

GIBELA

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.

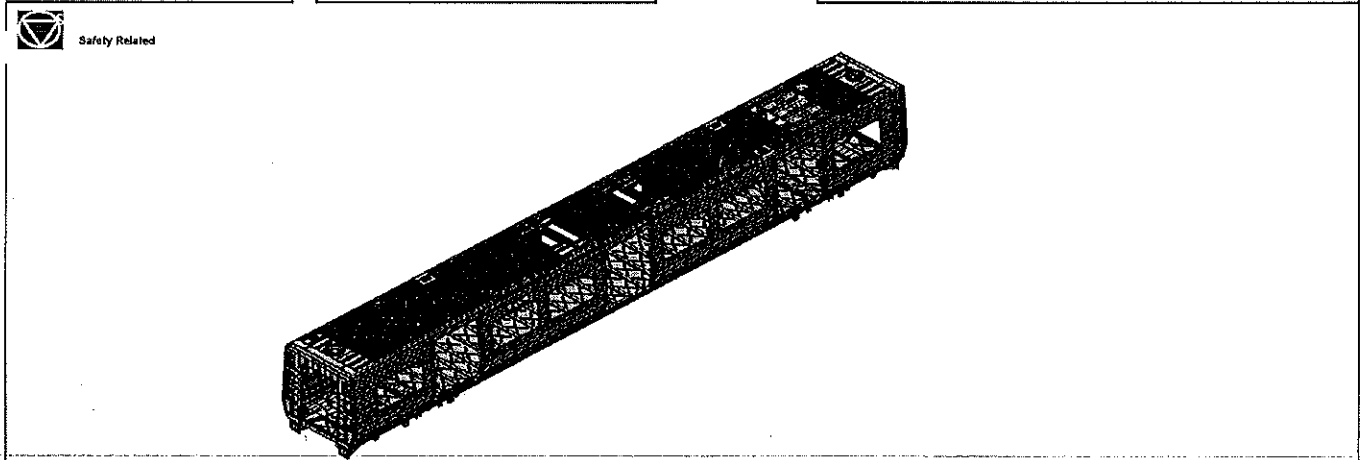
APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?
				TC1	M4	M1	M2	M3	TC2		
DTR3000152644	AAD0001278566	CARBODYSHELL M3,M4 ASSEMBLY	CB1210		X				X	PRA.CB1210.DTR30225 487/3.V30	YES

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	06/08/2020
			REVISED BY	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			REVISED BY	Bongane Masina	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi Collins	17/08/2021
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISED BY	Mpho Mulaudzi	17/08/2021
25	19/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi Collins	19/02/2022
			CHECKER	Andani Muthelo	19/02/2022
			REVISED BY	Andani Muthelo	19/02/2022
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlame Amogelang	14/04/2023
			REVISED BY	Mohlame Amogelang	14/04/2023
28	07/11/2023	Added traceability for welding sections	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Mohlame Amogelang	07/11/2023
			REVISED BY	Ntokozo Zwane	07/11/2023
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
T3233	M4	P. MALATJI	12/06/24	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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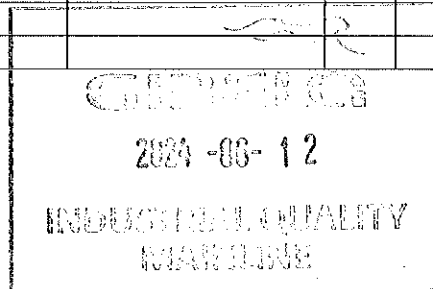



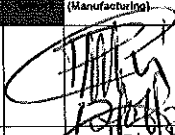
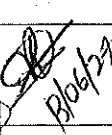
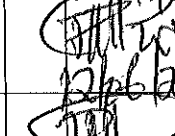
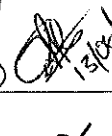

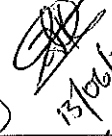


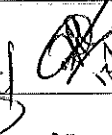
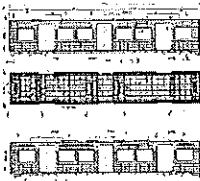
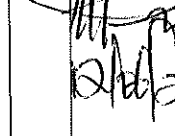

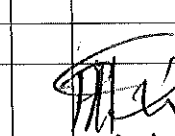
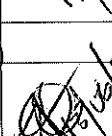
I - Documentation and Instruments Control

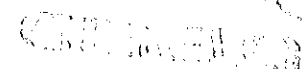
I.1 - Documentation Control									
Document	Type of car						Revision	Observation	OK
	TCL	MT	SE	SE	SE	SE			
DTR30225487/3						X	V28		✓
<div> <div>Signature/Date (Manufacturing)</div> <div>Signature/Date (Quality)</div> </div>									


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)	
IMBULAR	32823-0	15/05/25	✓		[Signature]	[Signature]	
LASER	125425920	02/11/25	✓		[Signature]	[Signature]	
SOIU	61870102	18/11/24	✓		[Signature]	[Signature]	

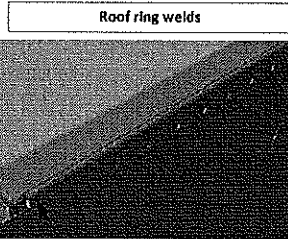
1.3 Consumables							
Welding Consumable Control - Used for Special Process							
Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)	
ER 308 LSI	31408-74057	111 C	✓		[Signature]	[Signature]	
ER 308 L	049624-70322	111 C	✓		[Signature]	[Signature]	13/06



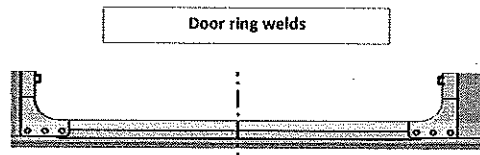
		CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V30		
			Date 07/11/2023			
II - Self Inspection - Items to Check						
II.1 - Items to check						
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		
02	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓		
03	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓		
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.	✓		


 2023-08-12
 ENDPOINT QUALITY
 10/08/2023

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



LHS Boiler maker (Name & Sign): <u>[Signature]</u>	Welder (Name & Sign): <u>KETU K. N. N. N.</u>
RHS Boiler maker (Name & Sign): <u>[Signature]</u>	Welder (Name & Sign): <u>MTHOKOZISI</u>



LHS

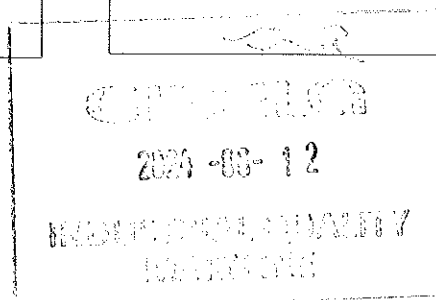
Boiler maker (Name & Sign): Innocent MKE

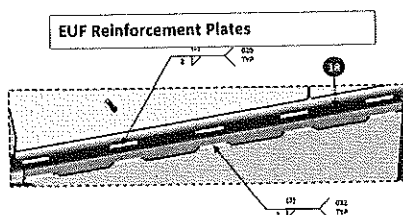
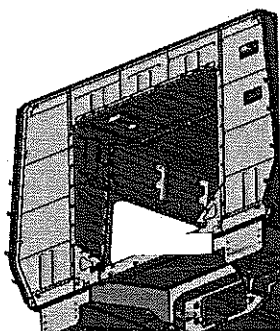
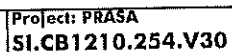
Welder (Name & Sign): BOBBY

RHS

Boiler maker (Name & Sign): Innocent MKE

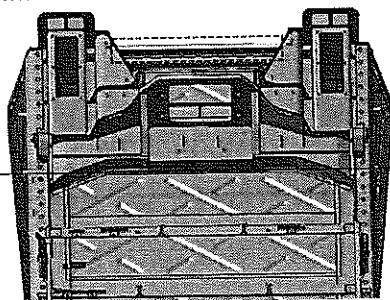
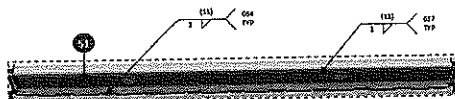
Welder (Name & Sign): BOBBY





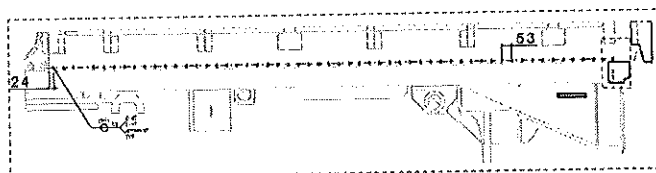
Boiler maker (Name & Sign):

Welder (Name & Sign):



Boiler maker (Name & Sign):

Welder (Name & Sign):



Operator:

[Handwritten:] 67-1000
67-1000
2004-08-12
RECEIVED BY MAIL ROOM
[Stamp:] AUG 12 2004

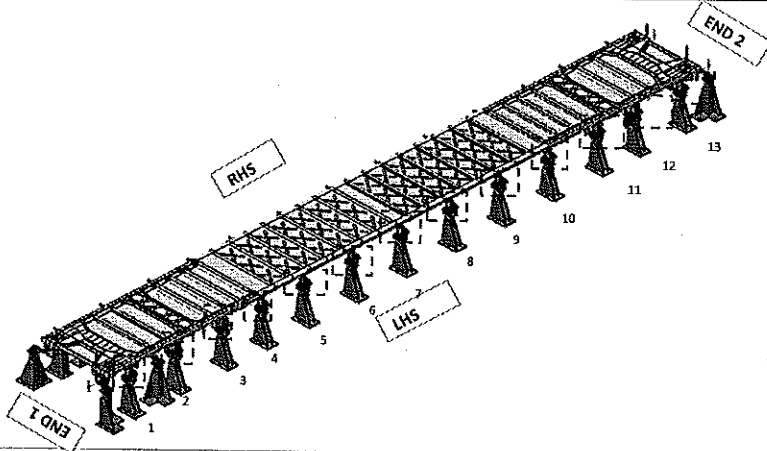


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.
28
Date
07/11/2023

Project: PRASA
SI.CB1210.254.V30

Specifications of Details for CBS measurement



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

After loading and clamping

Fill in the gap found on each jig pillars / chair and underframe should be 0mm.

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0

Signature Operations:

Date:

12/06/24

After Welding.

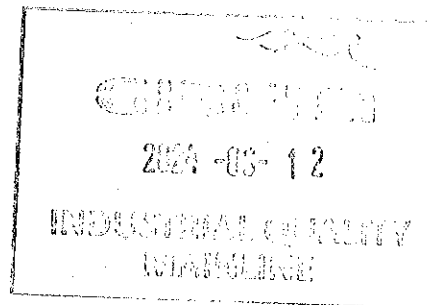
Fill in the gap found on each jig pillars / chair and underframe should be 0mm.

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0

Signature Industrial Quality:

Date:

14/06/24



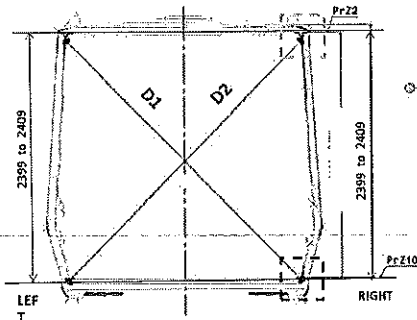
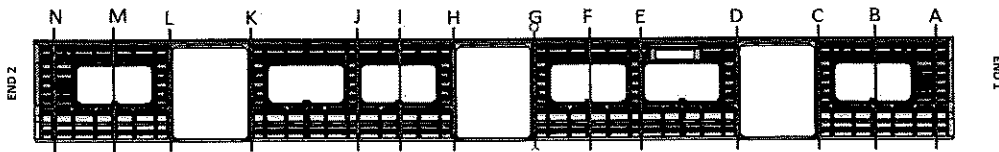


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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28
Date
07/11/2023

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SI.CB1210.254.V30

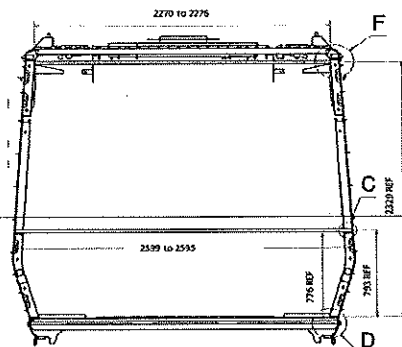
Specifications of Details for CBS measurement



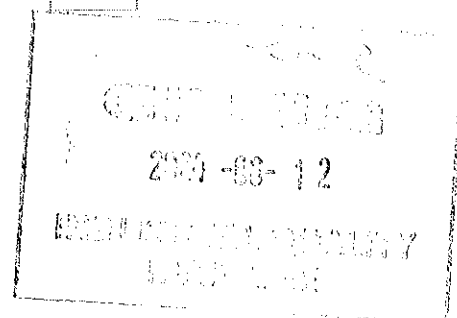
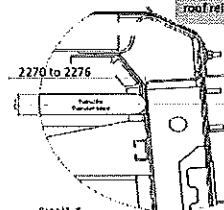
Measurement positions on roof rail and sidewall omega corner.



Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.





CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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28

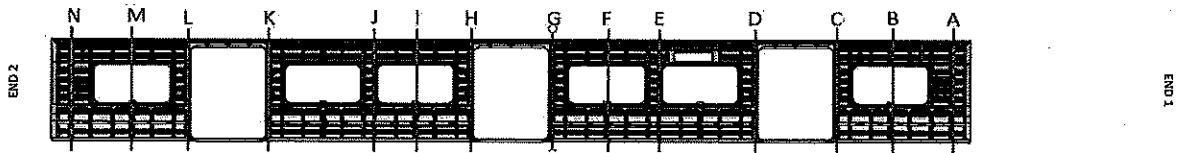
Date

07/11/2023

Project: PRASA

SI.CB1210.254.V30

Specifications of Details for CBS measurement

PME Column LHS - RHS should be $\leq 2\text{MM}$ on each point.


BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3269	3268	1	2404	2404	0
B	3268	3268	0	2406	2405	1
C	3271	3270	1	2404	2406	2
D	3270	3269	1	2404	2404	0
E	3271	3271	0	2405	2404	1
F	3270	3269	1	2406	2404	2
G	3268	3269	1	2403	2404	1
H	3269	3269	0	2404	2404	0
I	3271	3268	3	2404	2406	2
J	3269	3267	2	2404	2403	1
K	3268	3269	1	2404	2405	1
L	3268	3268	0	2404	2404	0
M	3269	3268	1	2406	2404	2
N	3266	3267	1	2405	2405	0

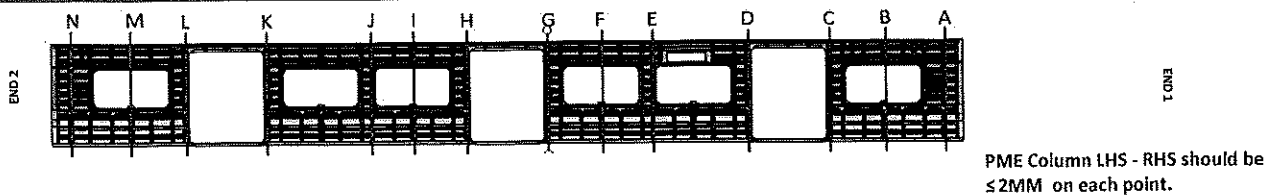
GIBELQ

2024-03-12

INDUSTRIAL QUALITY
LABORATORY


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


Specifications of Details for CBS measurement




AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3296	3296	0	2401	2403	1
B	3269	3267	2	2401	2405	1
C	3298	3297	1	2401	2401	0
D	3299	3299	0	2406	2404	2
E	3271	3270	1	2428	2401	1
F	3270	3270	0	2403	2401	1
G	3295	3298	3	2401	2404	0
H	3296	3296	0	2406	2405	1
I	3268	3267	1	2404	2406	2
J	3270	3269	1	2401	2405	1
K	3298	3297	1	2401	2401	0
L	3298	3298	0	2405	2401	1
M	3269	3268	1	2401	2406	2
N	3296	3297	1	2403	2405	2

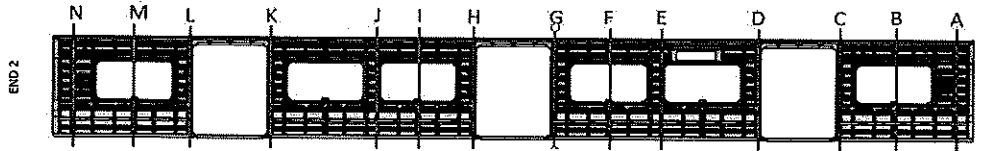

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12/06/24


2024-08-12
INTEGRITY
LAWYERS

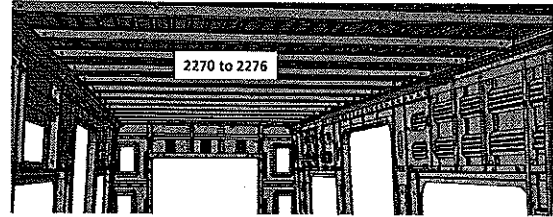
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		Date 07/11/2023	

CBS measurement

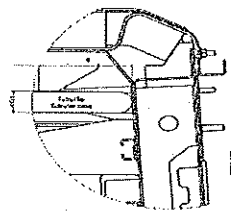
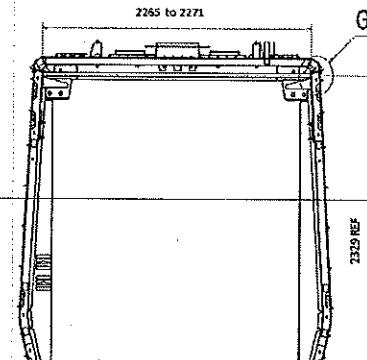
BEFORE WELDING



	2270 to 2276
A	2271
B	2274
C	2276
D	2278
E	2276
F	2274
G	2272
H	2274
I	2278
J	2276
K	2274
L	2272
M	2272
N	2274

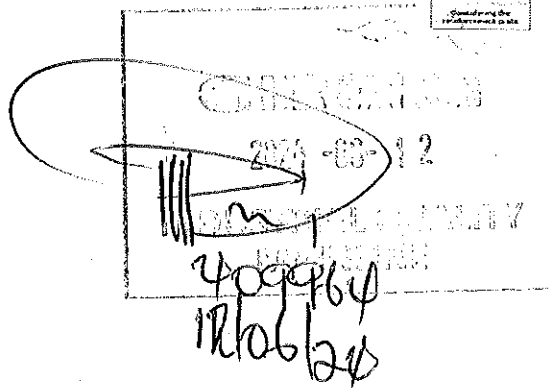



Do not consider reinforcement (Take measurements top area of zee profile



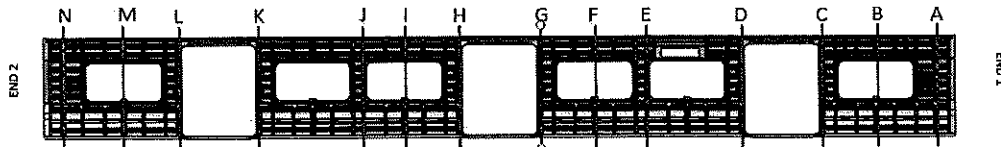
2265 to 2271

Detail 0
Detail from the reinforcement plate

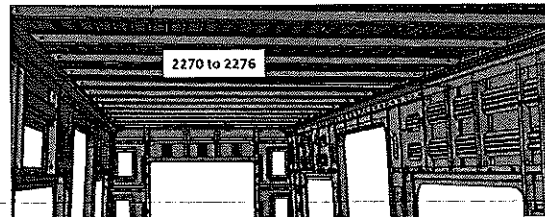


	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRA5A SI.CB1210.254.V30
		Date 07/11/2023	
		CBS measurement	

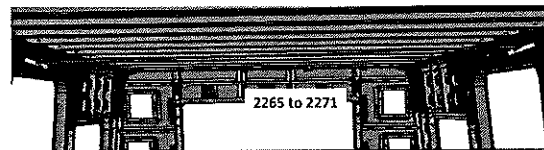
AFTER WELDING



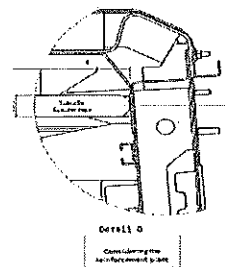
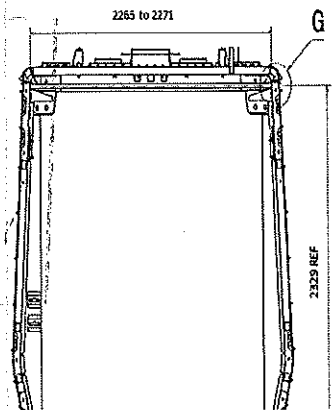
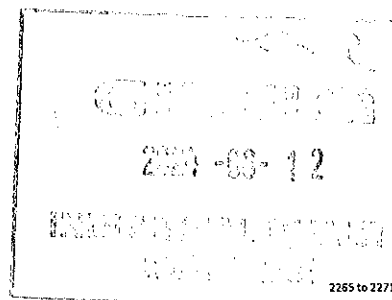
	2265 to 2271	2270 to 2276
A	2269	
B		2274
C	2265	
D	2267	
E		2276
F		2275
G	2268	
H	2266	
I		2273
J		2274
K	2267	
L	2265	
M		2276
N	2266	



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



Take measurement close to radius (considering reinforcement)



Handwritten signature and date 2024-08-12.

49964
010664

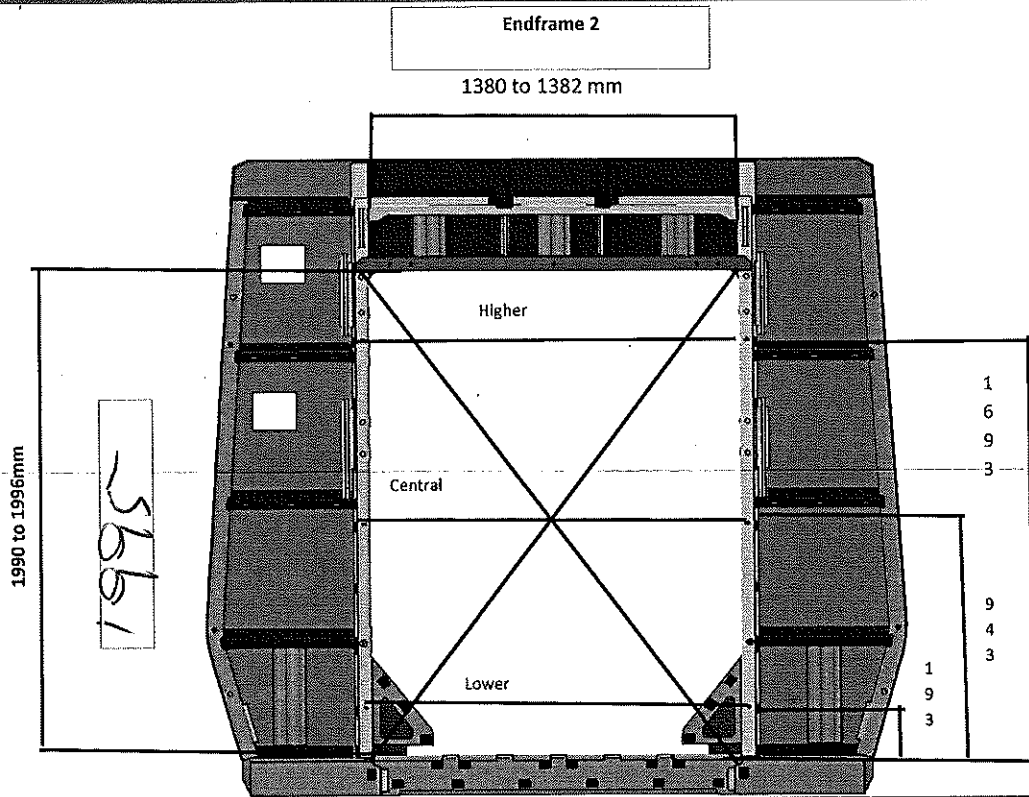


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1380

D1

2416

Central Dimension

1381

D2

2416

Lower Dimension

1380

D1-D2

0

2011-08-12
209964
12/06/24

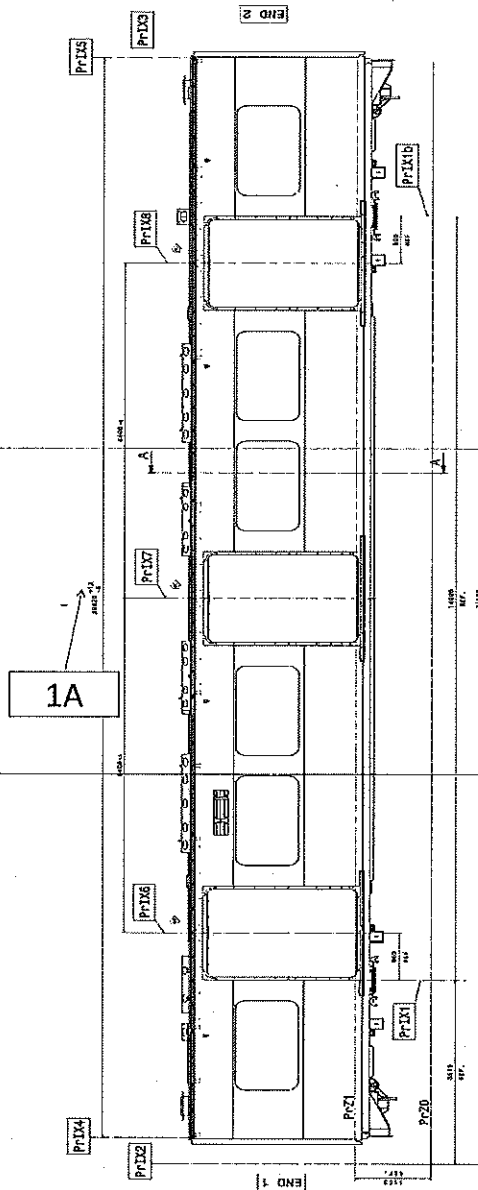


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

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Date
07/11/2023

Project: PRASA
SI.CB1210.254.V30

Specifications of Details for CBS measurement



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20616

RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20616


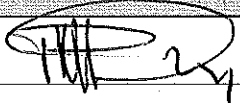

[Handwritten signature]
20632-20614
20616

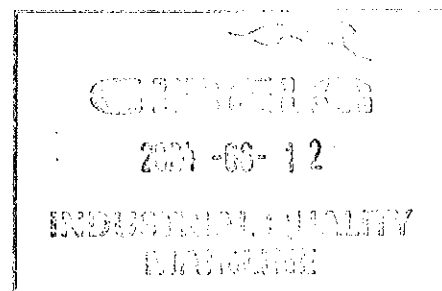
Dye penetrant test

Dye-penetration test to be performed by quality personnel



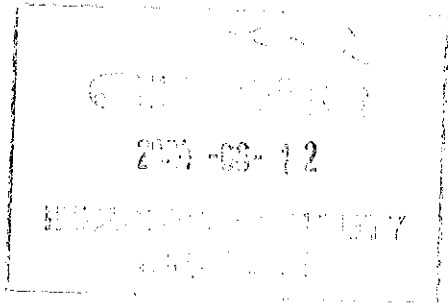
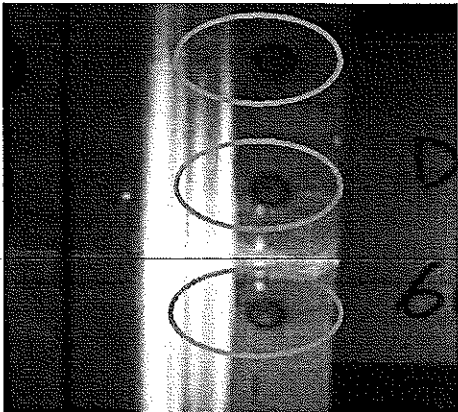
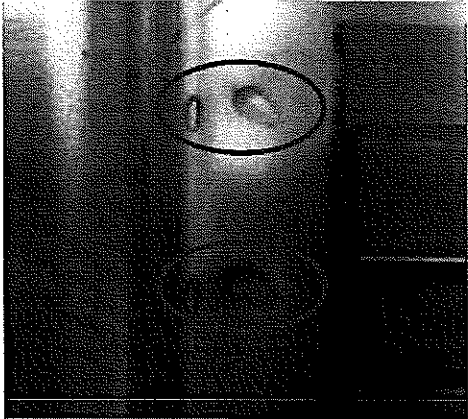
GIBELQ
254-03-12
INDUSTRIAL QUALITY
MANAGEMENT


		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 <small>(If activities are not complete, the missing activities must not impact the next stage)</small>	12/06/2024	P. MALAKI Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	12/04/2024	AMOGELANG Industrial Quality	
		There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)		Operations	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)		Industrial Quality	
In case of "NO GO", describe blocking problems					
In case of "NO GO", the operations manager must define below action plan to ensure "GO":					
Item	Description		Responsible	Due date	Status
Operations			Quality		



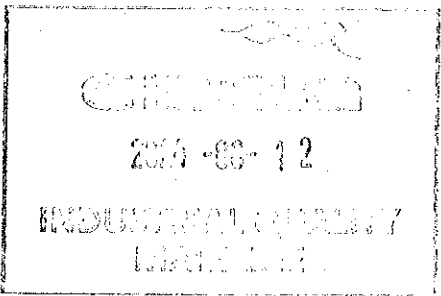
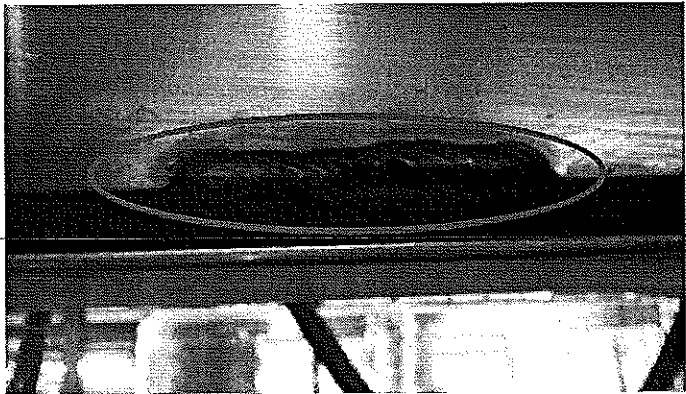
	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V30
		Date 07/11/2023	


ANNEXURE A: Spot Welding Quality Acceptance Standard



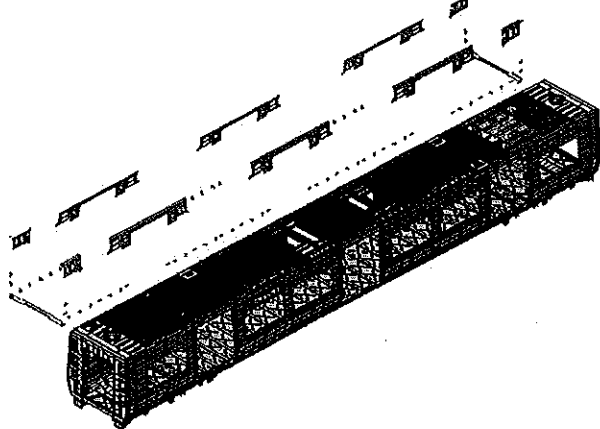





	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V30
		Date 07/11/2023	


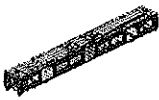
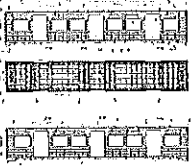


ANNEXURE B: Arc Welding Quality Acceptance Standard




GIBELA		PRASA PROJECT									
											
APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1 SELF INSPECTION SHEET											
CONFIDENTIAL INFORMATION This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.											
APPLICATION REFERENCE											
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY
				TC1	MA	M1	M2	M3	TC2		
<input type="checkbox"/>	DTR0225487/2	AA0001278555	CB2220		X	X		X		PRA.CB2220.DTR0225487/2.V21	YES
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
<input type="checkbox"/>											
REV	DATE	MODIFICATION CONTENT		RESPONSIBLE	NAME	DATE					
0	01/02/2018	GIBELA NEW CREATION		APPROVER	Itumeleng Modiba	01/02/2018					
				CHECKER	Nosizo Pindela	01/02/2018					
				COMPILED	Thanyani Mathegu	01/02/2018					
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager		APPROVER	Itumeleng Modiba	18/05/2018					
				CHECKER	Nosizo Pindela	18/05/2018					
				REVISED BY	Ramokone Motama	18/05/2018					
2	2018/07/05	Certain dimensional checks added and others moved to CB1210		APPROVER	Itumeleng Modiba	2018/07/05					
				CHECKER	Nosizo Pindela	2018/07/05					
				REVISED BY	Ramokone Motama	2018/07/05					
3	2018/06/12	Width tolerance as per DT0000336600		APPROVER	Itumeleng Modiba	2018/06/12					
				CHECKER	Nosizo Pindela	2018/06/12					
				REVISED BY	Nosizo Pindela	2018/06/12					
5	24/01/2019	As per Baseline 10.2		APPROVER	Itumeleng Modiba	24/01/2019					
				CHECKER	Nosizo Pindela	24/01/2019					
				REVISED BY	Vanessa Ntuli	24/01/2019					
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements Remove		APPROVER	Itumeleng Modiba	13/03/2019					
				CHECKER	Nosizo Pindela	13/03/2019					
				REVISED BY	Nosizo Pindela	13/03/2019					
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	05/08/2020	New Baseline 10.2.6		APPROVER	Timothy Maimela	06/08/2020					
				CHECKER	Bongane Masina	06/08/2020					
				REVISED BY	Bongane Masina	06/08/2020					
20	19/04/2021	New Baseline change 10.3		APPROVER	Timothy Maimela	19/04/2021					
				CHECKER	Bongane Masina	19/04/2021					
				REVISED BY	Bongane Masina	19/04/2021					
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING		APPROVER	Mbhombi Collins	17/08/2021					
				CHECKER	Mpho Mulaudzi	17/08/2021					
				REVISED BY	Mpho Mulaudzi	17/08/2021					
25	20/02/2022	New Baseline change 10.3.1		APPROVER	Collins Mbhombi	19/02/2022					
				CHECKER	Andani Muthelo	19/02/2022					
				REVISED BY	Andani Muthelo	19/02/2022					
26	14/05/2022	Update minimum temperature requirement for sealant application		APPROVER	Collins Mbhombi	14/05/2022					
				CHECKER	Andani Muthelo	14/05/2022					
				REVISED BY	Andani Muthelo	14/05/2022					
27	19/10/2022	Addition of traceability for sealant application & welding		APPROVER	Collins Mbhombi	19/10/2022					
				CHECKER	Ntokozo Zwane	19/10/2022					
				REVISED BY	Amogelang Mohlampe	19/10/2022					
28	14/04/2023	Added sealant batch number & welding consumables traceability		APPROVER	Vanessa Ntuli	14/04/2023					
				CHECKER	Ntokozo Zwane	14/04/2023					
				REVISED BY	Amogelang Mohlampe	14/04/2023					
29	28/10/2023	Addition of bracket quantity		APPROVER	Ngoeni Tyson	28/10/2023					
				CHECKER	Ntokozo Zwane	28/10/2023					
				REVISED BY	Amogelang Mohlampe	28/10/2023					
TRAINSET	CAR	OPERATOR NAME & ALPS NO		DATE	SELF INSPECTION NUMBER		PAGES				
223	M4	Leni 483003		13/06/2024	SI.CB2220.250.V29		13				

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA								
		29									
		Date	SI.CB2220.250.V29								
		28/10/2023									
Car: M1,M3&M4	MCR:	Work station:	CB2220								
 Safety Related											
											
I - Documentation and Instruments Control											
I.1 - Documentation Control											
Document	Type of car					Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
	TG	M1	M2	M3	M4						
DTR30226487/2						29	28/10/2023	X		N/A	13/06/24  13/06/24
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)			
Tubula	32823-3		15/03/2024 - 15/03/2025								
Measuring Tape	GIB740432		17/04/2024 - 17/04/2025		X		13/06/2024  13/06/24				
1.3 Consumables											
Welding Consumable Control - Used for Special Process											
Filler Material	Heat Number		Welding Process		OK		Signature/Date (Manufacturing)	Signature/Date (Quality)			
Welding 308LSI	E-221880		Mig								
							13/06/24  13/06/24				

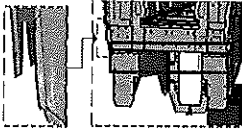

2024-06-25
INDUSTRIAL QUALITY
MANLINE

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev. 29	Project: PRASA SI.CB2220.250.V29			
		Date 28/10/2023				
II - Self Inspection - Items to Check						
II.1 - Items to check						
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB2220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB2220.DTR30225487/2	✓	13/06/2024 L. B. B.	13/06/24 [Signature]
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	13/06/2024 L. B. B.	13/06/24 [Signature]
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	13/06/2024 L. B. B.	13/06/24 [Signature]
04		Cleaning of all Stainless Steel Surface	According to GIB-WEL - PROC-0002	✓	13/06/2024 L. B. B.	13/06/24 [Signature]
05		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓	13/06/2024 L. B. B.	13/06/24 [Signature]
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.		13/06/2024 L. B. B.	13/06/24 [Signature]
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 Min - Max (°) Min-Max 10°C - 35°C Relative humidity Min - Max (%) Min-Max 25% - 60%	Sealant Batch No. 62477 Exp Date: 15/100/2021 Actuals Temperature: 10 Humidity: 56	✓	13/06/24 [Signature]	13/06/24 [Signature]
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓	13/06/24 [Signature]	13/06/24 [Signature]
09		Verification of safety welds	Approved according to DTD000210658 reference and Self inspection		13/06/2024 L. B. B.	13/06/24 [Signature]

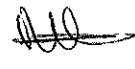
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	


II - Self Inspection - Items to Check

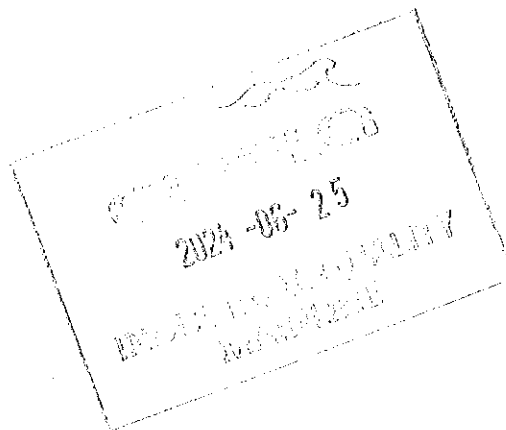
SEALANT APPLICATION





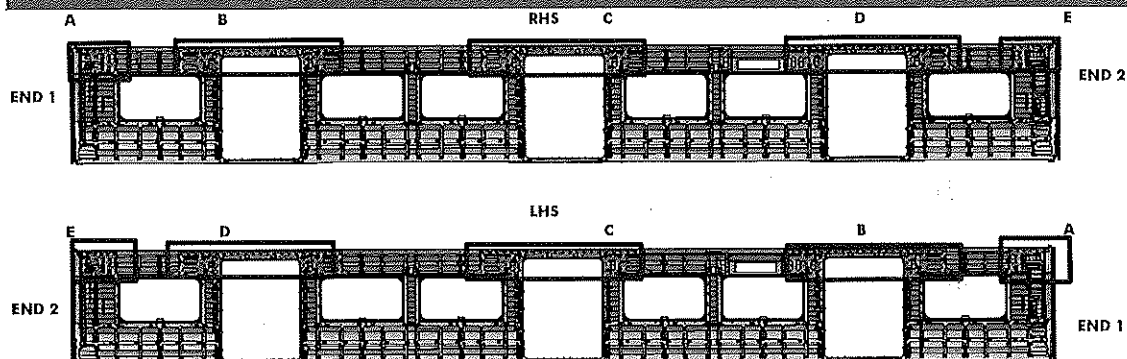
AREA 1 & 2 END 1

Operator (Name & sign):
Mtholozi: 

Operator (Name & sign):
Mtholozi: 

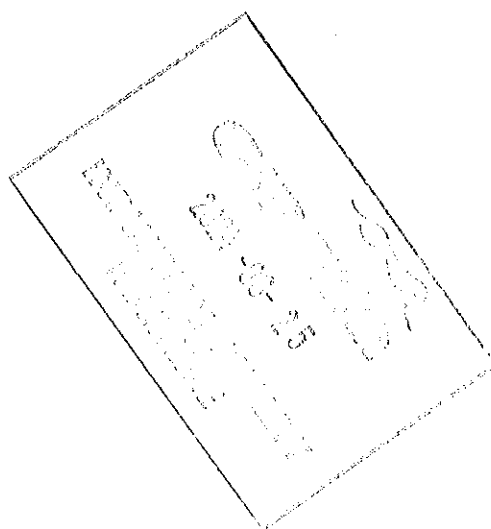



	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	
II - Self Inspection - Items to Check			

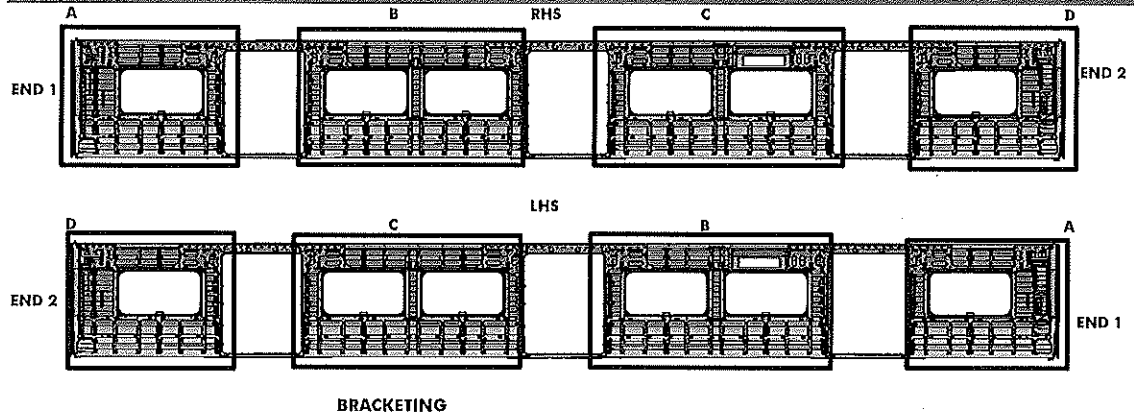


REINFORCEMENT WELDING


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

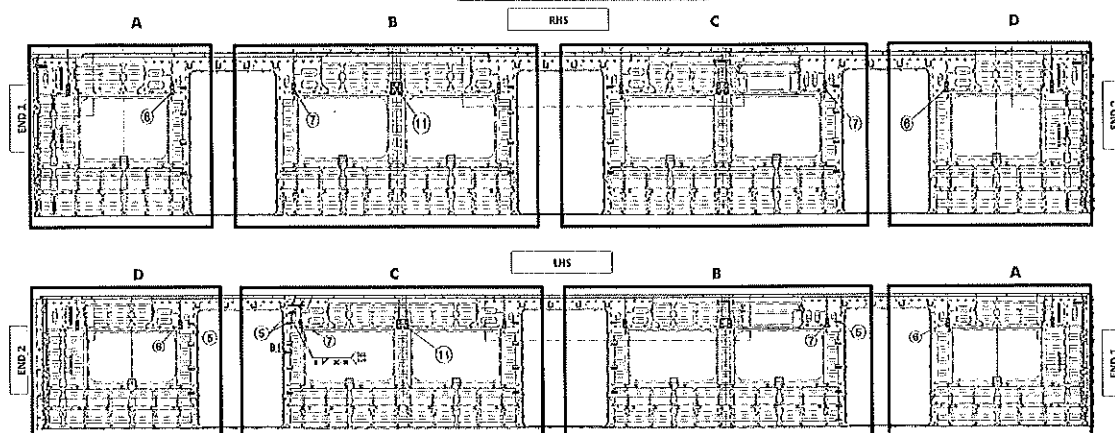


	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	
II - Self Inspection - Items to Check			



INSTALLATION	
C-RAILS:	Operator: <u>Arand</u>
	Operator: <u>Tetelo</u>
DOOR MECHANISMS:	Operator: <u>Luxo</u> (M)
	Operator: <u>Phiscilla</u>
TAPPING PADS	Operator: <u>Phiscilla</u>
	Operator: _____
INSTALLATION & VERIFICATION	
SEAT & LUGGAGE BRACKETS:	Operator: <u>Tetelo</u>
	Operator: <u>Arand</u>
SEAT BRACKETS VERIFICATION:	Operator: <u>Tetelo</u>
	Operator: <u>Arand</u>
WELDING	
AREA	LHS
A (Seat brackets)	: Operator (Name&sign): <u>Silvia</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Vitor</u>
B (Seat brackets)	: Operator (Name&sign): <u>Vitor</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Vitor</u>
C (Seat brackets)	: Operator (Name&sign): <u>Silvia</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Silvia</u>
D (Seat brackets)	Operator (Name&sign): <u>Silvia</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Silvia</u>
<div style="display: flex; justify-content: space-between;"> <div> <u>THULANI</u> <u>THULANI</u> <u>THULANI</u> <u>THULANI</u> </div> <div> <u>Silvia</u> <u>Vitor</u> <u>Silvia</u> <u>Silvia</u> </div> </div>	
ENDS	
END 1 TAPPING PADS WELDING:	Operator (Name&sign): <u>Silvia</u>
END 2 TAPPING PADS WELDING:	Operator (Name&sign): <u>Silvia</u>

	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			

M1/M3/M4 BRACKET INSTALLATION

QUANTITIES (M3/M4)

RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7		
	B	4		
	C	8		
	D	8		
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: _____

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	8		
	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: _____

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: _____

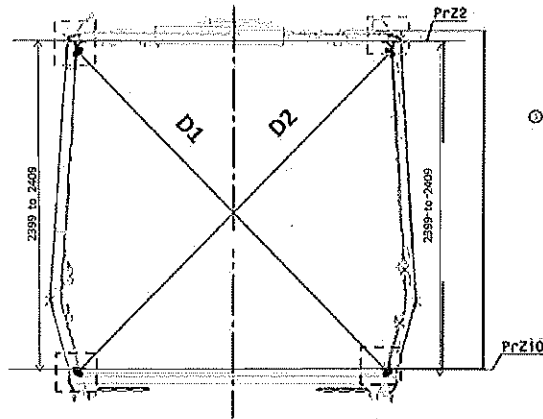
LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	10		
	C	11		
	D	6		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	7		
	C	9		
	D	2		

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

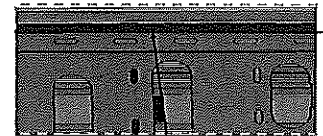
VERIFICATION BY: _____

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev.	Project: PRASA
		20	
		Date	SI.CB2220.250.V29
		28/10/2023	

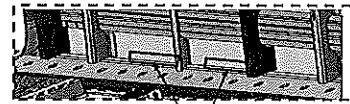
Specifications of Details for CBS measurement



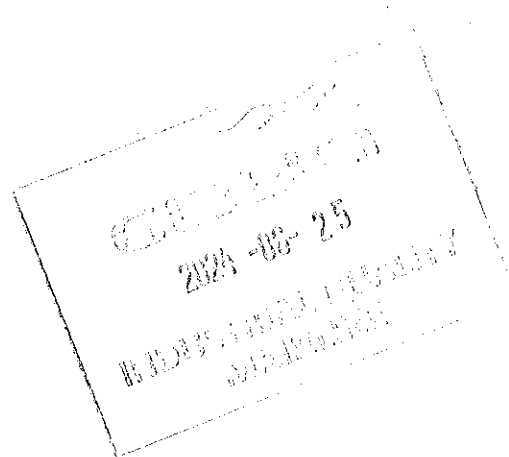
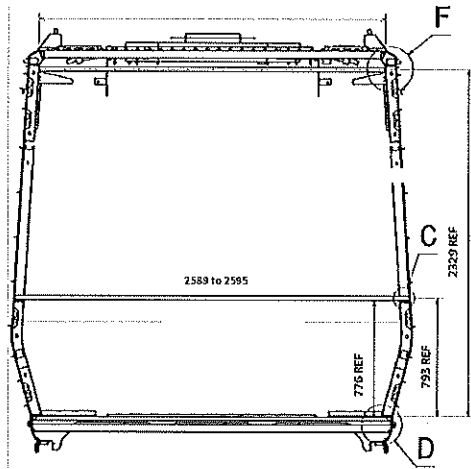
Measurement positions on roof rail and sidewall omega corner.

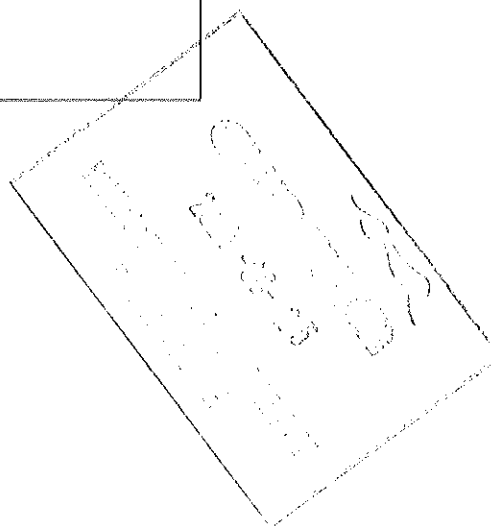
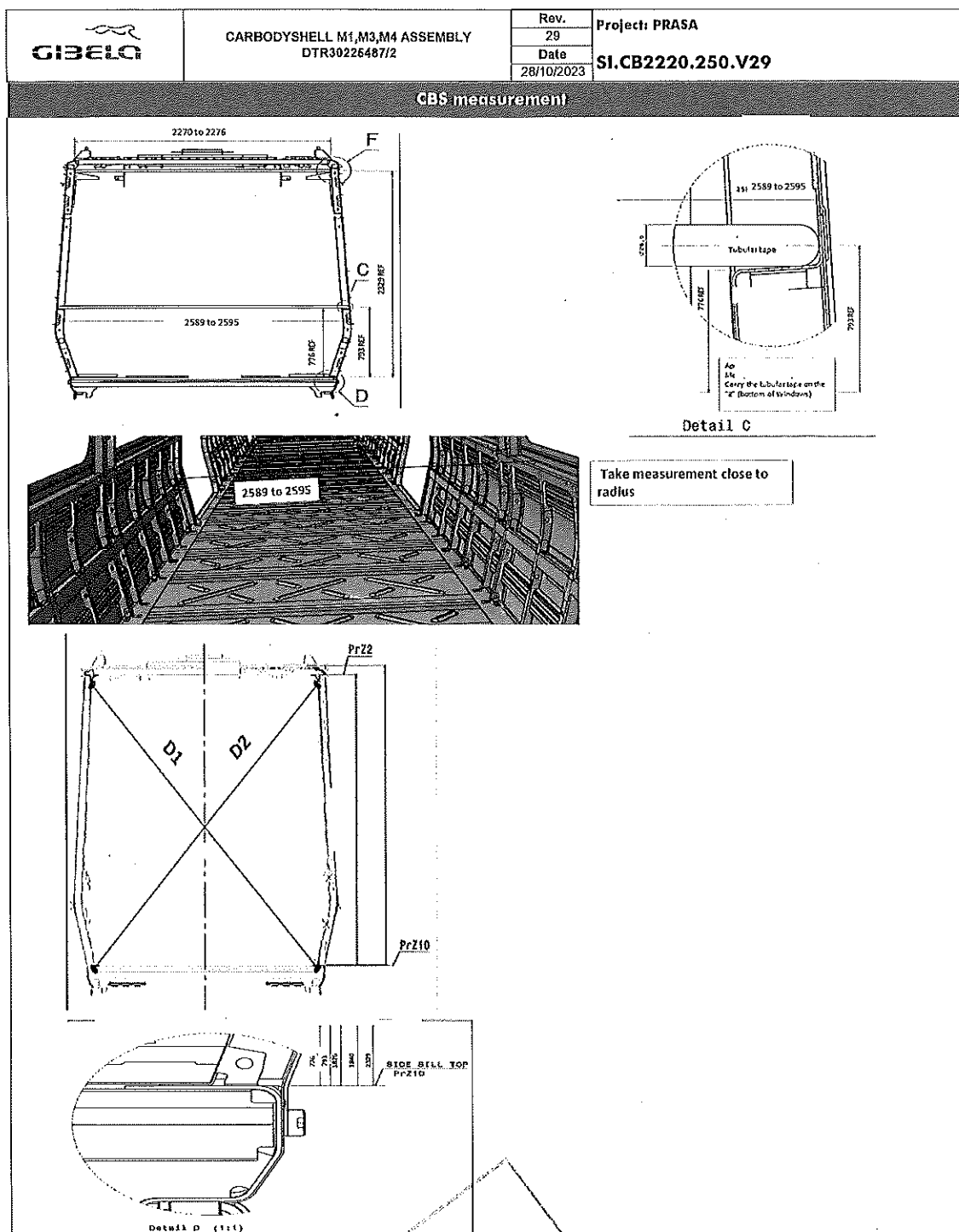



Reinforcement area measurement positions on roof reinforcement area.

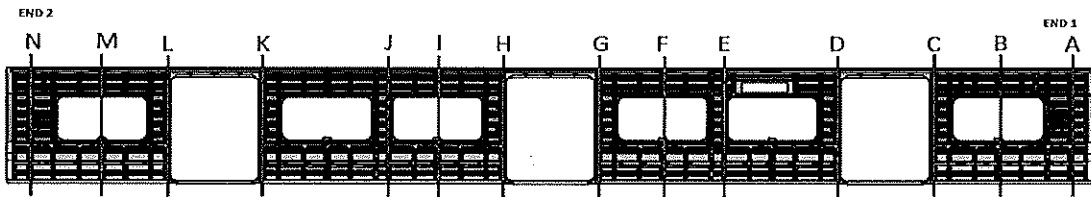


Measurement positions on sidewall and side sill corner.

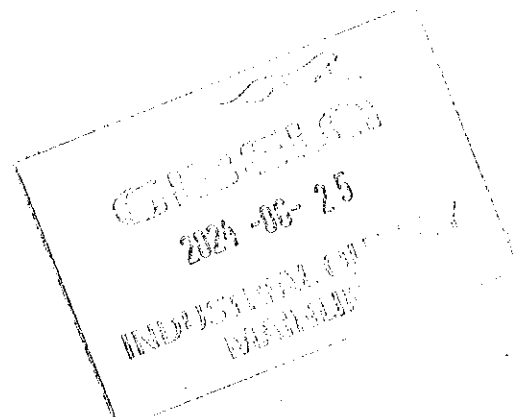



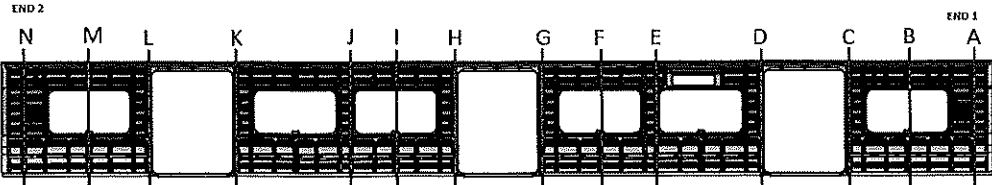


	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29	Project: PRASA SI.CB2220.250.V29
		Date 28/10/2023	
		CBS measurement	

BEFORE WELDING

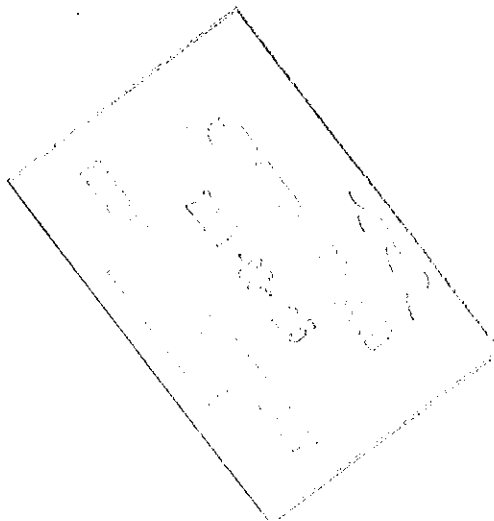
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3295	3291	2	—
B	3264	3265	1	—
C	3296	326	0	—
D	3296	3295	1	—
E	3264	3265	1	—
F	3262	3265	3	—
G	3295	3292	3	—
H	3294	3294	0	—
I	3265	3265	0	—
J	3265	3265	0	—
K	3295	3296	1	—
L	3296	3295	1	—
M	3265	3264	1	—
N	3294	3295	1	—




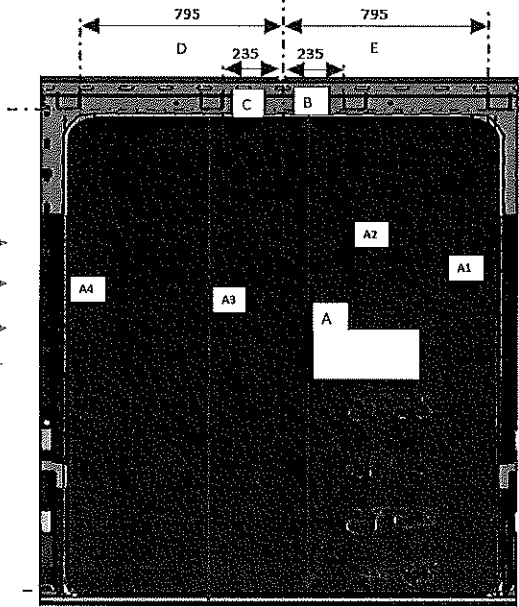
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		29	
		Date	
		28/10/2023	
CBS measurement			
			

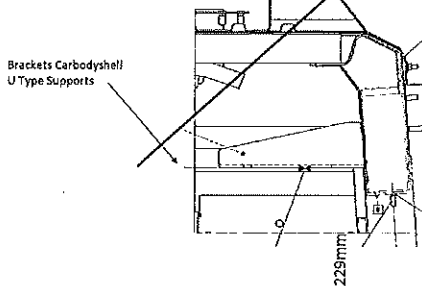
AFTER WELDING

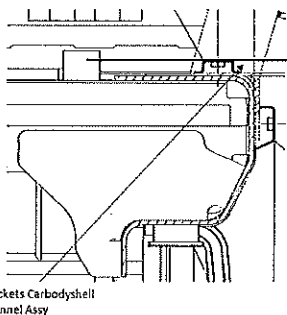
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3294	3293	1	2594
B	3264	3263	1	2595
C	3294	3296	2	2595
D	3292	3294	2	2595
E	3264	3265	1	2594
F	3265	3262	3	2593
G	3294	3295	1	2594
H	3294	3295	1	2595
I	3263	3262	1	2594
J	3265	3265	0	2594
K	3290	3295	5	2594
L	3296	3295	2	2590
M	3265	3264	1	2594
N	3296	3295	1	2595



	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev. 29	Project: PRASA SI.CB2220.250.V29
		Date 28/10/2023	
		Specifications of Details for CBS measurement CB1220	







DOOR 1 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2230
A3	2230 to 2232	2231
A4	2230 to 2232	2230
B	234 to 236	236
C	234 to 236	234
D	794 to 796	795
E	794 to 796	795

DOOR 2 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2231
A3	2230 to 2232	2230
A4	2230 to 2232	2230
B	234 to 236	236
C	234 to 236	234
D	794 to 796	796
E	794 to 796	794

DOOR 2 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2230
A3	2230 to 2232	2230
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 1 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2230
A3	2230 to 2232	2231
A4	2230 to 2232	2230
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	2231
A2	2230 to 2232	2231
A3	2230 to 2232	2231
A4	2230 to 2232	2230
B	234 to 236	234
C	234 to 236	236
D	794 to 796	796
E	794 to 796	794

DOOR 3 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2230
A3	2230 to 2232	2230
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



CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30226487/2

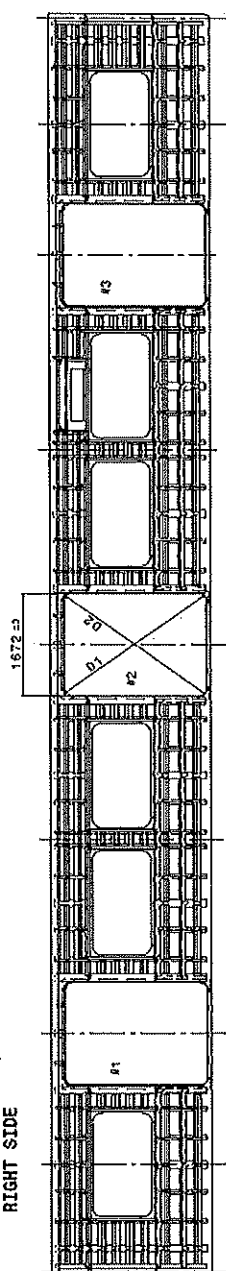
Rev.
29
Date
28/10/2023

Project: PRASA

SI.CB2220.250.V29

Specifications of Details for CBS measurement CB1220

End #2



End #1

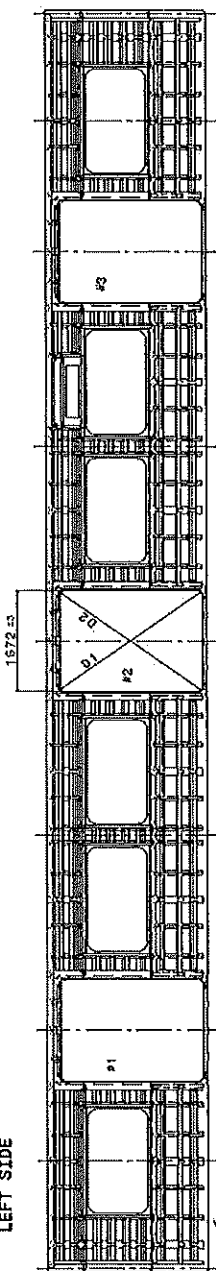
Doors diagonal D1-D2 maximum difference $\leq 4\text{mm}$

#1	#2	#3
D1 2749	2748	2747
D2 2747	2746	2748
D1-D2 2	2	1

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

Doors Length - 1672 $\pm 3\text{mm}$

End #1



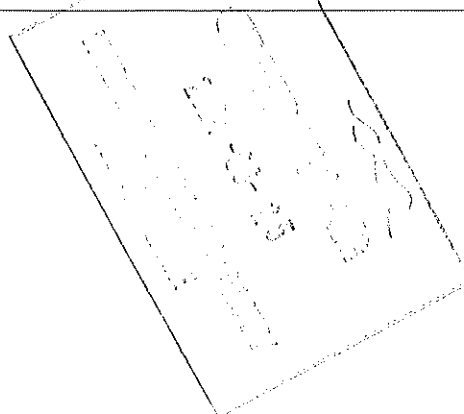
End #2


Doors diagonal D1-D2 maximum difference $\leq 4\text{mm}$

#1	#2	#3
D1 2749	2748	2747
D2 2747	2746	2748
D1-D2 2	2	1

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

Doors Length - 1672 $\pm 3\text{mm}$



	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	

GBS measurement (Manufacturing)

Dye penetrant test

Dye penetration test to be performed by quality personnel





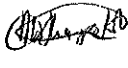
Item	Description of the Issue	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)

II.2 - Check List REX

Check List Items

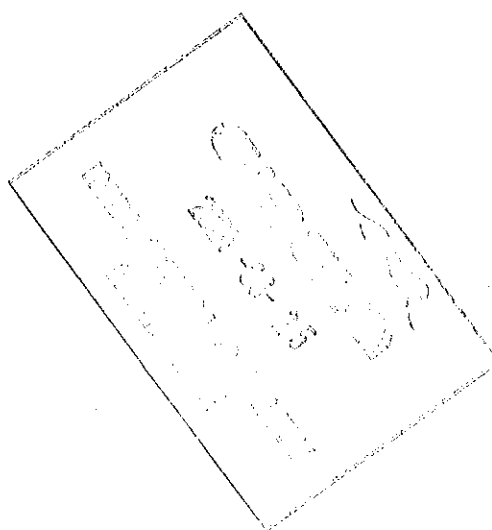
Item	Picture/Drawing	Description	Criteria/Record	OK	Signature/Date (Manufacturing)	Signature/Date Quality
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX			


2024-08-25

	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)	13/06/24	Lemi <small>Operations</small>	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party	13/06/24	Richmond <small>Industrial Quality</small>	
	NO GO	There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			
		There are non-conformities impact the quality of the product and there is no corrective action defined yet			
In case of "NO GO", describe blocking problems					
In case of "NO GO", the operations manager must define below action plan to ensure "GO":					
Item	Description	Responsible	Due date	Status	

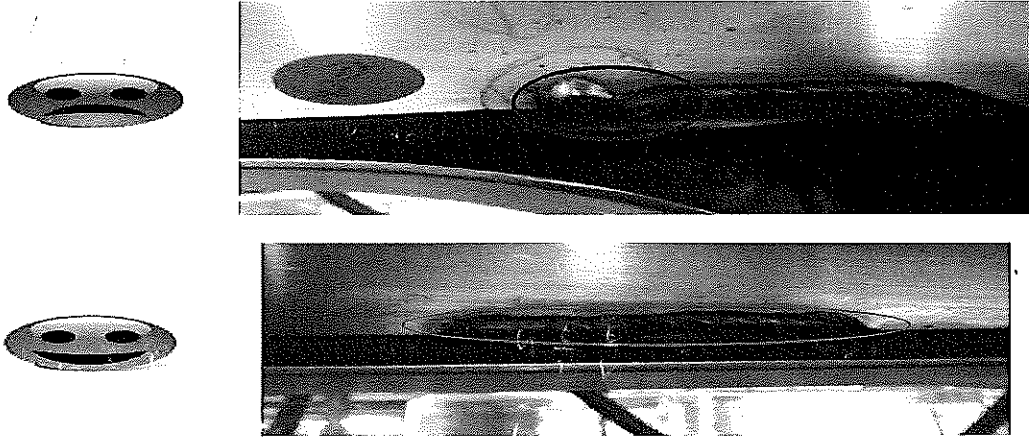
Operations

Quality

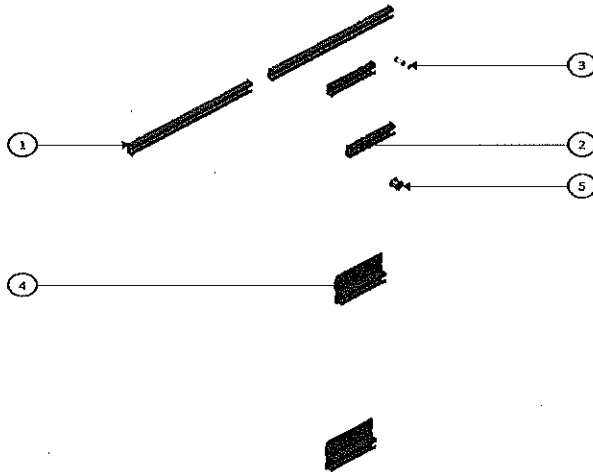


	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB2220.250.V29
		29	
		Date	
		28/10/2023	

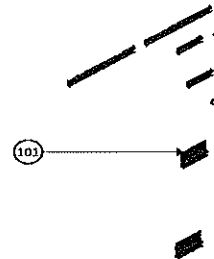
ANNEXURE A: Arc Welding Quality Acceptance Standard



Station: CB1220-004- U108 & U107



PART NO.	ITEM NO.	QTY	DESCRIPTION	MASS (KG)
DYF002097400A	5	6	EARTH STUD 6	0.096
AA00001201843	4	6	ASSEMBLY SUPPORT	0.371
DYF0000343305	3	12	WELDING STUD ISO13318 PT-15G20-SS1	0.007
AA00001160424	2	12	ASSEMBLY SUPPORT	0.193
AA00001184418	1	14	ASSEMBLY SUPPORT	0.522
AA00001163050	101	6	CARBODYSHELL BRACKETS CARBODYSHELL M1/M3/M4 CAR(SIDE FRAME MODULE STD-039)	12.132



GIBELA

PRASA PROJECT

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET


CONFIDENTIAL INFORMATION

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

APPLICATION REFERENCE

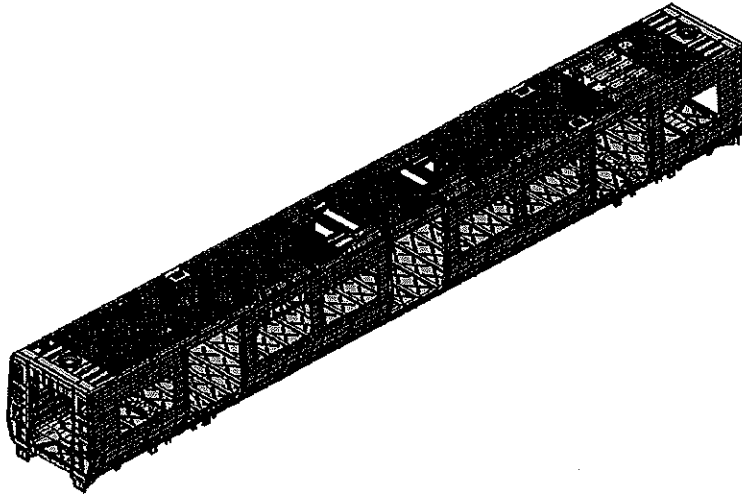
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?
				TC1	M1	M2	M3	TC2			
<input type="checkbox"/> DT00000225487	AAD0001278566	CARBODYSHELL M1,M2,M3 ASSEMBLY	CB2230		X	X		X		PRA.CB2230.DT000002 25487.V20	YES
<input type="checkbox"/>											
<input type="checkbox"/>											
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE						
0	2018/08/02	GIBELA NEW CREATION	APPROVER	Philippe Marques	2018/08/02						
			CHECKER	Nosizo Pindela	2018/08/02						
			COMPILER	Nosizo Pindela	2018/08/02						
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	30/5/2018						
			CHECKER	Nosizo Pindela	30/5/2018						
			REVISED BY	Nosizo Pindela	30/5/2018						
2	2018/05/07	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	2018/05/07						
			CHECKER	Nosizo Pindela	2018/05/07						
			REVISED BY	Ramokone Motama	2018/05/07						
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019						
			CHECKER	Nosizo Pindela	24/01/2019						
			REVISED BY	Vanessa Ntuli	24/01/2019						
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements	APPROVER	Itumeleng Modiba	13/03/2019						
			CHECKER	Nosizo Pindela	13/03/2019						
			REVISED BY	Nosizo Pindela	13/03/2019						
10	23/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	23/08/2019						
			CHECKER	Nosizo Pindela	23/08/2019						
			REVISED BY	Nosizo Pindela	23/08/2019						
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020						
			CHECKER	Bongane Masina							
			REVISED BY	Bongane Masina							
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021						
			CHECKER	Bongane Masina							
			REVISED BY	Bongane Masina							
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins 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	Ntokozo Zwane							
			REVISED BY	Amogelang Mohlampe							
29	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023						
			CHECKER	Ntokozo Zwane							
			REVISED BY	Amogelang Mohlampe							
30	06/11/2023	Added threshold traceability for boiler makers and welders	APPROVER	Ngobeni Tyson	06/11/2023						
			CHECKER	Andani Muthelo							
			REVISED BY	Ntokozo Zwane							
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES						
233	M4	Zanele 42774	15/06/24	SI.CB2230.256.V29	12						

INDUSTRIAL QUALITY
2024-08-12
CHECKED
202

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



Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car					Revision	Observation	OK		Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4	TCT						
PRA.CB2230.DT00000225487			7			30		✓		N/A	15/06/24

I.2 - Instruments Control

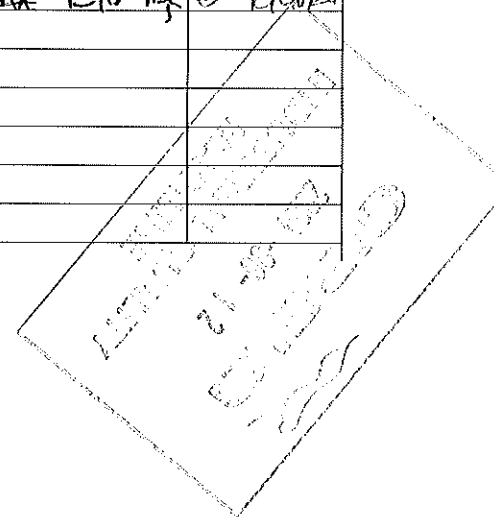
Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Operations)	Signature/Date (Quality)
Tubular	22173	26/06/24	X		15/06/24	15/06/24
Tape Measurement	618094	25/04/23	✓		15/06/24	15/06/24
Combination square	618002	27/07/24	X		15/06/24	15/06/24
			✓			

1.3 Consumables

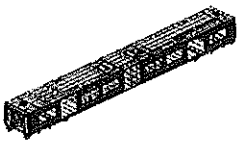
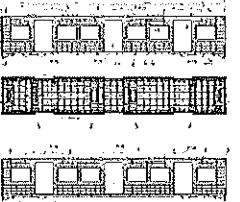
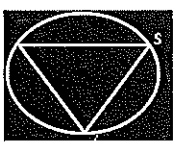
Welding Consumable Control - Used for Special Process


Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
308LSi	3737 79	mig	✓		15/06/24	15/06/24



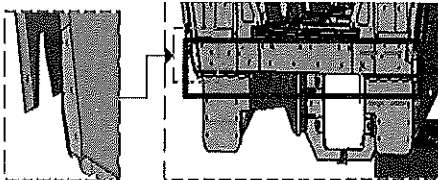
II - Self Inspection - Items to Check

II.1 - Items to check

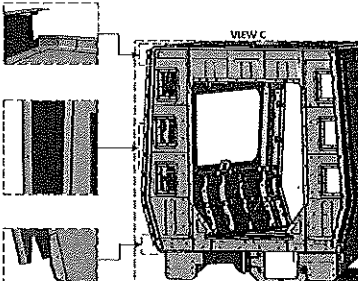
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK		Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	X		15/06/24	15/06/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	X		15/06/24	15/06/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	X		15/06/24	15/06/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	X		15/06/24	15/06/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	X		15/06/24	15/06/24
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.	X		15/06/24	15/06/24
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified: Temperature Min - Max (I) Min-Max 10°C - 35°C Relative humidity Min - Max (I) 25% - 80%	Sealant Batch No: B3499 Exp Date: 25/06/24 Actuals Temperature: 15°C Humidity: 28%	X		15/06/24	15/06/24
08	N/A	Verification of sealant application on the roof and sidewall finishers.	Sealant must be: -Applied straight and even -Free of gaps, cracks, damage and debris (flashes, dirt, dust) Refer to Annexure B	X		15/06/24	15/06/24
09	N/A	Verification of sealant application in certain regions in the drawing.	AAD0001278566	X		15/06/24	15/06/24

	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30	Project: PRASA SI.CB2230.256.V29
		Date	
		06/11/2023	
II - Self Inspection - Items to Check			


AREA 1





AREA 2 (VIEW C)



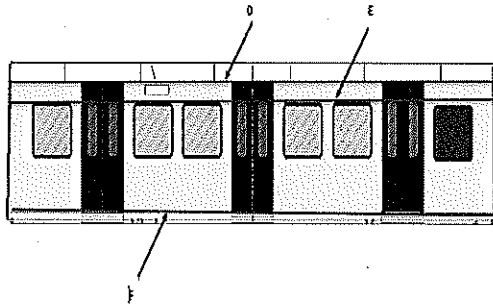
END 2 SEALANT

OPERATOR (Name & sign): Lerato 

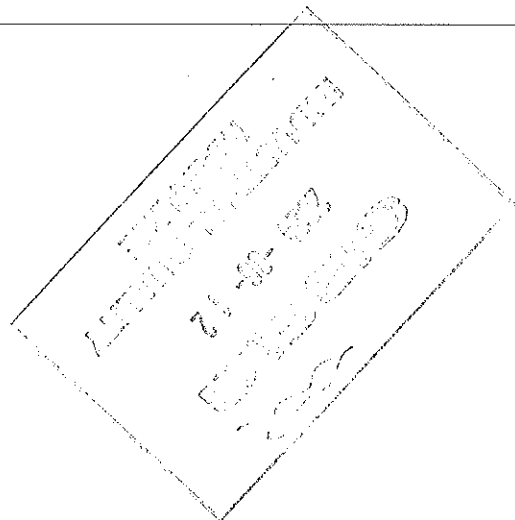
OPERATOR (Name & sign): Lerato 

OPERATOR (Name & sign): Lerato 

H



Area D,E,F,G,H,I	LHS	RHS
Operator (Name & sign):	<u>DIEGHI</u>	<u>DEFGHI</u>
Operator (Name & sign):	<u>Bhenolo</u>	<u>Bulte</u>
Operator (Name & sign):	<u>Hijit</u>	<u>Majob</u>
Operator (Name & sign):	_____	_____
Operator (Name & sign):	_____	_____
Operator (Name & sign):	_____	_____





CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
30

Date

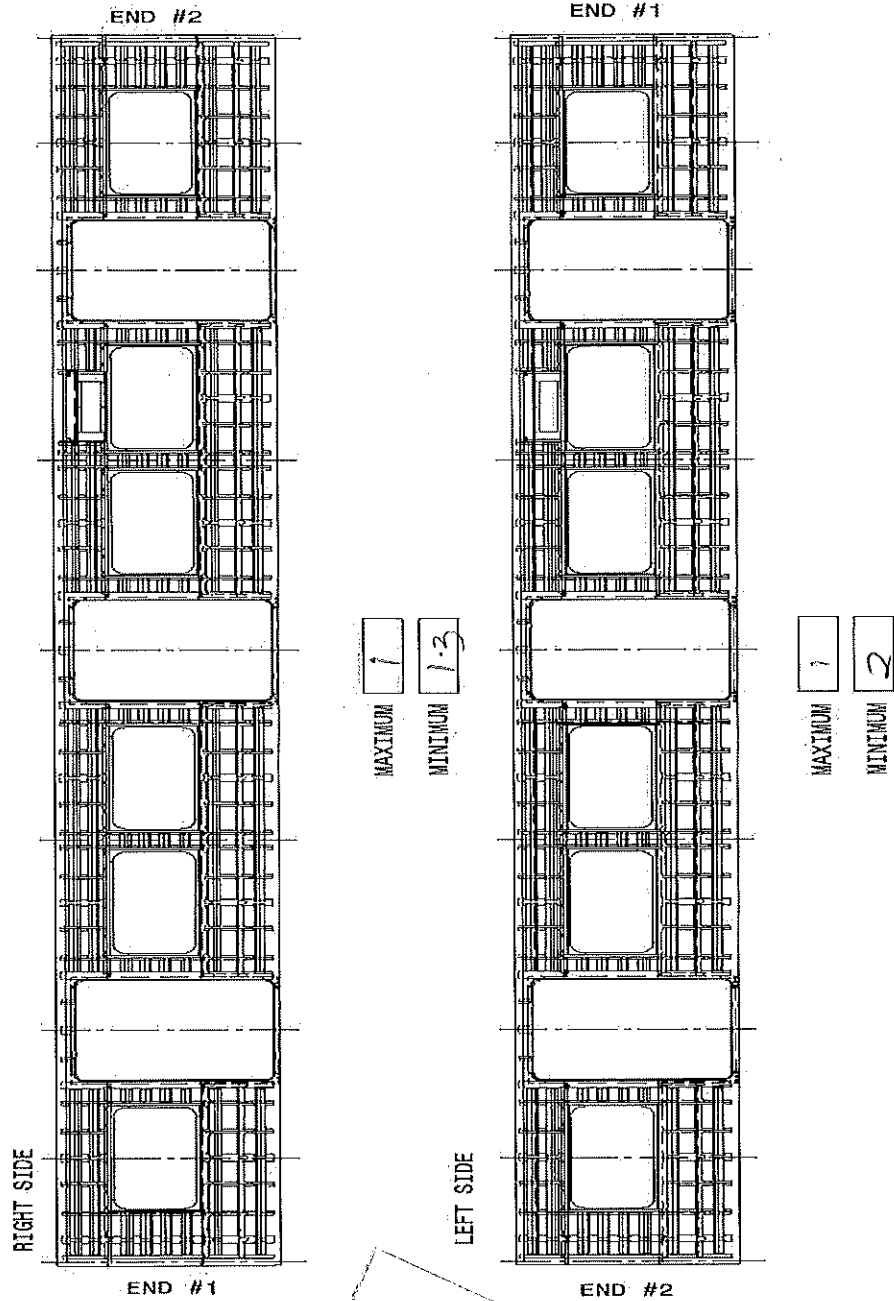
06/11/2023

Project: PRASA

SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230

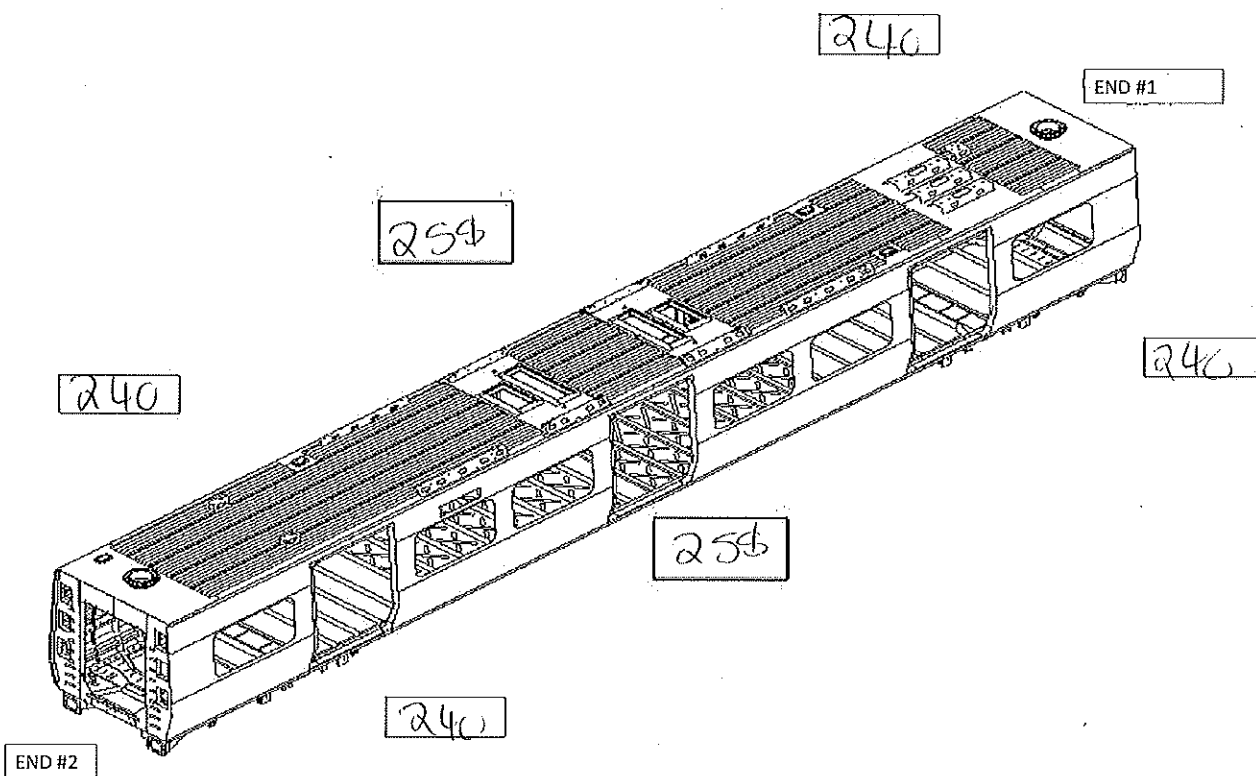
Flatness side left and right maximum of 2mm in the valley to peak measured in 900mm. Recod the maximum and minimum value found and indicate the corresponding region.



ENTERED
AUTOMATICALLY
21-06-2023
20:55:10

Specifications of Details for CBS measurement CB1230

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



MEASURED CAMBER VALUES

RIGHT	i1	15
LEFT	a1	15

APPROVED
21-08-2023
221230.256



CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000226487

Rev.
30

Date

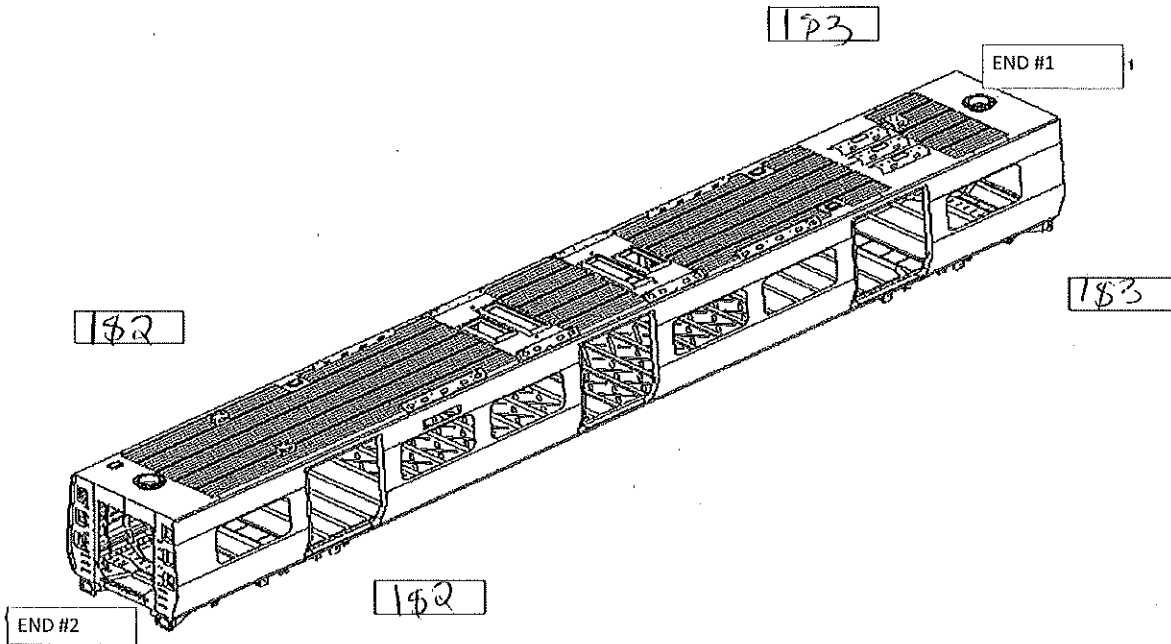
06/11/2023

Project: PRASA

SI.CB2230.256.V29

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

0

LONGITUDINAL

1

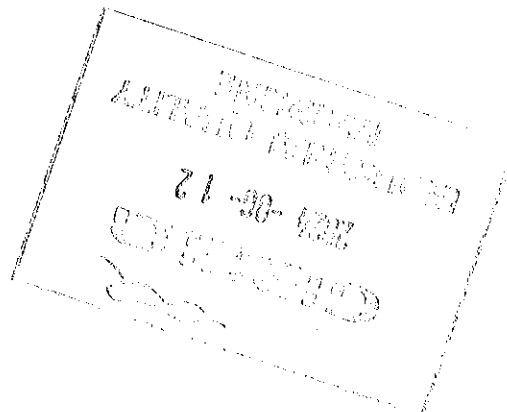
TWIST FOUND ON END 2

TRANVERSE

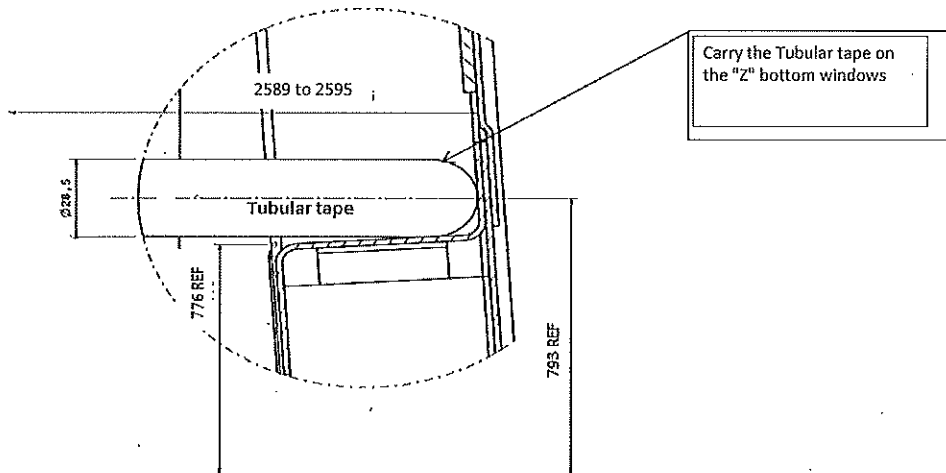
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LONGITUDINAL

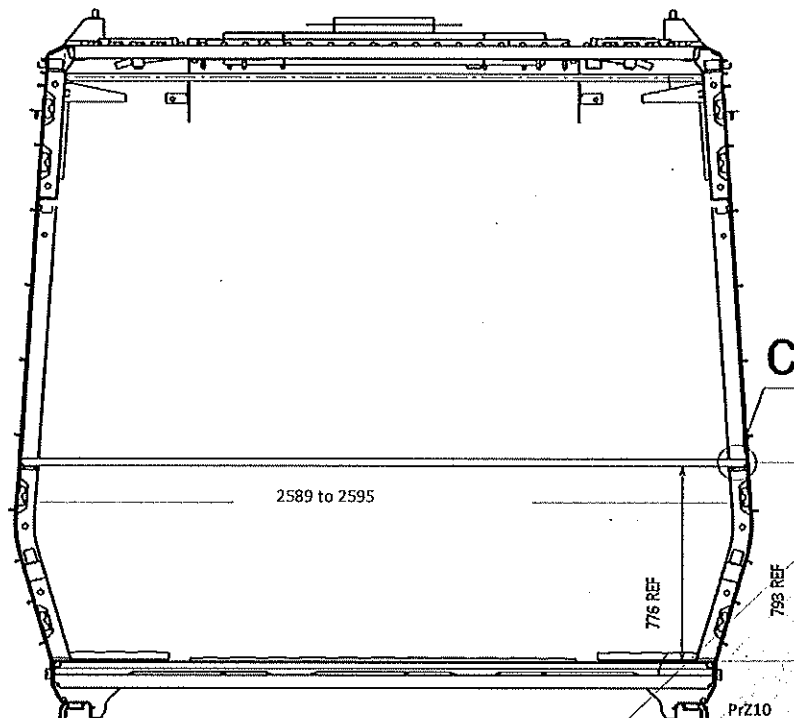
1



Specifications of Details for CBS measurement CB1230



Detail C





CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
30

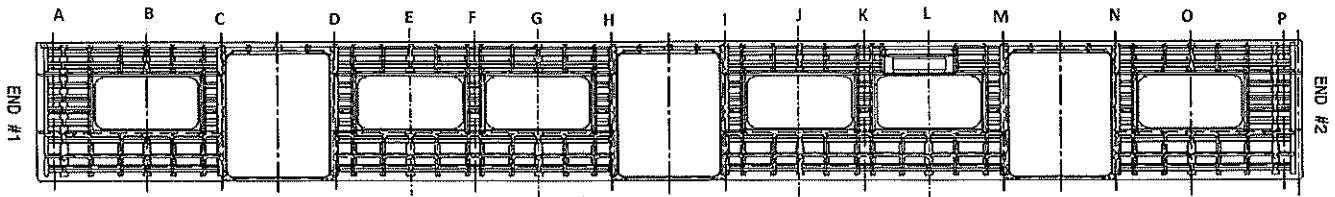
Date

06/11/2023

Project: PRASA

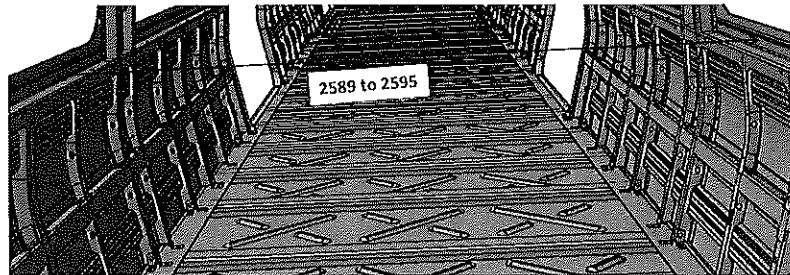
SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	2594
B	2593
C	2595
D	2596
E	2594
F	2596
G	2593
H	2595
I	2594
J	2592
K	2594
L	2595
M	2595
N	2593
O	2594
P	2594



Threshold verification						Nominal value :38	
Door 1		Door 2		Door 3		L	R
L	R	L	R	L	R		
38	39	39	38	39	39		
Door 4		Door 5		Door 6		L	R
L	R	L	R	L	R		
38	39	37	38	39	37		

BOILER MAKER:

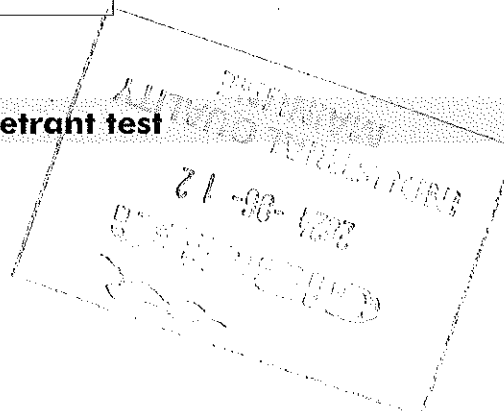
kgotso

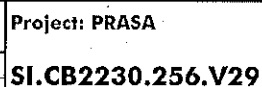
WELDER:

Emmanuel

Dye penetrant test


Dye-penetration test to be performed by quality personnel




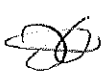
[illegible]

Item	Picture/Drawing	Description	Criteria /Record	OK	Not OK	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX				



	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30	Project: PRASA 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	GO	(If activities are not complete, the missing activities must not impact the next stage!)	15/06/24	Zanele Mahlangu Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	15/06/24	Andani Industrial Quality	
		There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)			
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)			

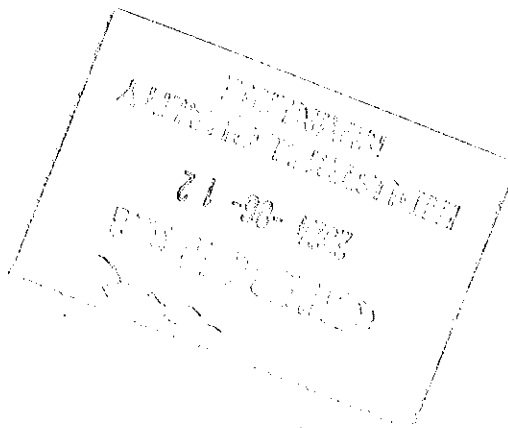
In case of "NO GO", describe blocking problems


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

Item	Description	Responsible	Due date	Status

Operations

Quality



	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29
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ANNEXURE A: Arc Welding Quality Acceptance Standard



7-8-23
 0825



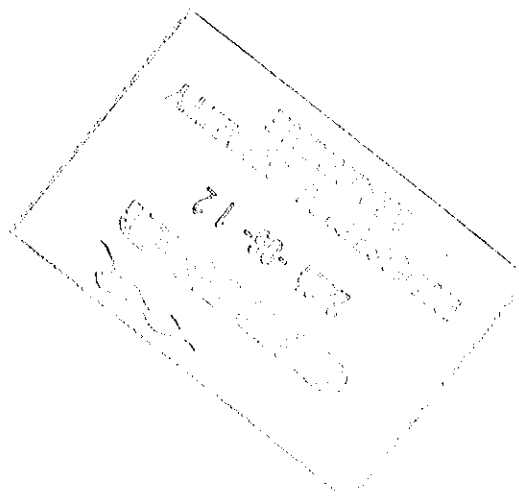
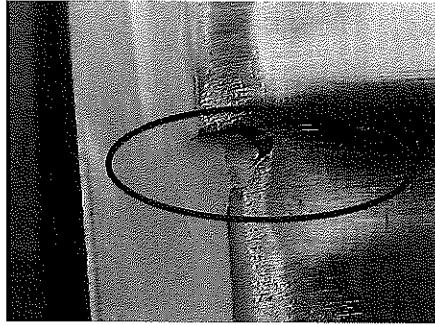
CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

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Project: PRASA

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ANNEXURE B: Sealant



~~2220 - P M2~~
~~1210 - P M3~~
~~2210 - P TC~~

1210 - P TC
2210 - P M2