

CABIN STRUCTURE
QUALITY CARD

CAB No.: CAB468__

WEIGHT: 1481 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	LP49402	
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	F20S272	
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegasus	28/02/2024	178488 104640 01	P300091	
RCS 355	20 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegasus	28/02/2024			
RCS 355	30 mm					

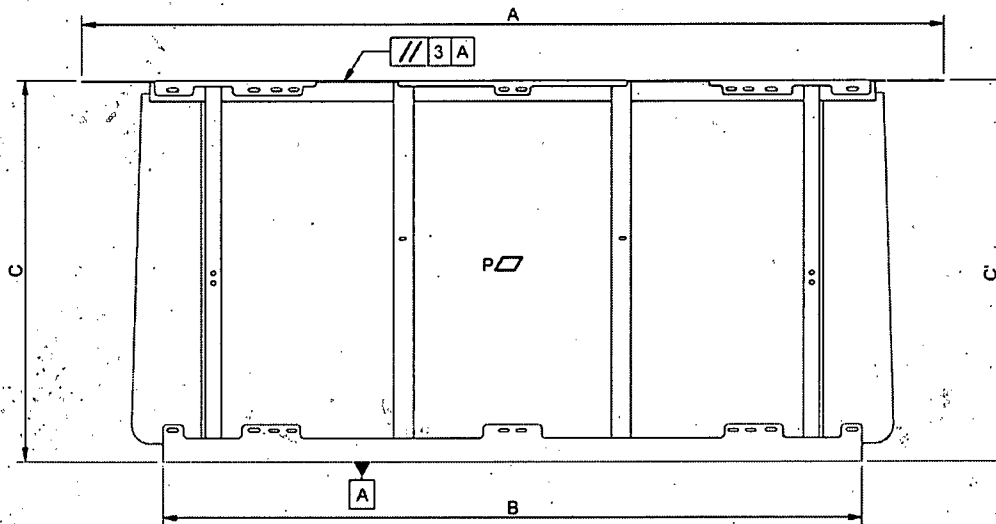
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	08/02/2024	178489 104640 01	VHC 35528	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	F207905	TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	14/02/2024	178815 104640 01	VHC 28402	
RCS 450	6 mm					
RCS 450	6 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	F207906	TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	22/11/2024	178569 102206 01	VHS 58432	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

Cabin Roof Assembly: GN002839

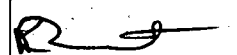
Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes <input type="checkbox"/>	No <input checked="" type="checkbox"/>
Operator:	DYLAN DAVIDS	Assembly Date:	2024/04/16	
Sign:		Wire Batch No.:	107238201	




Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes <input type="checkbox"/>	No <input checked="" type="checkbox"/>
QC Inspector:	Riccardo	Sign:		Date: 2024/04/16

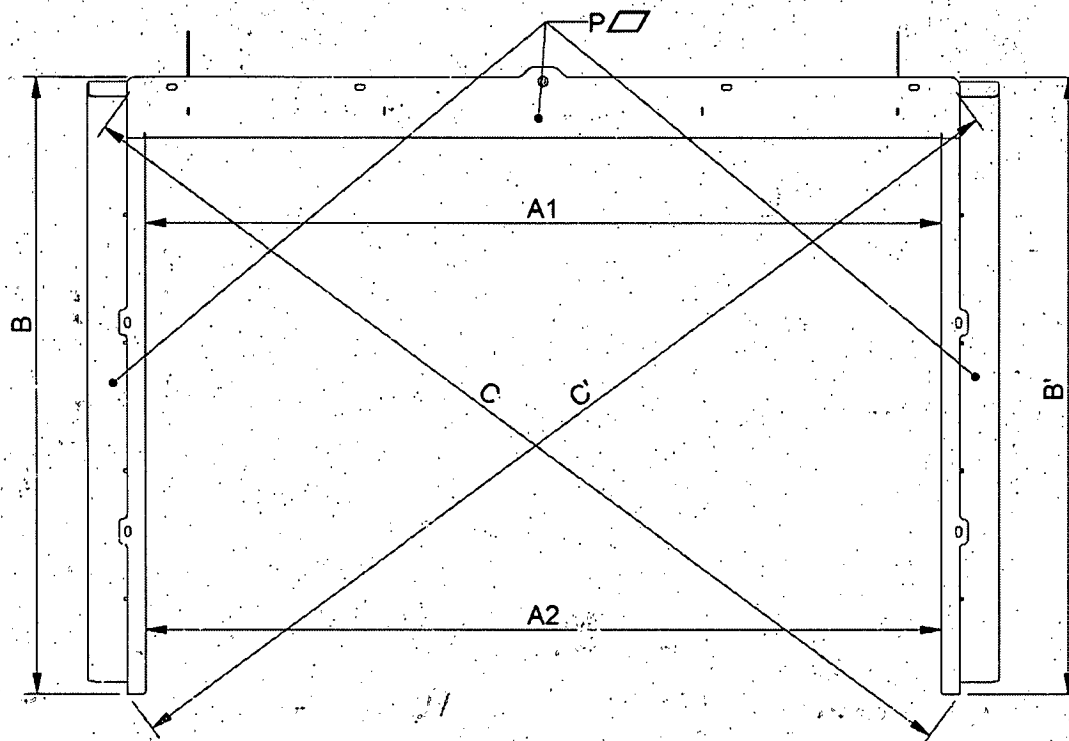
Dimensional Control

Rep		Toler.	Dimension measured		Measuring Equipment	Observations	
A	2216	+5/-0	2216		Tape Measure	acceptable	
B	1800	± 4	1800			acceptable	
C	976	+2/-3	977	977		acceptable	
QC Inspector:		Riccardo		Sign:		Date:	2024/04/16

Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment		Observations	
Planéité P 1		6 mm	PASSED		Ruler		acceptable	
//	3	A	PASSED		Set Square		acceptable	
QC Inspector:		Riccardo		Sign:			Date:	2024/04/16

Cabin Front Frame Assembly: GN002840				
Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>Donato B. C. Viana</i>	Assembly Date:	2024/04/16	
Sign:	<i>[Signature]</i>	Wire Batch No.:	SS 70-32	



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>Ricardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/04/16	
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension Measured		Observations	
A1	1910	± 2	1911		acceptable	
A2	1910		1911		acceptable	
B	1475	± 1	1474	1474	acceptable	
C	Diagonals C - C' ≤ 3		2474	2476	acceptable	
QC Inspector:	<i>Ricardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/04/16	
Geometrical Control						
Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P : Planeity		4 mm	Passed		Ruler	acceptable
QC Inspector:	<i>Ricardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/04/16	

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>T/K Boone</i>	Assembly Date:	20 <i>24</i> / <i>04</i> / <i>08</i>			
Sign: <i>[Signature]</i>	Wire Batch No.:	<i>552033</i>			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

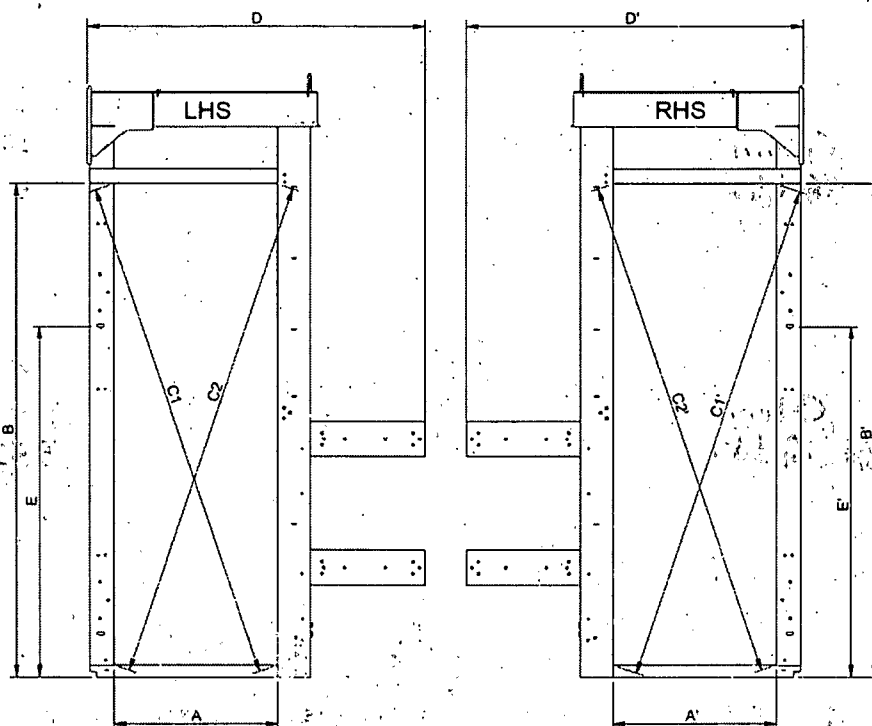
Assembly Completed as per WI/SOS MD_0065_0066	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator: <i>Glenn</i>	Assembly Date:	20 <i>24</i> / <i>04</i> / <i>08</i>			
Sign: <i>[Signature]</i>	Wire Batch No.:	<i>552033</i>			

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: <i>Glenn</i>	Assembly Date:	20 <i>24</i> / <i>04</i> / <i>08</i>			
Sign: <i>[Signature]</i>	Wire Batch No.:	<i>552033</i>			

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:	2024/04/10		
Sign:	<i>Glenn</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>Riccardo</i>	Date:	2024/04/11

Dimensional Control

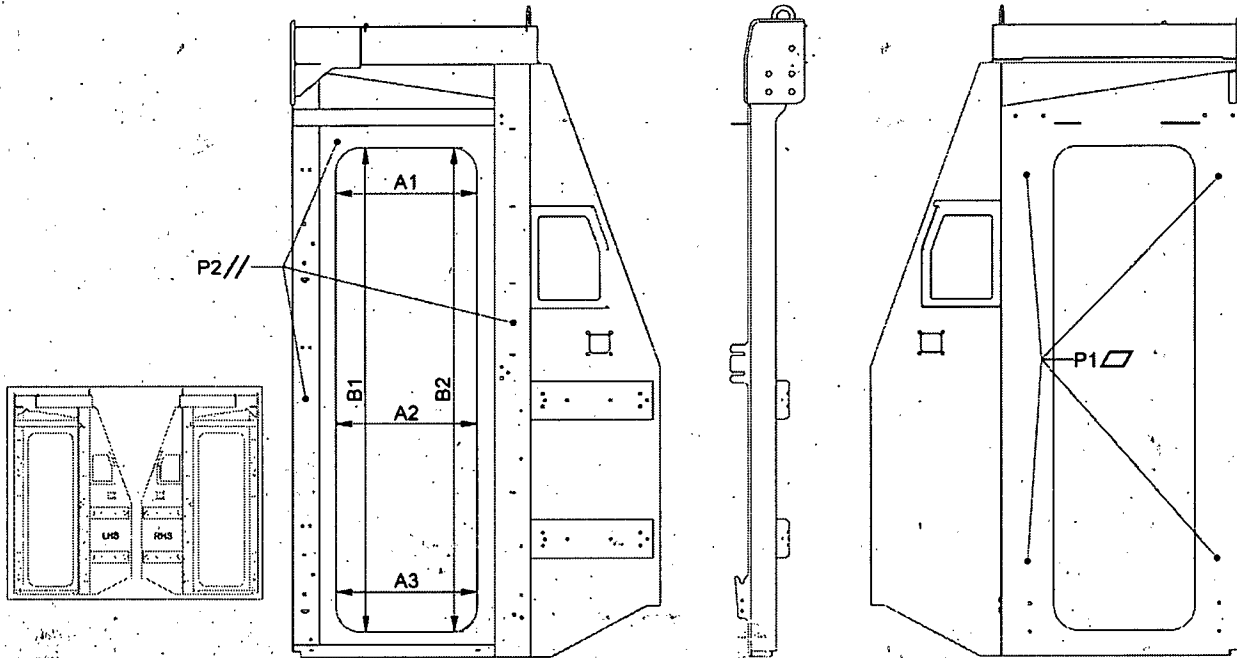
Rep	Theoretical-Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	697	Tape Measure	acceptable
B	2086	+1/-3	2085	2084		acceptable
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2153	2153		acceptable
C1 - C2			2154	2153		acceptable
D	1438	+2/-3	1438	1438		acceptable
E				1482		acceptable
QC Inspector:	Riccardo	Sign:	<i>Riccardo</i>	Date:	2024/04/11	

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1: planeity of 2 edges	4 mm	Passed	Ruler
QC Inspector:	Riccardo	Sign:	<i>Riccardo</i>
Date:	2024/04/10		

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>TK Boote</i>	Assembly Date:	20 24/04/10			
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:	2024/04/10	

Dimensional Control

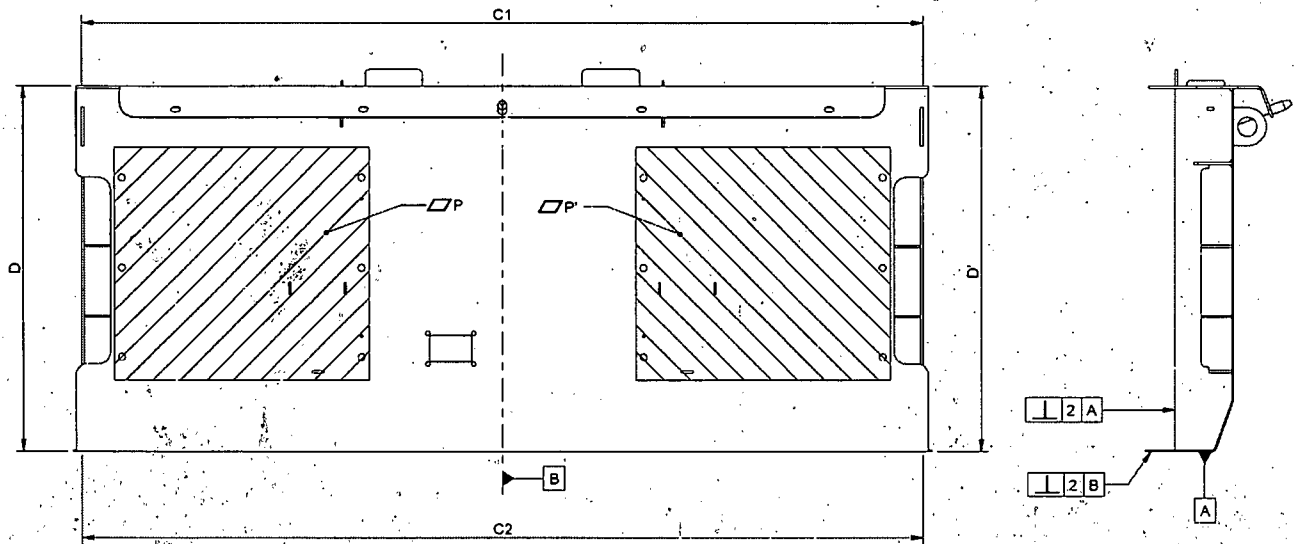
Rep.	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	560	± 2	558	559	Tape Measure	acceptable	
A2			560	560		acceptable	
A3			560	560		acceptable	
B1	1900	± 2	1898	1898		acceptable	
B2			1898	1898		acceptable	
QC Inspector:		Riccardo	Sign:		Date:	2024/09/16	

Geometrical Control

Nature of checks		Dimension Measured		Measuring Equipment	Observations	
P1: Planeity	4 mm	Passed		Ruler	acceptable	
P2: Planeity	2 mm	Passed		Ruler	acceptable	
QC Inspector:	Riccardo	Sign:	Riccardo	Date:	2024/03/10	

Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Riccardo Gama</i>	Assembly Date:	2024/04/14			
Sign:	<i>[Signature]</i>	Wire Batch No.:	SS 2033			



Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/04/14	

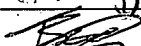
Dimensional Control

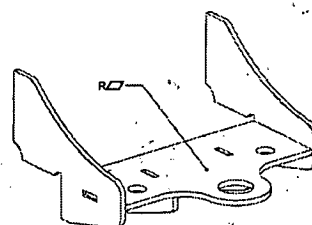
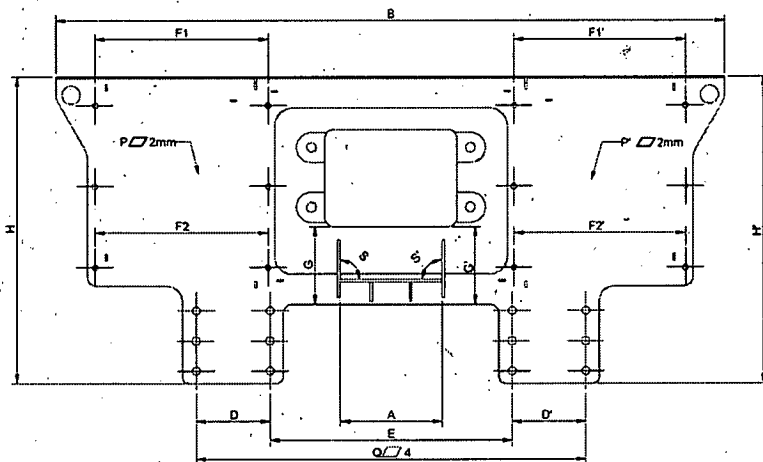
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2213	2210	Tape Measure	acceptable
D / D'	956	± 2	955	958		acceptable
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/04/14	

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:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/04/14	

Cabin Front Headstock Assembly: GN002841


Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	TK Boon	Assembly Date:	2024/04/12			
Sign:		Wire Batch No.:	552033			



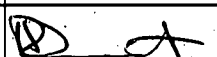
Welding Control

Visual inspection of all Welds as per Drawing and EN:ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Riccardo	Sign:		Date:	2024/04/12	

Dimensional Control

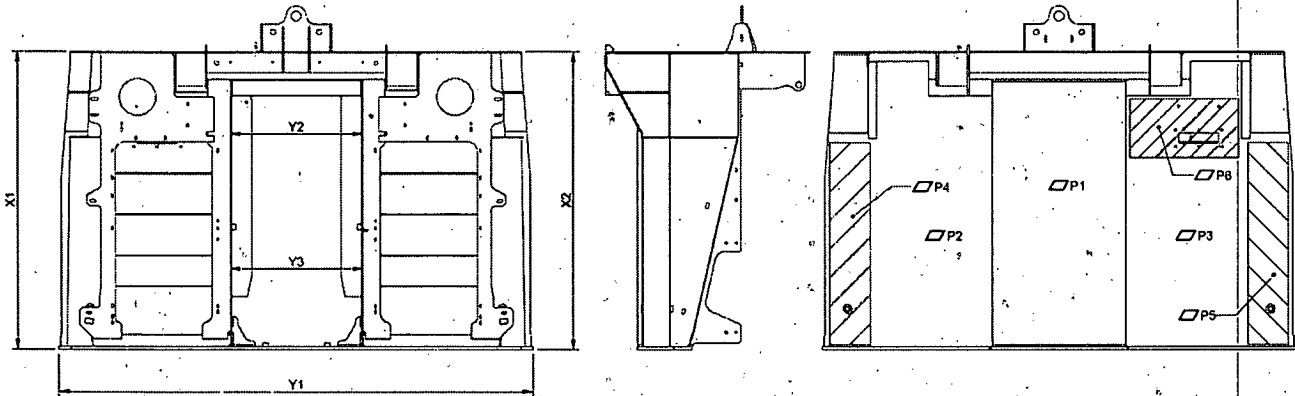
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	340	± 1	340		Tape Measure	acceptable	
B	2240	± 4	2244			acceptable	
D / D'	250	± 1	250	250		acceptable	
E	808	± 2	808			acceptable	
F1 / F1'	580	± 1	581	581		acceptable	
F2 / F2'			581	581		acceptable	
G / G'	258	± 1	259	259		acceptable	
H / H'	1019	± 2	1020	1020		acceptable	
QC Inspector:		Riccardo		Sign:		Date:	2024/04/12

Geometrical Control

Nature of checks		Dimension Measured		Measuring Equipment	Observations	
O: Planeity of global assembly	4 mm	Passed		Ruler	acceptable	
P / P': Planeity	2 mm	Passed		Ruler	acceptable	
Q: Planeity Surface of Supports	4 mm	Passed		Ruler	acceptable	
R: Planeity Coupler Support	2 mm	Passed		Ruler	acceptable	
S: Perpendicularity coupler	1mm	Passed		Square	acceptable	
QC Inspector:	Riccardo		Sign:		Date:	2024/04/12


Cabin Underframe Assembly: GN002835

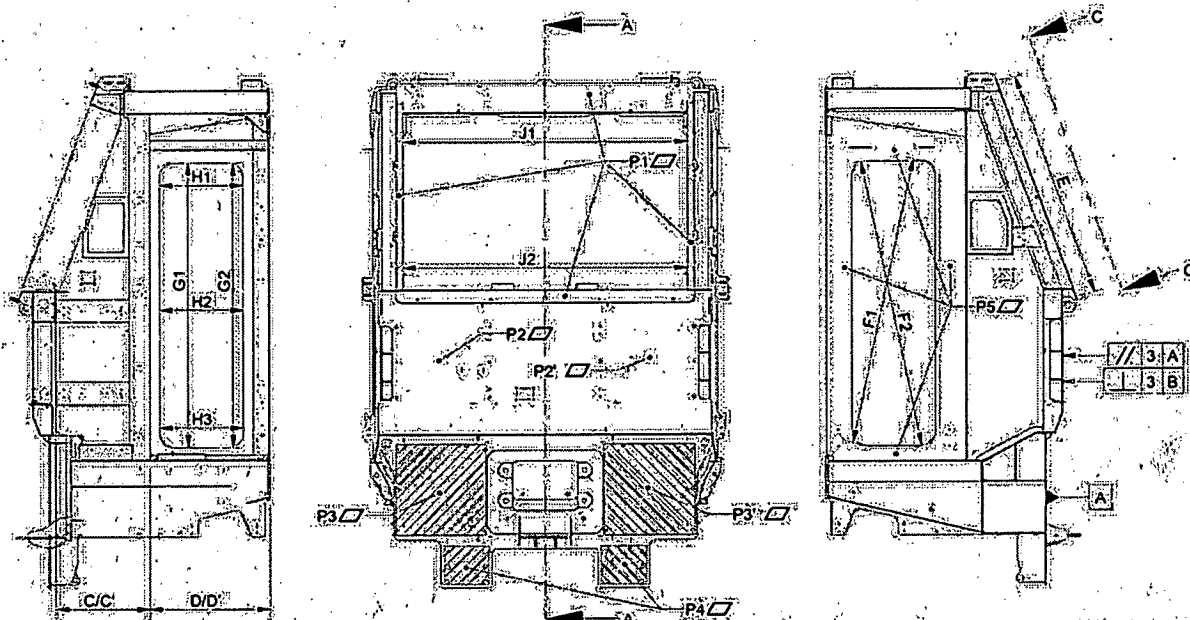
Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	2024/04/16	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152	



Welding Control					
Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No	
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/04/16
Dimensional Control					
Rep	Theoretical Dim	Toler.	Dimension Measured		Observations
X1 / X2	1485	+5 / -2	1486	1485	acceptable
Y1	2354	± 3			
Y2 / Y3	666	± 1	667	667	acceptable
QC Inspector:		<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date: 2024/04/16
Geometrical Control					
Nature of checks		Dimension Measured		Measuring Equipment	Observations
P1 : Planeity		4 mm	Passed	Ruler	acceptable
P2 / P3 : Planeity		4 mm	Passed	Ruler	acceptable
P4 / P5 : Planeity		2 mm	Passed	Ruler	acceptable
P6 : Planeity		2 mm	Passed	Ruler	acceptable
QC Inspector:		<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date: 2024/04/16

Cabin Structure Assembly: GN002834

Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLOEM	Assembly Date:	20 24 Oct 16			
Sign:		Wire Batch No.:	852033			




SECTION A-A

SECTION B-B

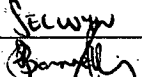
AUX VIEW C

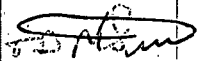
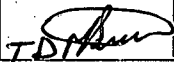


Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042				Confirmed		Yes		No	
QC Inspector:		Riccardo		Sign:		RMA		Date: 2024/04/22	
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	625	625	acceptable				
D / D'	813	± 2,5	813	811	acceptable				
E	1531.5	± 3	1531		acceptable				
G1 / G'1	Height	+1	1898	1898	acceptable				
G2 / G'2	1900	-3	1898	1898	acceptable				
H1 / H'1	Width 560	+1 -3	558	559	acceptable				
H2 / H'2			559	559	acceptable				
H3 / H'3			559	560	acceptable				
F1 / F'1	Diagonals 1939		1937	1936	acceptable				
F2 / F'2			1936	1934	acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	1	1	acceptable				
J	Gap of Doors	± 1,5	1	1	acceptable				
K1 / K2	1515	± 3	1513	1514	acceptable				
L1 / L2	1996	± 3	1998	1998	acceptable				
M1 / M'1	2306	± 3	2476	2476	acceptable				
M2 / M'2			2467	2467	acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2128	2129	acceptable				
T2 / T'2	2230 Top/Bottom		2230	2229	acceptable				
Difference	U - U' (3522)	≤ 4mm	3523	3521	acceptable				
QC Inspector:		Riccardo		Sign:		RMA		Date: 2024/04/22	
Geometrical Control									
Nature of checks				Toler.	LHS / Dimension Measured / RHS		acceptable		
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:		RMA		Date: 2024/04/22	

Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHAD BLOEM	Assembly Date:	2024/04/22			
Sign:		Wire Batch No.:	852033			

Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
Operator:	SELWYN	Assembly Date:	2024/04/22			
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 24/05/08				
Record of Shot Blasting					
Operator:		Date:	20 24/05/08		
Start Time:	08 45	End Time:	15 400		
Temperature ($\geq 15^\circ$):	20-04°C	Humidity ($\leq 75\%$):	61-02%/0		
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 24/05/08				
Shot Blasting Cleaning					
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID	Sign:			
Date:	20 24/05/09				
Shot Blasting Control					
Temperature $\geq 15^\circ$:	19-03°C	Humidity $\leq 75\%$:	63-07%		
Internal Roughness $3.2 \leq Ra \leq 12.5$		External Roughness $3.2 \leq Ra \leq 12.5$			
QC Inspector:	CARMEN	Sign:			
Date:	8/5/24				

Ra 6,441
 4,542
 6,822
 7,407
 8,026
 6,002
 7,142
 5,430
 5,712
 4,502



R2 38,061
 29,640
 42,795
 45,775
 51,149
 39,052
 46,094
 35,815
 36,926
 31,783



Ra 5,970
 5,583
 7,142
 6,503
 6,787
 6,145
 6,157
 6,554
 6,367
 6,771

R3 39,408
 R2 36,601
 46,252
 43,720
 40,399
 39,859
 35,508
 37,909
 39,535
 41,902

Record of Priming									
Start Time:		13:00		End Time:		15:00			
Temperature $\geq 15^{\circ}$:		26 $^{\circ}\text{C}$		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 $^{\circ}\text{C}$							
Operator:		musee		Sign:		musee			
Date:		2024/05/09							
Priming Control									
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front			
1: 69.3	5: 48.7	1: 54.2	5: 39.2	1: 63.3	5: 53.7	1: 70.1	5: 54.5		
2: 66.6	6: 78.8	2: 59.4	6: 61.0	2: 79.5	6: 56.8	2: 71.0	6: 52.1		
3: 53.2	7: 55.6	3: 61.9	7: 52.8	3: 48.6	7: 47.0	3: 66.1	7: 72.4		
4: 59.5	8: 62.0	4: 67.9	8: 57.1	4: 60.5	8: 55.3	4: 68.4	8: 40.9		
Min:	48.7	Min:	39.2	Min:	47.0	Min:	40.9		
Max:	78.8	Max:	67.9	Max:	79.5	Max:	72.4		
Average:	63.7	Average:	53.5	Average:	63.2	Average:	56.6		
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside			
1: 42.5	5: 75.0	1: 60.8	5: 76.7	1: 51.2	5: 64.3	1: 77.4	5: 51.8		
2: 63.3	6: 79.3	2: 65.8	6: 81.4	2: 70.1	6: 65.7	2: 73.6	6: 53.1		
3: 56.9	7: 68.1	3: 64.5	7: 57.4	3: 58.6	7: 46.6	3: 68.9	7: 55.0		
4: 77.7	8: 58.2	4: 50.6	8: 44.4	4: 54.9	8: 65.0	4: 50.8	8: 60.7		
Min:	42.5	Min:	44.4	Min:	46.6	Min:	50.8		
Max:	79.3	Max:	76.7	Max:	70.1	Max:	77.4		
Average:	60.9	Average:	59.0	Average:	55.3	Average:	64.1		
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS			
1: 49.0	5: 43.3	1: 63.1	5: 78.7	1: 59.1	5: 72.6	1: 51.5	5: 71.2		
2: 68.0	6: 50.6	2: 57.8	6: 67.0	2: 77.5	6: 55.3	2: 66.9	6: 45.2		
3: 74.2	7: 62.4	3: 52.3	7: 73.6	3: 55.8	7: 67.2	3: 56.1	7: 74.4		
4: 76.7	8: 62.9	4: 69.5	8: 44.3	4: 61.8	8: 67.9	4: 69.2	8: 64.7		
Min:	43.3	Min:	44.3	Min:	55.3	Min:	45.2		
Max:	76.7	Max:	78.7	Max:	77.5	Max:	74.4		
Average:	60.8	Average:	61.5	Average:	66.2	Average:	59.8		
Primer has been inspected and is free of defects				Confirmed		Yes <input checked="" type="checkbox"/>		No <input type="checkbox"/>	
QC Inspector:		Zothile		Sign:		musee			
Date:		14 May 2024							

Record of Painting NCSS3010 R90B					
Start Time:		18:00		End Time:	
Temperature $\geq 15^{\circ}$:		28°C		Humidity $\leq 75\%$:	
Paint Batch No.:		8216294		Paint Expiry Date:	
Hardener Batch No.:		8138195113		Hardener Expiry Date:	
Desolvation Start Time:		19:00		Desolvation End Time:	
Stoving Start Time:		19:15		Stoving End Time:	
Stoving Temp:		60°C			
Operator:		musa		Sign:	
Date:		2024/05/14		musa	
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: 81.3	5: 83.3	1: 137	5: 120		
2: 122	6: 91.4	2: 124	6: 117		
3: 104	7: 125	3: 101	7: 108		
4: 94.8	8: 131	4: 103	8: 113		
Min:	83.3	Min:	101		
Max:	131	Max:	137		
Average:	104	Average:	115		
Painting NCSS3010 R90B has been inspected and is free of defects					
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	
QC Inspector:		Zothile		Sign:	
Date:		16 May 2024			

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:	Neethuk	Sign:	
Date:	2024/05/15		
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: 139	5: 159	1: 124	5: 156
2: 134	6: 116	2: 112	6: 119
3: 122	7: 124	3: 138	7: 104
4: 148	8: 131	4: 100	8: 98.6
Min:	116	Min:	98.6
Max:	159	Max:	156
Average:	134	Average:	118
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:	16 May 2024		

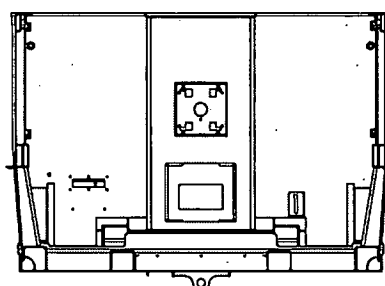
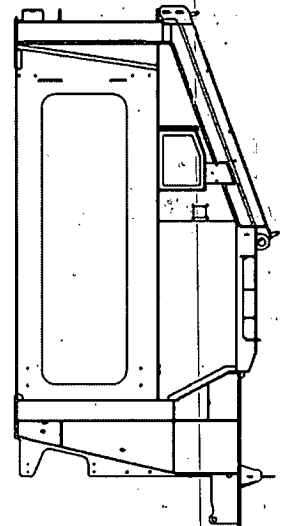
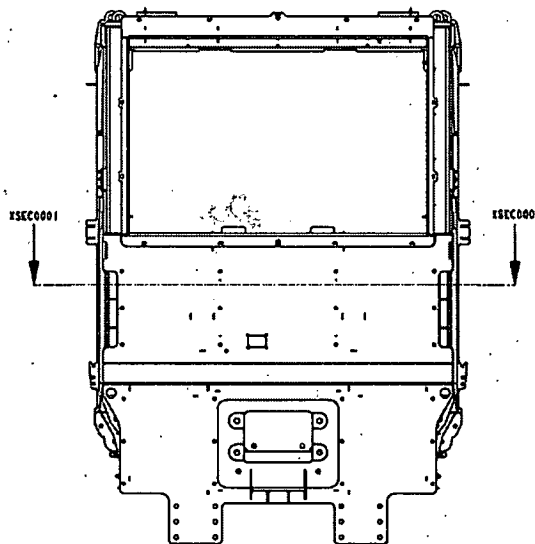
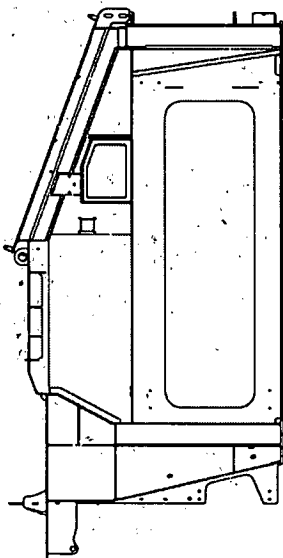
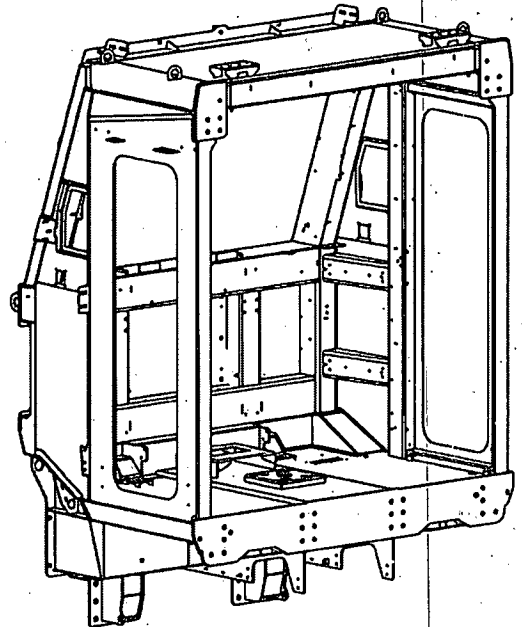
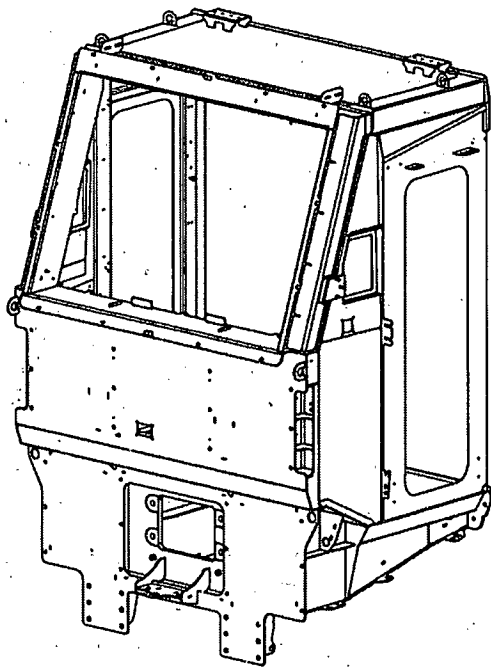
Record of RAL 7012							
Start Time:	03:00		End Time:	08:30			
Temperature $\geq 15^{\circ}$:	27°C		Humidity $\leq 75\%$:	61%			
Paint Batch No.:	8216273		Paint Expiry Date:	13.03.2025			
Hardener Batch No.:	8138195113		Hardener Expiry Date:	11/26			
Desolvation Start Time:	05:30		Desolvation End Time:	05:45			
Stoving Start Time:	05:45		Stoving End Time:	06:45			
Stoving Temp:	60°C						
Operator:	Ntvtkvko		Sign:				
Date:	20/05/25						
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 81.0	5: 154	1: 108	5: 127	1: 125	5: 142	1: 96.6	5: 132
2: 147	6: 134	2: 131	6: 124	2: 98.7	6: 105	2: 153	6: 87.1
3: 127	7: 93.6	3: 108	7: 110	3: 113	7: 109	3: 122	7: 89.7
4: 116	8: 150	4: 140	8: 115	4: 131	8: 80.7	4: 115	8: 162
Min:	81.0	Min:	108	Min:	80.7	Min:	87.1
Max:	154	Max:	140	Max:	142	Max:	153
Average:	125	Average:	120	Average:	113	Average:	119
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 93.1	5: 145	1: 112	5: 119	1: 136	5: 103	1: 151	5: 109
2: 159	6: 132	2: 119	6: 126	2: 115	6: 96.2	2: 98.7	6: 85.1
3: 148	7: 106	3: 127	7: 103	3: 101	7: 81.9	3: 84.3	7: 167
4: 82.5	8: 121	4: 134	8: 129	4: 97	8: 142	4: 90.4	8: 76.8
Min:	82.5	Min:	103	Min:	81.9	Min:	84.3
Max:	159	Max:	134	Max:	142	Max:	167
Average:	123	Average:	121	Average:	109	Average:	107
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 86.3	5: 155	1: 96.0	5: 121				
2: 158	6: 87.9	2: 148	6: 103				
3: 114	7: 165	3: 131	7: 132				
4: 124	8: 140	4: 105	8: 113				
Min:	86.3	Min:	96.0				
Max:	161	Max:	148				
Average:	128	Average:	118				
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No
GMS-SOS-GIBELA-PS-002 Gloss Test				Value			
QC Inspector:		16 May 2024		Sign:			
Date:		2 Zotwile (285)					
SEALING OF CABIN							
All areas where there is no welding has been sealed with SIKA				Confirmed	YES	<input checked="" type="checkbox"/>	NO
All sealants have been neatly applied along joints				Confirmed	YES	<input checked="" type="checkbox"/>	NO
SIGN/OFF							
CLOCK No:	2400		OPERATOR SIGN	AAHLE		DATE	16/5/24

CABIN WAXING					
CABIN IS WAXED				Confirmed	YES <input checked="" type="checkbox"/> NO <input type="checkbox"/>
SIGN OFF					
CLOCK No	2167	OPERATOR SIGN:	APHILE	DATE	16/8/24

[illegible]

REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)



[illegible][illegible]

