

CABIN STRUCTURE  
QUALITY CARD.

CAB No.: CAB 4 6 9 \_ \_

WEIGHT: 1 4 8 7 Kg

## RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	05/02/2024	178247 104825 01	LP19402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	14/02/2024	178820 104640 01	F205212	
RCS 355	3 mm					
RCS 355	3 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegasus	28/02/24	178488 104640 01	P300091	
RCS 355	20 mm					

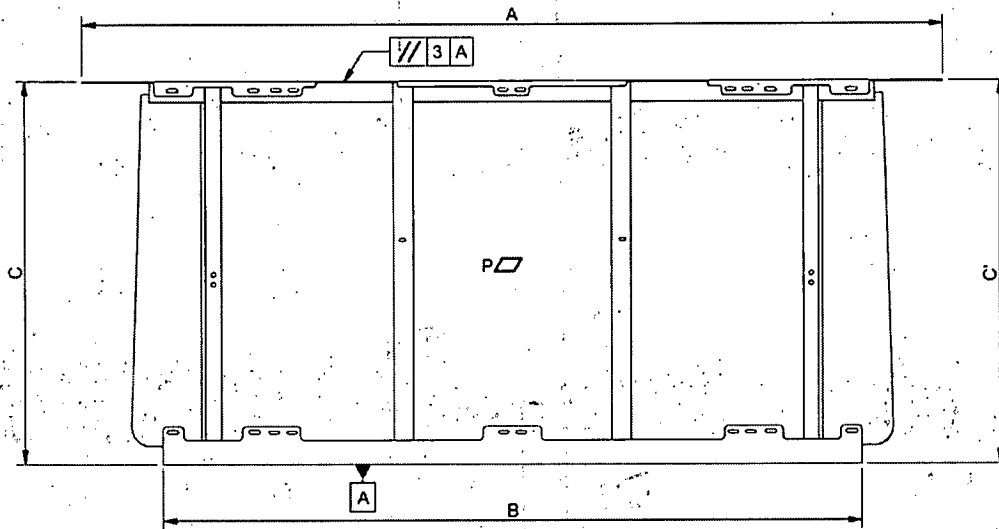
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegasus	12/02/2024			
RCS 355	30 mm					


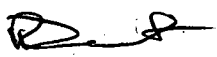
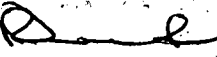
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	08/02/2024	178489 104640 01	VHC 35528	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	14/02/24	178815 104640 01	F207905	
RCS 450	6 mm				VHC 28402	
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	22/11/2024	175569 102206 01	F207906	
RCS 450	8 mm				VHS 58432	
RCS 450	8 mm					
RCS 450	8 mm					

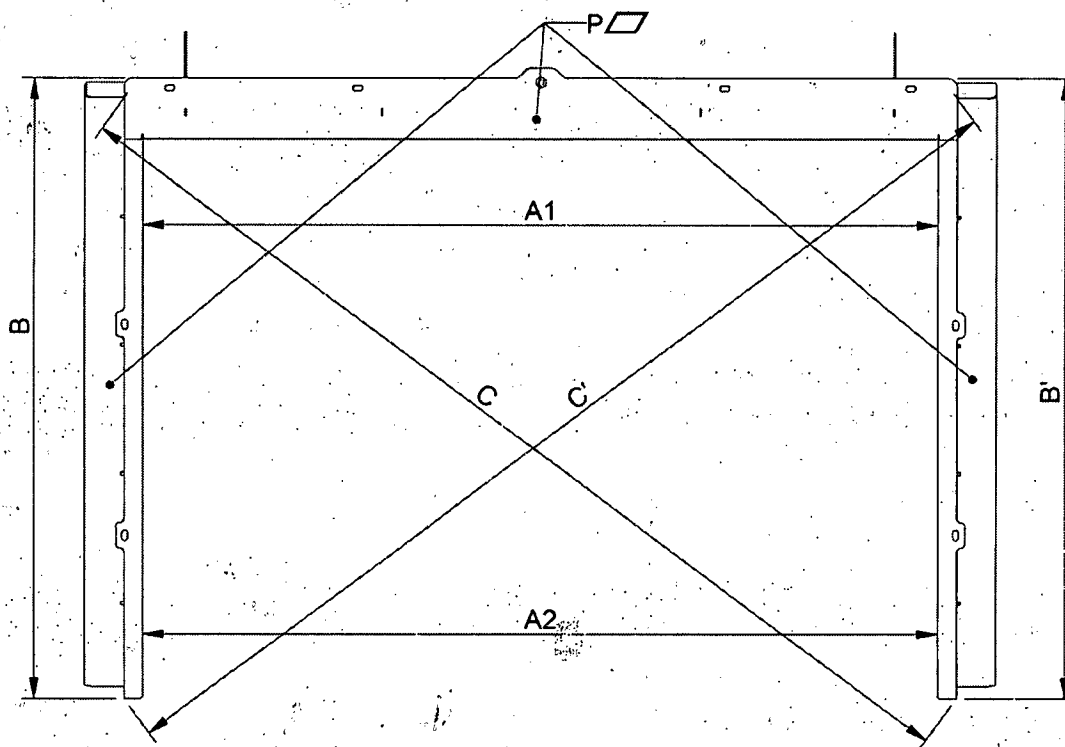
Cabin Roof Assembly: GN002839				
Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	DYLAN DAVIDS	Assembly Date:	2024/04/18	
Sign:		Wire Batch No.:	107238201	



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: 2024/04/18	
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		acceptable
QC Inspector:	Riccardo	Sign:		Date:	2024/04/18
Geometrical Control					
Nature of Checks		Dimension Measured		Measuring Equipment	Observations
Planity: P	6 mm	Passed		Ruler	acceptable
// 3	A	Passed		Set Square	acceptable
QC Inspector:	Riccardo	Sign:		Date:	2024/04/18

## Cabin Front Frame Assembly: GN002840

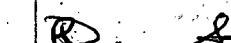
Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>Ramelo Guzman</i>	Assembly Date:	2024/04/18	
Sign:	<i>RB</i>	Wire Batch No.:	582033	



### 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:	<i>Riccardo</i>	Sign:	<i>RB</i>	Date: 2024/04/18

### 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	147.5	1475		acceptable	
C	Diagonals  C - C'  ≤ 3		2476	2478		acceptable	
QC Inspector:		Riccardo		Sign:		Date:	2024/04/18

### Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P: Planity	4 mm	<i>PASSED</i>	Ruler	acceptable
QC Inspector:	<i>Riccardo</i>	Sign:	<i>RB</i>	Date: 2024/04/18

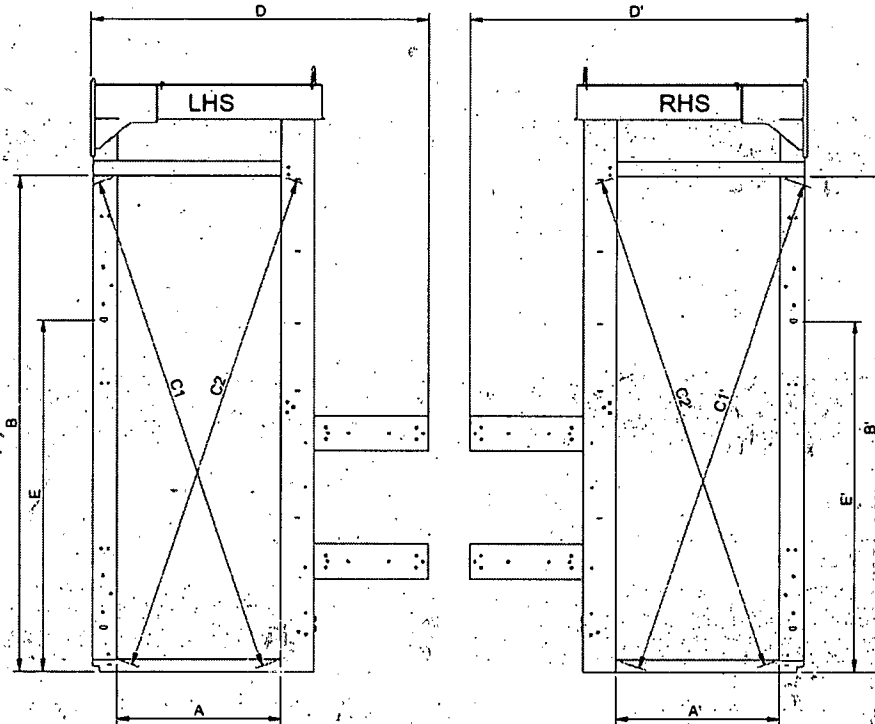
Cabin LHS/RHS Wing Mirror Plate Assembly: GN002846/GN002844				
Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	TK Booth	Assembly Date:	2024/04/10	
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033	

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:	2024/04/10	
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:	2024/04/10	
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:	2024/04/12		
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033		



### Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	Riccardo	Sign:	<i>[Signature]</i>	Date:	2024/04/15

### Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	695	696	Tape Measure	acceptable
B	2086	+1/-3	2085	2084		acceptable
C1 / C2	Difference of diagonals $ C1 - C2  \leq 3$		253	2252		acceptable
C1 - C2			2134	2254		acceptable
D	1438	+2/-3	1438	1441		acceptable
E			1481	1484		acceptable

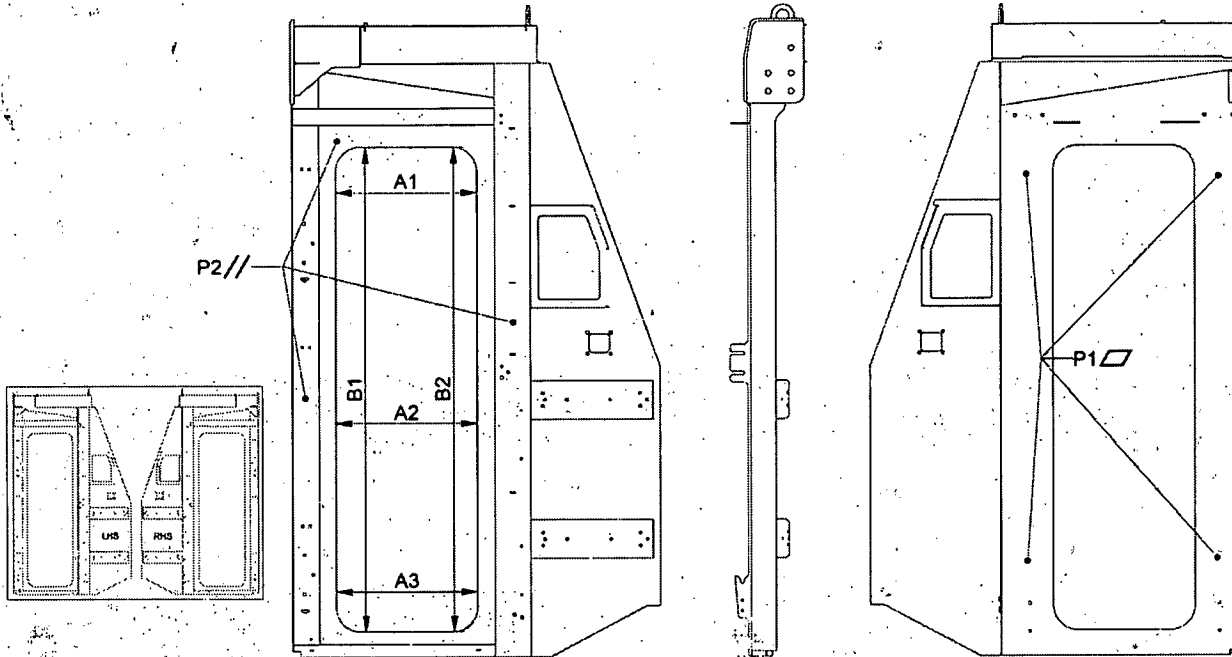
QC Inspector:	Riccardo	Sign:	<i>[Signature]</i>	Date:	2024/04/15
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### Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	Ruler	acceptable
QC Inspector:	Riccardo	Sign:	<i>[Signature]</i>
		Date:	2024/04/15

## 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>TKB</i>	Assembly Date:	2024/04/18	
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033	

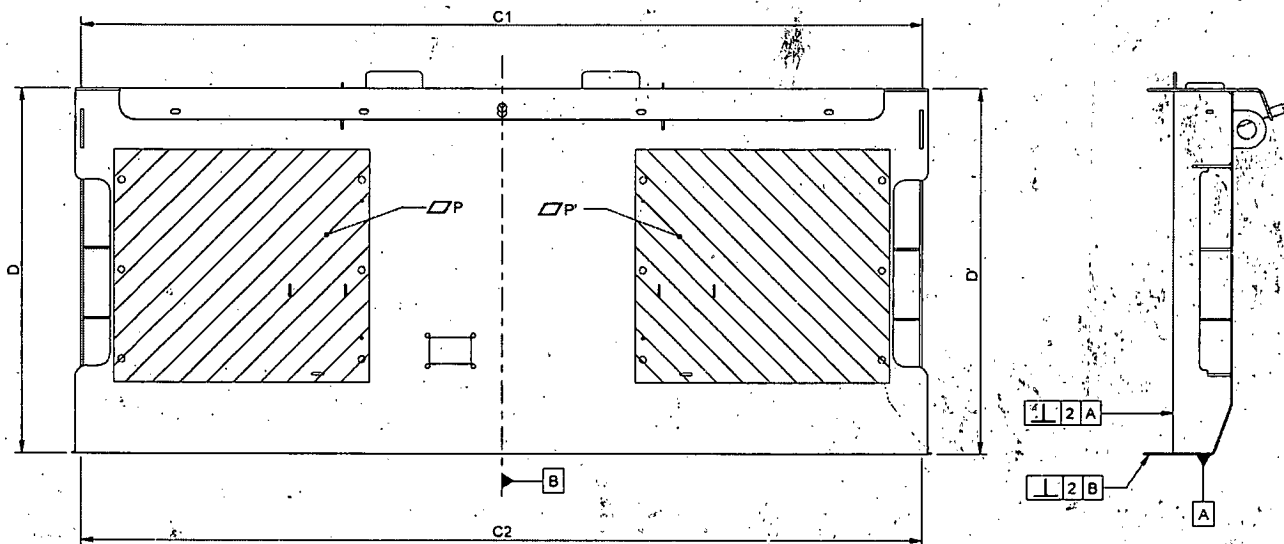


Welding Control				
Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes <input checked="" type="checkbox"/>	No <input type="checkbox"/>
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date: 2024/04/18

Dimensional Control					
Rep.	Theoretical Dim	Toler.	Dimension Measured		Observations
A1	560	$\pm 2$	558	559	acceptable
A2			560	559	acceptable
A3			560	559	acceptable
B1	1900	$\pm 2$	1898	1898	acceptable
B2			1898	1898	acceptable
QC Inspector:		<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date: 2024/04/18

Geometrical Control					
Nature of checks		Dimension Measured	Measuring Equipment	Observations	
P1	Planeity	4 mm	Ruler	acceptable	
P2	Planeity	2 mm	Ruler	acceptable	
QC Inspector:		<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date: 2024/04/18

Cabin Shield Assembly: GN002836				
Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>Bambelo Guinan</i>	Assembly Date:	20 <i>24</i> / <i>09</i> / <i>18</i>	
Sign:	<i>[Signature]</i>	Wire Batch No.:	<i>SS2033</i>	

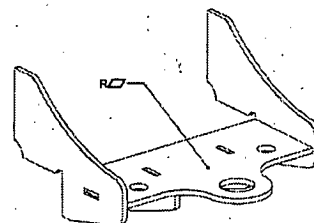
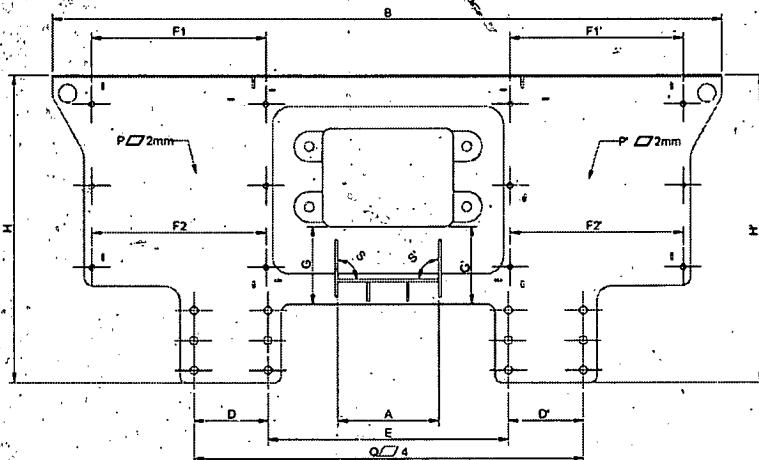


Welding Control					
Assembly Completed as per WI/SOS MD_0043			Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	20 <i>24</i> / <i>09</i> / <i>18</i>
Dimensional Control					
Rep	Theoretical Dim	Toler.	Dimension measured		Observations
C1 / C2	2210	± 4	<i>2212</i>	<i>2212</i>	Tape Measure <i>acceptable</i>
D / D'	956	± 2	<i>950.5</i>	<i>950.5</i>	
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	20 <i>24</i> / <i>09</i> / <i>18</i>
Geometrical Control					
Nature of Checks			Dimension Measured		Observations
Planarity P / P'		2 mm	<i>Passed</i>		<i>acceptable</i>
Perpendicularity	2	A	<i>Passed</i>		<i>acceptable</i>
	2	B	<i>Passed</i>		<i>acceptable</i>
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	20 <i>24</i> / <i>09</i> / <i>18</i>



## Cabin Front Headstock Assembly: GN002841

Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>T.K. Boodle</i>	Assembly Date:	2024/04/15	
Sign:	<i>[Signature]</i>	Wire Batch No.:	652033	



### Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/> No
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QC Inspector: *Riccardo* Sign: *[Signature]* Date: 2024/04/15

### 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	250		acceptable
E	808	± 2	808			acceptable
F1 / F1'	580	± 1	581	581		acceptable
F2 / F2'			581	581		acceptable
G / G'	258	± 1	259	259		acceptable
H / H'	1019	± 2	1020	1020		acceptable

QC Inspector: *Riccardo* Sign: *[Signature]* Date: 2024/04/15

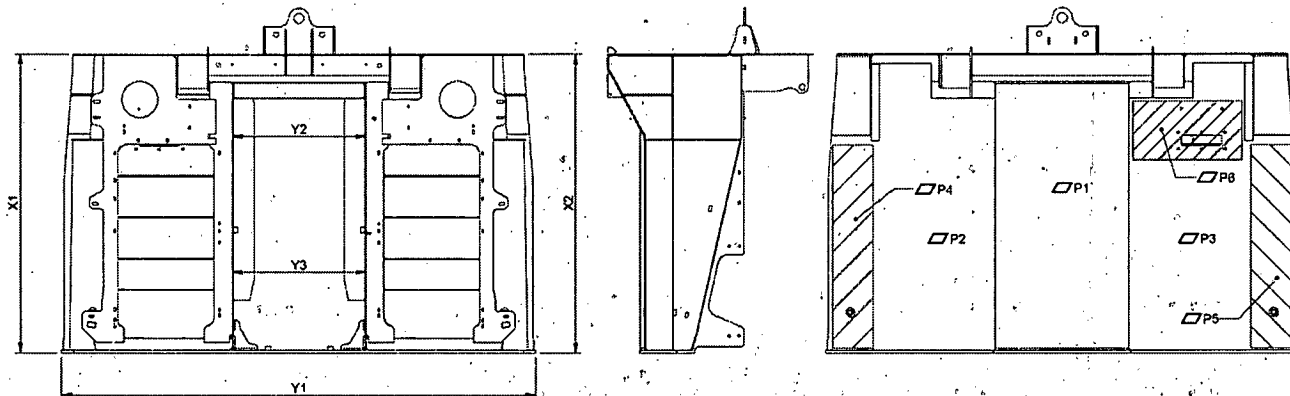
### Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
O: Planeity of global assembly	4 mm	Passed	Ruler	acceptable
P / P': Planeity	2 mm	Passed	Ruler	acceptable
Q: Planeity Surface of Supports	4 mm	Passed	Ruler	acceptable
R: Planeity Coupler Support	2 mm	Passed	Ruler	acceptable
S: Perpendicularity coupler	1mm	Passed	Square	acceptable

QC Inspector: *Riccardo* Sign: *[Signature]* Date: 2024/04/15

## Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS.MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	2024/04/18	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152	



### Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
QC Inspector:	<i>Riccardo</i>	Sign:	<i>Dant</i>	Date: 2024/04/18


### Dimensional Control

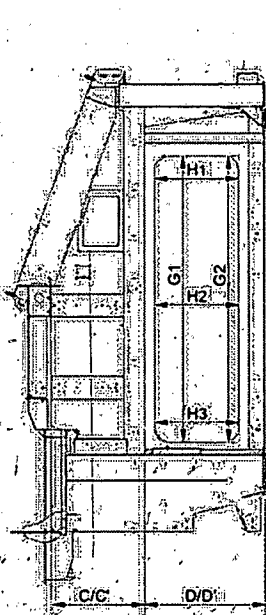
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1486	1486	Tape Measure	acceptable
Y1	2354	± 3				acceptable
Y2 / Y3	666	± 1	666	667		acceptable
QC Inspector:	<i>Riccardo</i>	Sign:	<i>Dant</i>	Date:	2024/04/18	

### Geometrical Control

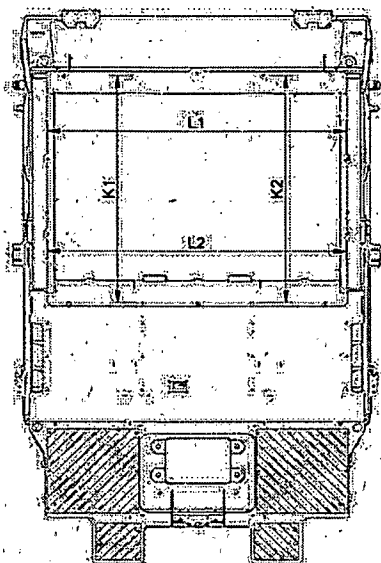
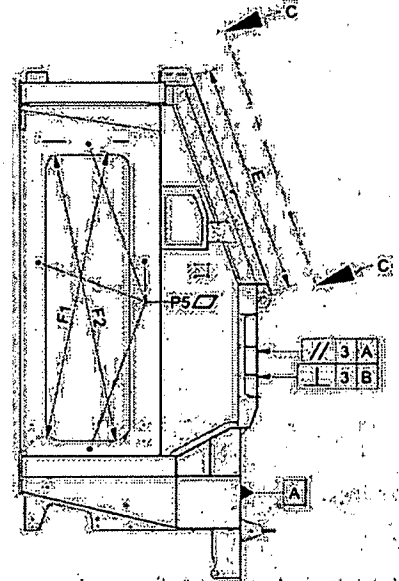
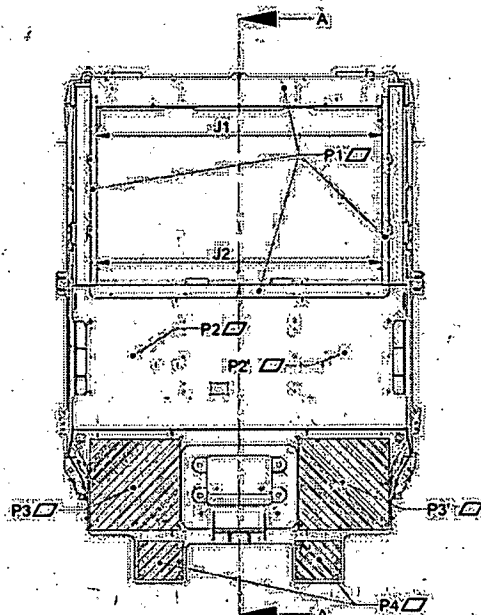
Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	<i>Passed</i>	Ruler	acceptable
P2 / P3 : Planeity	4 mm	<i>Passed</i>	Ruler	acceptable
P4 / P5 : Planeity	2 mm	<i>Passed</i>	Ruler	acceptable
P6 : Planeity	2 mm	<i>Passed</i>	Ruler	acceptable
QC Inspector:	<i>Riccardo</i>	Sign:	<i>Dant</i>	Date: 2024/04/18

# Cabin Structure Assembly: GN002834

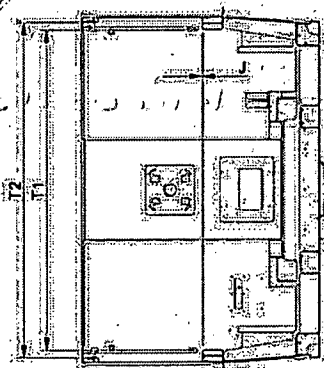
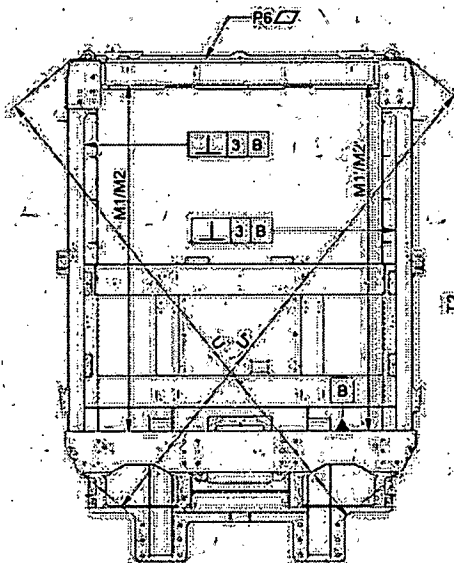
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	No
Operator:	CHALL BLOEM	Assembly Date:	2024/09/12	
Sign:		Wire Batch No.:	552033	



SECTION A-A

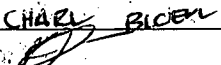


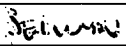
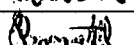
AUX VIEW: C


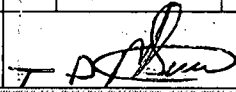
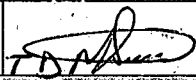



SECTION B-B

Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed		Yes		No
QC Inspector:		Riccardo		Sign:		R. A.		Date: 2024/04/25	
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	625	625	acceptable				
D / D'	813	± 2,5	813	812	acceptable				
E	1531.5	± 3	1534		acceptable				
G1 / G'1	Height 1900	+1	1898	1898	acceptable				
G2 / G'2		-3	1898	1897	acceptable				
H1 / H'1	Width 560	+1 -3	559	559	acceptable				
H2 / H'2			559	559	acceptable				
H3 / H'3			559	559	acceptable				
F1 / F'1	Diagonals 1939		1937	1936	acceptable				
F2 / F'2			1938	1937	acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	1	1	acceptable				
J	Gap of Doors	± 1,5	0	0	acceptable				
K1 / K2	1515	± 3	1515	1515	acceptable				
L1 / L2	1996	± 3	1996	1995	acceptable				
M1 / M'1	2396	± 3	2466	2466	acceptable				
M2 / M'2			2471	2477	acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2128	2128	acceptable				
T2 / T'2	2230 Top/Bottom		2230	2230	acceptable				
Difference	U - U' (3522)	≤ 4mm	3521	3521	acceptable				
QC Inspector:		Riccardo		Sign:		R. A.		Date: 2024/04/25	
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:				Sign:				Date: 2024/04/25	

Cabin Bracket Assembly: GN002833					
Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	CHARL BICEN	Assembly Date:	20 24 / 04 / 24		
Sign:		Wire Batch No.:	552033		

Cabin Rivnut Assembly: GN002832					
Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:		Assembly Date:	20 24 / 04 / 24		
Sign:		Wire Batch No.:			

Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Fasteners positioned in all Rivnuts and Bosses		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Masked as per GMS-SOS-GIBELA-CABIN-001		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DAVID	Sign:			
Date:	20 24 05/10				
Record of Shot Blasting					
Operator:		Date:	20 24 05/10		
Start Time:	08 H 52	End Time:	13 H 45		
Temperature ( $\geq 15^\circ$ ):	22 - 04 °C	Humidity ( $\leq 75\%$ ):	62 - 01 %		
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:	20 24 05/10				
Shot Blasting Cleaning					
Cabin free of all sand		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DAVID	Sign:			
Date:	20 24 05/10				
Shot Blasting Control					
Temperature $\geq 15^\circ$ :	20 - 01 °C	Humidity $\leq 75\%$ :	65 - 03 %		
Internal Roughness $3.2 \leq Ra \leq 12.5$	Ra 6,845 Rz 40,983	External Roughness $3.2 \leq Ra \leq 12.5$	Ra 7,571 Rz 41,876		
QC Inspector:	2473	Sign:			
Date:	10/5/24				

Record of Priming			
Start Time:	13:00	End Time:	15:00
Temperature $\geq 15^{\circ}$ :	26 $^{\circ}$ C	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:	15:00	Desolvation End Time:	15:15
Stoving Start Time:	15:15	Stoving End Time:	16:15
Stoving Temp:	60 $^{\circ}$ C		
Operator:	munsa	Sign:	
Date:	2024/05/10		munsa
Priming Control			
DFT Interior RHS		DFT Interior LHS	
1: 69.0	5: 72.0	1: 62.9	5: 60.15
2: 63.6	6: 56.3	2: 54.1	6: 77.3
3: 51.0	7: 68.6	3: 49.0	7: 68.2
4: 48.2	8: 78.9	4: 53.5	8: 58.1
Min:	48.2	Min:	49.0
Max:	78.9	Max:	77.3
Average:	63.4	Average:	63.1
DFT Floor		DFT Interior Front	
1: 43.1	5: 72.2	1: 78.2	5: 80.3
2: 49.2	6: 60.1	2: 64.8	6: 56.4
3: 67.4	7: 51.1	3: 49.7	7: 48.5
4: 59.7	8: 68.2	4: 54.0	8: 53.8
Min:	43.1	Min:	48.5
Max:	72.2	Max:	80.3
Average:	57.6	Average:	64.4
DFT Interior Roof		DFT Exterior LHS	
1: 71.4	5: 68.2	1: 77.3	5: 48.3
2: 62.9	6: 74.7	2: 58.8	6: 54.1
3: 66.5	7: 58.0	3: 62.0	7: 70.1
4: 74.6	8: 68.1	4: 42.8	8: 44.7
Min:	58.0	Min:	41.7
Max:	74.7	Max:	77.3
Average:	66.3	Average:	59.3
DFT Exterior RHS		DFT Underside	
1: 62.7	5: 39.9	1: 52.0	5: 82.6
2: 51.4	6: 68.4	2: 73.2	6: 68.5
3: 64.6	7: 75.5	3: 59.2	7: 60.3
4: 59.8	8: 65.1	4: 78.8	8: 177.9
Min:	39.9	Min:	52.0
Max:	75.5	Max:	82.6
Average:	57.7	Average:	67.3
DFT Exterior Front		DFT Exterior Roof	
1: 63.7	5: 70.3	1: 61.1	5: 38.9
2: 49.0	6: 77.4	2: 84.1	6: 48.5
3: 46.5	7: 52.8	3: 51.8	7: 47.2
4: 55.2	8: 38.9	4: 64.6	8: 70.4
Min:	38.9	Min:	38.9
Max:	77.4	Max:	84.1
Average:	58.1	Average:	61.5
DFT Machined Base		DFT Machined Top RHS/LHS	
1: 59.5	5: 62.1	1: 56.6	5: 77.3
2: 36.8	6: 75.0	2: 48.7	6: 64.0
3: 45.2	7: 62.4	3: 59.6	7: 61.6
4: 78.7	8: 46.9	4: 51.3	8: 73.3
Min:	36.8	Min:	48.7
Max:	78.7	Max:	77.3
Average:	57.7	Average:	61.5
Primer has been inspected and is free of defects		Confirmed	Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>
QC Inspector:	Zotnik	Sign:	
Date:	15 May 2024		

Record of Painting NCSS3010 R90B			
Start Time:	18:00	End Time:	19:00
Temperature $\geq 15^{\circ}$ :	28 $^{\circ}$ C	Humidity $\leq 75\%$ :	46%
Paint Batch No.:	8216294	Paint Expiry Date:	31-04-2025
Hardener Batch No.:	8138195 113	Hardener Expiry Date:	11/20
Desolvation Start Time:	19:00	Desolvation End Time:	19:15
Stoving Start Time:	19:15	Stoving End Time:	20:15
Stoving Temp:	60 $^{\circ}$ C		
Operator:	Ntuthuko	Sign:	
Date:	20/05/11		Ntuthuko
Painting NCSS3010 R90B Control			
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS	
1: 103	5: 82	1: 114	5: 128
2: 95.7	6: 115	2: 97.2	6: 149
3: 98.7	7: 101	3: 117	7: 194
4: 120.12	8: 99.2	4: 120	8: 93.7
Min: 82		Min: 114	
Max: 168		Max: 194	
Average: 112		Average: 128	
Painting NCSS3010 R90B has been inspected and is free of defects		Confirmed	Yes <input type="checkbox"/> No <input checked="" type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	320
QC Inspector:	2473	Sign:	
Date:	18/5/24		



Record of Painting Blue NCSS1565 B			
Start Time:	22:00	End Time:	22:30
Temperature $\geq 15^{\circ}$ :	29°C	Humidity $\leq 75\%$ :	56%
Paint Batch No.:	8216288	Paint Expiry Date:	27-03-2025
Hardener Batch No.:	8138195 113	Hardener Expiry Date:	11/26
Desolvation Start Time:	22:30	Desolvation End Time:	22:45
Stoving Start Time:	22:45	Stoving End Time:	23:45
Stoving Temp:	60°C		
Operator:	Attn: Chuk	Sign:	Attn: Chuk
Date:	20/05/11		
Painting Blue NCSS1565 B Control			
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS	
1: 138	5: 83	1: 126	5: 106
2: 91.6	6: 126	2: 83.5	6: 94.1
3: 86	7: 103	3: 95.1	7: 80
4: 91.5	8: 86.5	4: 102	8: 114
Min:	83	Min:	80
Max:	138	Max:	126
Average:	101	Average:	99.9
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:	91.2
QC Inspector:	Attn: B	Sign:	Attn: B
Date:	18/5/24		

Record of RAL 7012									
Start Time:		03:00		End Time:		05:20			
Temperature $\geq 15^{\circ}$ :		27°C		Humidity $\leq 75\%$ :		61%			
Paint Batch No.:		8216273		Paint Expiry Date:		13-03-25			
Hardener Batch No.:		8138195113		Hardener Expiry Date:		11/26			
Desolvation Start Time:		05:30		Desolvation End Time:		05:45			
Stoving Start Time:		05:45		Stoving End Time:		06:45			
Stoving Temp:		60°C							
Operator:		Nentunko		Sign:		Nentunko			
Date:		20/05/13							
RAL 7012 Control									
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front			
1: 109.2	5: 152	1: 147	5: 99.7	1: 107	5: 178	1: 82.5	5: 111		
2: 121	6: 94.6	2: 154	6: 97.7	2: 114	6: 162	2: 81.9	6: 89.1		
3: 183	7: 127	3: 97.7	7: 126	3: 87	7: 126.1	3: 116	7: 88.6		
4: 137	8: 148	4: 140	8: 150	4: 132	8: 119	4: 93.1	8: 106		
Min:	94.6	Min:	97.7	Min:	87	Min:	82.5		
Max:	183	Max:	154	Max:	178	Max:	116		
Average:	132	Average:	126	Average:	128	Average:	95.7		
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside			
1: 84.5	5: 118	1: 173	5: 136	1: 175	5: 93.6	1: 85	5: 79.5		
2: 124	6: 109	2: 123	6: 83.5	2: 108	6: 138	2: 73.6	6: 110		
3: 89.6	7: 81	3: 159	7: 78.0	3: 107	7: 147	3: 89.6	7: 125		
4: 117	8: 148	4: 149	8: 82	4: 184	8: 132	4: 108	8: 166		
Min:	81	Min:	78	Min:	93.6	Min:	73.6		
Max:	124	Max:	159	Max:	184	Max:	166		
Average:	108	Average:	128	Average:	135	Average:	104		
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test					
1: 108	5: 125	1: 115	5: 84.1						
2: 80	6: 117	2: 91.5	6: 90.2						
3: 85.5	7: 128	3: 89.5	7: 116						
4: 80	8: 98.2	4: 101	8: 107						
Min:	80	Min:	84.1						
Max:	128	Max:	116						
Average:	103	Average:	98.5						
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed		Yes		No	
GMS-SOS-GIBELA-PS-002 Gloss Test				Value		39.8			
QC Inspector:		2473		Sign:					
Date:		18/5/24							
SEALING OF CABIN									
All areas where there is no welding has been sealed with SIKA						Confirmed		YES	
All sealants have been neatly applied along joints						Confirmed		YES	
SIGN OFF									
CLOCK No:		2400		OPERATOR SIGN:		APHILE		DATE	
								18/5/24	

CABIN WAXING				
CABIN IS WAXED			Confirmed	YES <input type="checkbox"/> NO <input checked="" type="checkbox"/>
SIGN OFF				
CLOCK No:	2400	OPERATOR SIGN:	A PHILE	DATE: B / 5 / 24

**Confirmed**

**YES**

☒ NO

## SIGN OFF

CLOCK No.

2400

## OPERATOR SIGN:

APHILE

DATE \_\_\_\_\_

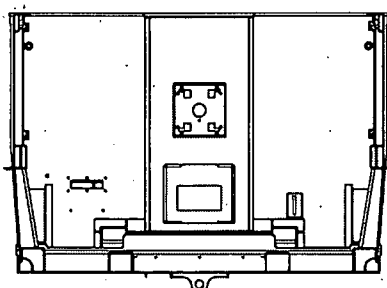
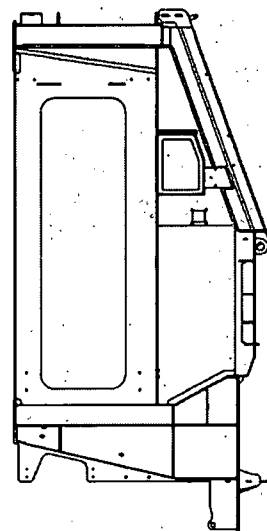
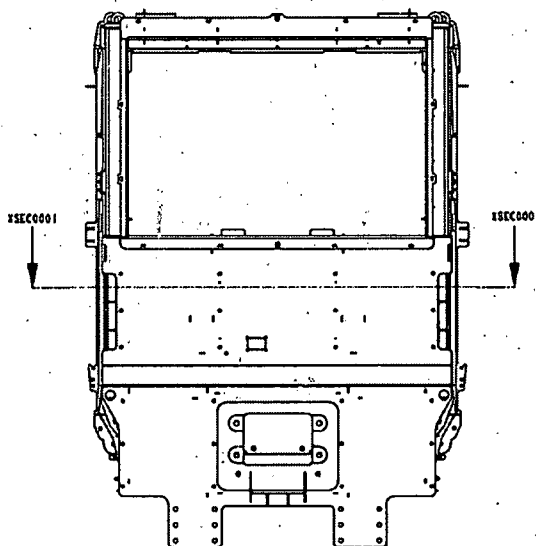
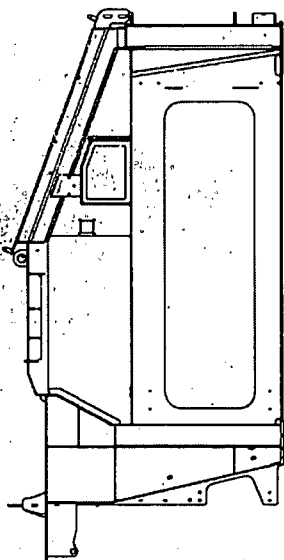
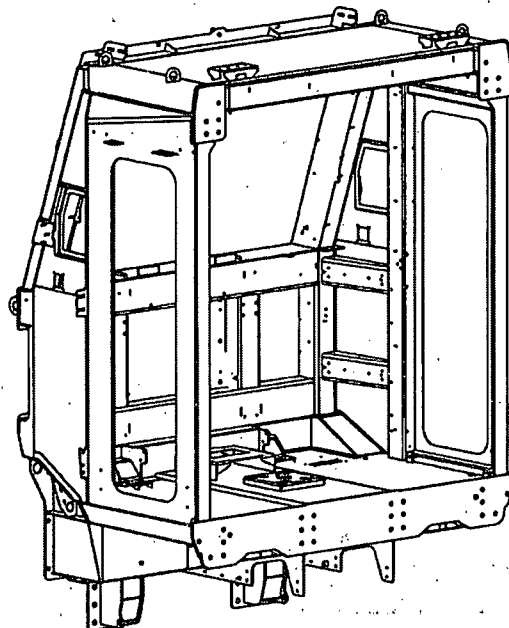
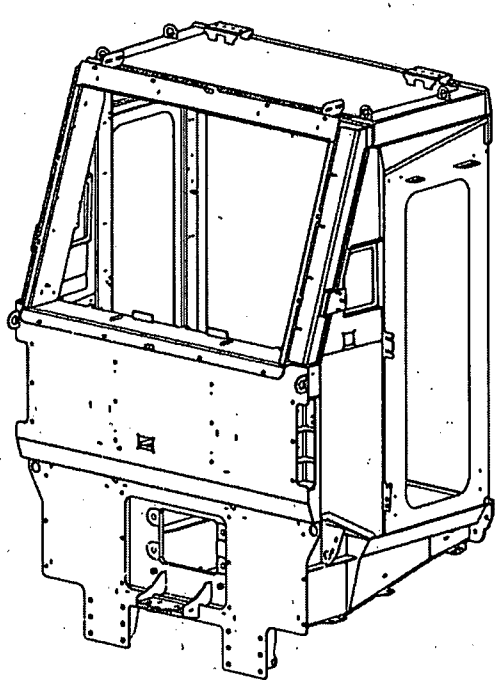
R-1524

## Request for Weld Repair

[illegible]

## REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)



**FAULT TRACKING**

[illegible]

REMINDERS / COMMENTS


[illegible]



Running No.:		Updated By:	Jonathan Chetty
Frame No.:	0469	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
	2285	4 20 May 2024