

## CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 4 6 1   

WEIGHT: 1 4 8 9 Kg

## RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegman	26/05/24	F305031 VHE 79055	LP49402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegman	26/05/24	F204957 VHE 73052	183653 107087 01	
RCS 355	3 mm					
RCS 355	3 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegman	26/05/24	P31080 VPE 03542	1836 F205272	
RCS 355	20 mm					

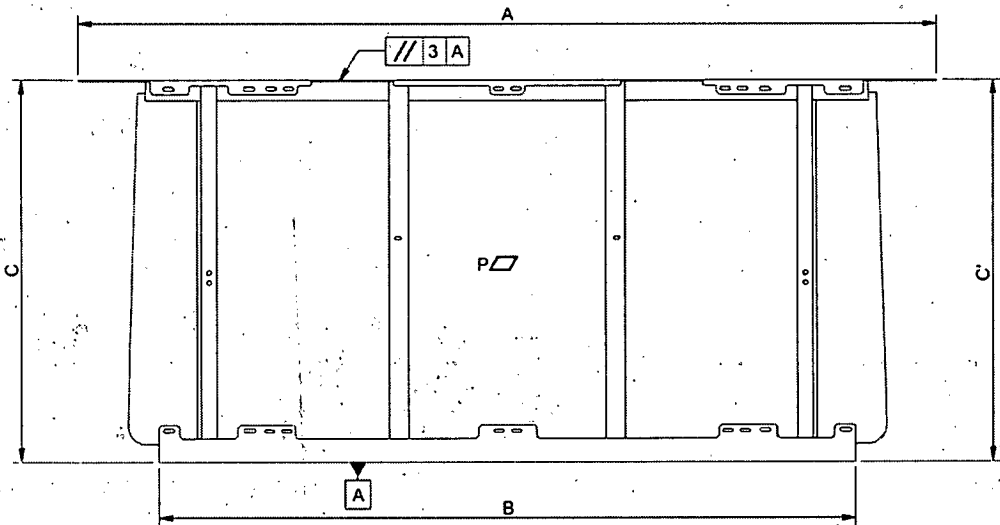
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegman	26/05/24		182592 107087 01	
RCS 355	30 mm					

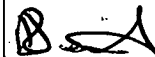

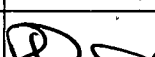
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegman	26/05/24	F207906 VHL 47403	182739 107087 01	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegman	26/05/24	F207907 VHS 62363	183446 107087 01	
RCS 450	6 mm					
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegman	22/05/24	F207908 VHS 62375	183451 107087 01	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

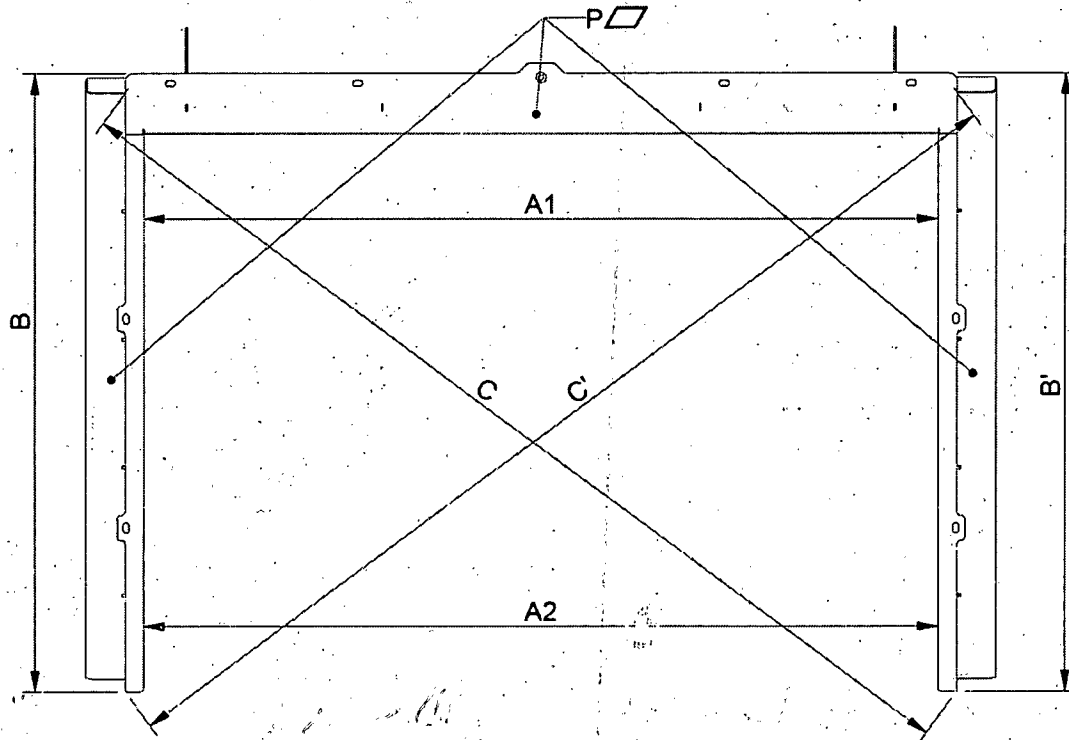
Cabin Roof Assembly: GN002839				
Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	JYLAN DAVIDS	Assembly Date:	20.24/03/28	
Sign:		Wire Batch No.:	107238201	



Welding Control					
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042			Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	Riccardo	Sign:		Date:	2024/03/28
Dimensional Control					
Rep		Toler.	Dimension measured	Measuring Equipment	Observations
A	2216	+5/-0	2216	Tape Measure	acceptable
B	1800	± 4	1801		acceptable
C	976	+2/-3	976 976		acceptable
QC Inspector:	Riccardo	Sign:		Date:	2024/03/28
Geometrical Control					
Nature of Checks		Dimension Measured		Measuring Equipment	Observations
Planeity P		6 mm	Passed	Ruler	acceptable
//	3	A	Passed	Set Square	acceptable
QC Inspector:	Riccardo	Sign:		Date:	2024/03/28

## Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047	Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator: <u>B. G. G. G.</u>	Assembly Date:	2024/04/02	
Sign: <u>[Signature]</u>	Wire Batch No.:	SS2033	



### 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:	<u>Riccardo</u>	Sign:	<u>[Signature]</u>	Date: 20__/__/__

### Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	1910	± 2	1911		Tape Measure	acceptable	
A2	1910		1911			acceptable	
B	1475	± 1	1474	1474		acceptable	
C	Diagonals  C - C'  ≤ 3		2476	2475		acceptable	
QC Inspector:		Riccardo		Sign:	Dave	Date:	2024/04/02

### Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P : Planeity	4 mm	<u>Passed</u>	Ruler	acceptable
QC Inspector:	<u>Riccardo</u>	Sign:	<u>[Signature]</u>	Date: 2024/04/02

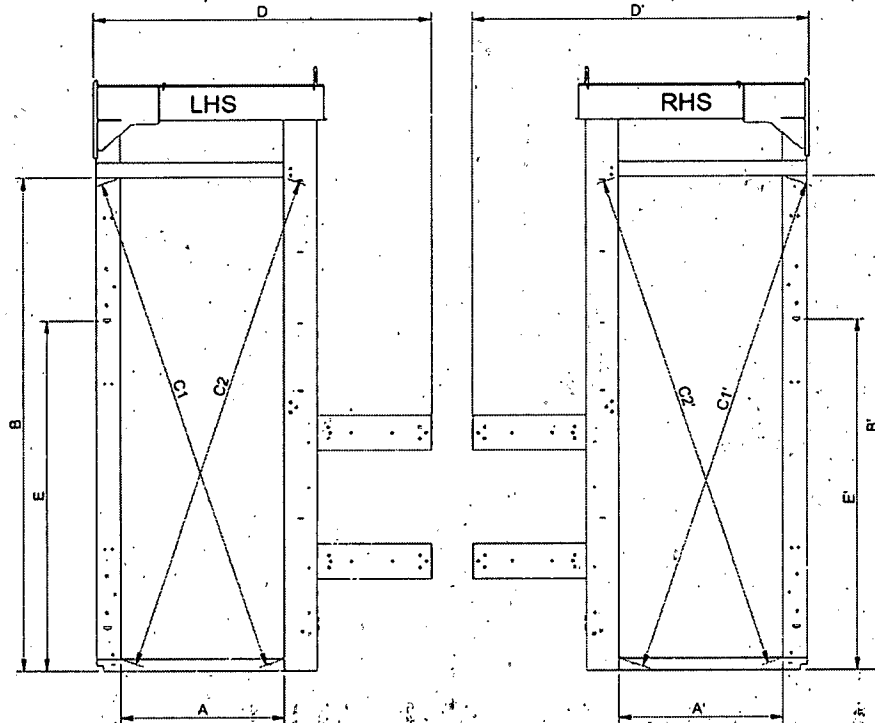
Cabin LHS/RHS Wing Mirror Plate Assembly: GN002846/GN002844				
Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>Xander</i>	Assembly Date:	2024/03/25	
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033	

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907				
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	Glenn	Assembly Date:	2024/03/20	
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033	

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897				
Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	Glenn	Assembly Date:	2024/03/20	
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033	

# Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	Glenn	Assembly Date:	2024/03/22	
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: 2024/03/25

## Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	697	Tape Measure	acceptable
B	2086	+1/-3	2085	2084		acceptable
C1 / C2	Difference of diagonals		2151	2150		acceptable
C1 - C2	C1 - C2  ≤ 3		2150	2153		acceptable
D )	1438	+2/-3	1438	1436		acceptable
E			1482	1482		

QC Inspector:	Riccardo	Sign:	<i>[Signature]</i>	Date:	2024/03/25
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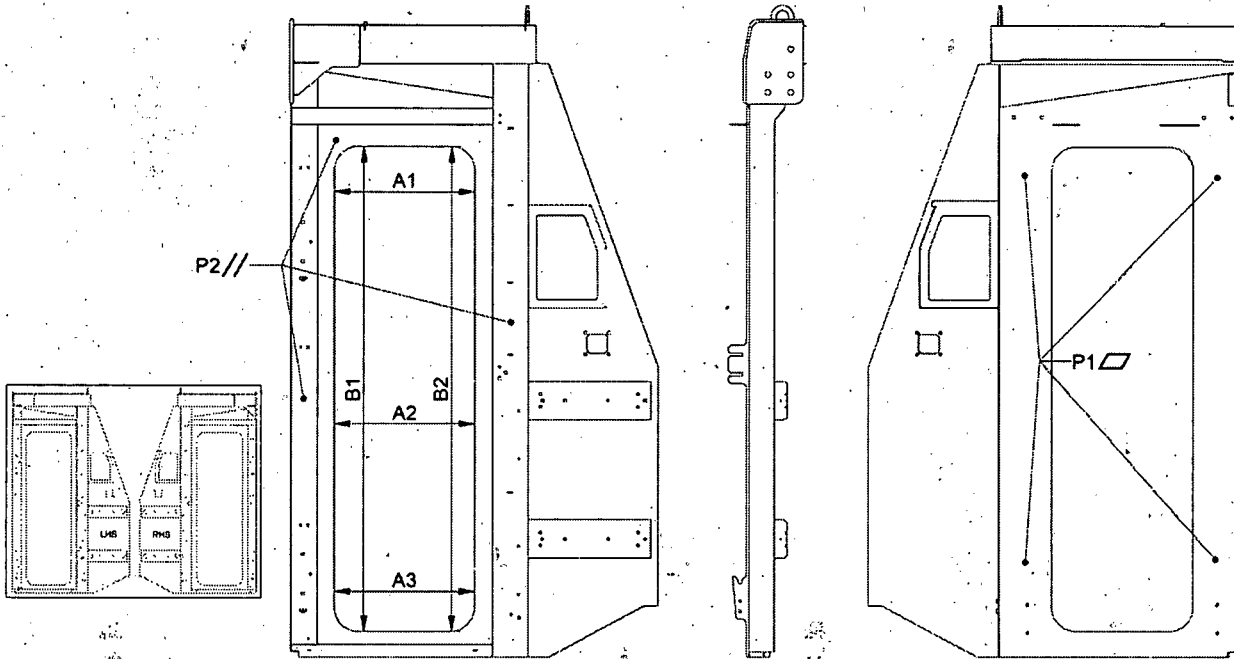
## Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	Passgo	Ruler	acceptable
QC Inspector:	Riccardo	Sign:	<i>[Signature]</i>	Date: 2024/03/25



## Cabin LHS/RHS Side Assembly: GN002838/GN002837

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Kander</i>	Assembly Date:	2024/03/26			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			



### Welding Control


Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/03/28	

### Dimensional Control


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

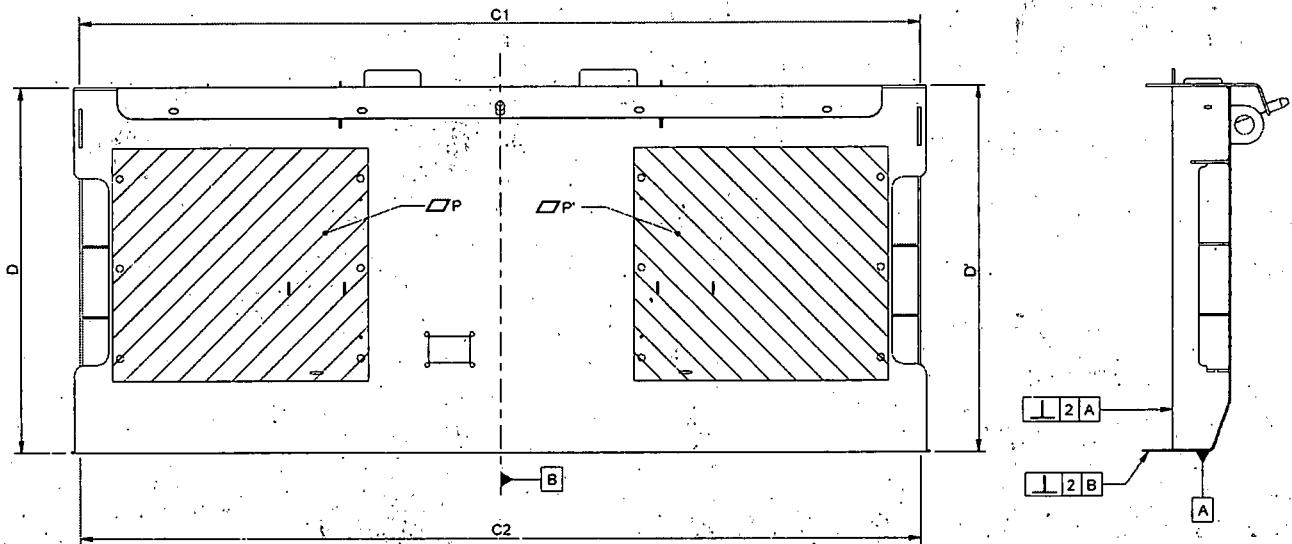
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/03/28	
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### Geometrical Control


Nature of checks		Dimension Measured	Measuring Equipment	Observations	
P1 : Planeity	4 mm	PASSED	Ruler	Accepted	
P2 : Planeity	2 mm	PASSED	Ruler	Accepted	
QC Inspector:	Riccardo	Sign:		Date:	2024/03/28

## Cabin Shield Assembly: GN002836


Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Rambelo Grinan	Assembly Date:	20 24/04/02			
Sign:		Wire Batch No.:	552033			



### Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Riccardo	Sign:		Date:	2024/04/02	

### Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2213	2214	Tape Measure	acceptable
D / D'	956	± 2	956	955		acceptable
QC Inspector:	Riccardo		Sign:		Date:	2024/04/02

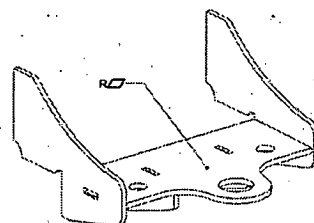
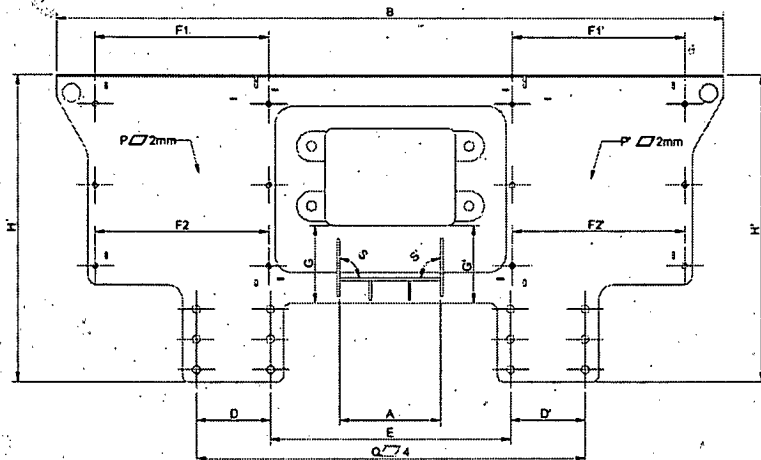
### Geometrical Control

Nature of Checks				Dimension Measured	Measuring Equipment	Observations
Planarity P / P'		2 mm		Passed	Ruler	acceptable
Perpendicularity		2	A	Passed	Set Square	acceptable
		2	B	Passed	Set Square	acceptable
QC Inspector:	Riccardo		Sign:		Date:	2024/04/02



## Cabin Front Headstock Assembly: GN002841


Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	No
Operator:	<i>TK BOOTH</i>	Assembly Date:	2024/03/25	
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	No
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date: 2024/03/25

### Dimensional Control

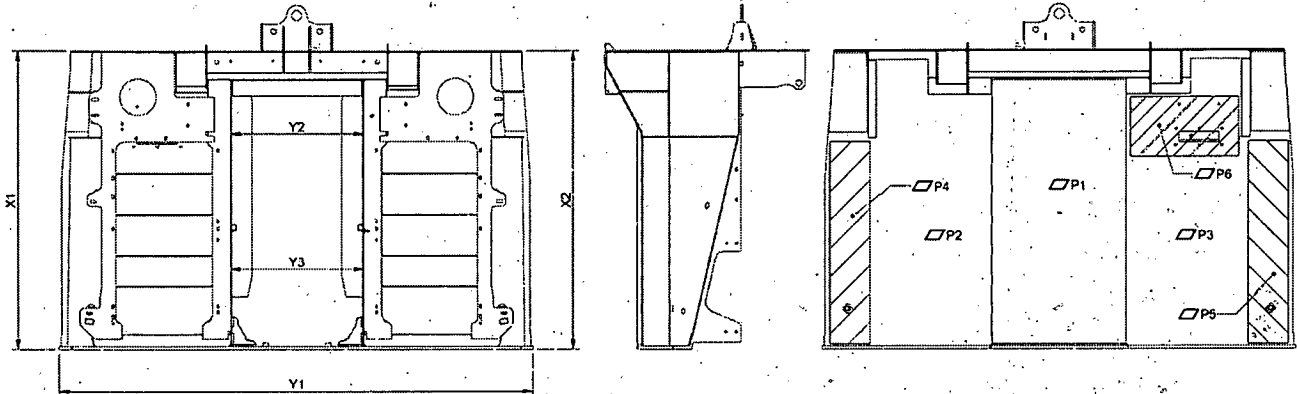
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	340	± 1	340		Tape Measure	acceptable	
B	2240	± 4	2244			acceptable	
D / D'	250	± 1	250	251		acceptable	
E	808	± 2	808			acceptable	
F1 / F1'	580	± 1	581	581		acceptable	
F2 / F2'			58	581		acceptable	
G / G'	258	± 1	258	259		acceptable	
H / H'	1019	± 2	1020	1020		acceptable	
QC Inspector:		Riccardo		Sign:		Date:	2024/03/25

### Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
O: Planeity of global assembly	4 mm	Ruler	acceptable
P / P': Planeity	2 mm	Ruler	acceptable
Q: Planeity Surface of Supports	4 mm	Ruler	acceptable
R: Planeity Coupler Support	2 mm	Ruler	acceptable
S: Perpendicularity coupler	1mm	Square	acceptable
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>
Date:	2024/03/25		

## Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	Michael Wood	Assembly Date:	2024/03/28	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202/52	



### Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
QC Inspector:	Leon	Sign:	<i>[Signature]</i>	Date: 2024/03/28


### Dimensional Control

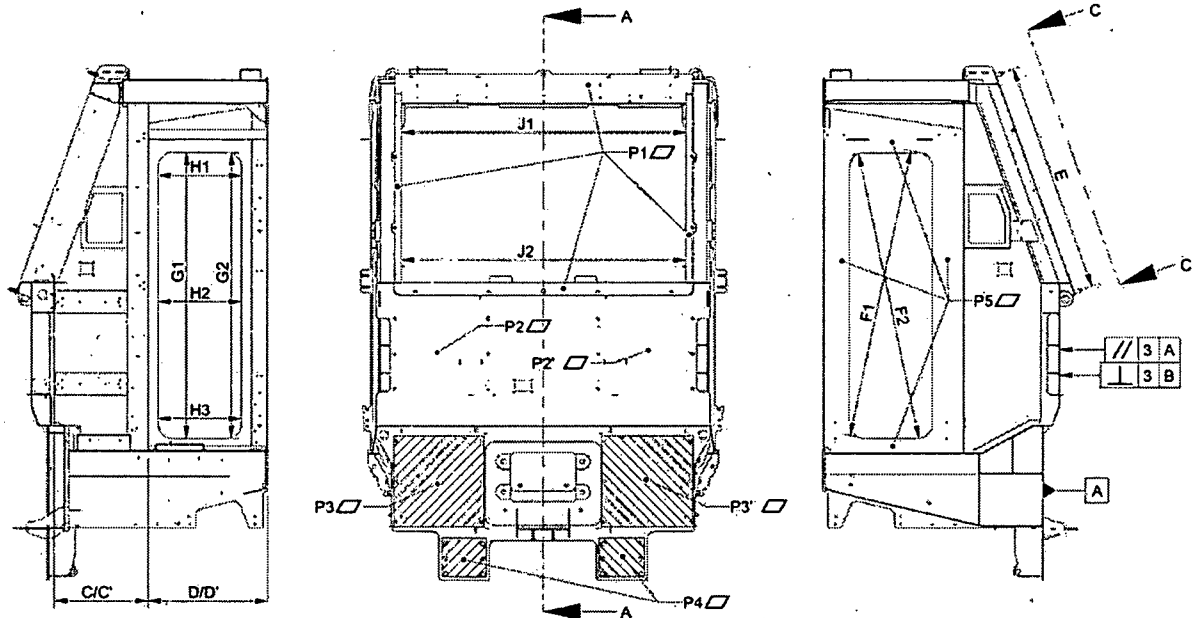
Rep	Theoretical Dim	Tolér.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1486	1486	Tape Measure	Accepted
Y1	2354	± 3	2352			Accepted
Y2 / Y3	666	± 1	666	668		Accepted
QC Inspector:		Leon	Sign:	<i>[Signature]</i>	Date:	2024/03/28

### Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations	
P1 : Planeity	4 mm	Pass	Ruler	Accepted	
P2 / P3 : Planeity	4 mm	Pass	Ruler	Accepted	
P4 / P5 : Planeity	2 mm	Pass	Ruler	Accepted	
P6 : Planeity	2 mm	Pass	Ruler	Accepted	
QC Inspector:	Leon	Sign:	A	Date:	2024/03/28

# 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 24/04/03		
Sign:		Wire Batch No.:	552635		



SECTION A-A

SECTION B-B

AUX VIEW: C

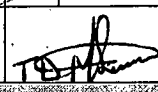
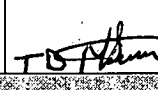
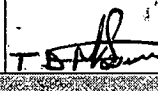
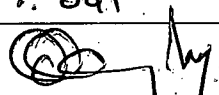
Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN-ISO 10042					Confirmed		Yes	<input checked="" type="checkbox"/>	No
QC Inspector:		Riccardo		Sign:		RD		Date:	2024/04/05
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	±2	625	625	acceptable				
D / D'	813	±2,5	813	813	acceptable				
E	1531.5	±3	1531		acceptable				
G1 / G'1	Height 1900	+1	1898	1897	acceptable				
G2 / G'2		-3	1898	1897	acceptable				
H1 / H'1	Width 560	+1	558	558	acceptable				
H2 / H'2		-3	559	558	acceptable				
H3 / H'3			560	559	acceptable				
F1 / F'1	Diagonals 1939		1937	1938	acceptable				
F2 / F'2			1937	1937	acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	0	1	acceptable				
J	Gap of Doors	± 1,5	1	1	acceptable				
K1 / K2	1515	±3	1514	1513	acceptable				
L1 / L2	1996	±3	1998	1997	acceptable				
M1 / M'1	2306	±3	2477	2477	acceptable				
M2 / M'2			2467	2468	acceptable				
T1 / T'1	2130 Top/Bottom	±3	2130	2128	acceptable				
T2 / T'2	2230 Top/Bottom		2231	2231	acceptable				
Difference	U - U' (3522)	≤ 4mm	3521	3520	acceptable				
QC Inspector:		Riccardo		Sign:		RD		Date:	2024/04/05
Geometrical Control									
Nature of checks				Toler.	LHS / Dimension Measured / RHS				
P1 / P'1	Planeity			2 mm	Passed		acceptable		
P2 / P'2	Planeity			2 mm	Passed		acceptable		
P3 / P'3	Planeity			4 mm	Passed		acceptable		
P4 / P'4	Planeity			4 mm	Passed		acceptable		
P5 / P'5	Planeity			4 mm	Passed		acceptable		
P6 Roof	Planeity			6 With 2m Ruler	Passed		acceptable		
Shield	//	3	A	3	Passed		acceptable		
Shield	⊥	3	A	3	Passed		acceptable		
Door Post	⊥	3	A	Front	Passed		acceptable		
				Back	Passed		acceptable		
QC Inspector:		Riccardo		Sign:		RD		Date:	2024/04/05

### Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>D. Miller</i>	Assembly Date:	2024/02/05			
Sign:	<i>[Signature]</i>	Wire Batch No.:	SS2-53			

### Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>S. L. Wynn</i>	Assembly Date:	20 __/__/__			
Sign:	<i>[Signature]</i>	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: DAVID		Sign: 			
Date: 2024/05/14					
Record of Shot Blasting					
Operator:		Date:		2024/05/14	
Start Time: 08 H 13		End Time:		13 H 07	
Temperature ( $\geq 15^\circ$ ): 20 - 08 °C		Humidity ( $\leq 75\%$ ):		66 - 03	
Shot Blasting Self-Inspection					
Interior of Cabin: Sa 1 - Light Stripping		Confirmed	Yes	<input checked="" type="checkbox"/>	No
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping		Confirmed	Yes	<input checked="" type="checkbox"/>	No
		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator: DAVID		Sign: 			
Date: 2024/05/14					
Shot Blasting Cleaning					
Cabin free of all sand		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator: DAVID		Sign: 			
Date: 2024/05/14					
Shot Blasting Control					
Temperature $\geq 15^\circ$ : 20 - 02 °C		Humidity $\leq 75\%$ :		63 - 06	
Internal Roughness $3.2 \leq Ra \leq 12.5$		External Roughness $3.2 \leq Ra \leq 12.5$		7.041	
QC Inspector: 2473		Sign: 			
Date: 14/05/24					

2a 5,099  
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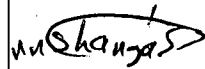

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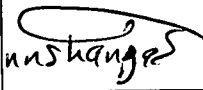

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22 36,666  
 34,828  
 38,591  
 36,008  
 32,243  
 34,775  
 36,748  
 39,604  
 42,383  
 32,442



Record of Priming							
Start Time:	18:00			End Time:	17:00		
Temperature $\geq 15^{\circ}$ :	26%			Humidity $\leq 75\%$ :	43%		
Paint Batch No.:	8016059			Paint Expiry Date:	08/25		
Hardener Batch No.:	7331119			Hardener Expiry Date:	01/11/24		
Desolvation Start Time:	17:00			Desolvation End Time:	17:15		
Stoving Start Time:	17:15			Stoving End Time:	18:15		
Stoving Temp:	60°C						
Operator:	musa			Sign:			
Date:	20/04/24				musa		
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 80.3	5: 56	1: 83	5: 78.6	1: 63.6	5: 66.2	1: 39	5: 40.6
2: 74.2	6: 44	2: 33.6	6: 100	2: 113.6	6: 60.4	2: 70.6	6: 102.3
3: 70.8	7: 41.3	3: 60	7: 86.3	3: 90.6	7: 61.2	3: 89.2	7: 70.6
4: 96.1	8: 39.6	4: 70	8: 74.2	4: 100.8	8: 71.8	4: 78.9	8: 77.8
Min:	39.6	Min:	33.6	Min:	60.4	Min:	39
Max:	86.3	Max:	100	Max:	113.6	Max:	102.3
Average:	58.5	Average:	73.2	Average:	78.5	Average:	68.6
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 56.7	5: 60.9	1: 100.6	5: 60.8	1: 50.3	5: 60	1: 69.8	5: 77.8
2: 113.8	6: 102.6	2: 46.7	6: 70.6	2: 54	6: 90	2: 60.8	6: 70.4
3: 45.6	7: 98.2	3: 78.9	7: 71.8	3: 43	7: 74	3: 74	7: 80.6
4: 39.4	8: 110.6	4: 39.8	8: 30.6	4: 61.2	8: 50.7	4: 69.8	8: 90.6
Min:	39.4	Min:	30.6	Min:	50.3	Min:	60.8
Max:	113.8	Max:	100.6	Max:	90	Max:	90.6
Average:	78.4	Average:	64.3	Average:	61	Average:	73
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 54.6	5: 113.6	1: 54	5: 28.3	1: 77.3	5: 70.6	1: 86.1	5: 77.6
2: 57.8	6: 104	2: 80.6	6: 76.8	2: 89.2	6: 43.6	2: 100.6	6: 43.6
3: 83.2	7: 60.8	3: 77.8	7: 93.2	3: 93.2	7: 78.6	3: 74.6	7: 59.8
4: 77.6	8: 74.6	4: 68.2	8: 77.6	4: 78.6	8: 39.8	4: 68.8	8: 70.6
Min:	54.3	Min:	28.3	Min:	39.8	Min:	43.6
Max:	113.6	Max:	93.2	Max:	93.2	Max:	100.6
Average:	77.8	Average:	69	Average:	70	Average:	71
Primer has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	Reece			Sign:	Reece		
Date:	22/05/24						

Record of Painting NCSS3010 R90B			
Start Time:	21:00	End Time:	21:30
Temperature $\geq 15^{\circ}$ :	27 $^{\circ}$ C	Humidity $\leq 75\%$ :	61%
Paint Batch No.:	8216294	Paint Expiry Date:	04/04/2025
Hardener Batch No.:	8138195113	Hardener Expiry Date:	11/26
Desolvation Start Time:	21:30	Desolvation End Time:	21:45
Stoving Start Time:	21:45	Stoving End Time:	22:45
Stoving Temp:	60 $^{\circ}$ C		
Operator:	Ntuthuko	Sign:	
Date:	2024/05/22		
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: 180	5: 158	1: 91.2	5: 68.5
2: 113	6: 152	2: 73.5	6: 82.3
3: 129	7: 190	3: 81.7	7: 103
4: 157	8: 163	4: 101	8: 95.5
Min:	133	Min:	68.5
Max:	190	Max:	103
Average:	155	Average:	87.8
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	
QC Inspector:	Zothile	Sign:	
Date:	24 May 2024		

Record of Painting Blue NCSS1565 B					
Start Time:		03:00		End Time: 03:30	
Temperature ≥ 15°:		031°C		Humidity ≤ 75%: 64%	
Paint Batch No.:		8216288		Paint Expiry Date: 27.03.2025	
Hardener Batch No.:		8138195113		Hardener Expiry Date: 11/26	
Desolvation Start Time:		03:30		Desolvation End Time: 03:45	
Stoving Start Time:		03:45		Stoving End Time: 04:45	
Stoving Temp:		60°C			
Operator:		ntutuko		Sign: 	
Date:		2024/05/23			
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: 97.6	5: 133	1: 106	5: 99.5		
2: 97.1	6: 100	2: 99.7	6: 76.4		
3: 98.1	7: 178	3: 101	7: 99.1		
4: 99.8	8: 122	4: 89.4	8: 106		
Min:	97.1	Min:	89.4		
Max:	178	Max:	106		
Average:	115	Average:			
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	
QC Inspector:		Zothile		Sign: 	
Date:		24 May			

Record of RAL 7012			
Start Time:	14:00	End Time:	16:00
Temperature $\geq 15^{\circ}$ :	30°C	Humidity $\leq 75\%$ :	58
Paint Batch No.:	8196593	Paint Expiry Date:	16-02-25
Hardener Batch No.:	8138195113	Hardener Expiry Date:	11/26
Dissolution Start Time:	16:00	Dissolution End Time:	16:15
Stoving Start Time:	16:15	Stoving End Time:	17:15
Stoving Temp:	60°C	Sign:	MUSA
Operator:	MUSA		
Date:	2024/05/22		

RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 104	5: 118	1: 143	5: 104	1: 146	5: 99.4	1: 81.8	5: 80.8
2: 111	6: 96.1	2: 99.6	6: 120	2: 106	6: 91.1	2: 75.3	6: 102
3: 90.8	7: 96.1	3: 95.0	7: 86.3	3: 94.4	7: 141	3: 156	7: 98.1
4: 127	8: 96.1	4: 80.2	8: 118	4: 86.0	8: 90.0	4: 118	8: 140
Min:	90.8	Min:	80.2	Min:	86.0	Min:	75.3
Max:	127	Max:	143	Max:	146	Max:	156
Average:	104	Average:		Average:	106	Average:	106
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 108	5: 103	1: 152	5: 99.3	1: 152	5: 143	1: 87.8	5: 143
2: 102	6: 99.9	2: 102	6: 98.5	2: 119	6: 144	2: 92.2	6: 90.1
3: 83.8	7: 104	3: 124	7: 161	3: 133	7: 154	3: 91.5	7: 122
4: 120	8: 144	4: 99.3	8: 98.5	4: 115	8: 160	4: 174	8: 148
Min:	83.8	Min:	98.5	Min:	115	Min:	87.8
Max:	144	Max:	152	Max:	160	Max:	174
Average:	107	Average:	109	Average:	140	Average:	118
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 111	5: 170	1: 92.8	5: 198	<div>Confirmed</div> <div>Value</div> <div>Sign: </div> <div> <div>Confirmed</div> <div>YES</div> <div>NO</div> </div>			
2: 101	6: 128	2: 108	6: 158				
3: 94.2	7: 134	3: 94.6	7: 174				
4: 127	8: 180	4: 122	8: 167				
Min:	94.2	Min:	92.8				
Max:	180	Max:	198				
Average:		Average:	129				

Painting NCSS3010 R90B has been inspected and is free of defects

GMS-SOS-GIBELA-PS-002 Gloss Test

QC Inspector:

Zahile

Date:

24 May 2024

SEALING OF CABIN

All areas where there is no welding has been sealed with SIKA  
All sealants have been neatly applied along joints

SIGN OFF

OPERATOR SIGN:

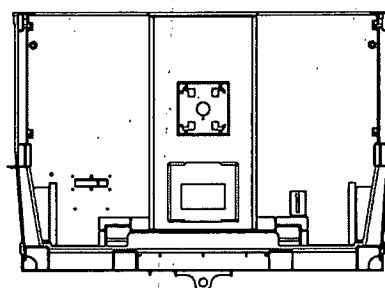
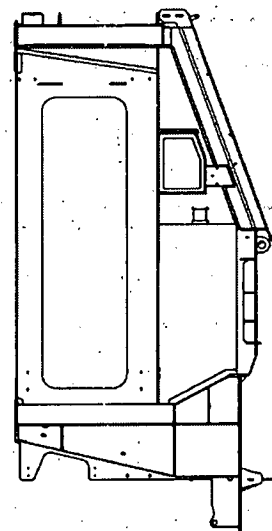
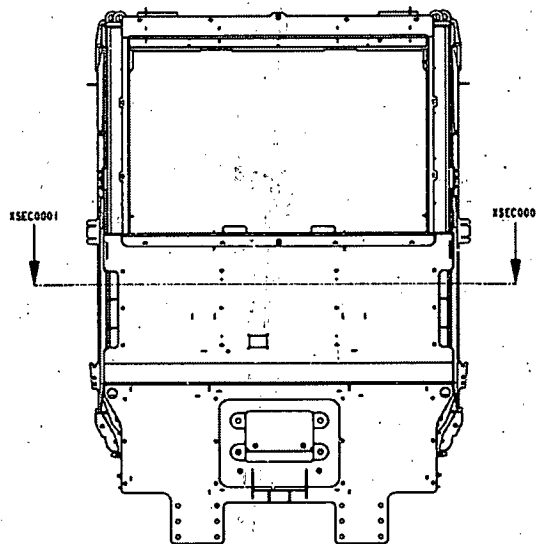
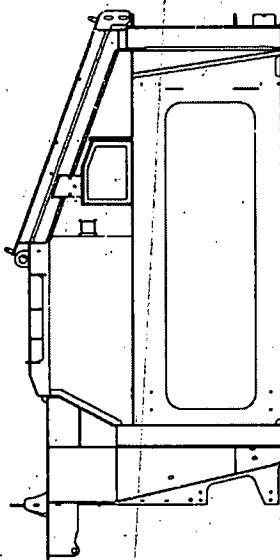
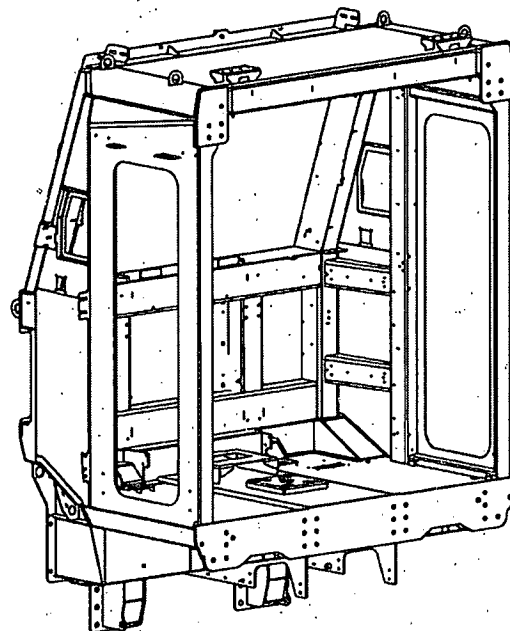
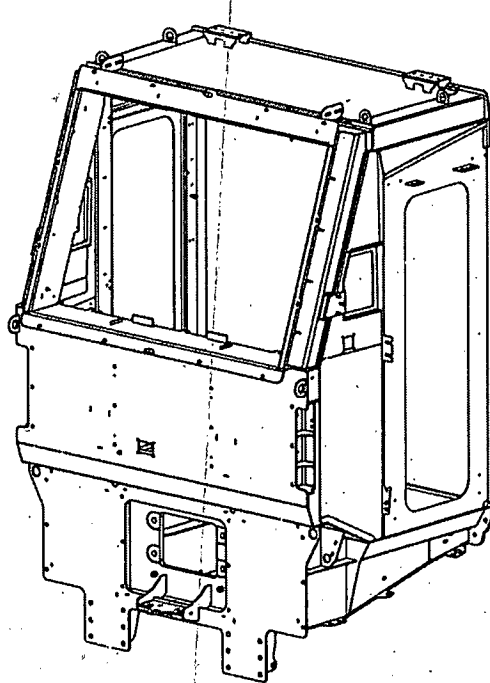
DATE:

24 May 2024



# REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)





## FAULT TRACKING

[illegible]

**REMINDERS / COMMENTS**

[illegible]





## CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	461	Checks Updated:	2022/08/26

Disposition Key:	0	Pass
	X	Fail (Concession required)
	Δ	Rework required

No.	Description of inspection	Disposition	Validation after rework		Sign
			Repairer	Disposition	
1	WELDS ARE CLOSED	○			
2	NO PIN HOLES ON CAB STRUCTURE	○			
3	SEALANT IS APPLIED CORRECTLY <ul style="list-style-type: none"><li>JOINTS ARE CLOSED</li><li>NO BREAKS IN THE SEALANT</li><li>CORRECT BEAD</li></ul>	○			
4	RIVET NUTS ARE PROPERLY CRIMPED <ul style="list-style-type: none"><li>RIVETS ARE MARKED</li><li>CORRECT GRIP RANGE USED</li></ul>	○			
5	NO MISS WELDS PRESENT AFTER SANDBLASTING	○			
6	NO VISUAL MISS WELDS (INSPECTION AFTER SEALING)	○			
7	NO PAINT IN THREADS	○			
8					
9					
10					
11					
12					
13					
14					

Quality approval for release Signature	CO. NO:	DATE
	2291	27/05/24