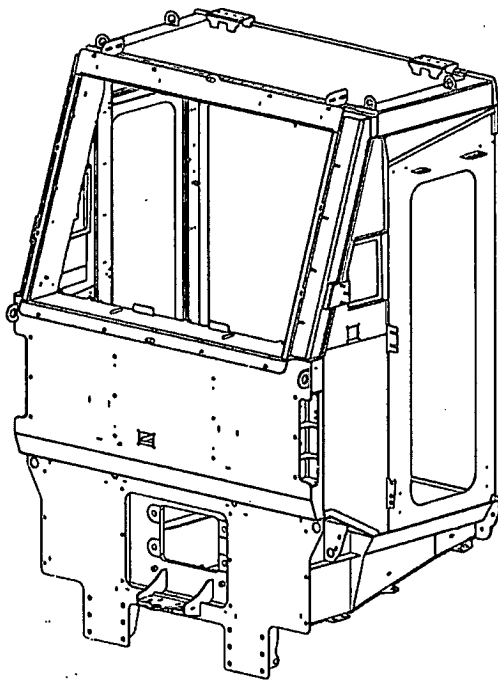
Record of Painting Blue NCSS1565 B			
Start Time:	09:00	End Time:	10:00
Temperature $\geq 15^{\circ}$ :		Humidity $\leq 75\%$ :	
Paint Batch No.:	8216288	Paint Expiry Date:	27-03-25
Hardener Batch No.:	8187506 024	Hardener Expiry Date:	02-27
Desolvation Start Time:	10:00	Desolvation End Time:	10:15
Stoving Start Time:	10:15	Stoving End Time:	11:15
Stoving Temp:	60 $^{\circ}\text{C}$		
Operator:	mula	Sign:	mula
Date:	2024/05/27		
Painting Blue NCSS1565 B Control			
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS	
GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)			
1: 125	5: 125	1: 127	5: 123
2: 116	6: 952	2: 130	6: 139
3: 98.9	7: 108	3: 101	7: 121
4: 122	8: 119	4: 99.0	8: 110
Min:	95.2	Min:	99.0
Max:	135	Max:	139
Average:	115	Average:	119
Painting NCSS3010 R90B has been inspected and is free of defects		Confirmed	Yes <input type="checkbox"/> No <input checked="" type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	90.3
QC Inspector:	Zawle	Sign:	Zawle
Date:	28 May 2024		

Record of RAL 7012									
Start Time:		13:00		End Time:		15:00			
Temperature $\geq 15^{\circ}$ :		28 $^{\circ}$ C		Humidity $\leq 75\%$ :		46%			
Paint Batch No.:		8216273		Paint Expiry Date:		13-03-25			
Hardener Batch No.:		8787506024		Hardener Expiry Date:		02/7			
Desolvation Start Time:		15:00		Desolvation End Time:		15:15			
Stoving Start Time:		15:15		Stoving End Time:		16:15			
Stoving Temp:		60 $^{\circ}$ C							
Operator:		musa		Sign:		musa			
Date:		2024/05/24							
RAL 7012 Control									
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front			
1: 89.9	5: 103	1: 122	5: 157	1: 122	5: 151	1: 101	5: 128		
2: 107	6: 122	2: 131	6: 151	2: 167	6: 144	2: 85.7	6: 162		
3: 116	7: 113	3: 92.2	7: 132	3: 148	7: 85.6	3: 99.6	7: 78.9		
4: 108	8: 165	4: 156	8: 142	4: 125	8: 94.2	4: 114	8: 142		
Min:	89.5	Min:	92.2	Min:	85.6	Min:	78.9		
Max:	165	Max:	154	Max:	167	Max:	162		
Average:	127	Average:	123	Average:	126	Average:	120		
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside			
1: 99.8	5: 152	1: 127	5: 131	1: 88.6	5: 109	1: 103	5: 124		
2: 135	6: 147	2: 131	6: 83.6	2: 109	6: 102	2: 99.5	6: 102		
3: 82.7	7: 138	3: 120	7: 95.2	3: 101	7: 105	3: 80.9	7: 161		
4: 111	8: 141	4: 118	8: 134	4: 124	8: 93.4	4: 86.8	8: 128		
Min:	82.7	Min:	83.6	Min:	83.6	Min:	80.9		
Max:	157	Max:	134	Max:	124	Max:	161		
Average:	119	Average:	108	Average:	103	Average:	120		
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test					
1: 123	5: 98.3	1: 104	5: 122						
2: 108	6: 116	2: 129	6: 138						
3: 119	7: 108	3: 89.3	7: 157						
4: 142	8: 125	4: 117	8: 114						
Min:	98.3	Min:	89.3						
Max:	142	Max:	157						
Average:	120	Average:	123						
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		42.6	25 May 2024		
QC Inspector:		Zorile		Sign:		Haw			
Date:		25 May 24							
SEALING OF CABIN									
All areas where there is no welding has been sealed with SIKA						Confirmed	YES	<input checked="" type="checkbox"/>	NO
All sealants have been neatly applied along joints						Confirmed	YES	<input checked="" type="checkbox"/>	NO
SIGN OFF									
CLOCK No:	2400	OPERATOR SIGN:		A. P. M. H. H.		DATE:			



## REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)



[illegible][illegible]




# CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	470	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	NO PAINT IN THREADS	0			
8					
9					
10					
11					
12					
13					
14					

Quality approval for release Signature	CO. NO.	DATE
	2285	30 May 2024