





PRASA PROJECT



APPLICABLE FROM TRAINSET 190+ AS PER BASELINE 10.4


SELF INSPECTION SHEET

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

APPLICATION REFERENCE												
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ? 	
				TC1	M4	M1	M2	M3	TC2			
<input type="checkbox"/>	DTR3000152644	AAD0001278566	CARBODYSHELL M3,M4 ASSEMBLY	CB1210		X			X		PRA,CB1210,DTR30225 487/3.V30	YES
<input type="checkbox"/>												

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018
			CHECKER	Nosizo Pindela	10/01/2018
			COMPILER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motama	2018/05/18
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230	APPROVER	Itumeleng Modiba	2018/07/04
			CHECKER	Nosizo Pindela	2018/07/04
			REVISED BY	Ramokone Motama	2018/07/04
3	2018/12/12	Added dimensional check points to CB1210	APPROVER	Itumeleng Modiba	2018/12/12
			CHECKER	Nosizo Pindela	2018/12/12
			REVISED BY	Ramokone Motama	2018/12/12
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	22/01/2019
			CHECKER	Nosizo Pindela	22/01/2019
			REVISED BY	Vanessa Ntuli	22/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	21/08/2019
			CHECKER	Nosizo Pindela	21/08/2019
			REVISED BY	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	
			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	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021
			CHECKER	Mpho Mulaudzi	
			REVISED BY	Mpho Mulaudzi	
25	19/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	19/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlampe Amogelang	
			REVISED BY	Mohlampe Amogelang	
28	07/11/2023	Added traceability for welding sections	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Mohlampe Amogelang	
			REVISED BY	Ntokozi Zwane	

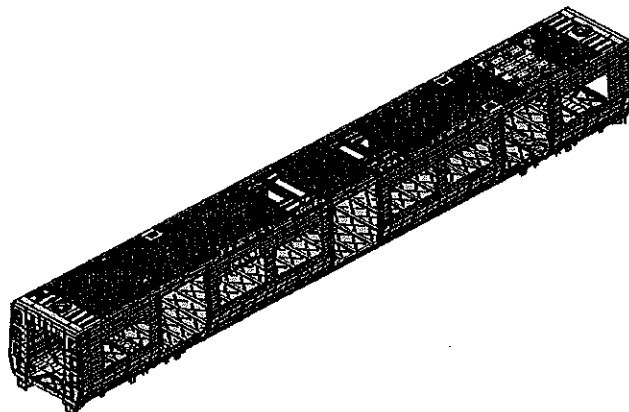
TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
232	M4	LUNGA 471497	07/06/24	SI.CB1210.254.V30	17

	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V30
		Date 07/11/2023	

Car: M3 & M4	NCR:	Work station: CB1210
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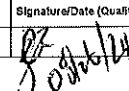


Safety Related




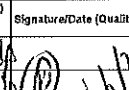

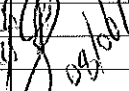

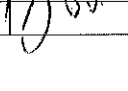
I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	D	M	S	S	M	T						
DTR30225487/3					X		26		✓			


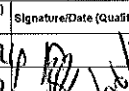

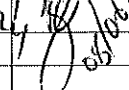
I.2 - Instruments Control


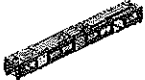
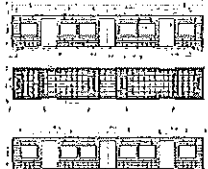
Monitoring and Measuring Instrument Control - Used for Special Process


Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULAR	52823-2	15/03/24	✓			
30 M TAPE	GIBTP0084	14/03/24	✓			
LASER TAPE	125425124	08/01/24	✓			

1.3 Consumables

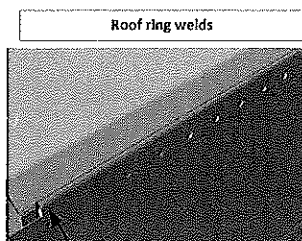
Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
AUT ROD 308LSI	E721880	MIG	✓			
ER 309 LSI	518394	MIG	✓			

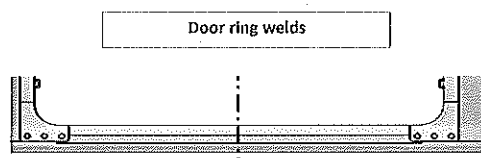
		Rev. 28 Date 07/11/2023	Project: PRASA SI.CB1210.254.V30			
CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3						
III - Self Inspection - Items to Check						
II.1 - items to check						
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	10/10 07/06/24	07/06/24
02	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-014 e DTD0000210675	✓	10/10 07/06/24	07/06/24
03	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	10/10 07/06/24	07/06/24
04		Cleoning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	10/10 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.	✓	10/10 07/06/24	07/06/24
06	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓	10/10 07/06/24	07/06/24

	CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3	Rev. 28	Project: PRA5A SI.CB1210.254.V30
		Date 07/11/2023	

Welding Traceability



<u>LHS</u>	
Boiler maker (Name & Sign): <u>Tim [Signature]</u>	Welder (Name & Sign): <u>MTIHOKEB [Signature]</u>
<u>RHS</u>	
Boiler maker (Name & Sign): <u>LAWRENCE [Signature]</u>	Welder (Name & Sign): <u>KUITU [Signature]</u> *



LHS


Boiler maker (Name & Sign): LAWRENCE [Signature]

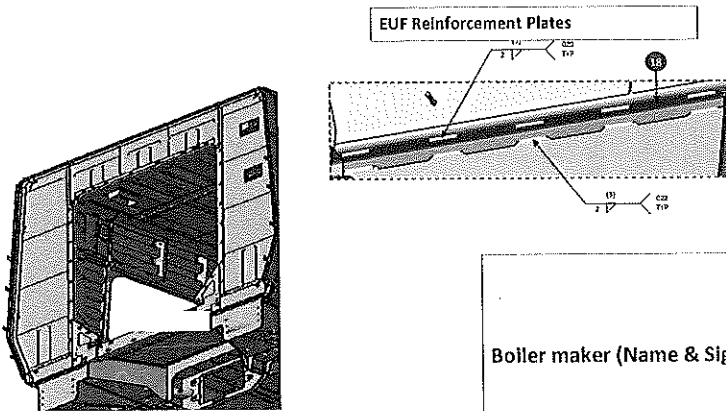
Welder (Name & Sign): BOBBIE [Signature]

RHS


Boiler maker (Name & Sign): LAWRENCE [Signature]


Welder (Name & Sign): BOBBIE [Signature]

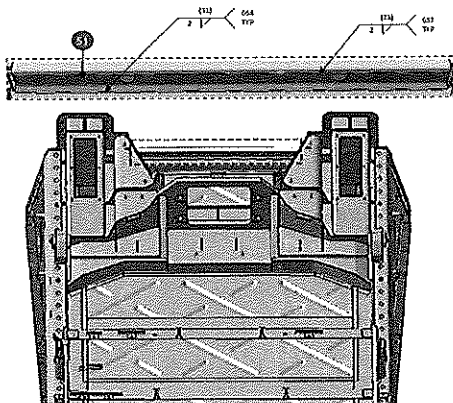
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		Date 07/11/2023	



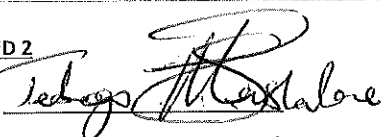
END 1


Boiler maker (Name & Sign): GEALD 

Welder (Name & Sign): SIPHUKAZI 



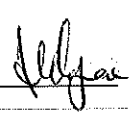
END 2

Boiler maker (Name & Sign): Thang 

Welder (Name & Sign): THABANG 



FEDOLI

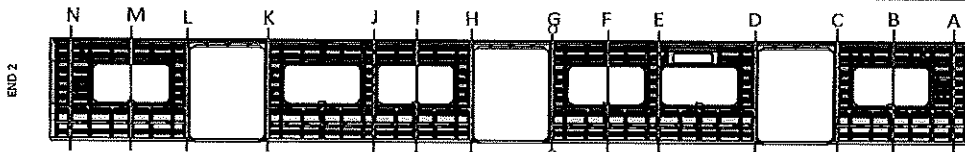
Operator: LAWRENCE 



CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

Rev.
28
Date
07/11/2023Project: PRA5A
SI.CB1210.254.V30

Specifications of Details for CBS measurement

PME Column LHS - RHS should be
≤ 2MM on each point.

BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	32.68	32.69	1	24.07	24.06	1
B	32.65	32.68	3	24.06	24.06	0
C	32.68	32.68	0	24.04	24.05	1
D	32.69	32.67	2	24.06	24.05	1
E	32.65	32.65	0	24.05	24.07	2
F	32.66	32.64	2	24.06	24.07	1
G	32.68	32.68	0	24.05	24.05	0
H	32.67	32.69	2	24.04	24.05	1
I	32.65	32.66	1	24.05	24.06	1
J	32.66	32.66	0	24.05	24.05	0
K	32.68	32.68	0	24.04	24.06	2
L	32.69	32.68	1	24.07	24.07	0
M	32.69	32.65	4	24.06	24.05	1
N	32.68	32.68	0	24.07	24.06	1

10/10
07/06/24



CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.

28

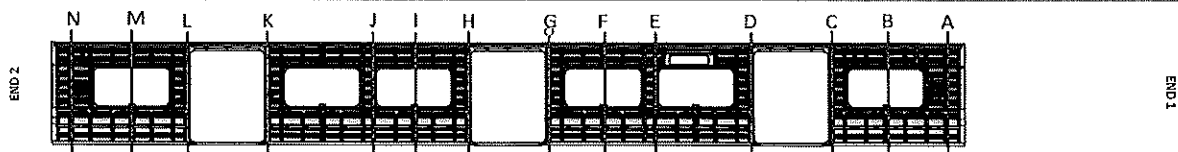
Date

07/11/2023

Project: PRASA

SI.CB1210.254.V30


Specifications of Details for CBS measurement

PME Column LHS - RHS should be
≤2MM on each point.

AFTER WELDING

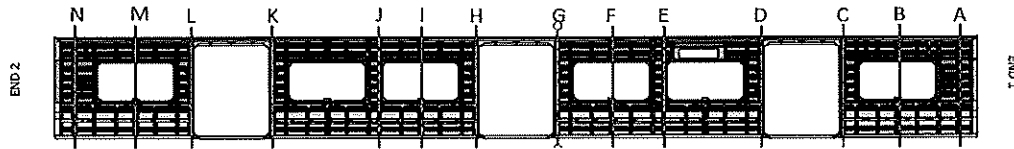
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3294	3295	1	2405	2407	2
B	3268	3265	3	2406	2405	1
C	3296	3296	2	2404	2406	2
D	3295	3295	0	2405	2405	0
E	3266	3266	1	2405	2405	0
F	3266	3264	2	2407	2406	1
G	3293	3294	1	2405	2404	1
H	3295	3295	0	2406	2406	0
I	3264	3265	1	2405	2406	1
J	3266	3266	0	2406	2405	1
K	3295	3295	0	2405	2405	0
L	3296	3295	1	2405	2405	0
M	3266	3268	2	2406	2407	1
N	3294	3295	1	2407	2407	0

07/06/24

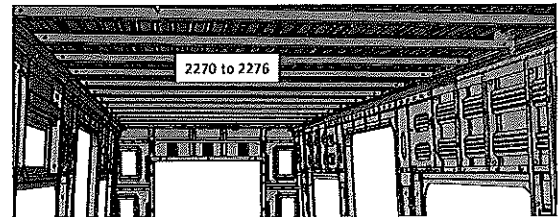
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		Date 07/11/2023	

CBS measurement

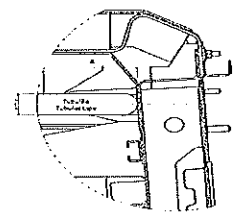
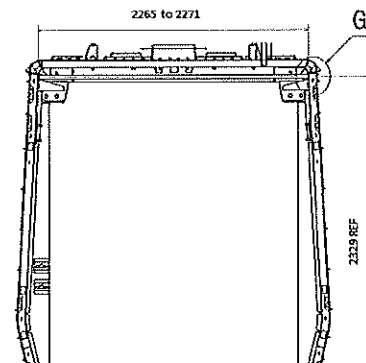
BEFORE WELDING



	2270 to 2276
A	2272
B	2275
C	2271
D	2273
E	2278
F	2276
G	2273
H	2272
I	2276
J	2277
K	2273
L	2271
M	2276
N	2272




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

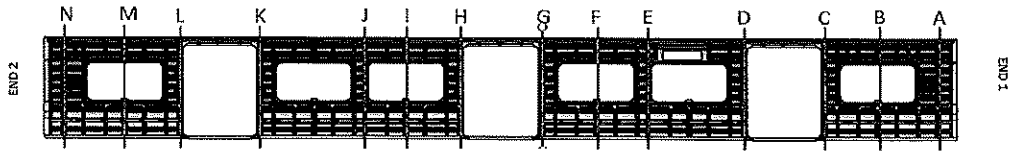


Detail G
Consider girth
or other secured plate

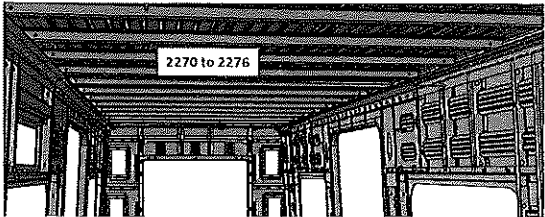
10/19
07/06/24

	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev, 28	Project: PRASA SI.CB1210.254.V30
		Date 07/11/2023	
		CBS measurement	

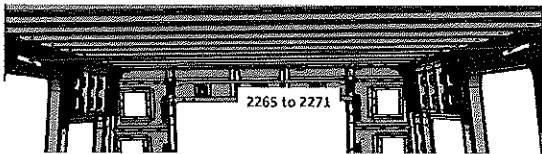
AFTER WELDING



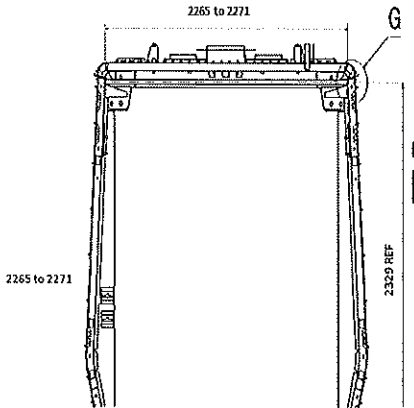
	2265 to 2271	2270 to 2276
A	2265	
B		2273
C	2268	
D	2270	
E		2276
F		2276
G	2269	
H	2266	
I		2275
J		2276
K	2266	
L	2268	
M		2274
N	2265	



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

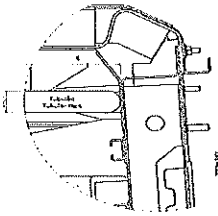


Take measurement close to radius (considering reinforcement)



07/06/24

2265 to 2271



Detail G

Consider angle reinforcement plate



CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.

28

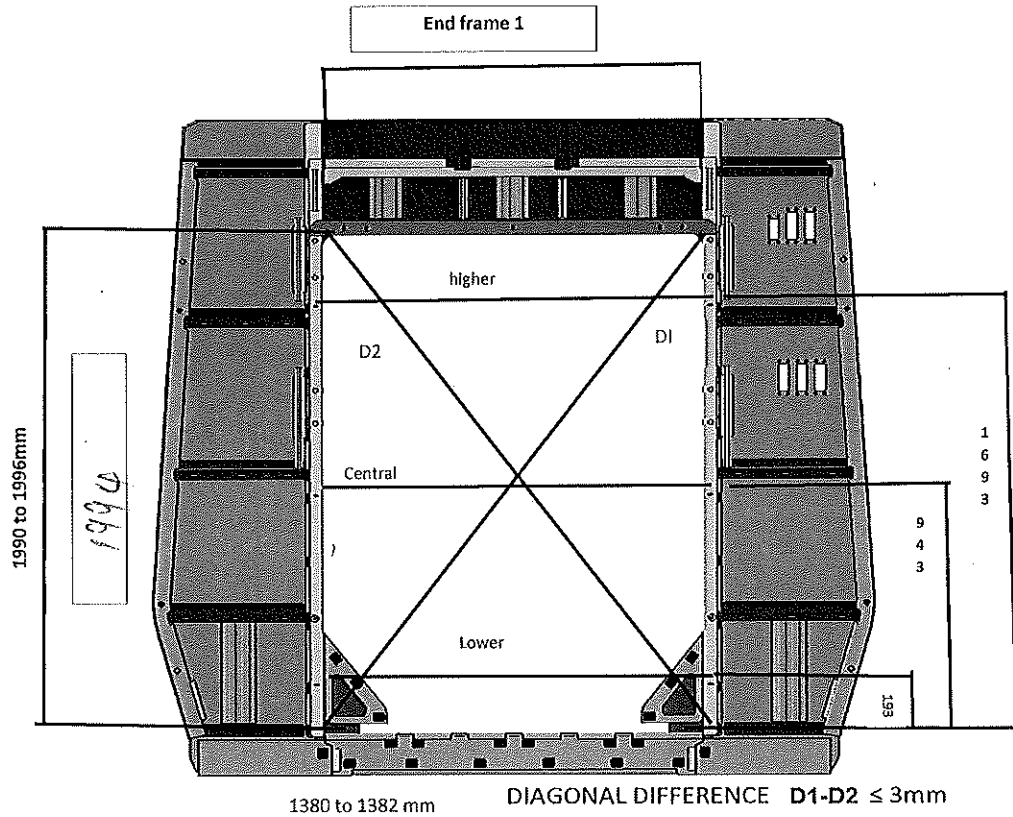
Date

07/11/2023

Project: PRASA

SI.CB1210.254.V30

Specifications of Details for CBS measurement



Higher Dimension

1381

D1

2414

Central Dimension

1381

D2

2414

Lower Dimension

1380

D1-D2

0

07/06/24



CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

Rev.

28

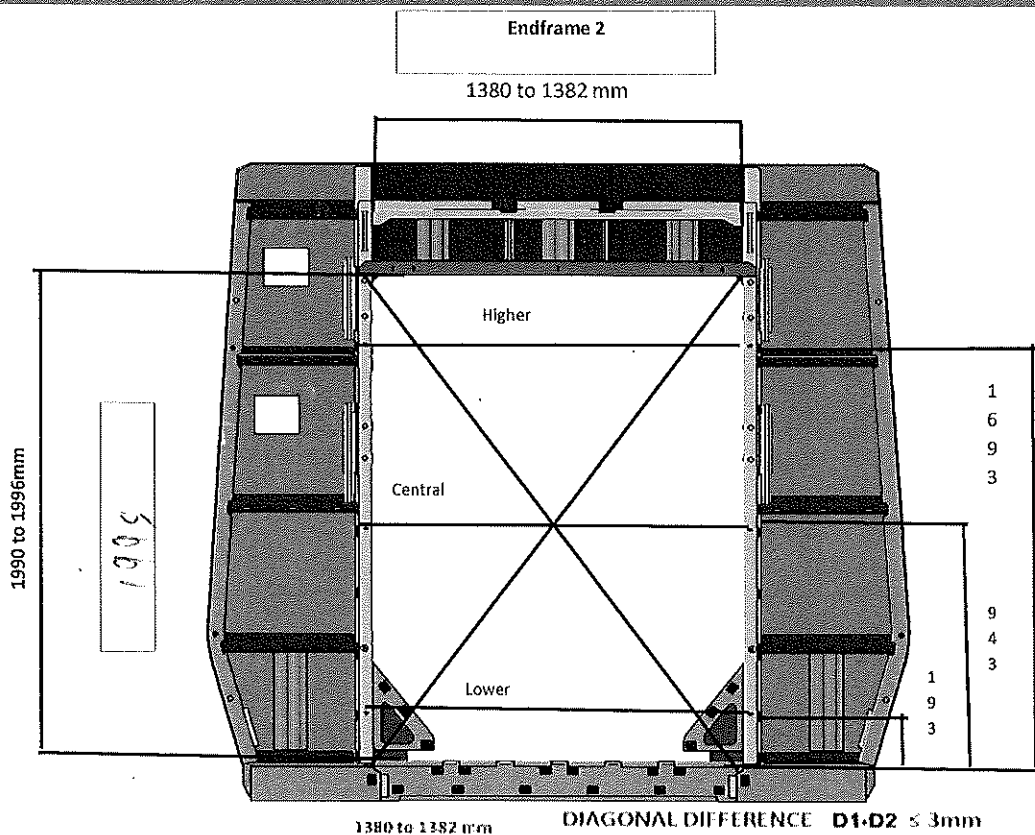
Date

07/11/2023

Project: PRASA

SI.CB1210.254.V30

Specifications of Details for CBS measurement



Higher Dimension

1382

D1

2413

Central Dimension

1381

D2

2415

Lower Dimension

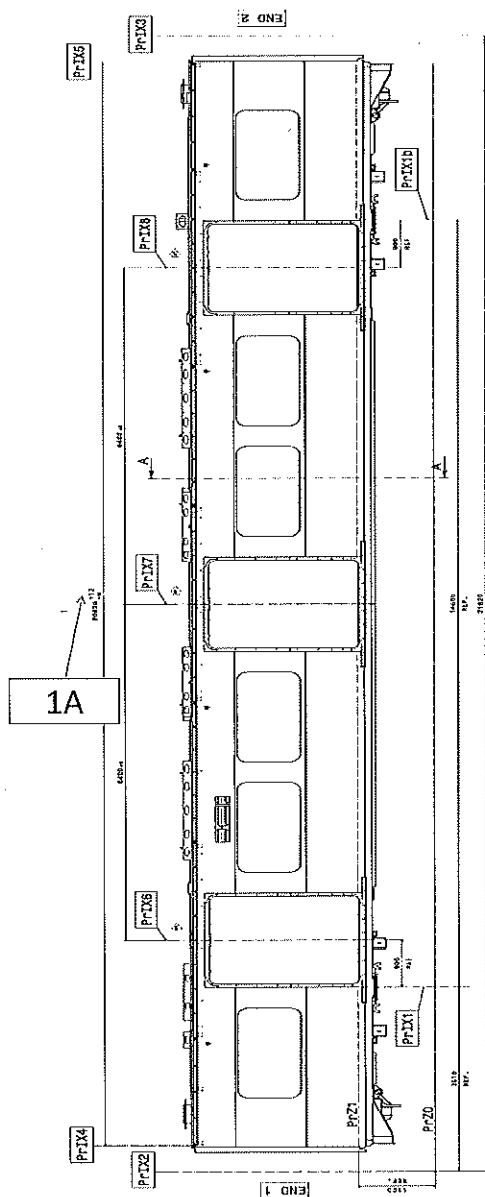
1381

D1-D2

2

07/06/24

Specifications of Details for CBS measurement



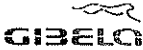
LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20615




	RIGHT SIDE	
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20615

Dye penetrant test

Dye-penetration test to be performed by quality personnel




		CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3		Rev. 28		Project: PRASA			
				Date 07/11/2023		SI.CB1210.254.V30			
Item	Description of the Issue				OK	Signature/Date (Manufacturing)		Signature/Date (Quality)	
II.2 - Check List REX									
Check List Items									
Item	Picture/Drawing	Description	Criteria /Record	OK			Signature/Date (Manufacturing)	Signature/Date (Quality)	
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX						

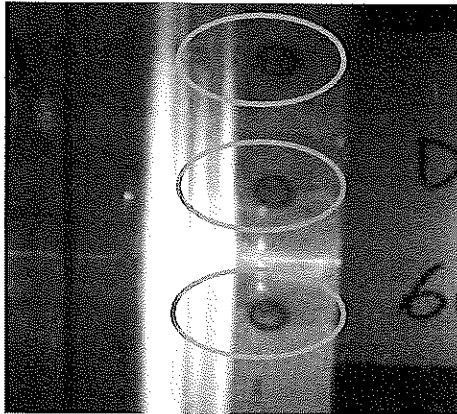
		CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3		Rev. 28 Date 07/11/2023	Project: PRASA SI.CB1210.254.V30	
Self Inspection - Final Result						
			DATE	NAME	SIGNATURE	
HOLD POINT		GO	(If activities are not complete, the missing activities must not impact the next stage)	07/06/24	N. NGA Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	07/06/24	N. NGA Industrial Quality	
	NO GO		There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			Operations
			There are non-conformities impact the quality of the product and there is no corrective action defined yet)			Industrial Quality
In case of "NO GO", describe blocking problems						
In case of "NO GO", the operations manager must define below action plan to ensure "GO":						
Item	Description		Responsible	Due date	Status	


Operations

Quality

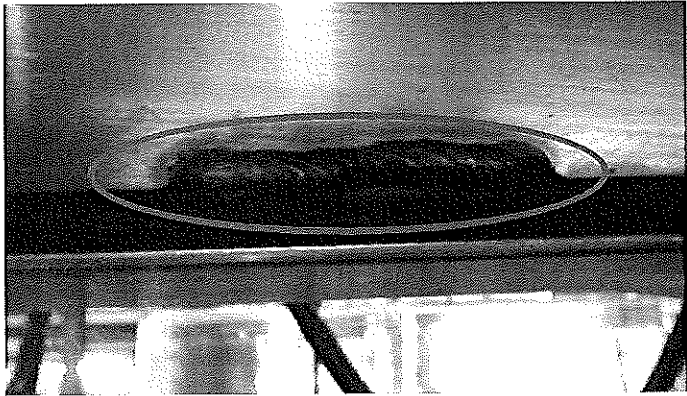
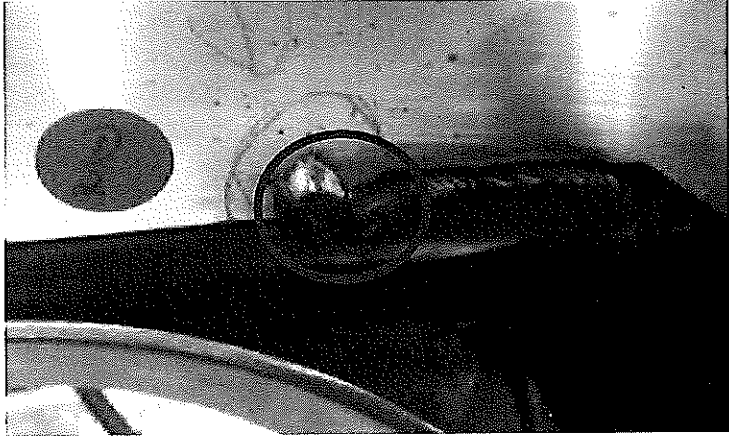
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ANNEXURE A: Spot Welding Quality Acceptance Standard



	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V30
		Date 07/11/2023	

ANNEXURE B: Arc Welding Quality Acceptance Standard





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		
				TCL	M4	M3	M2	M1				
<input type="checkbox"/>	DTR30225487/2	A400001278366	CARBODY/SHELL M1,M3,M4 ASSEMBLY	CB2220		X	X		X		PRA CB2220.DTR3022548 7/2.V21	YES
<input type="checkbox"/>												
<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				
			COMPLIER			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	APPROVER			Itumeleng Modiba		13/03/2019				
			CHECKER			Nosizo Pindela		13/03/2019				
			REVISED BY			Nosizo Pindela		13/03/2019				
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						
			REVISED BY			Bongane Masina						
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER			Mbhombi Collins		17/08/2021				
			CHECKER			Mpho Mulaudi						
			REVISED BY			Mpho Mulaudi						
25	20/02/2022	New Baseline change 10.3.1	APPROVER			Collins Mbhombi		19/02/2022				
			CHECKER			Andani Muthelo						
			REVISED BY			Andani Muthelo						
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER			Collins Mbhombi		14/06/2022				
			CHECKER			Andani Muthelo						
			REVISED BY			Andani Muthelo						
27	19/10/2022	Addition of traceability for sealant application & welding	APPROVER			Collins Mbhombi		19/10/2022				
			CHECKER			Ntokozo Zwane						
			REVISED BY			Amogelang Mohlampe						
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER			Vanessa Ntuli		14/04/2023				
			CHECKER			Ntokozo Zwane						
			REVISED BY			Amogelang Mohlampe						
29	28/10/2023	Addition of bracket quantity	APPROVER			Ngobeni Tyson		28/10/2023				
			CHECKER			Ntokozo Zwane						
			REVISED BY			Amogelang Mohlampe						
TRAINSET	CAR	OPERATOR NAME& ALPS NO		DATE	SELF INSPECTION NUMBER		PAGES					
232	MU	A5A-104 409974		18-06-24	SI.CB2220.250.V29		13					

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29	Project: PRA5A SI.CB2220.250.V29	
		Date 28/10/2023		
Car: M1,M3&M4	NCR:	Work station:		CB2220

Safety Related

I - Documentation and Instruments Control

I.1 - Documentation Control


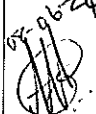
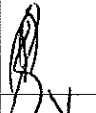
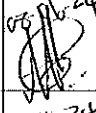
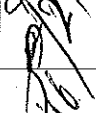
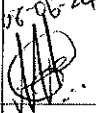

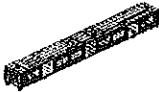
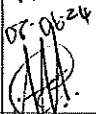

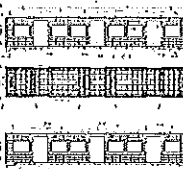
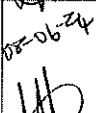

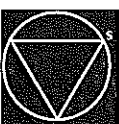
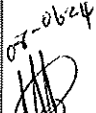

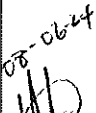

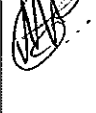


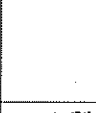
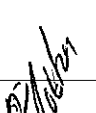
Document	Type of car					Revision	Observation	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)
	T01	M1	M2	M3	M4						
DTR30225487/2				X		29	28-10-2023	X	N/A		08-06-24 08/06/24


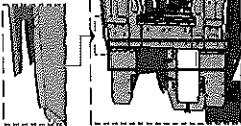
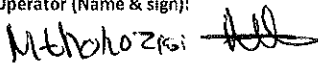


I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process						
Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
Tubular	52823	15/13/2025	X			08-06-24
measuring tape	61374831	06/08/2025	X			08-06-24 08/06/24


I.3 Consumables

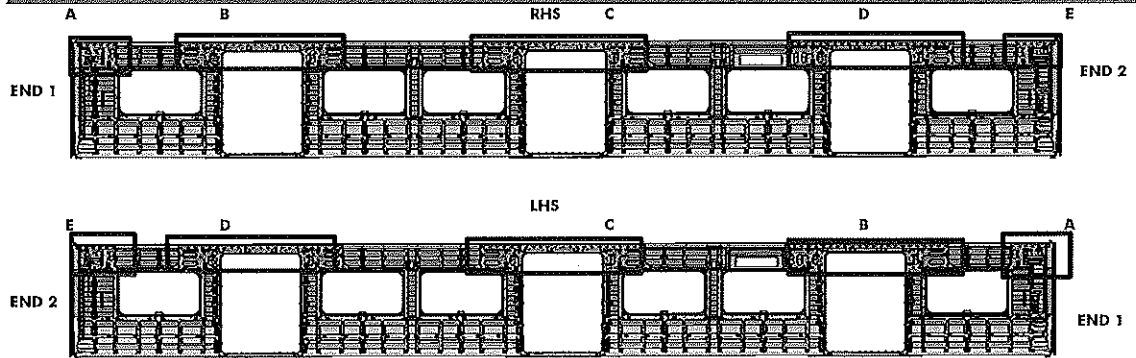
Welding Consumable Control - Used for Special Process						
Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
308	313179	MIG	X			08-06-24 08/06/24

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2		Rev.	Project: PRASA SI.CB2220.250.V29			
			29				
			Date				
			28/10/2023				
II - Self Inspection - Items to Check							
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.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB2220.DTR30225487/2	✓		 08-06-24	 08/06/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		 08-06-24	 08/06/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 08-06-24	 08/06/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 08-06-24	 08/06/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		 08-06-24	 08/06/24
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.	✓		 07-06-24	 08/06/24
07	N/A	<p>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:</p> <p>Temperature Min - Max (°C) Min Max 10°C - 35°C</p> <p>Relative humidity Min - Max (%) Min Max 25% - 60%</p>	<p>Sealant Batch No: 133491</p> <p>Exp Date: 15/06/24</p> <p>Actuals</p> <p>Temperature: 11</p> <p>Humidity: 56</p>	✓		 08-06-24	 08/06/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD00001278566	✓		 08-06-24	 08/06/24
09		Verification of safety welds	Approved according to DTD0000210658 reference and Self inspection	✓		 08-06-24	 08/06/24

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	
II - Self Inspection - Items to Check			
SEALANT APPLICATION			
AREA 1 & 2 END 1			
	Operator (Name & sign):		
	Operator (Name & sign):		
			


M4 232

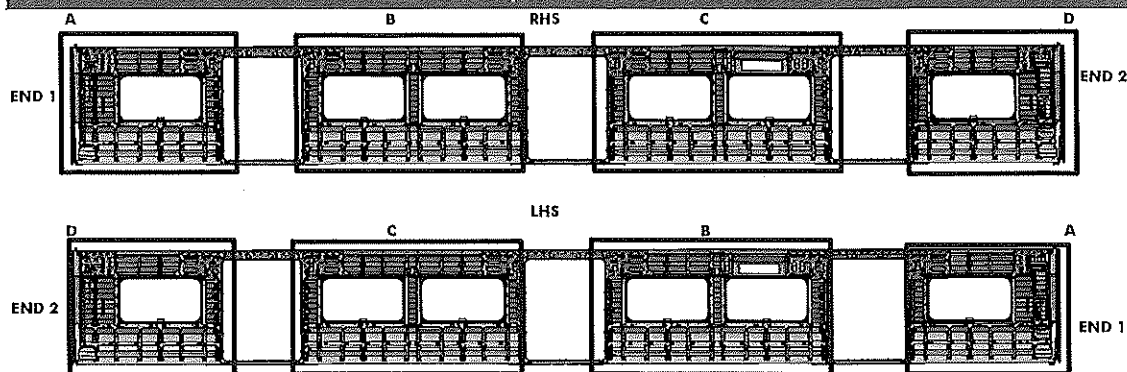
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	
II - Self Inspection - Items to Check			



REINFORCEMENT WELDING

AREA	LHS	RHS
A	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>
B	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>
C	Operator (Name&sign): <u>Mashurky</u>	<u>[Signature]</u>
D	Operator (Name&sign): <u>[Signature]</u>	<u>THULANI W</u>
E	Operator (Name&sign): <u>[Signature]</u>	<u>THULANI W</u>

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



BRACKETING

		INSTALLATION	
C-RAILS:	Operator:	<u>Priscillo</u>	
	Operator:		
DOOR MECHANISMS:	Operator:	<u>Mashudu</u>	
	Operator:		
TAPPING PADS	Operator:	<u>Sibusiso</u>	
	Operator:	<u>Nkulunga Dikw</u>	
		INSTALLATION & VERIFICATION	
SEAT & LUGGAGE BRACKETS:	Operator:	<u>heni</u>	
	Operator:		
SEAT BRACKETS VERIFICATION:	Operator:	<u>heni</u>	
	Operator:		
WELDING			
AREA	LHS	RHS	
A (Seat brackets)	: Operator (Name&sign):	<u>Nkulunga Dikw</u>	
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	<u>LINDO</u>	
B (Seat brackets)	: Operator (Name&sign):	<u>Sibusiso</u>	
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	<u>J. Dikw</u>	
C (Seat brackets)	: Operator (Name&sign):	<u>Mashudu</u>	
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	<u>THULANE</u>	
D (Seat brackets)	: Operator (Name&sign):	<u>Sibusiso</u>	
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	<u>THULANE</u>	
ENDS			
END 1 TAPPING PADS WELDING:	Operator (Name&sign):	<u>Nkulunga Dikw</u>	
END 1 TAPPING PADS WELDING:	Operator (Name&sign):	<u>Sibu</u>	



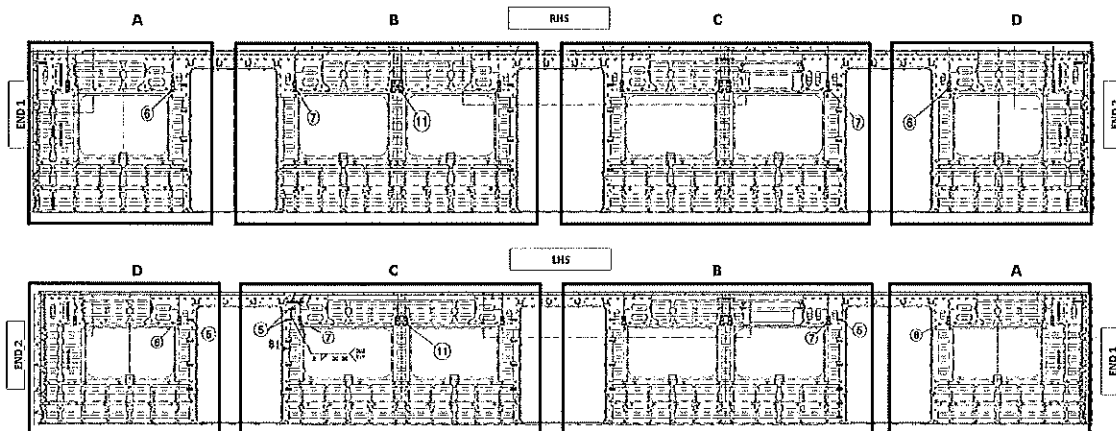
CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB2220.250.V29

II - Self Inspection - Items to Check

M3/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7		
	B	4		
	C	8		
	D	0		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	5		
	C	4		
	D	3		

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

VERIFICATION BY: ASA-IDA

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	6		
	C	11		
	D	8		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	5		
	C	6		
	D	2		

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

VERIFICATION BY: ASA-IDA

QUANTITIES (M1)

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

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

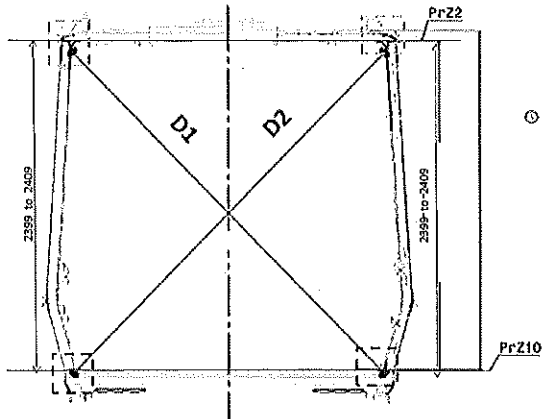
VERIFICATION BY: _____

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	10		
	C	11		
	D	8		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	7		
	C	6		
	D	2		

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

VERIFICATION BY: _____

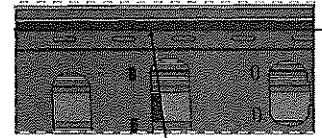
Specifications of Details for CBS measurement



①



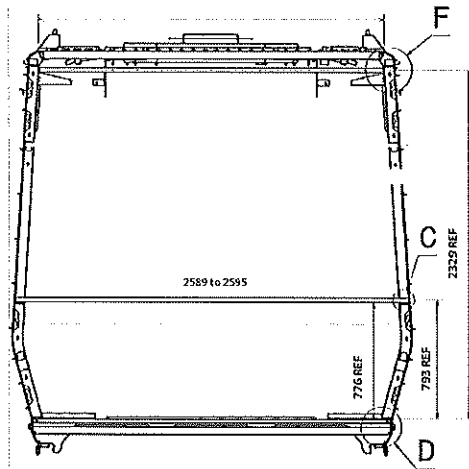
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



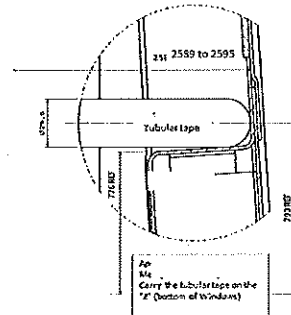
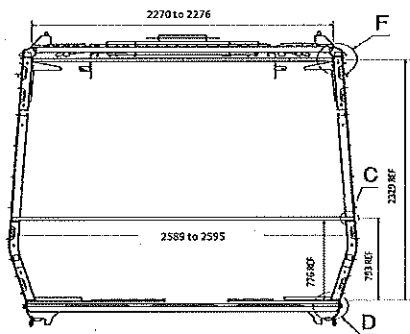


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

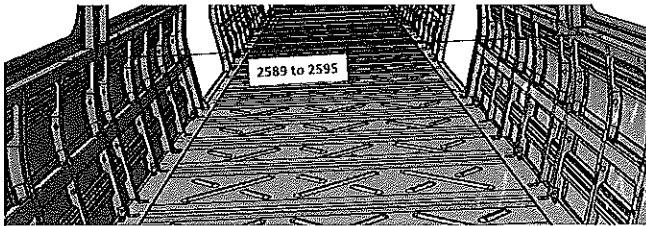
Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB2220.250.V29

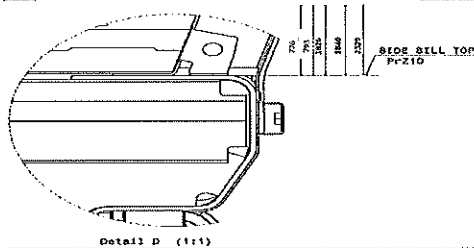
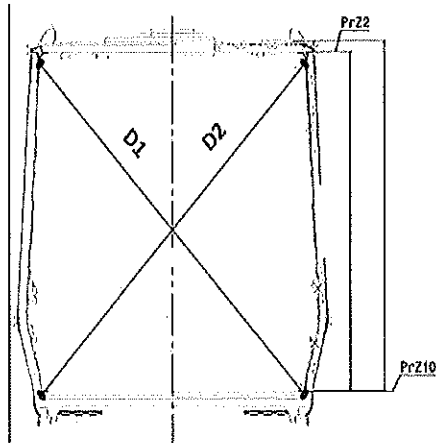
CBS measurement




Detail C

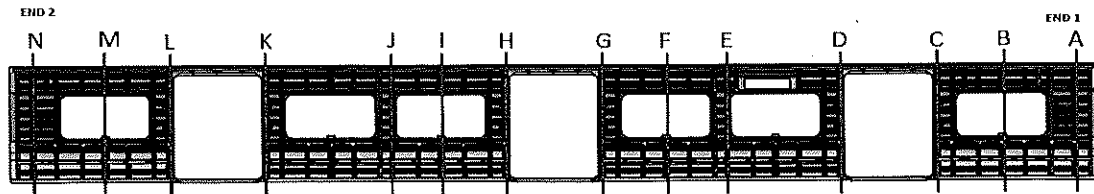


Take measurement close to
radius



Detail D (1:1)


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



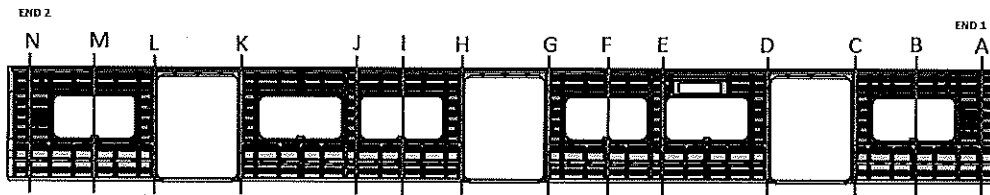
BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3296	3300	4	
B	3267	3263	4	
C	3294	3292	2	
D	3292	3298	6	
E	3265	3265	0	
F	3264	3263	1	
G	3298	3294	4	
H	3296	3295	1	
I	3262	3263	1	
J	3264	3269	5	
K	3299	3294	5	
L	3300	3295	5	
M	3265	3264	1	
N	3297	3296	1	

08-06-24

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

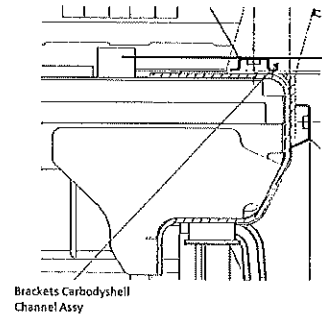
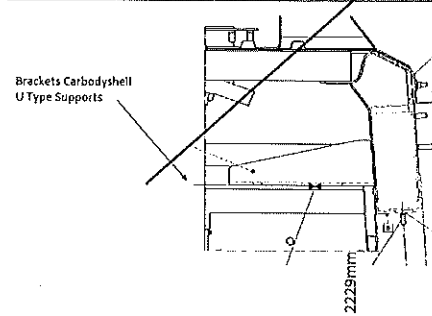
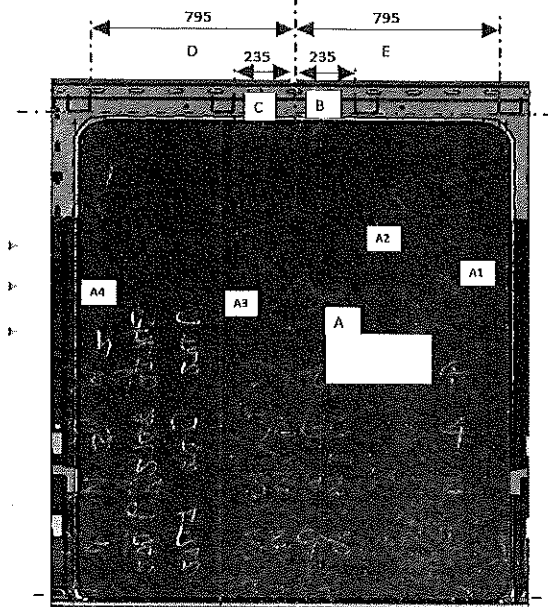
CBS measurement



AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3293	3297	4	2596
B	3264	3262	2	2591
C	3295	3291	4	2581
D	3294	3300	6	2596
E	3264	3268	4	2594
F	3263	3263	0	2596
G	3294	3297	3	2594
H	3300	3297	3	2595
I	3267	3262	5	2594
J	3265	3268	3	2593
K	3295	3300	5	2597
L	3300	3297	3	2591
M	3265	3266	2591	2593
N	3297	3296	2	2593

Specifications of Details for CBS measurement CB1220



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

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

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

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

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

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

Handwritten signature and date:
08-06-24

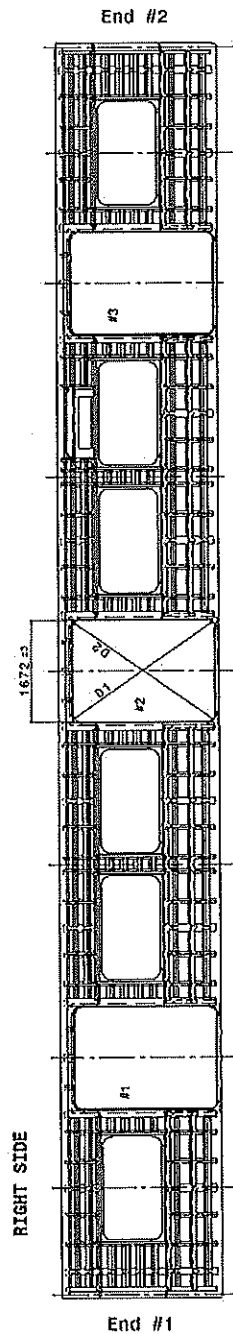


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB2220.250.V29

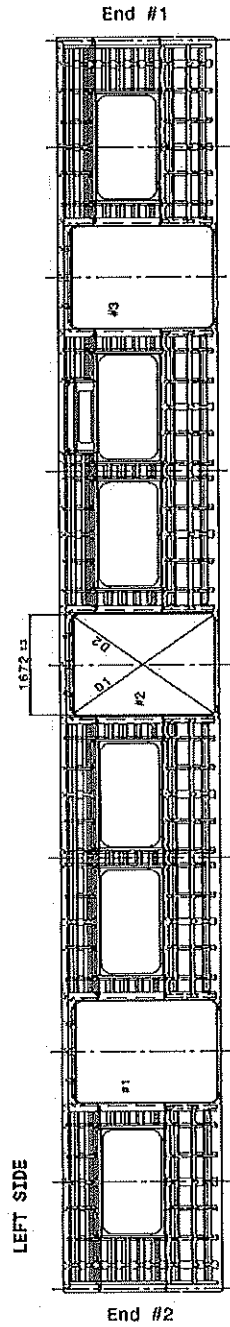
Specifications of Details for CBS measurement CB1220



Doors diagonal D1-D2 maximum difference ≤4mm

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

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






Doors diagonal D1-D2 maximum difference ≤4mm


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

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

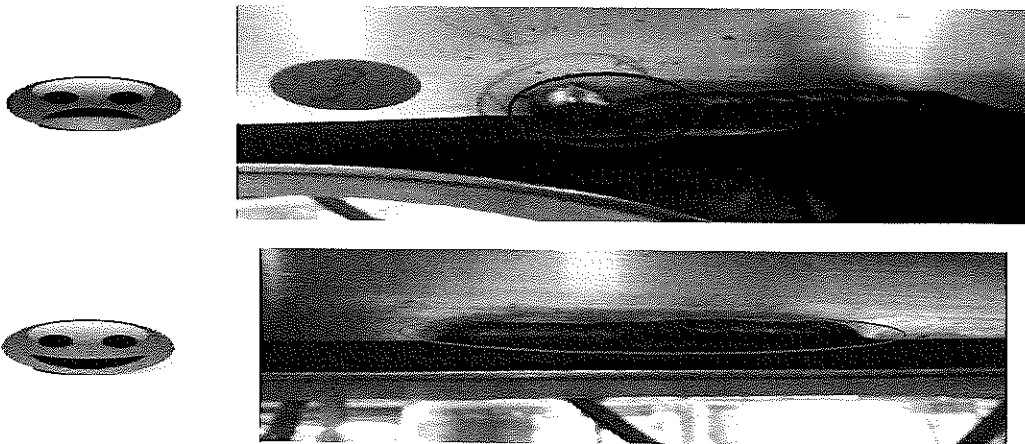
42-90-80

[illegible]

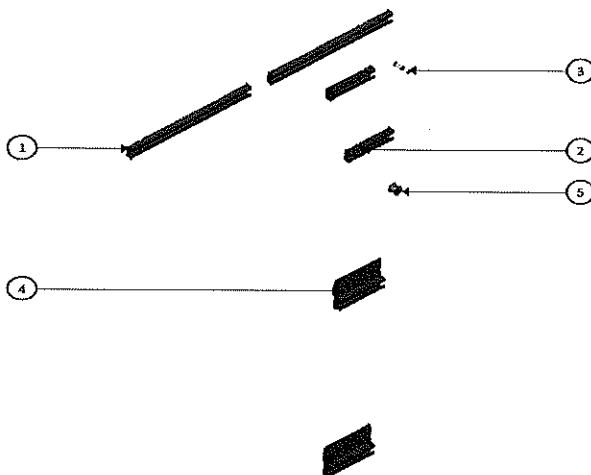
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB2220.250.V29			
		29				
		Date				
		28/10/2023				
Self Inspection - Final Result						
Is the car good to advance to the next workstation/process? (Approval of Operations Manager and Industrial Quality)			DATE	NAME	SIGNATURE	
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)	08-06-24	ASANDA Operations		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	08/06/24	N. Stolor Industrial Quality		
		There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			Operations	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)			Industrial Quality	
In case of "NO GO", describe blocking problems						
In case of "NO GO", the operations manager must define below action plan to ensure "GO":						
Item	Description		Responsible	Due date	Status	
			<div style="display: flex; justify-content: space-around;"> <div> Operations </div> <div> Quality </div> </div>			

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

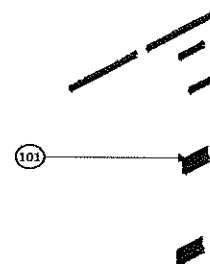
ANNEXURE A: Arc Welding Quality Acceptance Standard



Station: CB1220-004- U108 & U107



PART NO.	ITEM NO.	QTY	DESCRIPTION	MASS [KG]
DTR002097408	5	6	EARTH STUD 6	0.036
AA0001221648	4	6	ASSEMBLY SUPPORT	0.273
DTR000348305	3	12	WELDING STUD ISO13918 PT - M2X20 - SST	0.007
AA0001180124	2	12	ASSEMBLY SUPPORT	0.193
AA0001164418	1	14	ASSEMBLY SUPPORT	0.522
AA0001161080	101	6	CARBODYSHELL BRACKETS CARBODYSHELL M1/M3/M4 CAR (SIDE FRAME MODULE FHD - OPP)	12.132



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	CARTYPE						WORK INSTRUCTION	SAFETY ?	
				TC	MA	MS	RE	MR	TC			
<input type="checkbox"/>	DT90000216487	ADD0001278586	CARBODY SHELL MLM3144 ASSEMBLY	CB1230		X	X		X		PRA.CB2230.0T000002 25687.V20	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
REV	DATE	MODIFICATION CONTENT		RESPONSIBLE	NAME	DATE						
	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	Humeleng 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	Humeleng 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	Humeleng 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	Humeleng Modiba	13/03/2019						
				CHECKER	Nosizo Pindela	13/03/2019						
				REVISED BY	Nosizo Pindela	13/03/2019						
10	23/08/2019	New Baseline 10.2.5		APPROVER	Humeleng 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 Mhombhi	20/02/2022						
				CHECKER	Andani Muthelo							
				REVISED BY	Andani Muthelo							
26	14/06/2022	Update minimum temperature requirement for sealant application		APPROVER	Collins Mhombhi	14/06/2022						
				CHECKER	Andani Muthelo							
				REVISED BY	Andani Muthelo							
27	26/07/2022	Threshold measurements addition		APPROVER	Collins Mhombhi	26/07/2022						
				CHECKER	Andani Muthelo							
				REVISED BY	Andani Muthelo							
28	17/10/2022	Added traceability of sealant application		APPROVER	Collins Mhombhi	17/10/2022						
				CHECKER	Ntokoza Zwane							
				REVISED BY	Amogelang Mhlampe							
29	14/04/2023	Added sealant batch number & welding consumables traceability		APPROVER	Vanessa Ntuli	14/04/2023						
				CHECKER	Ntokoza Zwane							
				REVISED BY	Amogelang Mhlampe							
30	06/11/2023	Added threshold traceability for boiler makers and welders		APPROVER	Ngobeni Tyson	06/11/2023						
				CHECKER	Andani Muthelo							
				REVISED BY	Ntokoza Zwane							
TRAINSET	CAR	OPERATOR NAME & NO.	DATE	SELF INSPECTION NUMBER		PAGES						
232	M024	RULE 4969165	10/06/24	SI.CB2230.256.V29		12						

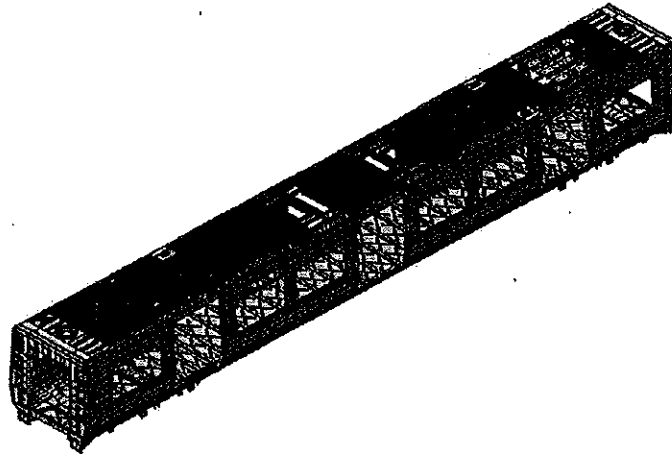


	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30	Project: PRA5A SI.CB2230.256.V29
		Date 06/11/2023	

Car:	NCR:	Work station:	CB2230
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Safety Related



I - Documentation and Instruments Control

1.1 - Documentation Control

Document	Type of car				Revision	Observation	✓	NCR	Recvd.	Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4							
PRA.CB2230.DT00000225487				X	29		✓		N/A	18/06/24	18/06/24

1.2 - Instruments Control

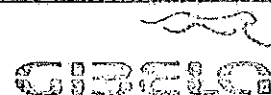
Monitoring and Measuring Instrument Control - Used for Special Process

Instrument(s)	Serial Number	Calibration or Verification Validation Date	✓	NCR	Signature/Date (Operations)	Signature/Date (Quality)
Combination Square	578504026	10/06/2024	✓		18/06/24	18/06/24
Ruler	GTBST30	14/09/2024	✓		18/06/24	18/06/24
Measuring Tape	51870007	23/02/2025	✓		18/06/24	18/06/24
Universal	2002-2	19/02/2025	✓		18/06/24	18/06/24

1.3 Consumables


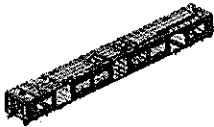
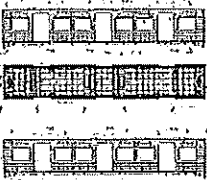
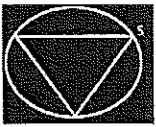
Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	✓	NCR	Signature/Date (Manufacturing)	Signature/Date (Quality)
308 LSi	273471	Mig Welding	✓		18/06/24	18/06/24




2024-06-06

INDUSTRIAL QUALITY
MAINLINE

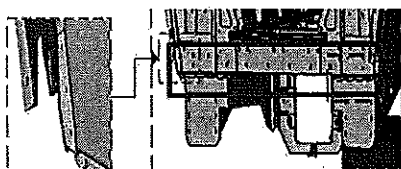
		CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487		Rev. 30 Date 08/11/2023	Project: PRASA SI.CB2230.256.V29		
II - Self Inspection - Items to Check							
II.1 - Items to check							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Not OK	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering nº PRA.CB1230.DT00000225487 Verification of filament for all brackets.	PRA.CB1230.DT00000225487	✓		10/06/24	10/06/2024
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		10/06/24	10/06/2024
03	REFER TO ANNEXURE A	Arc Welding Inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		10/06/24	10/06/2024
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		10/06/24	10/06/2024
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		10/06/24	10/06/2024
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.	✓		10/06/24	10/06/2024
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: Temperature Max + Min (°C) Min-Max 10°C - 35°C Relative humidity Min - Max (%) 25% - 80%	Sealant Batch No: 102, 70, 03 Exp Date: 09/09/24 Actuals Temperature: 11.2°C Humidity: 54%	✓		10/06/24	10/06/2024
08	N/A	Verification of sealant application on the roof and sidewall finishes.	Sealant must be: -Applied straight and even -Free of gaps, cracks, damage and debris (flashes, dirt, dust) Refer to Annexure B	✓		10/06/24	10/06/2024
09	N/A	Verification of sealant application in certain regions in the drawing	AAD0001278566	✓		10/06/24	10/06/2024

2024-06-06
 INDUSTRIAL QUALITY
 MANAGER

	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev.	Project: PRASA
		30	
		Date	SI.CB2230.256.V29
		08/11/2023	

II - Self Inspection - Items to Check

AREA 1



END 2 SEALANT

OPERATOR
(Name & sign):

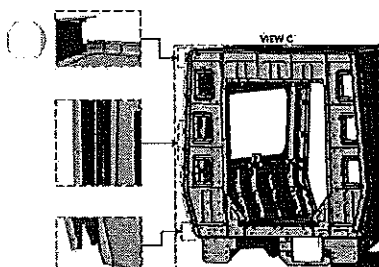
[Signature] Zanele

OPERATOR
(Name & sign):

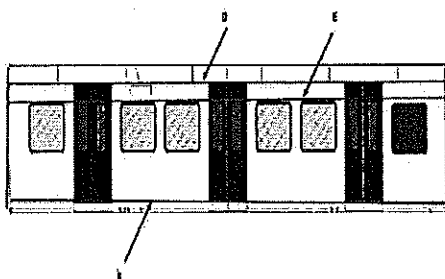
Zanele *[Signature]*

OPERATOR
(Name & sign):

AREA 2 (VIEW C)



H



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

Operator (Name & sign):

LHS

[Signature] D,E,F,G,H,I

RHS

[Signature] D,E,F,G,H,I

Operator (Name & sign):

[Signature] Sible

[Signature] Sinte

Operator (Name & sign):

[Signature] Tshenote *[Signature]* Tshenote

Operator (Name & sign):

[Signature] Sinte

[Signature] Sinte

Operator (Name & sign):

[Signature]

[Signature]

Operator (Name & sign):



2024-06-06

INDUSTRIAL QUALITY
MAINLINE



CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

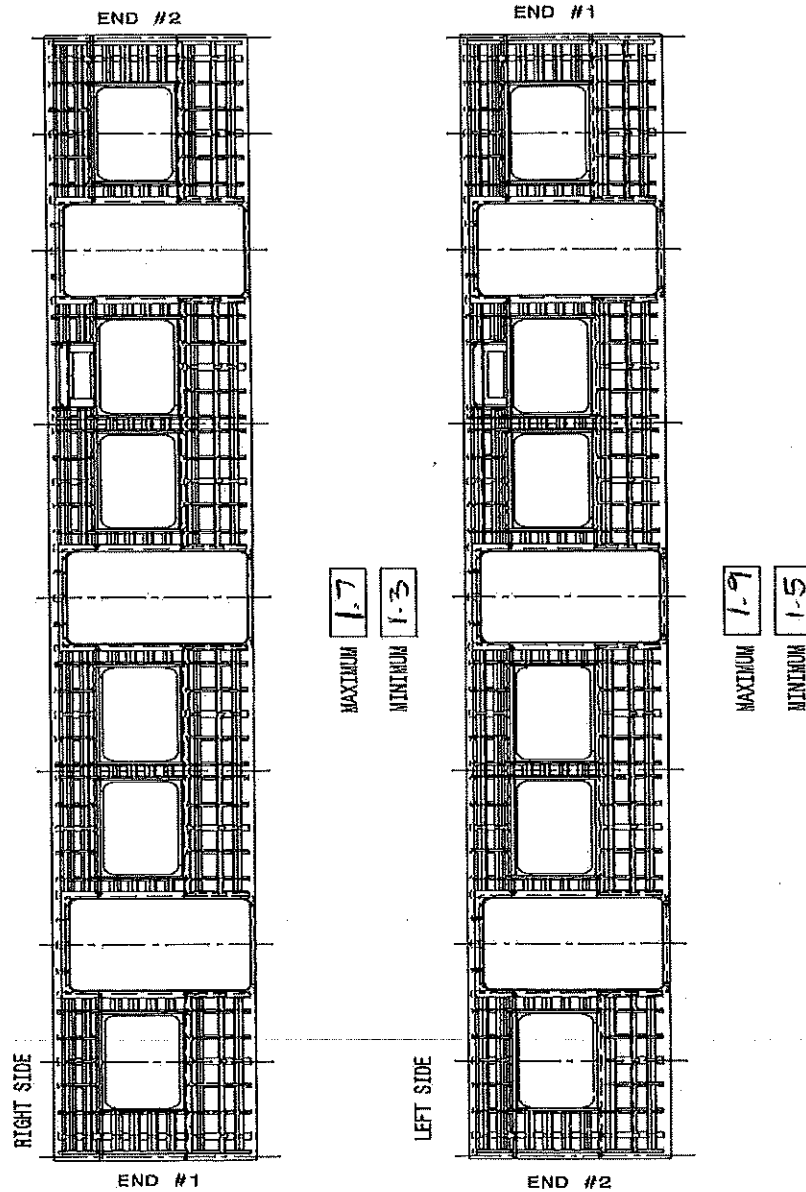
Rev.
30
Date
06/11/2023

Project: PRASA

SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230

Flatness side left and right maximum of 2mm in the valley to peak measured in 900mm. Recod the maximum and minimum value found and indicate the corresponding region.



2024-06-06

INDUSTRIAL QUALITY
MAINLINE



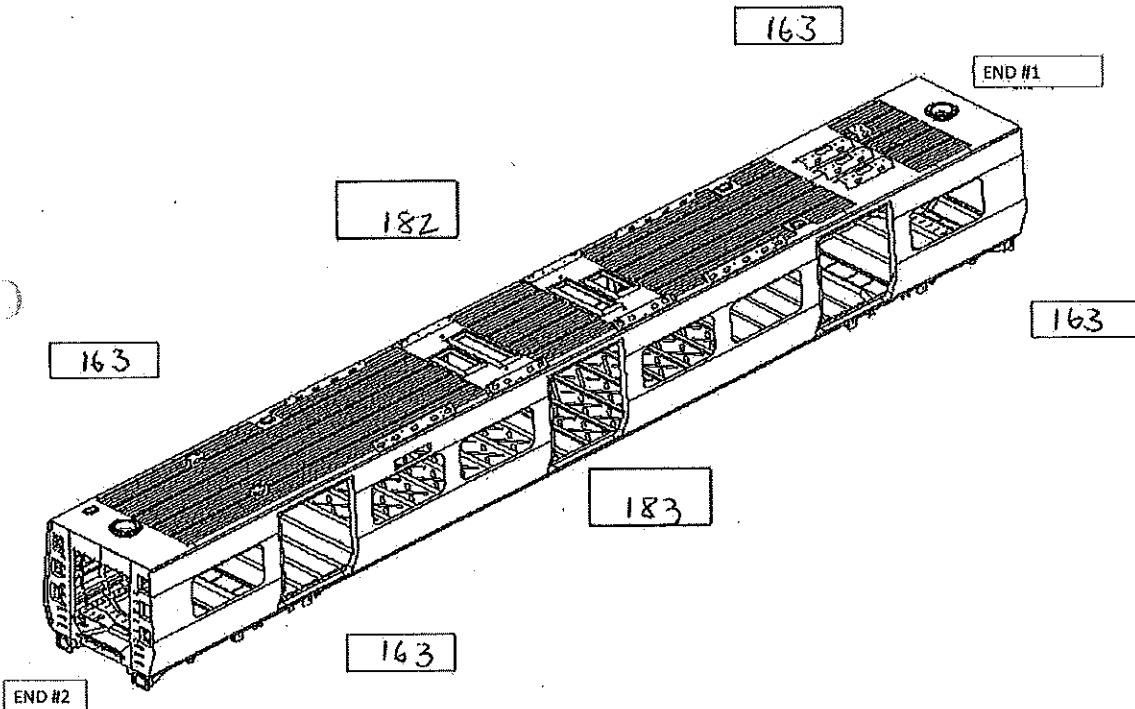
CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
30
Date
08/11/2023


Project: PRASA
SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230

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

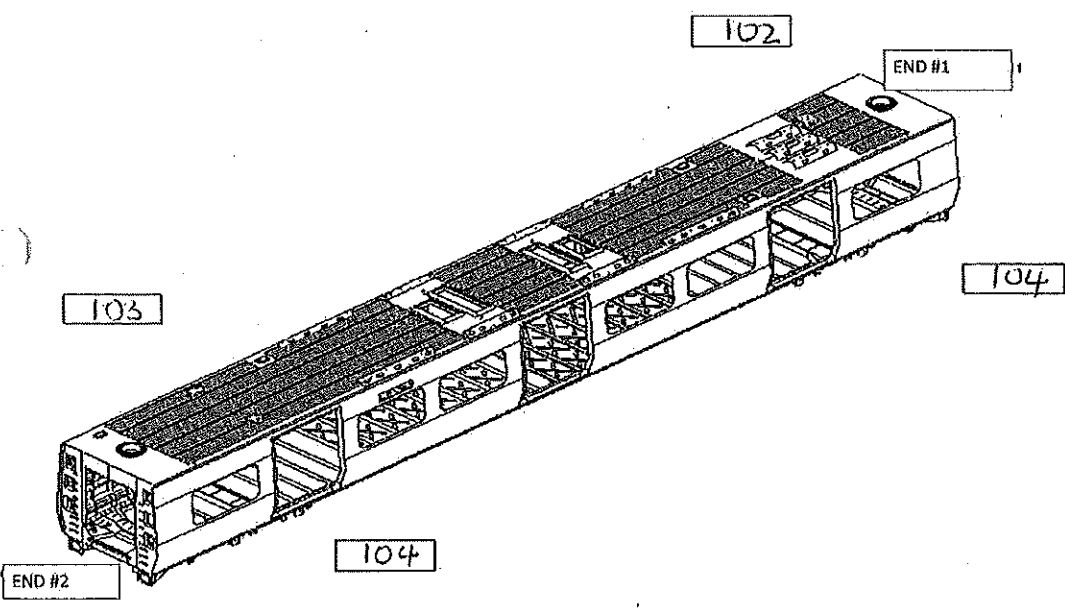


MEASURED CAMBER VALUES	
RIGHT	11 20
LEFT	11 19

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

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

LONGITUDINAL

TWIST FOUND ON END 2

TRANVERSE

LONGITUDINAL

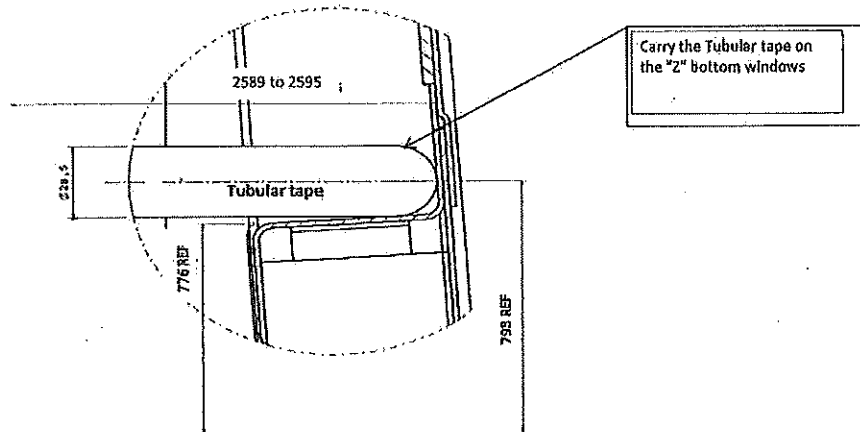


CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000226487

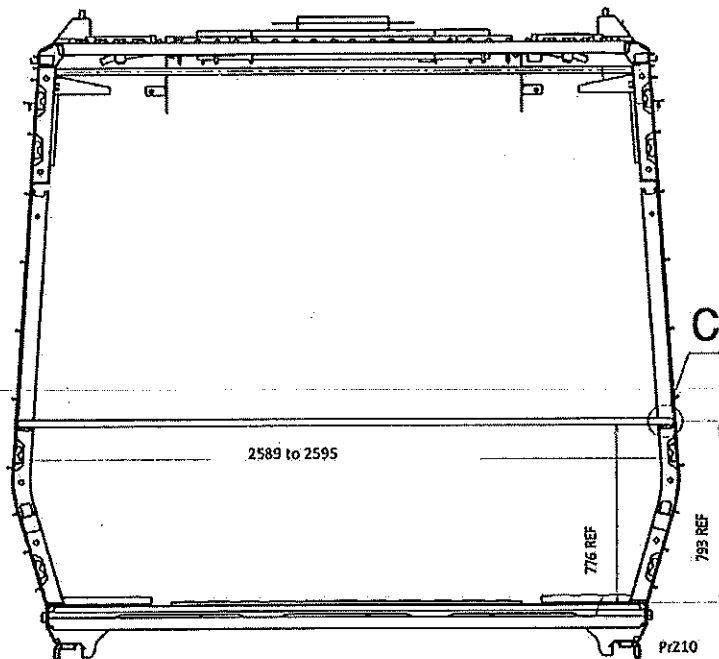
Rev.
30
Date
08/11/2023

Project: PRASA
SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230



Detail C



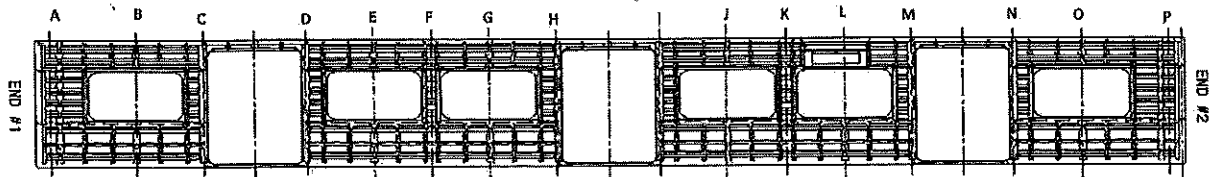


CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000226487

Rev.
30
Date
08/11/2023

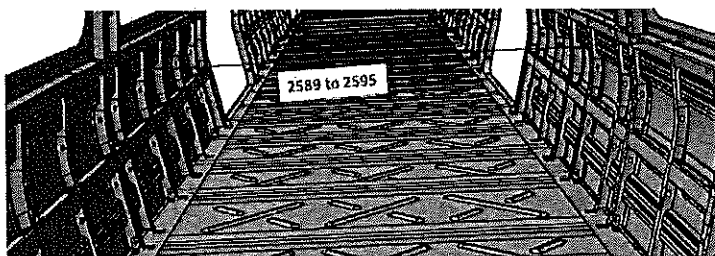
Project: PRASA
SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	2595
B	2592
C	2593
D	2592
E	2595
F	2594
G	2592
H	2593
I	2595
J	2595
K	2595
L	2594
M	2592
N	2595
O	2593
P	2594



Threshold verification

Nominal value :38

Door 1		Door 2		Door 3	
L	R	L	R	L	R
38	38	38	39	38	38
Door 4		Door 5		Door 6	
L	R	L	R	L	R
38	39	38	38	38	38

BOILER MAKER: Nonblanbla

WELDER: Lindokuhle


(Signature)

Dye penetrant test

Dye-penetration test to be performed by quality personnel



[illegible]

	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30	Project: PRA5A SI.CB2230.256.V29
		Date 08/11/2023	

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		YES	(If facilities are not complete, the missing activities must not impact the next stage)	10/06/24	Buhle Operations	BAgola
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	10/06/24	Amo Industrial Quality	
		NO GO	There are activities pending that impact/top 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

