



**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
<input type="checkbox"/>											
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE			NAME		DATE			
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba		10/01/2018					
			CHECKER	Nosizo Pindela		10/01/2018					
			COMPILER	Thanyani Mathegu		10/01/2018					
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba		2018/05/18					
			CHECKER	Nosizo Pindela		2018/05/18					
			REVISED BY	Ramokone Motama		2018/05/18					
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230	APPROVER	Itumeleng Modiba		2018/07/04					
			CHECKER	Nosizo Pindela		2018/07/04					
			REVISED BY	Ramokone Motama		2018/07/04					
3	2018/12/12	Added dimensional check points to CB1210	APPROVER	Itumeleng Modiba		2018/12/12					
			CHECKER	Nosizo Pindela		2018/12/12					
			REVISED BY	Ramokone Motama		2018/12/12					
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba		22/01/2019					
			CHECKER	Nosizo Pindela		22/01/2019					
			REVISED BY	Vanessa Ntuli		22/01/2019					
6	13/03/2019	Added D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba		13/03/2019					
			CHECKER	Nosizo Pindela		13/03/2019					
			REVISED BY	Nosizo Pindela		13/03/2019					
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba		21/08/2019					
			CHECKER	Nosizo Pindela		21/08/2019					
			REVISED BY	Nosizo Pindela		21/08/2019					
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela		06/08/2020					
			CHECKER	Bongane Masina		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	Mohlampe Amogelang		14/04/2023					
			REVISED BY	Mohlampe Amogelang		14/04/2023					
28	07/11/2023	Added traceability for welding sections	APPROVER	Ngobeni Tyson		07/11/2023					
			CHECKER	Mohlampe Amogelang		07/11/2023					
			REVISED BY	Ntokozo Zwane		07/11/2023					

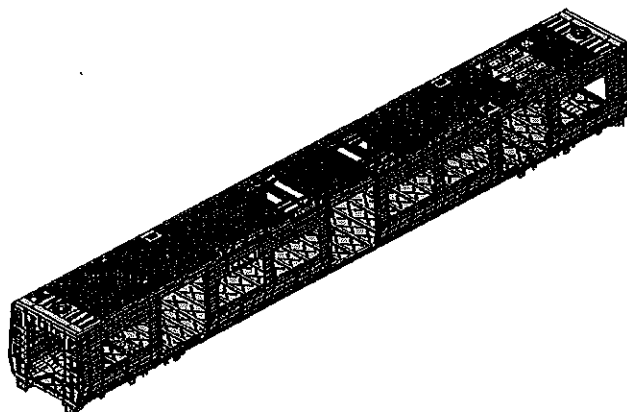
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
234	M4	12000 482833	18/06/24	SI.CB1210.254.V30	17

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

Car: M3 & M4	NCR:	Work station: CB1210
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
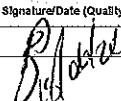


Safety Related




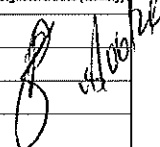


### I - Documentation and Instruments Control

#### I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	P	M	N	P	M	N					
DTR30225487/3					X		26		✓		


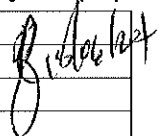

#### I.2 - Instruments Control

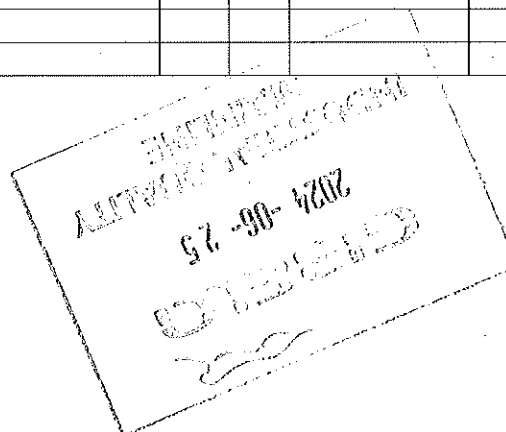
##### Monitoring and Measuring Instrument Control - Used for Special Process



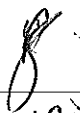
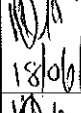

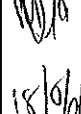

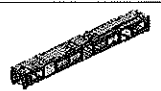

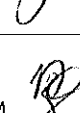
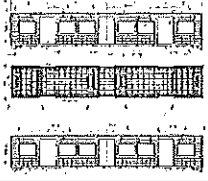
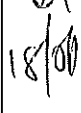




Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULAR	52823-2	15/03/24	✓	 18/06/24	
30 M TAPE	G1KTP0084	14/08/24	✓	 18/06/24	
LASER TAPE	125425924	08/01/24	✓	 18/06/24	

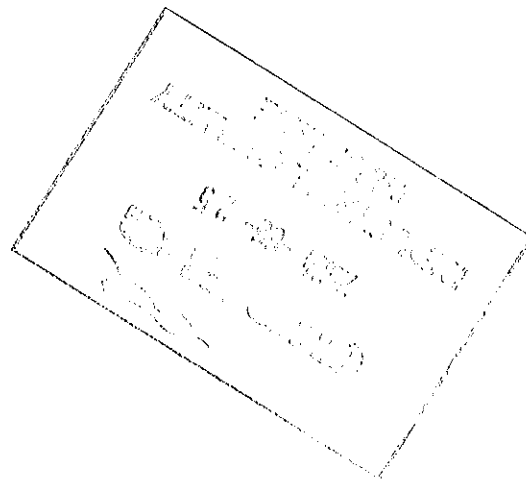
#### 1.3 Consumables


##### Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
AUTRAD 308 LSI	15221880	MIG	✓	 18/06/24	
ER 309 LSI	318394	MIG	✓	 18/06/24	

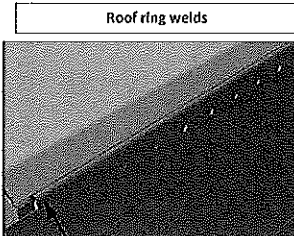


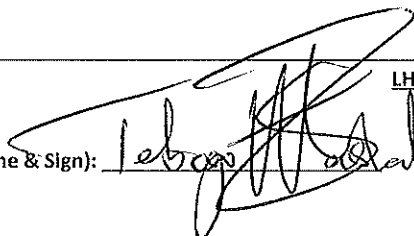
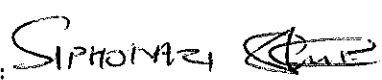

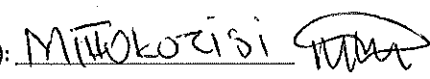
		CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28 Date 07/11/2023	Project: PRASA SI.CB1210.254.V30			
<b>II - Self Inspection - Items to Check</b>							
H.1 - Items to check							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Corshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		 18/06/24	 15/06/24
02	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓		 18/06/24	 15/06/24
03	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 18/06/24	 15/06/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 18/06/24	 15/06/24
05		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓		 18/06/24	 15/06/24
06	N/A 	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓		 18/06/24	 15/06/24

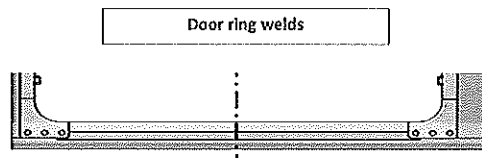


	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V30
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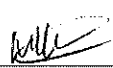

**Welding Traceability**



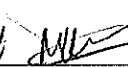
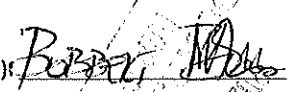
<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <u>LHS</u>   </div> <div style="text-align: center;">  </div> </div>	
Boiler maker (Name & Sign): _____  	Welder (Name & Sign): _____  
<div style="display: flex; justify-content: space-around;"> <div style="text-align: center;"> <u>RHS</u>   </div> <div style="text-align: center;">  </div> </div>	
Boiler maker (Name & Sign): _____  	Welder (Name & Sign): _____  



LHS

Boiler maker (Name & Sign): <u>Innocent</u> 	
Welder (Name & Sign): <u>Robert</u> 	

RHS

Boiler maker (Name & Sign): <u>Innocent</u> 	
Welder (Name & Sign): <u>Robert</u> 	

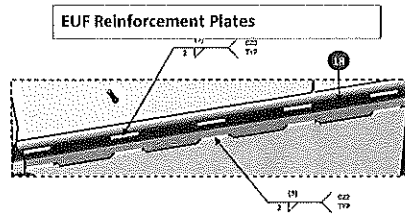
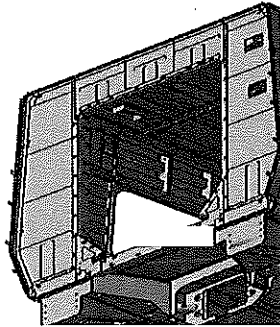
2024-06-25  
 07-00-1700  
 00-11-000000  
 00-11-000000



CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.  
28  
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07/11/2023

Project: PRA5A  
SI.CB1210.254.V30



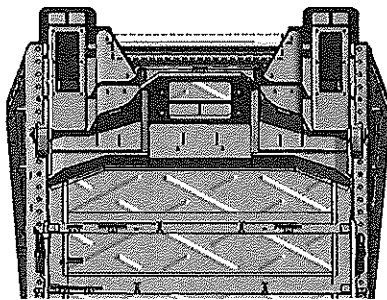
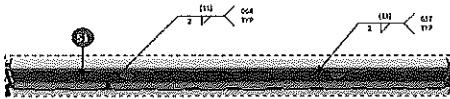
END 1

Boiler maker (Name & Sign):

*Lawrence Wigeo*

Welder (Name & Sign):

*Kertu Kertu*



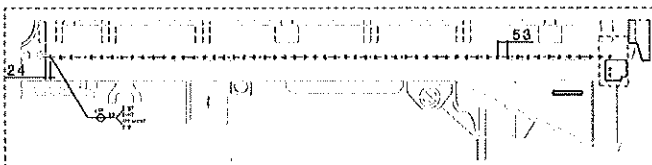
END 2

Boiler maker (Name & Sign):

*Thabang Thabang*

Welder (Name & Sign):

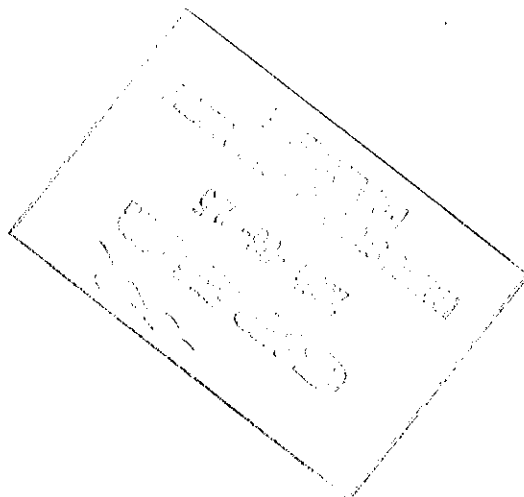
*Thabang Thabang*

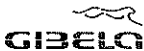


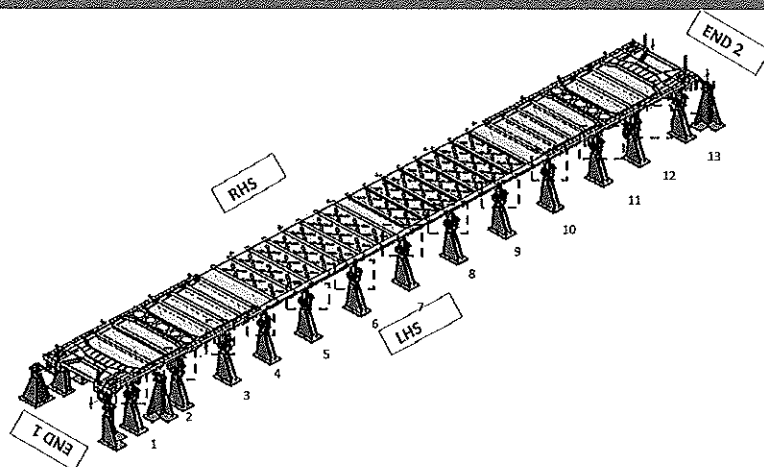
FEDOLI

Operator:

*Leban Lebani*



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		07/11/2023	
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: 18/06/24

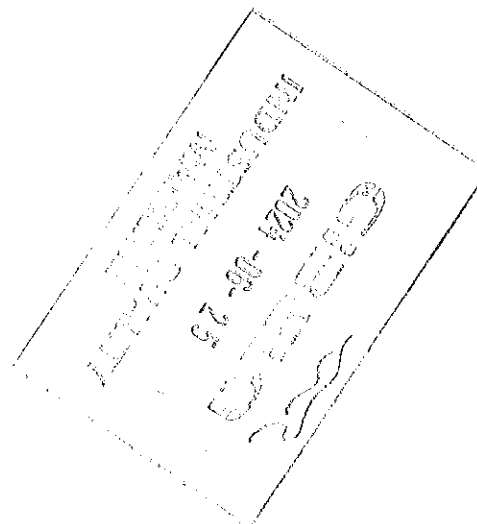
After Welding.

Fill in the gap found 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



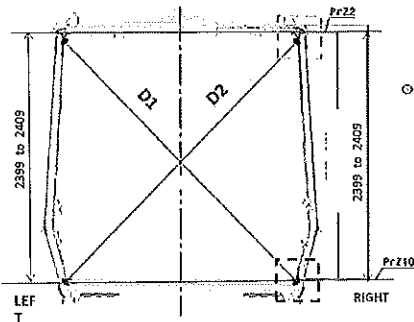
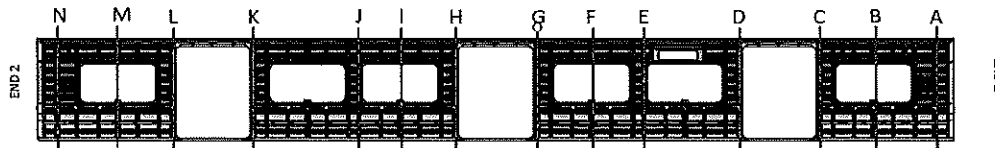


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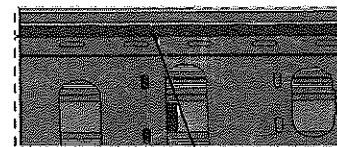
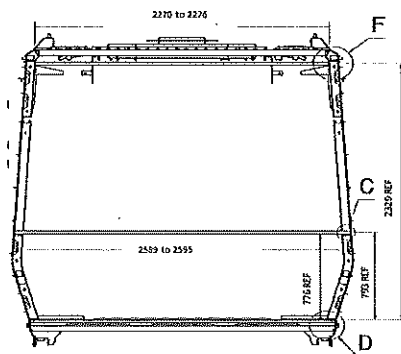
### Specifications of Details for CBS measurement



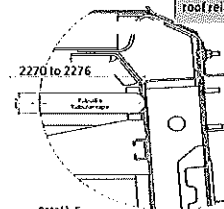
Measurement positions on roof rail and sidewall omega corner.



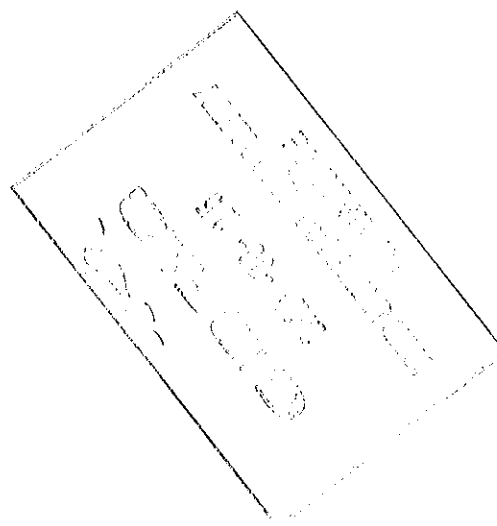
Measurement positions on sidewall and side sill corner.




Reinforcement area measurement positions on roof reinforcement area.

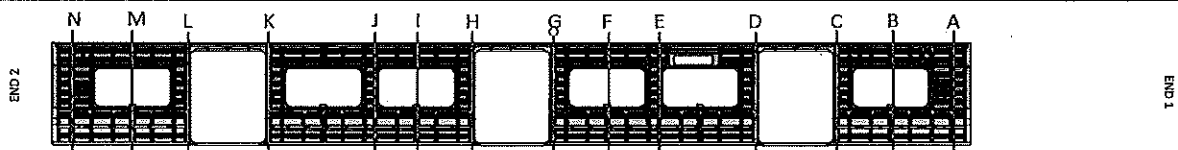


Details F  
Blue lines showing the reinforcement area.



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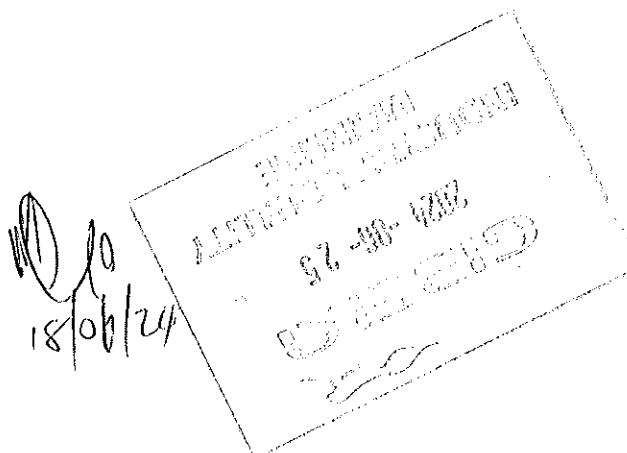
Specifications of Details for CBS measurement



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

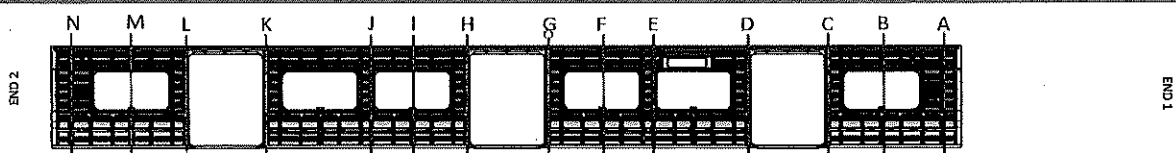
BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS $\leq 2$
A	3268	3267	1	2406	2407	1
B	3265	3267	2	2405	2405	0
C	3268	3268	0	2406	2405	1
D	3269	3267	2	2404	2405	1
E	3265	3265	0	2406	2406	0
F	3264	3266	2	2405	2407	2
G	3268	3268	0	2406	2406	0
H	3268	3267	1	2404	2405	1
I	3265	3264	1	2406	2405	1
J	3266	3266	0	2406	2407	1
K	3267	3267	0	2406	2406	0
L	3268	3269	1	2405	2405	0
M	3264	3267	3	2407	2406	1
N	3268	3268	0	2406	2406	0





### Specifications of Details for CBS measurement

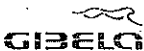


PME Column LHS - RHS should be  $\leq 2\text{MM}$  on each point.

### AFTER WELDING

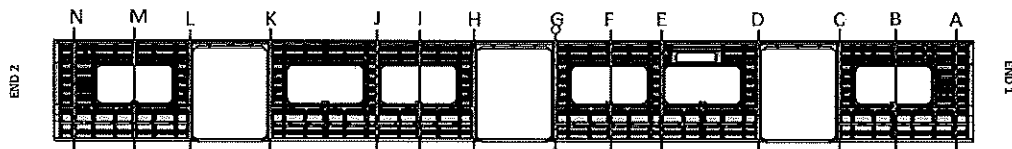
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	32.95	32.94	1	2406	2406	0
B	32.66	32.68	2	2404	2405	1
C	32.95	32.94	1	2405	2401	2
D	32.94	32.94	0	2406	2405	1
E	32.65	32.65	0	2406	2404	2
F	32.66	32.65	1	2405	2405	0
G	32.96	32.94	2	2406	2405	1
H	32.95	32.95	0	2405	2405	0
I	32.64	32.65	1	2404	2406	2
J	32.66	32.66	0	2405	2406	1
K	32.94	32.94	0	2406	2404	2
L	32.95	32.94	1	2405	2405	0
M	32.68	32.65	3	2406	2405	1
N	32.94	32.94	0	2407	2406	1

18/06/24

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### CBS measurement

#### BEFORE WELDING



2270 to 2276

A 2271

B 2275

C 2274

D 2272

E 2278

F 2270

G 2272

H 2273

I 2276

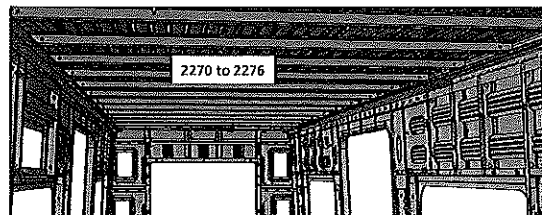
J 2277

K 2271

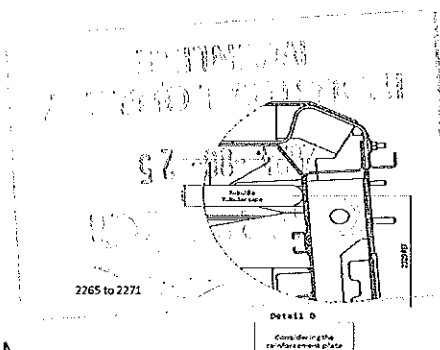
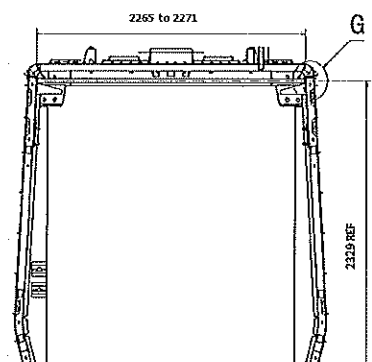
L 2273

M 2274


N 2272



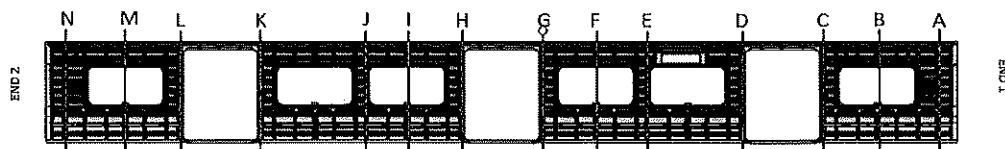
Do not consider reinforcement ( Take measurements top area of zee profile



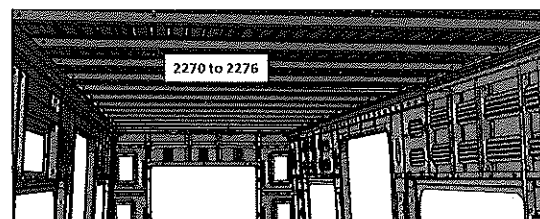
18/06/24

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

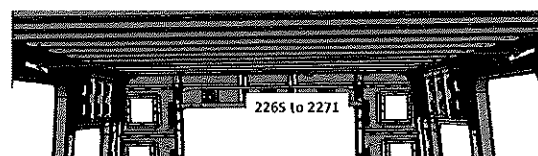
AFTER WELDING



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

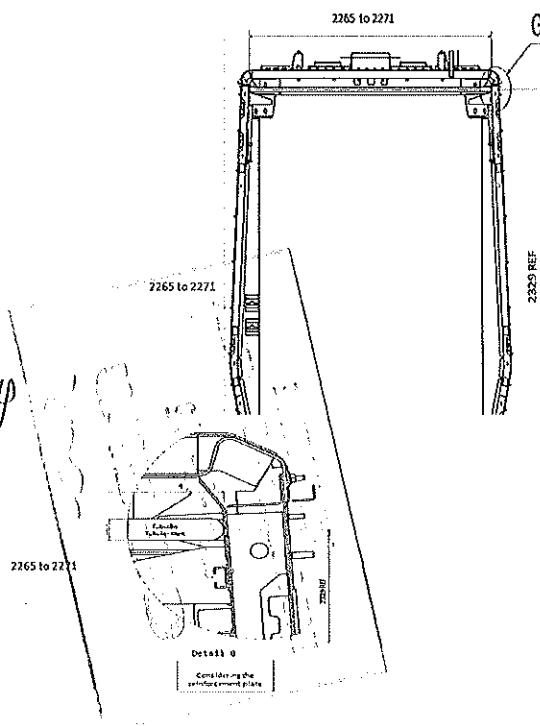


Do not consider reinforcement ( Take measurements top area of zee profile



Take measurement close to radius ( considering reinforcement)

18/10  
18/06/24



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JAN 28 1972  
FBI - NEW YORK

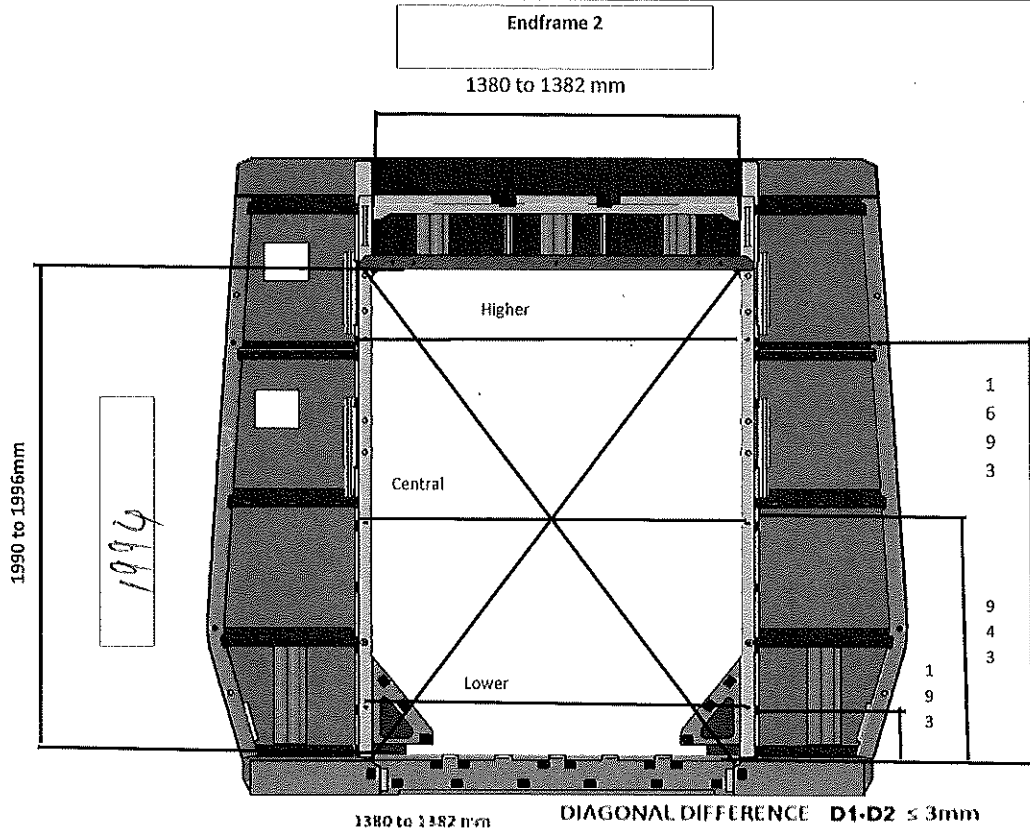


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.  
28  
Date  
07/11/2023

Project: PRASA  
SI.CB1210.254.V30

Specifications of Details for CBS measurement



Higher Dimension

1382

D1

24/13

Central Dimension

1381

D2

24/14

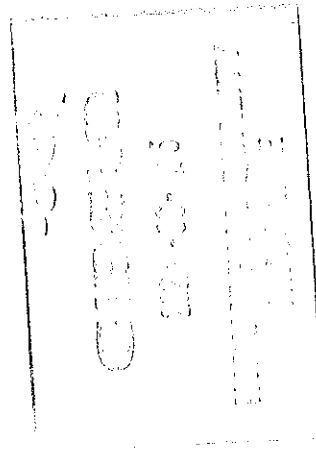
Lower Dimension

1381

D1-D2


1


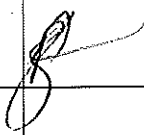
18/06/24



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JAN 10 1964  
U.S. AIR FORCE  
HEADQUARTERS  
AIR FORCE  
WASHINGTON, D.C.



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

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>	18/06/24	Ind 68 <small>Operations</small>	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	18/06/24	Ntokou <small>Industrial Quality</small>	
		NO GO <small>There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)</small>		<small>Operations</small>	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)		<small>Industrial Quality</small>	

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

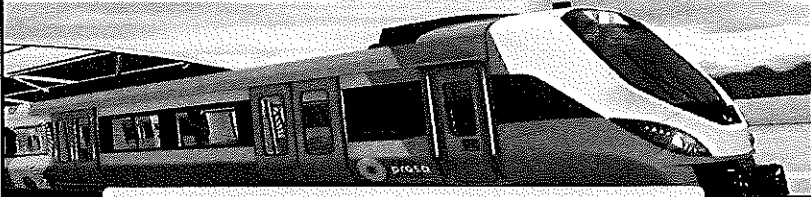
12/06/2024

12/06/2024



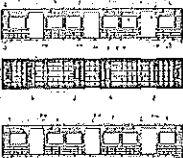


12/06/2024


12/06/2024



GIBELA		PRASA PROJECT										
												
APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1 <b>SELF INSPECTION SHEET</b>												
<b>CONFIDENTIAL INFORMATION</b> 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 ?	
				TC4	M4	M1	M2	M3	TC2			
<input type="checkbox"/>	DTR3000152548	AAD0001278556	CARBODYSHELL	CB2220			X				PRA.CB2220.DTR3022548 7/2.V21	YES
<input type="checkbox"/>	DTR3000152549	AAD0001278556	M1,M3,M5 ASSEMBLY	CB2220		X	X		X		PRA.CB2220.UIN3022548 7/2.V21	YES
<input type="checkbox"/>			CARBODYSHELL									
<input type="checkbox"/>			M1,M3,M5 ASSEMBLY									
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
REV	DATE	MODIFICATION CONTENT		RESPONSIBLE	NAME	DATE						
0	01/02/2018	GIBELA NEW CREATION		APPROVER	Itumeleng Modiba	01/02/2018						
				CHECKER	Nosizo Pindela	01/02/2018						
				COMPILER	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 DT0000936600		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	06/08/2020	New Baseline 10.2.6		APPROVER	Timothy Maimela	06/08/2020						
				CHECKER	Bongane Masina	06/08/2020						
				REVISED BY	Bongane Masina	06/08/2020						
20	19/04/2021	New Baseline change 10.3		APPROVER	Timothy Maimela	19/04/2021						
				CHECKER	Bongane Masina							
				REVISED BY	Bongane Masina							
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING		APPROVER	Mbhombi collins	17/08/2021						
				CHECKER	Mpho Mulaudzi							
				REVISED BY	Mpho Mulaudzi							
25	20/02/2022	New Baseline change 10.3.1		APPROVER	Collins Mbhombi	19/02/2022						
				CHECKER	Andani Muthelo							
				REVISED BY	Andani Muthelo							
26	14/06/2022	Update minimum temperature requirement for sealant application		APPROVER	Collins Mbhombi	14/06/2022						
				CHECKER	Andani Muthelo							
				REVISED BY	Andani Muthelo							
27	19/10/2022	Addition of traceability for sealant application & welding		APPROVER	Collins Mbhombi	19/10/2022						
				CHECKER	Ntokozo Zwane							
				REVISED BY	Amogelang Mohlampe							
28	14/04/2023	Added sealant batch number & welding consumables traceability		APPROVER	Vanessa Ntuli	14/04/2023						
				CHECKER	Ntokozo Zwane							
				REVISED BY	Amogelang Mohlampe							
29	28/10/2023	Addition of bracket quantity		APPROVER	Ngobeni Tyson	28/10/2023						
				CHECKER	Ntokozo Zwane							
				REVISED BY	Amogelang Mohlampe							
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF-INSPECTION NUMBER	PAGES							
234	M4	Lenny 489203 19/06/2024	19/06/2024	SI.CB2220.250.V29	13							

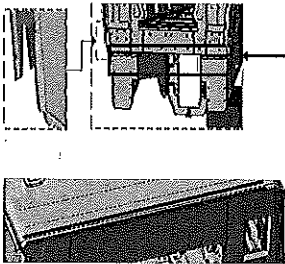
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		29																							
		Date																							
		28/10/2023																							
Car: M1,M3&M4		NCR:		Work station: CB2220																					
Safety Related																									
<b>I - Documentation and Instruments Control</b>																									
<b>I.1 - Documentation Control</b>																									
Document	Type of car	Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)																			
DTR30225487/2	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%;">M1</td> <td style="width: 10%;">M3</td> <td style="width: 10%;">M4</td> <td style="width: 10%;">M5</td> <td style="width: 10%;">M6</td> <td style="width: 10%;">M7</td> <td style="width: 10%;">M8</td> <td style="width: 10%;">M9</td> <td style="width: 10%;">M10</td> </tr> <tr> <td style="text-align: center;">1</td> <td style="text-align: center;">1</td> <td style="text-align: center;">1</td> <td style="text-align: center;">1</td> <td style="text-align: center;">1</td> <td style="text-align: center;">1</td> <td style="text-align: center;">1</td> <td style="text-align: center;">1</td> <td style="text-align: center;">1</td> </tr> </table>	M1	M3	M4	M5	M6	M7	M8	M9	M10	1	1	1	1	1	1	1	1	1	29	28/10/2023	X	N/A	19/06/24 	19/06/24 
M1	M3	M4	M5	M6	M7	M8	M9	M10																	
1	1	1	1	1	1	1	1	1																	
<b>I.2 - Instruments Control</b>																									
Monitoring and Measuring Instrument Control - Used for Special Process																									
Instruments	Serial number	Calibration or Verification Validation Date		OK	Signature/Date (Manufacturing)	Signature/Date (Quality)																			
Measuring Tape	32825-3	17/04/2024 - 17/04/2025		X	19/06/24	19/06/24																			
Tubular	91677042	15/03/2024 - 15/03/2025		X	19/06/24	19/06/24																			
<b>1.3 Consumables</b>																									
Welding Consumable Control - Used for Special Process																									
Filler Material	Heat Number	Welding Process		OK	Signature/Date (Manufacturing)	Signature/Date (Quality)																			
Welding 308 LSi	E220880	Mig		X	19/06/24	19/06/24																			

	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DTR30225487/2	Rev.	Project: PRASA				
		29					
		Date	SI.CB2220.250.V29				
		28/10/2023					
<b>II - Self Inspection - Items to Check</b>							
<b>II.1 - Items to check</b>							
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	✓		19/06/24 LWB	19/06/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		19/06/24 LWB	19/06/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		19/06/24 LWB	19/06/24
04		Cleaning of oil Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		19/06/24 LWB	19/06/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		19/06/24 LWB	19/06/24
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-038. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓		19/06/24 LWB	19/06/24
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 (t) Min-Max 10°C - 35°C Relative humidity Min - Max (t) Min-Max 25% - 60%	Sealant Batch No: 6-132-1-32/24 Exp Date: 04/08/24 Actuals Temperature: 25°C Humidity: 40%	✓		19/06/24 LWB	19/06/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278556	✓		19/06/24 LWB	19/06/24
09		Verification of safety welds	Approved according to DTD0000210658 reference and Self inspection	✓		19/06/24 LWB	19/06/24

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

**II - Self Inspection - Items to Check**


**SEALANT APPLICATION**



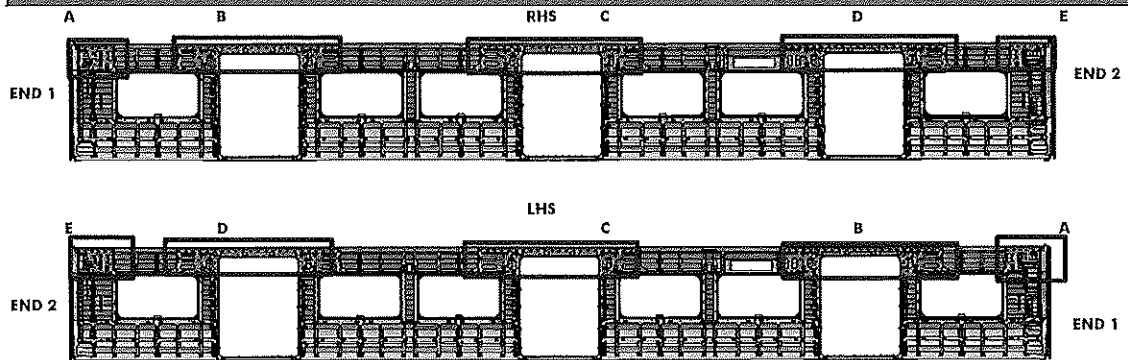
**AREA 1 & 2 END 1**

Operator (Name & sign): *Rosalia*

Operator (Name & sign): *Rosalia*


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

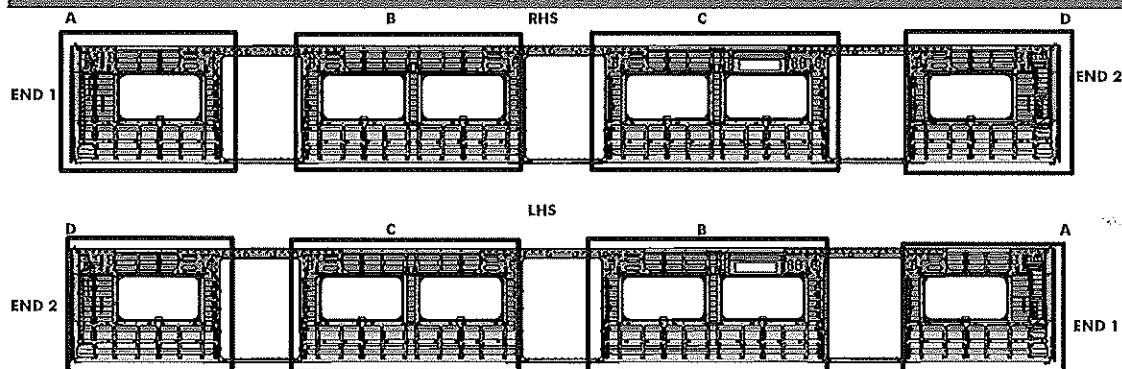
**II - Self Inspection - Items to Check**



**REINFORCEMENT WELDING**

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

	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	



### BRACKETING

#### INSTALLATION

C-RAILS: Operator: \_\_\_\_\_

DOOR MECHANISMS: Operator: Tetelo

TAPPING PADS: Operator: Pruseller

Operator: \_\_\_\_\_

#### INSTALLATION & VERIFICATION

SEAT & LUGGAGE BRACKETS: Operator: Mthelozzi

Operator: \_\_\_\_\_

SEAT BRACKETS VERIFICATION: Operator: Leri

Operator: \_\_\_\_\_


#### WELDING

AREA	LHS	RHS
A (Seat brackets)	: Operator (Name&sign): <u>S. Mado</u>	<u>S. Mado</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Mthelozzi</u>	<u>S. Mado</u>
B (Seat brackets)	: Operator (Name&sign): <u>Mthelozzi</u>	<u>S. Mado</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Mthelozzi</u>	<u>S. Mado</u>
C (Seat brackets)	: Operator (Name&sign): <u>Gibiga</u>	<u>S. Mado</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Gibiga</u>	<u>S. Mado</u>
D (Seat brackets)	: Operator (Name&sign): <u>Gibiga</u>	<u>S. Mado</u>
(C-rails, Luggage and earth bushes)	: Operator (Name&sign): <u>Gibiga</u>	<u>S. Mado</u>

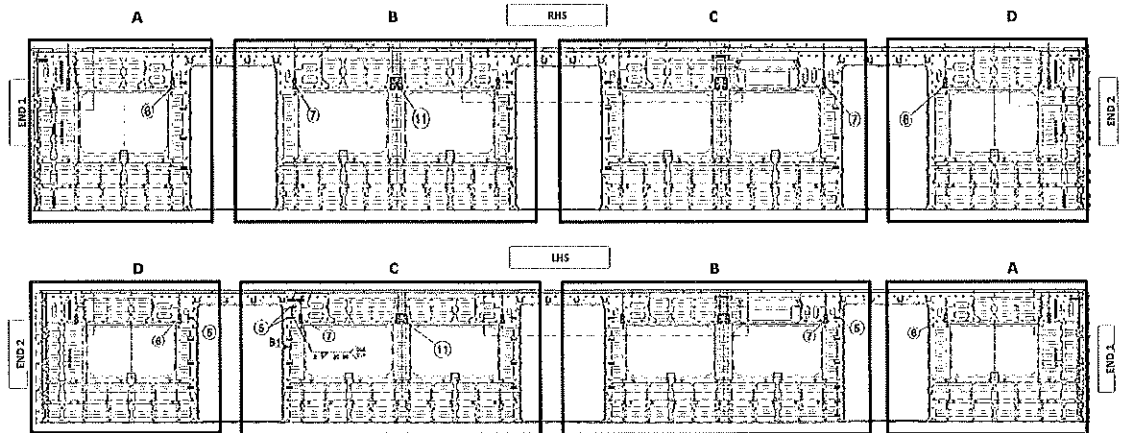
ENDS

END 1 TAPPING PADS WELDING: Operator (Name&sign): S. Mado

END 2 TAPPING PADS WELDING: Operator (Name&sign): Mthelozzi

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

**M1/M3/M4 BRACKET INSTALLATION**



**QUANTITIES (M3/M4)**

RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7	✓	
	B	4	✓	
	C	6	✓	
	D	6	✓	
SEAT BRACKETS	A	13	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	3	✓	
	B	4	✓	
	C	4	✓	
	D	3	✓	

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

VERIFICATION BY: LSB

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2	✓	
	B	6	✓	
	C	11	✓	
	D	6	✓	
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: LSB

**QUANTITIES (M1)**

RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7		
	B	4		
	C	6		
	D	6		
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**

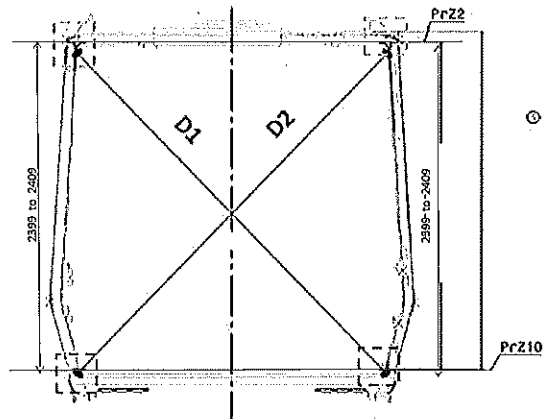
VERIFICATION BY: \_\_\_\_\_

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	6		
	D	2		

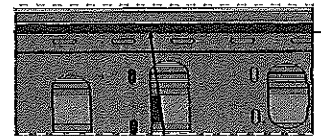
**ROOF ENDS:**  
**CRAILS 2 OFF EACH END**  
**EARTH BUSH 6 OFF EACH END**

VERIFICATION BY: \_\_\_\_\_

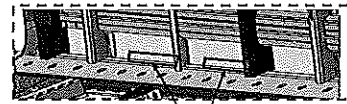
Specifications of Details for CBS measurement



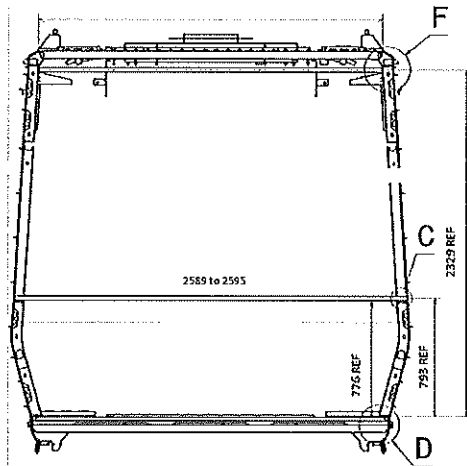
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.

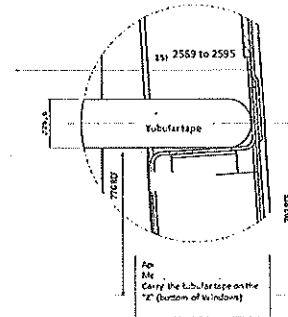
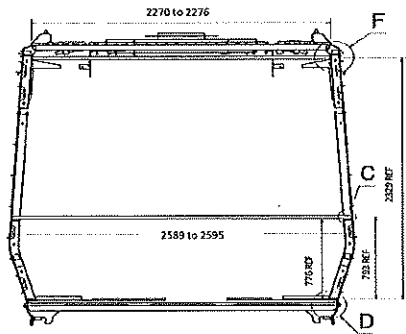


Measurement positions on sidewall and side sill corner.

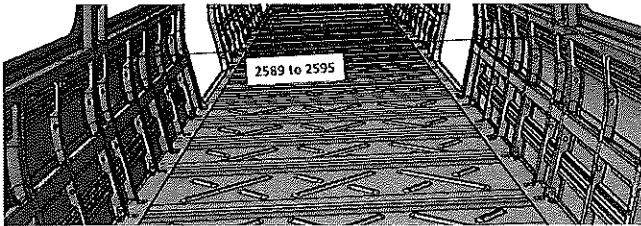




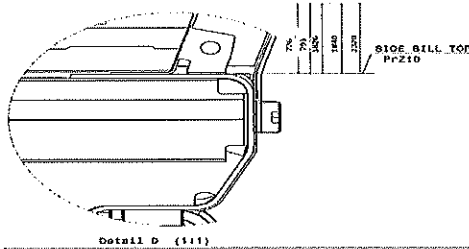
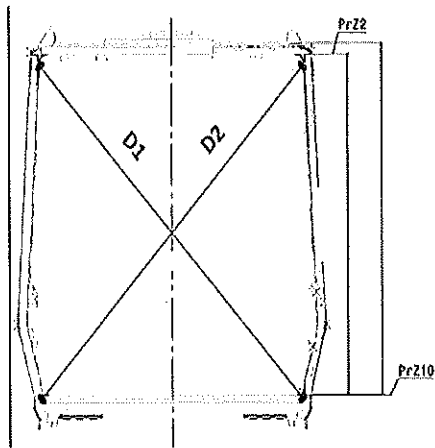
**CBS measurement**




**Detail C**

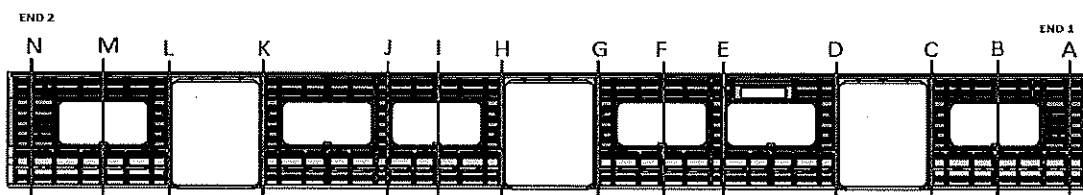


Take measurement close to radius




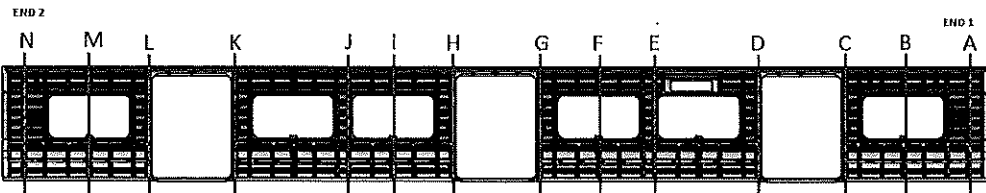
**Detail D (111)**

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



**BEFORE WELDING**

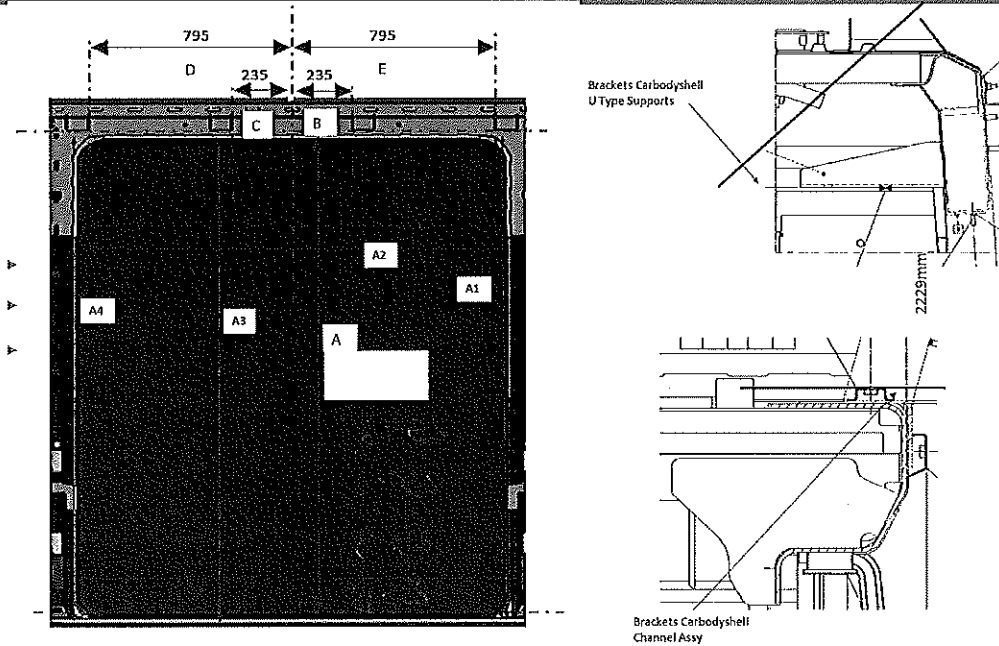
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3295	3295	0	—
B	3265	3264	1	—
C	3285	3286	1	—
D	3298	3298	0	—
E	3298	3294	1	—
F	3262	3266	4	—
G	3299	3299	2	—
H	3295	3300	5	—
I	3266	3267	1	—
J	3264	3267	3	—
K	3295	3297	2	—
L	3292	3293	1	—
M	3264	3267	3	—
N	3295	3297	2	—

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

AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3299	3298	1	2595
B	3266	3265	1	2593
C	3294	3293	1	2592
D	3293	3292	1	2593
E	3266	3265	1	2593
F	3265	3264	1	2595
G	3297	3295	2	2591
H	3293	3295	2	2590
I	3270	3265	5	2595
J	3267	3263	4	2590
K	3295	3296	1	2590
L	3294	3294	0	2589
M	3265	3260	5	2592
N	3289	3291	2	2595

Specifications of Details for CBS measurement CB1220

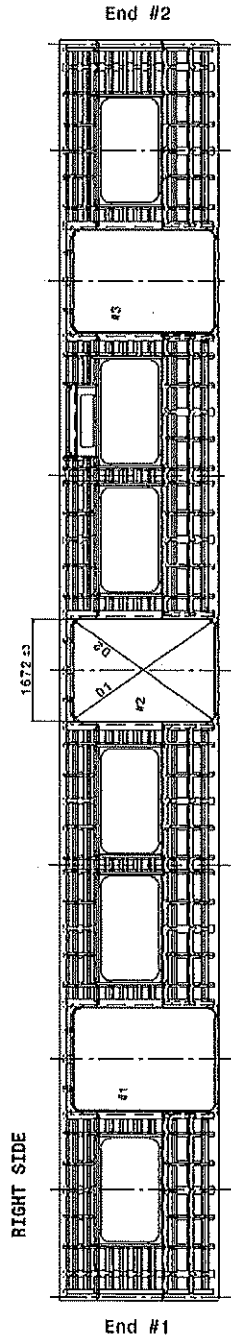


DOOR 1 - LHS		DOOR 2 - LHS		DOOR 2 - LHS	
VALUE	ACTUAL	VALUE	ACTUAL	VALUE	ACTUAL
A1 2230 to 2232	2231	A1 2230 to 2232	2231	A1 2230 to 2232	2231
A2 2230 to 2232	2230	A2 2230 to 2232	2232	A2 2230 to 2232	2232
A3 2230 to 2232	2231	A3 2230 to 2232	2232	A3 2230 to 2232	2232
A4 2230 to 2232	2230	A4 2230 to 2232	2232	A4 2230 to 2232	2231
B 234 to 236	235	B 234 to 236	235	B 234 to 236	235
C 234 to 236	235	C 234 to 236	235	C 234 to 236	235
D 794 to 796	795	D 794 to 796	795	D 794 to 796	795
E 794 to 796	795	E 794 to 796	795	E 794 to 796	795

DOOR 1 - RHS		DOOR 2 - RHS		DOOR 3 - RHS	
VALUE	ACTUAL	VALUE	ACTUAL	VALUE	ACTUAL
A1 2230 to 2232	2231	A1 2230 to 2232	2231	A1 2230 to 2232	2231
A2 2230 to 2232	2230	A2 2230 to 2232	2231	A2 2230 to 2232	2230
A3 2230 to 2232	2231	A3 2230 to 2232	2232	A3 2230 to 2232	2231
A4 2230 to 2232	2230	A4 2230 to 2232	2231	A4 2230 to 2232	2231
B 234 to 236	235	B 234 to 236	235	B 234 to 236	235
C 234 to 236	235	C 234 to 236	235	C 234 to 236	235
D 794 to 796	795	D 794 to 796	795	D 794 to 796	795
E 794 to 796	795	E 794 to 796	795	E 794 to 796	795

Specifications of Details for CBS measurement CB1220

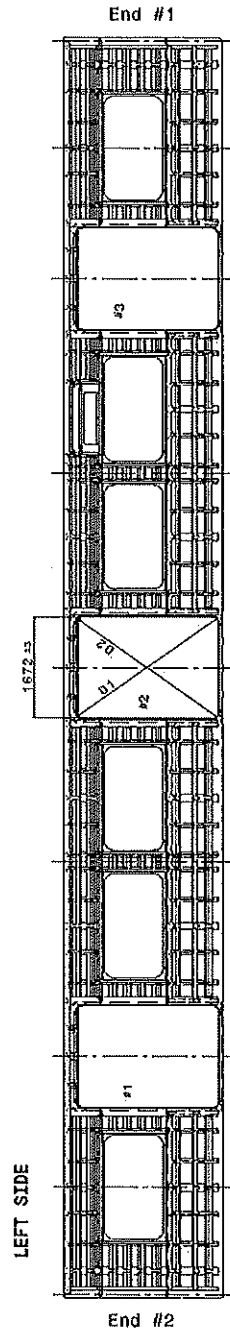


Doors diagonal D1-D2 maximum difference ≤4mm

#1	#2	#3
D1	2748	2748
D2	2743	2746
D1-D2	~	2

Doors Length - 1672 ±3mm

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




Doors diagonal D1-D2 maximum difference ≤4mm


#1	#2	#3
D1	2546	2547
D2	2545	2548
D1-D2	2	1

Doors Length - 1672 ±3mm

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

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




CBS 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				

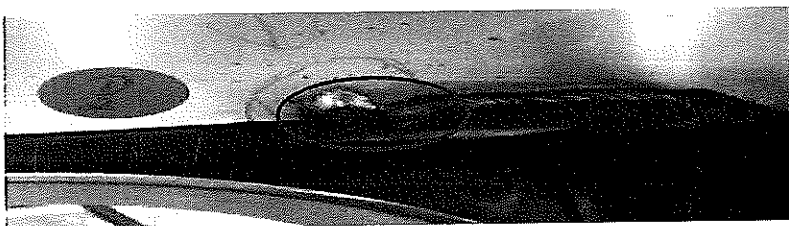
	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DTR30225487/2	Rev.	<b>Project: PRASA</b>  <b>SI.CB2220.250.V29</b>		
		29			
		Date			
		28/10/2023			
<b>Self Inspection - Final Result</b>					
<b>Is the car good to advance to the next workstation/process?</b> (Approval of Operations Manager and Industrial Quality)		DATE	NAME	SIGNATURE	
<b>HOLD POINT</b>	<b>GO</b>	(If activities are not complete, the missing activities must not impact the next stage)	19/06/2024	Lewi <small>Operations</small>	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party	19/06/24	Andani <small>Industrial Quality</small>	
	<b>NO GO</b>	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

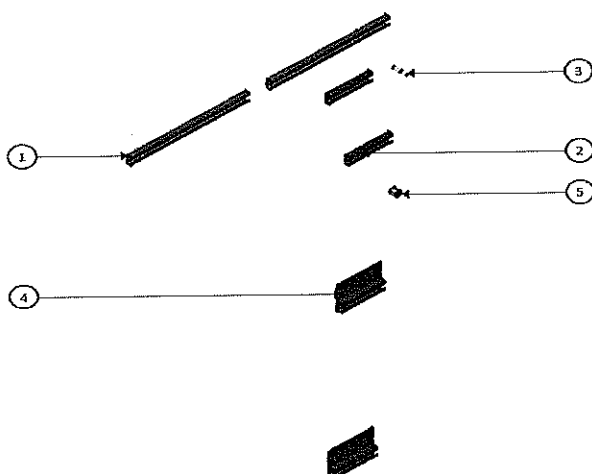
Quality

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

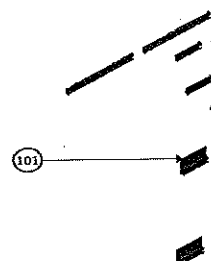
### ANNEXURE A: Arc Welding Quality Acceptance Standard



Station: CB1220-004- U108 & U107



PART NO.	ITEM NO.	QTY	DESCRIPTION	MOQS (KG)
DTF00010074053	5	6	EARTH STUD 6	0.036
AZ00001201848	4	6	ASSEMBLY SUPPORT	0.271
DTF00000348365	8	12	WELDING STUD BOLT 1/2" PT - 6-80GB - SST	0.007
AZ00001150924	2	12	ASSEMBLY SUPPORT	0.293
AZ00001151118	1	14	ASSEMBLY SUPPORT	0.522
AZ00001151080	101	6	CARBODYSHELL BRACKETS CARBODYSHELL M1/M3/M4 CAR(SIDE FRAME MODULE STD - OFF)	12.132





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.

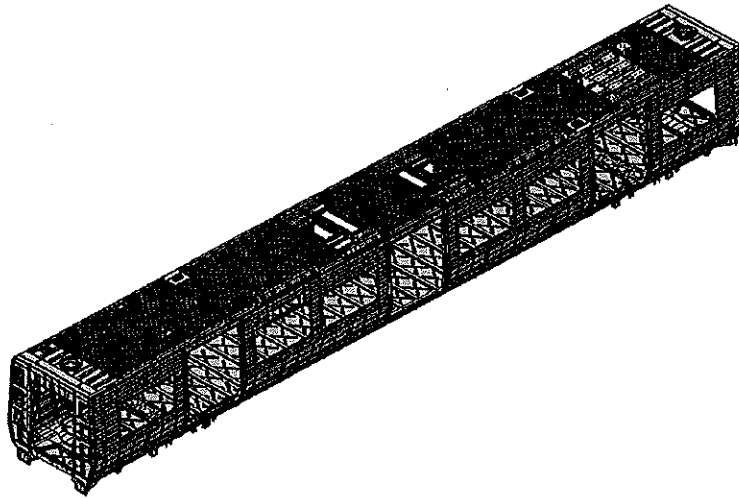
## APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?
				TC1	M4	M1	M2	M3	TC2		
<input type="checkbox"/> DTR3000152669	AAD0001278566	CARBODYSHELL M1, M3, M4 ASSEMBLY	CB2230			X				PRA.CB2230.DT000002 25487.V20	YES
<input type="checkbox"/> DTR3000152673	AAD0001278566	CARBODYSHELL M3, M3, M4 ASSEMBLY	CB2230		X			X		PRA.CB2230.DT000002 25487.V20	YES
	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 10.2.5			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 Mbombhi		20/02/2022		
					CHECKER		Andani Muthelo				
					REVISED BY		Andani Muthelo				
26	14/06/2022	Update minimum temperature requirement for sealant application			APPROVER		Collins Mbombhi		14/06/2022		
					CHECKER		Andani Muthelo				
					REVISED BY		Andani Muthelo				
27	26/07/2022	Threshold measurements addition			APPROVER		Collins Mbombhi		26/07/2022		
					CHECKER		Andani Muthelo				
					REVISED BY		Andani Muthelo				
28	17/10/2022	Added traceability of sealant application			APPROVER		Collins Mbombhi		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			
234	M04	Nontlanhla 421423		20/06/24		SI.CB2230.256.V29		12			

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

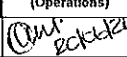


Safety Related



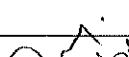
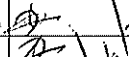
### I - Documentation and Instruments Control

#### I.1 - Documentation Control

Document	Type of car					Revision	Obsevation	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4	TC2						
PRA.CB2230.DT00000225487						30		✓		N/A	 20/06/24

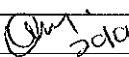
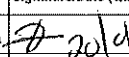
#### I.2 - Instruments Control






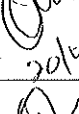
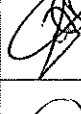
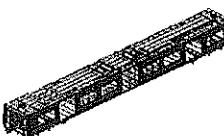
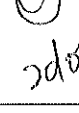

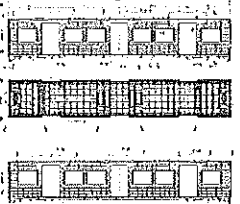


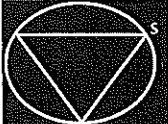





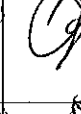
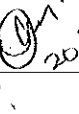
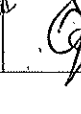
##### Monitoring and Measuring Instrument Control - Used for Special Process


Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
Tubular	22615	11/10/24	✓		 20/06/24	 20/06/24
Combination Square	61850131	22/08/24	✓			
Measuring Tape	61850049	24/07/2024	✓			

#### 1.3 Consumables

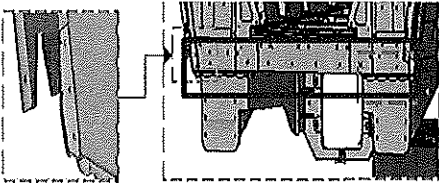
##### Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSI	E23167	MIG	✓		 20/06/24	 20/06/24

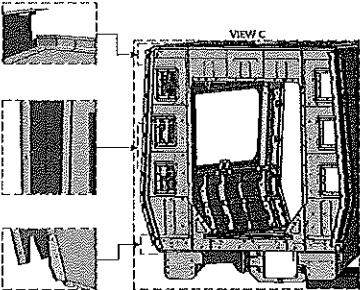
		<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DT00000225487		Rev. 30 Date 06/11/2023	Project: PRASA  <b>SI.CB2230.256.V29</b>									
<b>II - Self Inspection - Items to Check</b>														
<b>II.1 - Items to check</b>														
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK			Signature/Date (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	✓			 20/06/24	 20/06/24						
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓			 20/06/24	 20/06/24						
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓			 20/06/24	 20/06/24						
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓			 20/06/24	 20/06/24						
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			 20/06/24	 20/06/24						
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.	✓			 20/06/24	 20/06/24						
07	N/A	<p>Before application of sealant record the expiry date and make sure that the room temperature and humidity are withion specified values as per Works Instructions Specified:</p> <table border="0"> <tr> <td>Temperature Min - Max (I)</td> <td>M'n-Max</td> <td>10°C - 35°C</td> </tr> <tr> <td>Relative humidity M'n - Max (I)</td> <td>M'n-Max</td> <td>25% - 80%</td> </tr> </table>	Temperature Min - Max (I)	M'n-Max	10°C - 35°C	Relative humidity M'n - Max (I)	M'n-Max	25% - 80%	<p>Sealant Batch No: 105337 Exp Date: Aug 24</p> <p>Actuals Temperature: 135°C Humidity: 56%</p>	✓			 20/06/24	 20/06/24
Temperature Min - Max (I)	M'n-Max	10°C - 35°C												
Relative humidity M'n - Max (I)	M'n-Max	25% - 80%												
08	N/A	Verification of sealant application on the roof and sidewall finishers.	<p>Sealant must be:</p> <ul style="list-style-type: none"> <li>-Applied straight and even</li> <li>-Free of gaps,cracks,damage and debris (flashes, dirt, dust)</li> </ul> <p><b>Refer to Annexure B</b></p>	✓			 20/06/24	 20/06/24						
09	N/A	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓			 20/06/24	 20/06/24						

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

AREA 1



AREA 2 (VIEW C)



END 2 SEALANT

OPERATOR  
(Name & sign):

Lerato (LM)

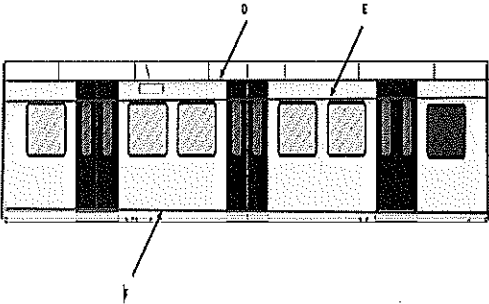
OPERATOR  
(Name & sign):

Lerato (LM)

OPERATOR  
(Name & sign):

Lerato (LM)

H

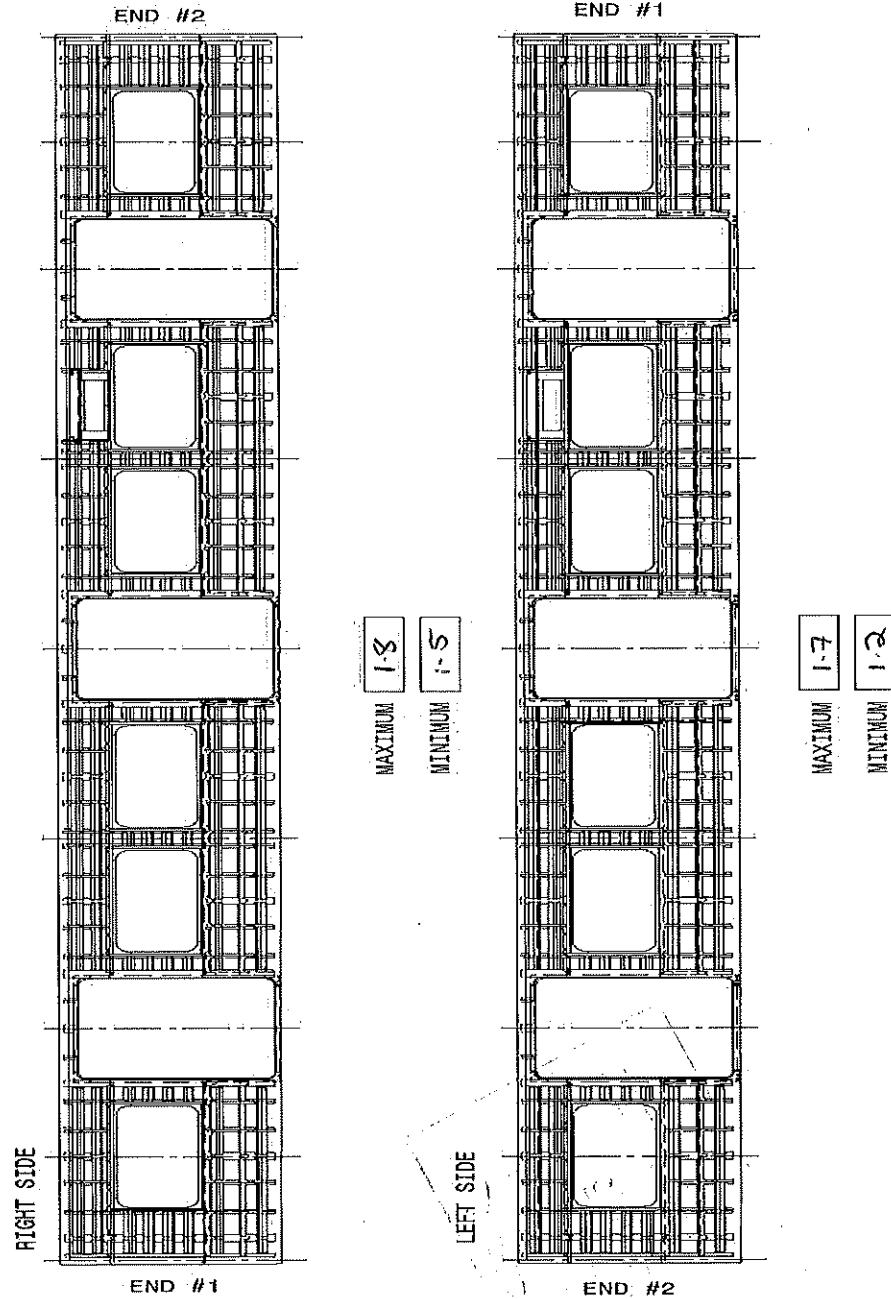


Area D,E,F,G,H,I

Operator (Name & sign):	LHS E, H (bottom)	RHS E, H, I (bottom)
Operator (Name & sign):	Bunie Abgela	Bunie Abgela
Operator (Name & sign):	D, E, H, I (Tp)	D, E, H, I (Tp)
Operator (Name & sign):	Sinie	Tshenolo
Operator (Name & sign):	Tshenolo	Sinie
Operator (Name & sign):		

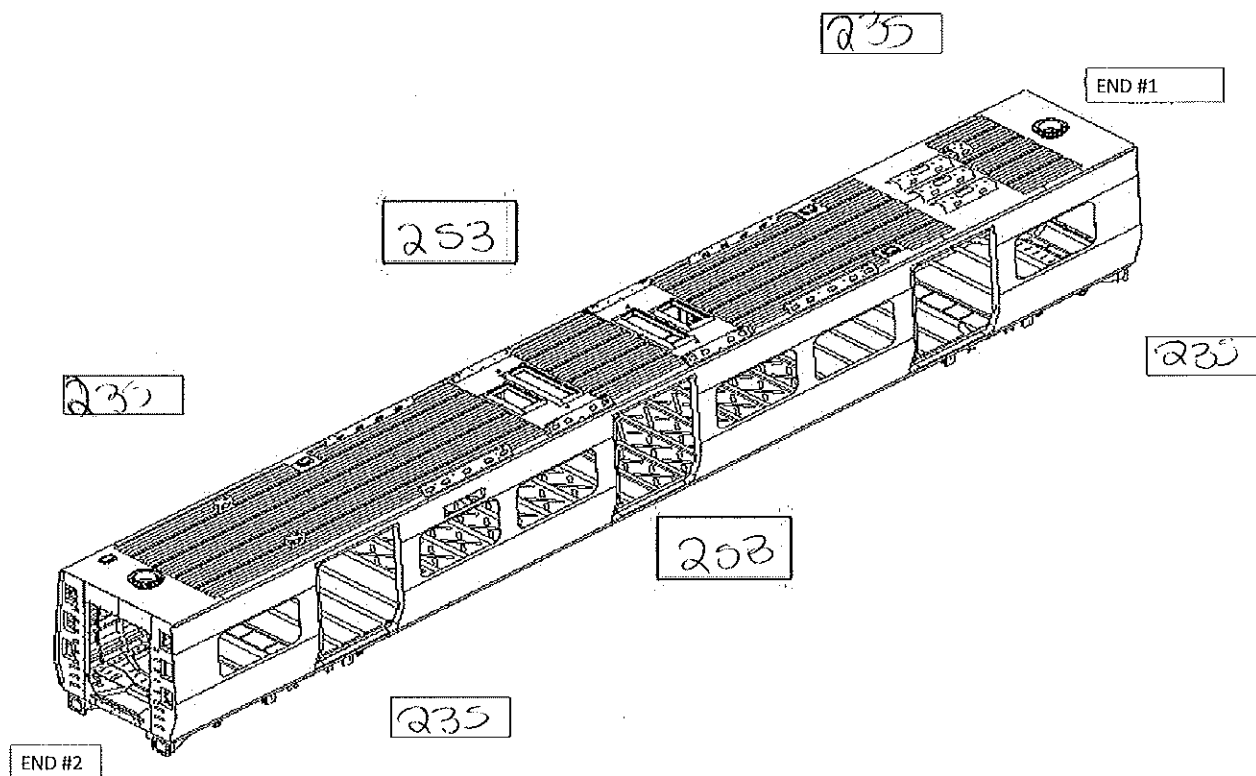
Specifications of Details for CBS measurement CB1230

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.



Specifications of Details for CBS measurement CB1230

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



MEASURED CAMBER VALUES

RIGHT  $\mu$  18

LEFT  $\mu$  18

Handwritten notes:

1. 18mm

2. 18mm

3. 18mm

4. 18mm

5. 18mm

6. 18mm

7. 18mm

8. 18mm

9. 18mm

10. 18mm

11. 18mm

12. 18mm

13. 18mm

14. 18mm

15. 18mm

16. 18mm

17. 18mm

18. 18mm

19. 18mm

20. 18mm

21. 18mm

22. 18mm

23. 18mm

24. 18mm

25. 18mm

26. 18mm

27. 18mm

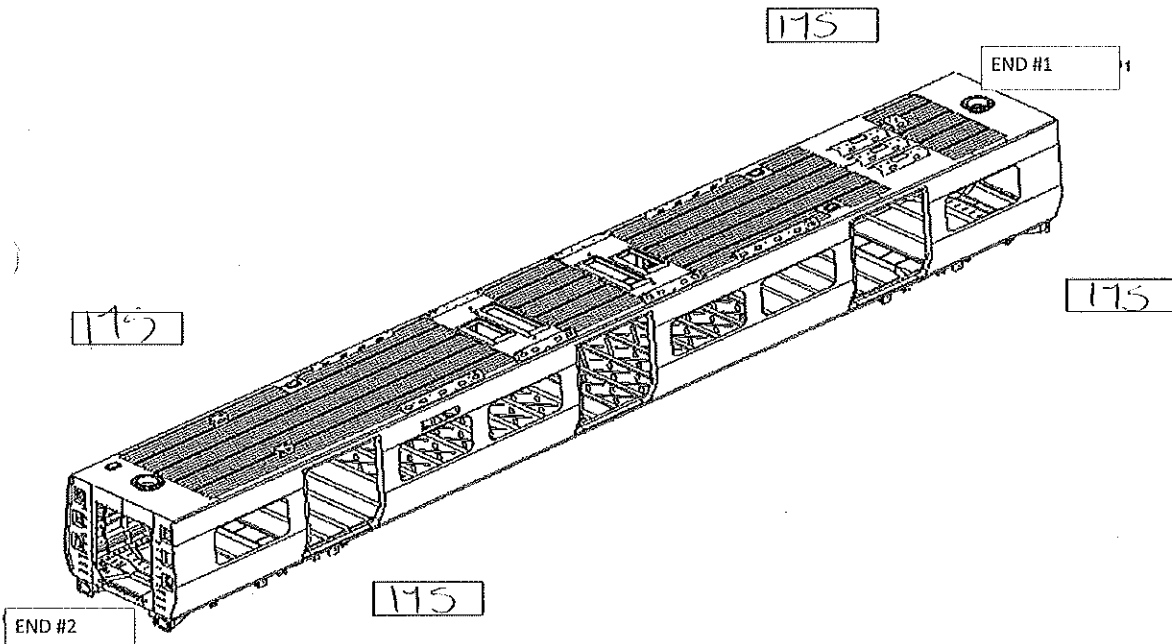
28. 18mm

29. 18mm

30. 18mm

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

0

TWIST FOUND ON END 2

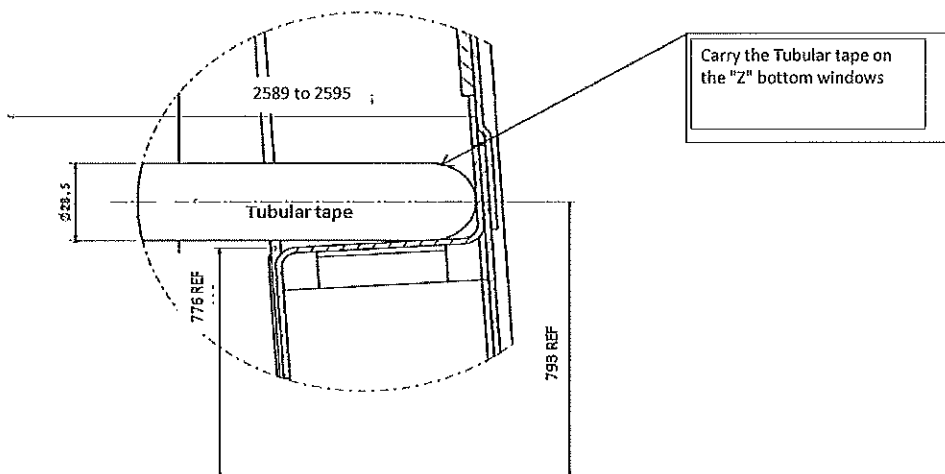
TRANVERSE

0

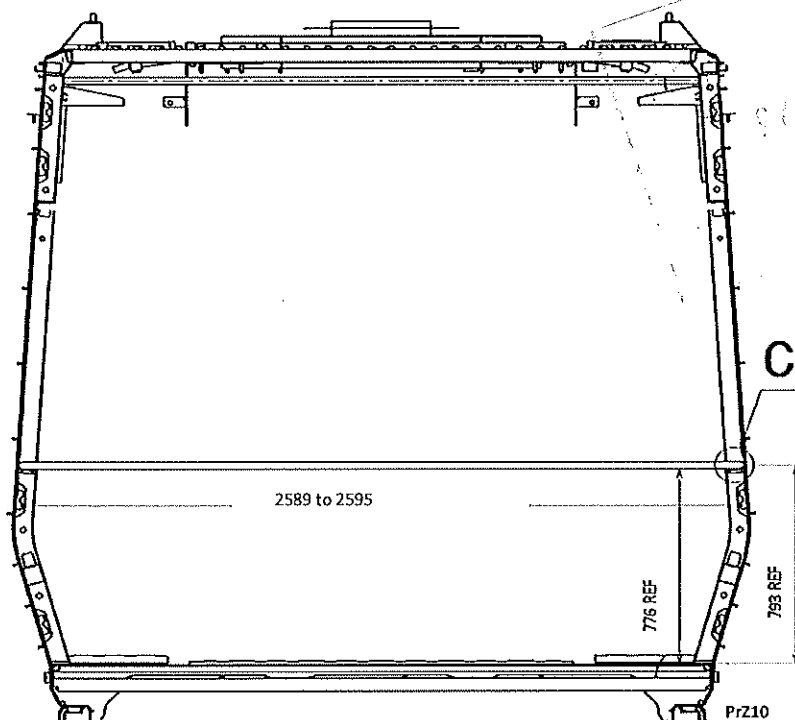
LONGITUDINAL

0

Specifications of Details for CBS measurement CB1230

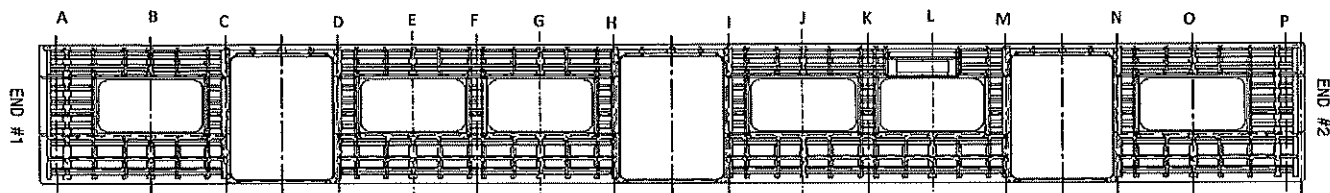


Detail C



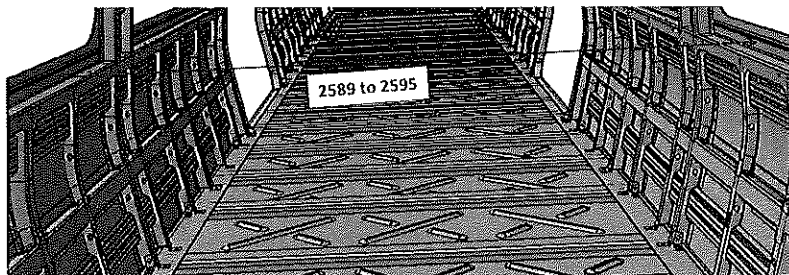


Specifications of Details for CBS measurement CB1230

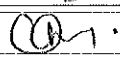


2589 to 2595mm

A	2591
B	2592
C	2595
D	2595
E	2592
F	2591
G	2594
H	2590
I	2591
J	2592
K	2593
L	2590
M	2591
N	2592
O	2594
P	2591



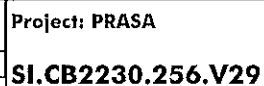
Threshold verification						Nominal value :38
Door 1		Door 2		Door 3		
L	R	L	R	L	R	
36	36	37	37	37	38	
Door 4		Door 5		Door 6		
L	R	L	R	L	R	
37	38	38	38	37	37	

BOILER MAKER: Honhkinhla   
WELDER: Zanele


Dye penetrant test

Dye-penetration test to be performed by quality personnel





[illegible]

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

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

Self Inspection - Final Result

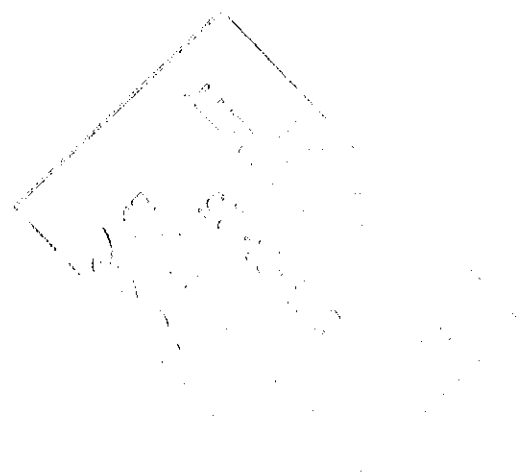
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)			DATE	NAME	SIGNATURE
HOLD POINT		GO (If activities are not complete, the missing activities must not impact the next stage)	20/06/2024	Tbnnhlanhka Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	20/06/2024	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 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	Project: PRASA  SI.CB2230.256.V29
		Date	
		06/11/2023	

**ANNEXURE A: Arc Welding Quality Acceptance Standard**

