


**PRASA PROJECT**


APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

# SELF INSPECTION SHEET

**CONFIDENTIAL INFORMATION**

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

**APPLICATION REFERENCE**

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY? 
				TC1	M4	M1	M2	M3	TC2		
<input type="checkbox"/> DTR3000152647	AAD0001413323	CARBOYSHELL M2 ASSEMBLY	cb2210				X			PRA.cb2210.DTR313744 97/3.V25	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 cb2210	APPROVER	Itumeleng Modiba	12/12/2018						
			CHECKER	Nosizo Pindela	12/12/2018						
			REVISED BY	Ramokone Motama	12/12/2018						
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							
			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							
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021						
			CHECKER	Mpho Mulaudzi							
			REVISED BY	Mpho Mulaudzi							
25	21/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	21/02/2022						
			CHECKER	Andani Muthelo							
			REVISED BY	Andani Muthelo							
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023						
			CHECKER	Mohlampe Amogelang							
			REVISED BY	Mohlampe Amogelang							
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023						
			CHECKER	Zwane Ntokozi							
			REVISED BY	Mohlampe Amogelang							
28	07/11/2023	Addition of welder traceability	APPROVER	Ngobeni Tyson	07/11/2023						
			CHECKER	Andani Muthelo							
			REVISED BY	Ntokozi Zwane							
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES						
TS 234	M2	JUSTICE 410035	20/06/24	SI.CB2210.247.V28	17						

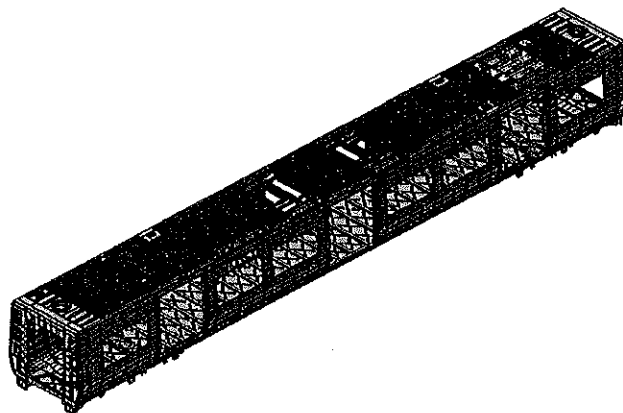


	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
		Date 07/11/2023	

Car: M2	NCR:	Work station: CB2210
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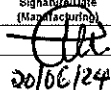
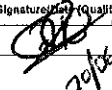


Safety Related




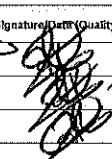
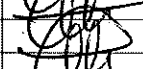
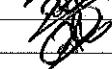
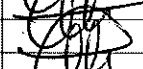
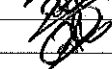
## I - Documentation and Instruments Control

### I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)
	D	E	S	S	E	H						
DTR31374497/3			X				28		X	N/A	 20/06/24	 20/06/24

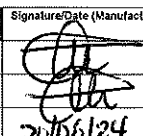
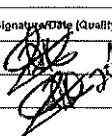
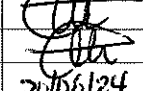
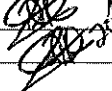
### I.2 - Instruments Control



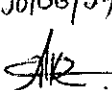

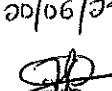

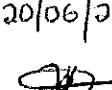

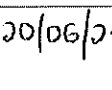


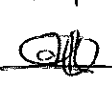
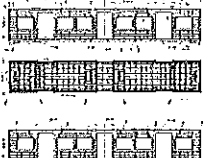

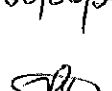


#### Monitoring and Measuring Instrument Control - Used for Special Process


Instruments	Serial number	Calibration or Verification Validation Date	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULAR	32823-2	15/03/25	X			
LASER TAPE	125425424	08/02/25	X			
SUN TAPE	G1817002	18/11/24	X			

### I.3 - Consumables

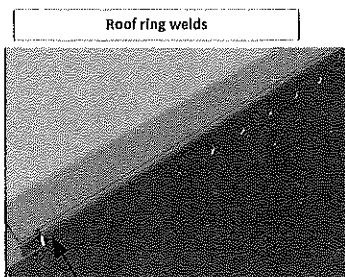
#### Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LS	314018-74097	MIG	X			
ER 308 L	299687-70302	MIG	X			

		CARBODYSHELL M2 ASSEMBLY DTR31374497/3		Rev. 28 Date 07/11/2023	Project: PRA5A SI.CB2210.247.V28		
<b>II - Self Inspection - Items to Check</b>							
II.1 - Items to check							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls, Endframes, Roof and Underframe)	AA00001375051	✓		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	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓		20/06/24 	20/06/24 
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		20/06/24 	20/06/24 
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		20/06/24 	20/06/24 
06		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 
07	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.	✓		20/06/24 	20/06/24 

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**Welder traceability**



LHS

Boiler maker (Name & Sign): Justice Ali

RHS

Boiler maker (Name & Sign): Portso H

Welder (Name & Sign): GIFI

Welder (Name & Sign): GIFI

END 1

LHS

Boiler maker (Name & Sign): Justice Ali

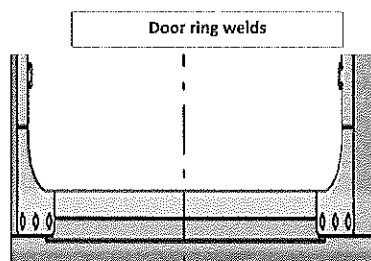
RHS

Boiler maker (Name & Sign): Portso H

Welder (Name & Sign): GIFI

Welder (Name & Sign): GIFI

END 2



LHS

Boiler maker (Name & Sign): Tim Rader


Welder (Name & Sign): Babbar B

RHS

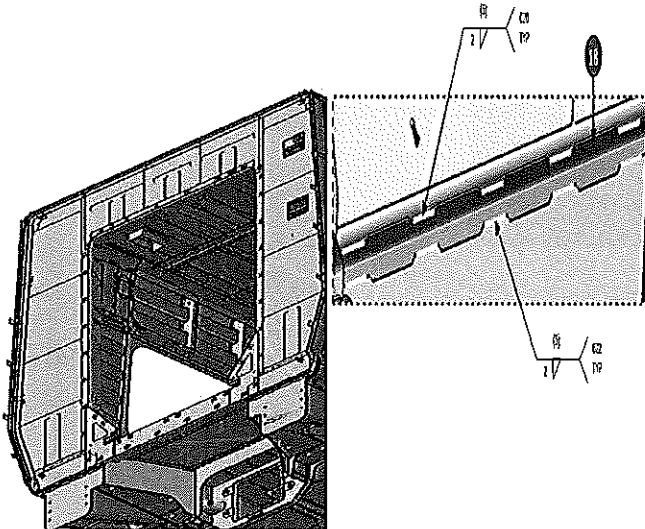
Boiler maker (Name & Sign): Tim Rader

Welder (Name & Sign): Leila K. Webb

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
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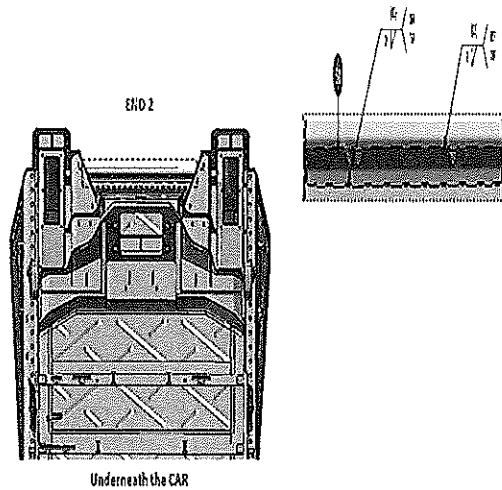
#### EUFR Reinforcement Plates



#### END 1

Boiler maker (Name & Sign): Lawrence Mlyar

Welder (Name & Sign): Bobbar & Babbat

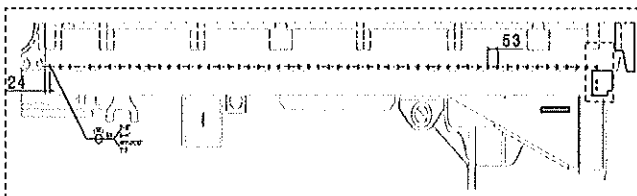


Underneath the CAR

#### END 2

Boiler maker (Name & Sign): Lebaga M. Kishabe


Welder (Name & Sign): Kettu K. N. M. D.

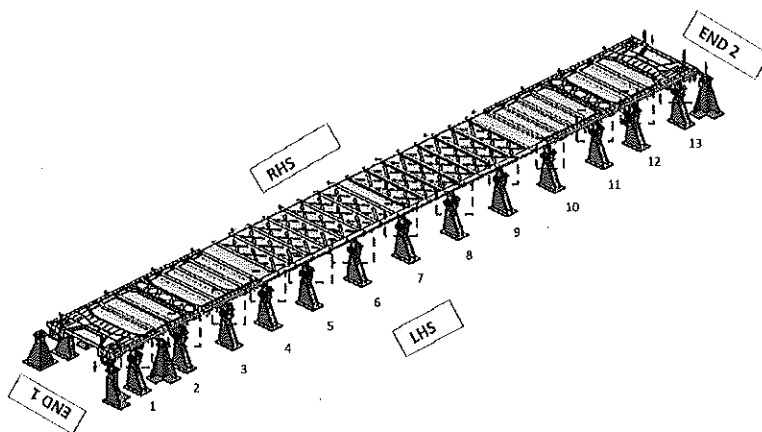


#### FEDOLI

Operator:

Lawrence Mlyar

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
		Date 07/11/2023	
Specifications of Details for CBS measurement			



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

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: 20/06/24

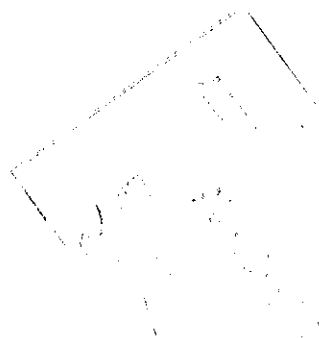
After Welding.

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: 20/06/24





CARBODYSHELL M2 ASSEMBLY DTR31374497/3

Rev.

28

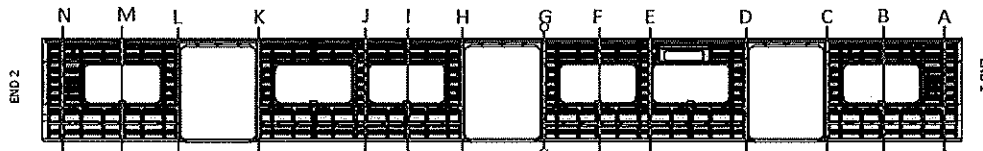
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07/11/2023

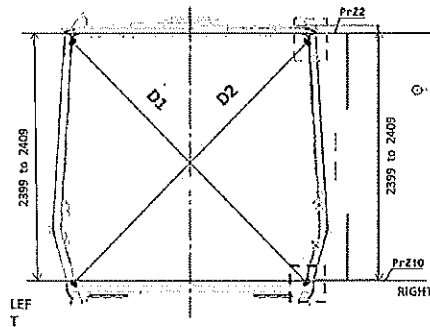
Project: PRASA

SI.CB2210.247.V28

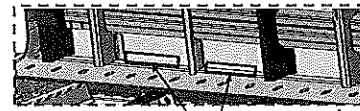
### Specifications of Details for CBS measurement



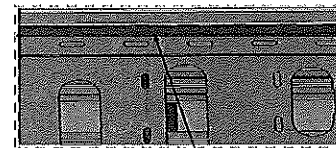
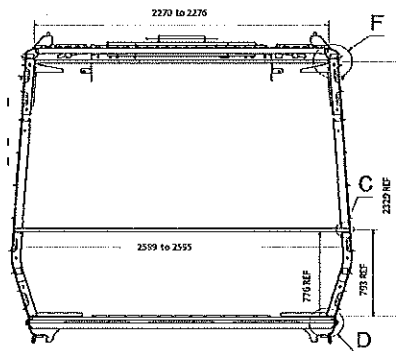
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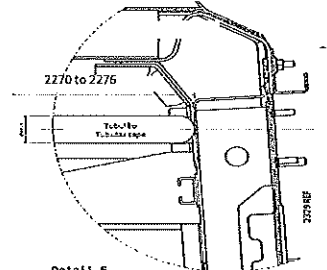
Measurement positions on roof rail and sidewall omega corner.



Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.



Detail F

Don't considering the reinforcement





CARBODYSHELL M2 ASSEMBLY DTR31374497/3

Rev.

26

Date

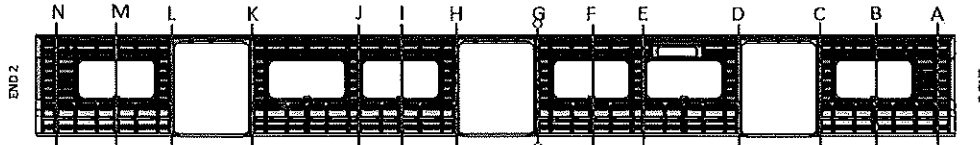
07/11/2023

Project: PRASA

SI.CB2210.247.V28

## Specifications of Details for CBS measurement

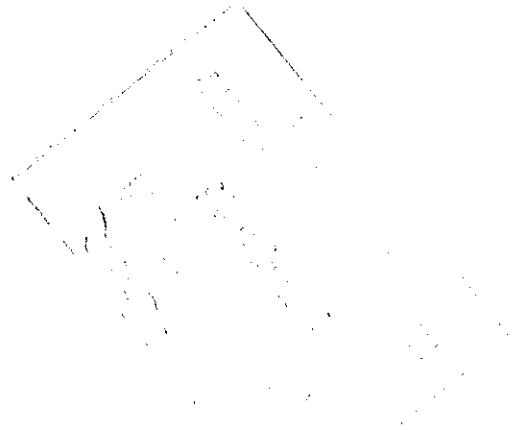
## BEFORE WELDING




Note: The difference in Height values measured on the LHS and RHS should be  $\leq 2\text{MM}$  on each point.

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS $\leq 2$
A	3266	3264	2	2406	2406	0
B	3262	3262	0	2407	2405	2
C	3264	3264	0	2404	2404	0
D	3265	3263	2	2406	2404	2
E	3260	3260	0	2407	2405	1
F	3267	3265	2	2405	2405	0
G	3264	3264	0	2408	2406	2
H	3266	3265	1	2406	2405	1
I	3261	3261	0	2407	2406	1
J	3263	3262	1	2408	2407	2
K	3266	3266	0	2405	2404	1
L	3265	3263	2	2405	2405	0
M	3265	3264	1	2406	2406	0
N	3264	3262	2	2407	2406	1

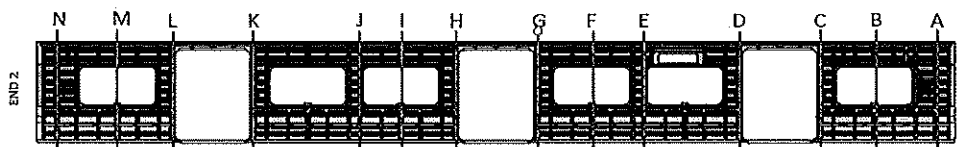
26/06/24



	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
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### Specifications of Details for GBS measurement

#### AFTER WELDING

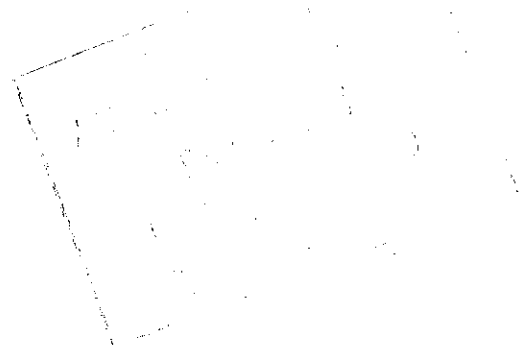



Note: The difference in Height values measured on the LHS and RHS should be  $\leq 2\text{MM}$  on each point.

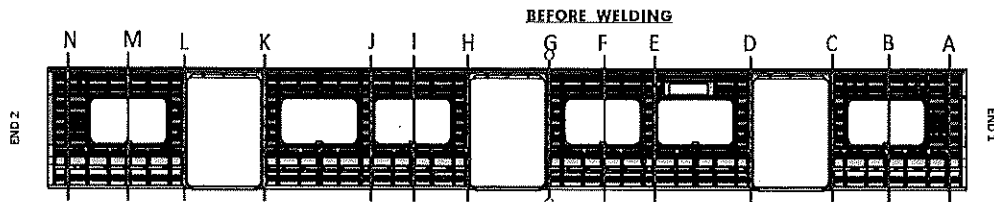
	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS $\leq 2$
A	3296	3296	0	2407	2405	2
B	3267	3265	2	2406	2405	1
C	3298	3298	0	2406	2406	0
D	3295	3294	1	2408	2406	2
E	3265	3265	0	2405	2405	0
F	3266	3264	2	2407	2407	0
G	3298	3296	2	2406	2404	2
H	3297	3295	2	2405	2405	0
I	3268	3266	2	2407	2406	1
J	3266	3264	2	2408	2408	0
K	3298	3296	2	2406	2406	0
L	3295	3295	0	2407	2405	2
M	3266	3264	2	2408	2408	0
N	3295	3295	0	2405	2405	0



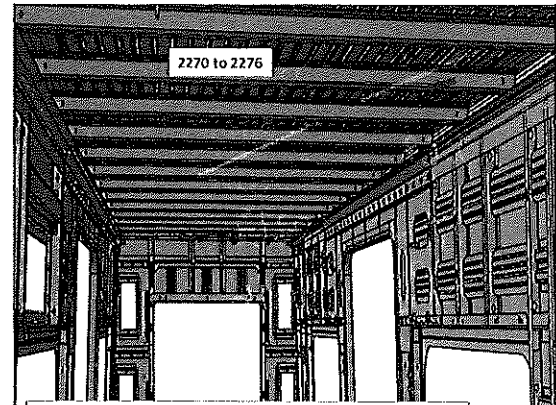
20/06/24



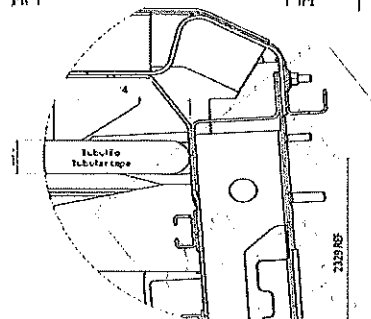
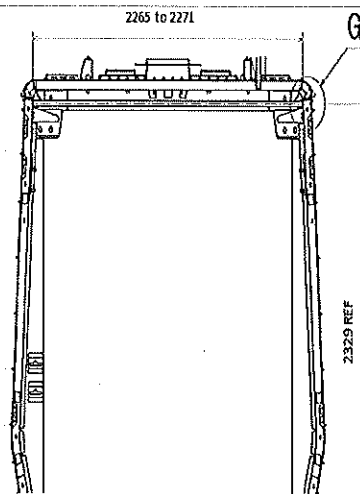
	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
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CBS measurement			



	2270 to 2276
A	2273
B	2270
C	2274
D	2275
E	2271
F	2272
G	2276
H	2274
I	2272
J	2272
K	2274
L	2275
M	2270
N	2271

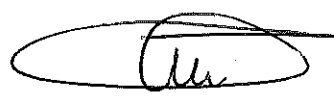



Do not consider reinforcement ( Take measurements top area of zee profile



Detail G

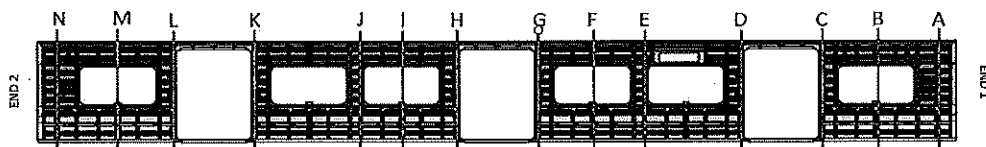
Considering the reinforcement plate

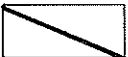

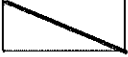
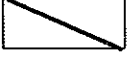
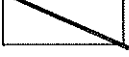
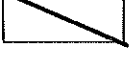
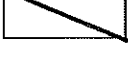

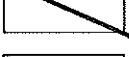
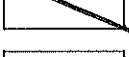
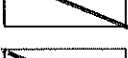

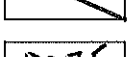
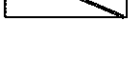
  
20/06/24

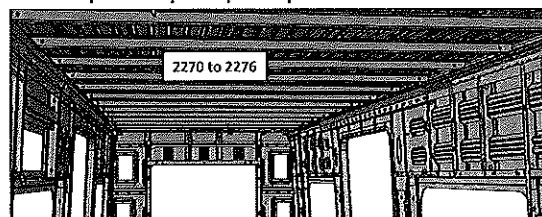
	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRASA SI.CB2210.247.V28
		Date 07/11/2023	

CBS measurement

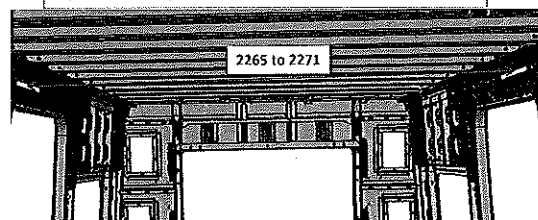
AFTER WELDING



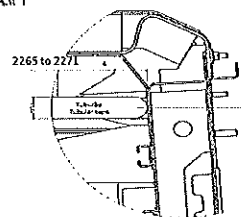
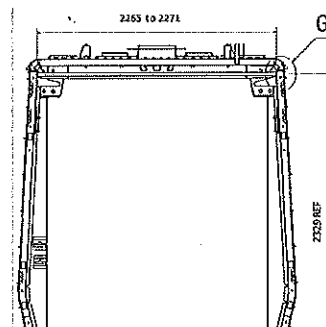
	2265 to 2271	2270 to 2276
A		2275
B	2268	
C		2273
D		2276
E	2265	
F	2269	
G		2273
H		2274
I	2270	
J	2270	
K		2274
L		2270
M	2269	
N		2276



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



Take measurement close to radius ( considering reinforcement)



Detail G

Consider the reinforcement plate



CARBODYSHELL M2 ASSEMBLY DTR31374497/3

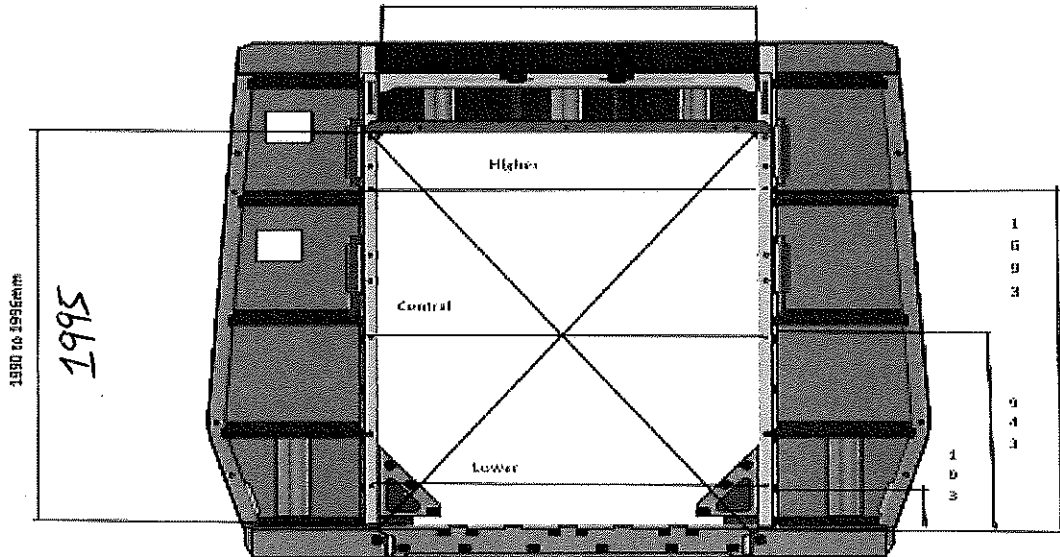
Rev.  
28  
Date  
07/11/2023

Project: PRASA  
SI.CB2210.247.V28

CBS measurement

End frame 1

1380 to 1382 mm



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1382

D1

2415

Central Dimension

1380

D2

2413

Lower Dimension

1381

D1-D2

2

20/06/24

1

20/66/4

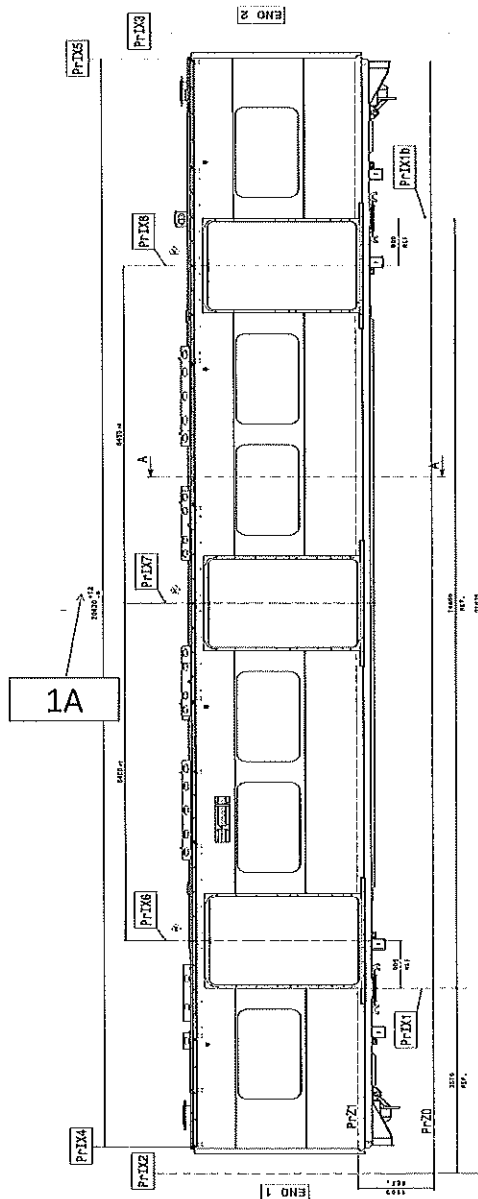


CARBODYSHELL M2 ASSEMBLY DTR31374497/3

Rev.  
28  
Date  
07/11/2023

Project: PRASA  
SI.CB2210.247.V28

### Specifications of Details for CBS measurement



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20631

RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20630

*[Signature]*  
20/06/24




### Dye penetrant test

Dye-penetration test to be performed by quality personnel








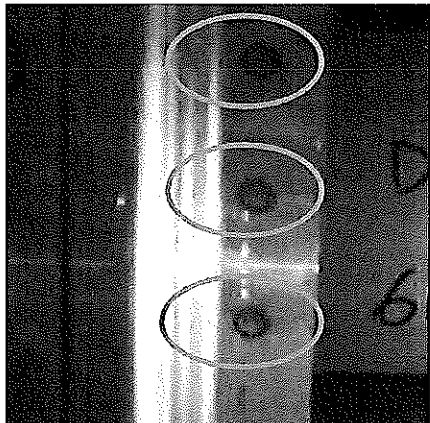
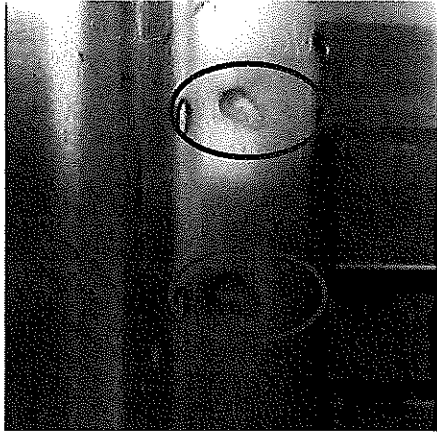
		CARBODYSHELL M2 ASSEMBLY DTR31374497/3		Rev. 28 Date 07/11/2023	Project: PRASA SI.CB2210.247.V28	
Self Inspection - Find Result						
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)	20/06/24	Justice Operations		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	20/06/24	AMOGELANG Industrial Quality		
	NO GO	There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)				
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)				
In case of "NO GO", describe blocking problems						
In case of "NO GO", the operations manager must define below action plan to ensure "GO":						
Item	Description		Responsible	Due date	Status	


Operations



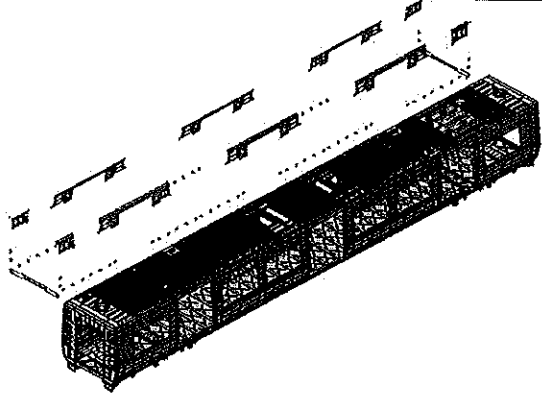
Quality

	CARBODYSHELL M2 ASSEMBLY DTR31374497/3	Rev. 28	Project: PRA5A SI.CB2210.247.V28
		Date 07/11/2023	








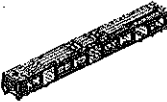


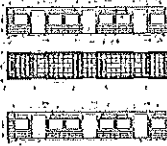


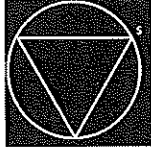






**ANNEXURE A: Spot Welding Quality Acceptance Standard**




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 ?	
				TE1	MA	M1	M2	M3	TC2				
<input type="checkbox"/>	DIR1000132665	A400001433273	CARBODYSHELL M2 ASSEMBLY	CB2220					X			PRA.CB2220.DTR3137 4497/2.V21	YES
<input type="checkbox"/>													
<input type="checkbox"/>													
<input type="checkbox"/>													
<input type="checkbox"/>													
<input type="checkbox"/>													
<input type="checkbox"/>													
REV	DATE	MODIFICATION CONTENT			RESPONSIBLE		NAME		DATE				
0	01/02/2018	GIBELA NEW CREATION			APPROVER	Itumeleng Modiba	01/02/2018						
					CHECKER	Nosizo Pindela	01/02/2018						
					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 DT0000336800			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			APPROVER	Itumeleng Modiba	13/03/2019						
					CHECKER	Nosizo Pindela	13/03/2019						
					REVISED BY	Nosizo Pindela	13/03/2019						
7	27/05/2019	Removed measurement positions on the display windows			APPROVER	Itumeleng Modiba	27/05/2019						
					CHECKER	Nosizo Pindela	27/05/2019						
					REVISED BY	Nosizo Pindela	27/05/2019						
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	19/04/2021						
					REVISED BY	Bongane Masina	19/04/2021						
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING			APPROVER	Mpho Mulaudzi	17/08/2021						
					CHECKER	Mpho Mulaudzi	17/08/2021						
					REVISED BY	Mpho Mulaudzi	17/08/2021						
25	20/02/2022	New Baseline change 10.3.1			APPROVER	Mphombi Collins	20/02/2022						
					CHECKER	Andani Muthelo	20/02/2022						
					REVISED BY	Andani Muthelo	20/02/2022						
26	14/06/2022	Update minimum temperature requirement for sealant application			APPROVER	Mphombi Collins	14/06/2022						
					CHECKER	Andani Muthelo	14/06/2022						
					REVISED BY	Andani Muthelo	14/06/2022						
27	17/10/2022	Addition of traceability for sealant application and welding.			APPROVER	Mphombi Collins	17/10/2022						
					CHECKER	Ntokozi Zwane	17/10/2022						
					REVISED BY	Amogelang Mohlampe	17/10/2022						
28	14/04/2023	Added sealant batch number & welding consumables traceability			APPROVER	Vanessa Ntuli	14/04/2023						
					CHECKER	Ntokozi Zwane	14/04/2023						
					REVISED BY	Amogelang Mohlampe	14/04/2023						
29	28/10/2023	Addition of bracket quantity			APPROVER	Ngobeni Tyson	28/10/2023						
					CHECKER	Mathapo Kelebone	28/10/2023						
					REVISED BY	Mohlampe Amogelang	28/10/2023						
TRAINSET	CAR	OPERATOR NAME & ALPS NO.		DATE	SELF INSPECTION NUMBER		PAGES						
234	M02	Tebelo		21/06/24	SI.CB2220.276.V29		15						

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA																		
		29																			
		Date	SI.CB2220.276.V29																		
		28/10/2023																			
Car: M2	NCR:	Work station:	CB2220																		
 Safety Related																					
																					
<b>I - Documentation and Instruments Control</b>																					
<b>I.1 - Documentation Control</b>																					
	<table border="1"> <tr> <th colspan="5">Type of car</th> </tr> <tr> <th>TC1</th> <th>TC2</th> <th>TC3</th> <th>TC4</th> <th>TC5</th> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Type of car					TC1	TC2	TC3	TC4	TC5						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Type of car																					
TC1	TC2	TC3	TC4	TC5																	
DTR31374497/2		29	29	V	N/A																
					21/06/24	21/06/24															
<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)																
Tubular	32823-2	15/03/25	V																		
Measuring Tape	GTBTA055	12/04/25	V																		
					21/06/24																
<b>I.3 Consumables</b>																					
Welding Consumable Control - Used for Special Process																					
Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)																
Welding Wire	E231067	MIG welding	V	21/06/24																	
					21/06/24																

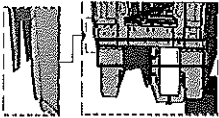
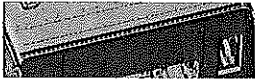


	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA									
		29										
		Date	SI.CB2220.276.V29									
		28/10/2023										
<b>II - Self Inspection - Items to Check</b>												
II.1 - Items to check												
Item	Pictures/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)						
01	N/A	Assembly according to Instruction Engineering n° PRA.CB2220. DTR31374497/2 Verification of fitment for all reinforcement brackets.	PRA.CB2220. DTR31374497/2	✓	 28/06	 21/06/24						
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	 21/06	 21/06/24						
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	 21/06	 21/06/24						
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	 21/06	 21/06/24						
05		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓	 21/06	 21/06/24						
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.	✓	 21/06	 21/06/24						
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 Work Instructions  <table border="1" style="font-size: small;"> <tr> <th colspan="2">Specified</th> </tr> <tr> <td>Temperature Min - Max (°C)</td> <td>20°C - 35°C</td> </tr> <tr> <td>Relative humidity Min - Max (%)</td> <td>25% - 65%</td> </tr> </table>	Specified		Temperature Min - Max (°C)	20°C - 35°C	Relative humidity Min - Max (%)	25% - 65%	Sealant Batch No: <u>B9371-04/24</u> Exp Date: <u>      </u> / <u>      </u> / <u>      </u>  Actuals Temperature: <u>25°C</u> Humidity: <u>40%</u>		 21/06	 21/06/24
Specified												
Temperature Min - Max (°C)	20°C - 35°C											
Relative humidity Min - Max (%)	25% - 65%											
08	NA	Verification of sealant application in certain regions in the drawing	AAD0001413929		 21/06	 21/06/24						

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB2220.276.V29
		29	
		Date	
		28/10/2023	

**SEALANT APPLICATION**

AREA 1 & 2 END 1

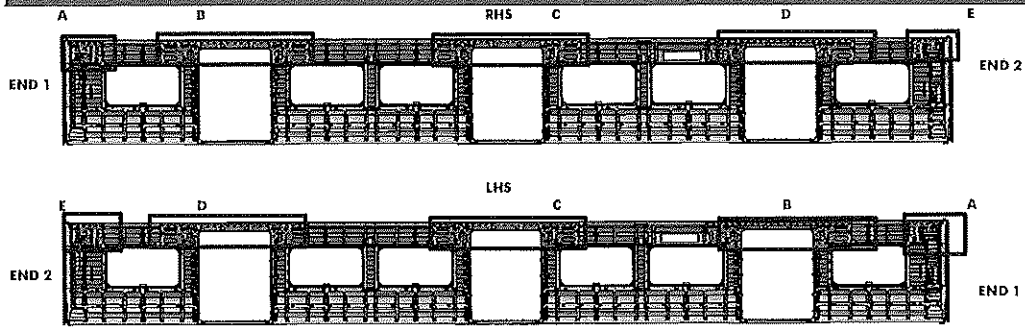
Operator (Name & sign): *Piscillon*

Operator (Name & sign): *Piscillon*

*Handwritten signature: Piscillon*  
*Handwritten signature: Piscillon*  
*Handwritten signature: Piscillon*


	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB2220.276.V29
		29	
		Date	
		28/10/2023	

II - Self Inspection - Items to Check

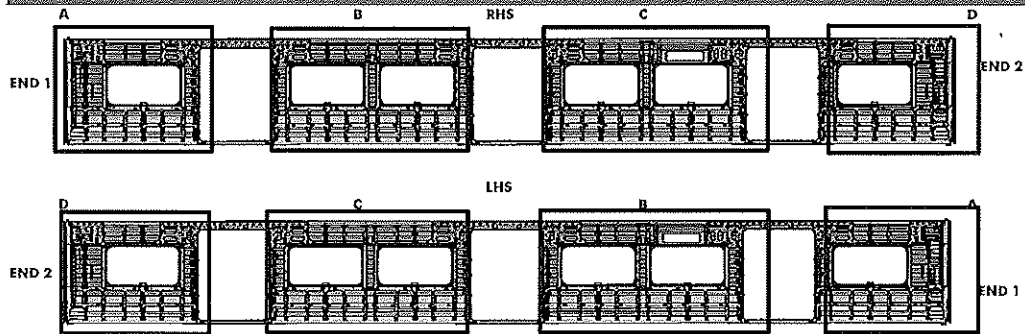


REINFORCEMENT WELDING

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>Matheus M [signature]</u>	<u>Matheus M [signature]</u>
D	Operator (Name&sign): <u>[signature]</u>	<u>[signature]</u>
E	Operator (Name&sign): <u>[signature]</u>	<u>[signature]</u>

	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project PRASA
		29	
		Date	SI.CB2220.276.V29
		28/10/2023	

### II - Self Inspection - Items to Check



#### BRACKETING

##### INSTALLATION

C-RAILS:

Operator:

Lumi WAB

Operator:

DOOR MECHANISMS:

Operator:

Priscilla Casan

Operator:

TAPPING PADS

Operator:

Priscilla Casan

Operator:

##### INSTALLATION & VERIFICATION

SEAT & LUGGAGE BRACKETS:

Operator:

Tebeu TAB

Operator:

SEAT BRACKETS VERIFICATION:

Operator:

Tebeu TAB

Operator:

#### WELDING

AREA

LHS

RHS

A (Seat brackets)

: Operator (Name&sign):

S. M. P. M. B.

(C-rails, Luggage and earth bushes)

: Operator (Name&sign):

T. M. A. P. M.

B (Seat brackets)

: Operator (Name&sign):

S. M. A. P. M.

(C-rails, Luggage and earth bushes)

: Operator (Name&sign):

T. M. A. P. M.

C (Seat brackets)

: Operator (Name&sign):

S. M. A. P. M.

(C-rails, Luggage and earth bushes)

: Operator (Name&sign):

S. M. A. P. M.

D (Seat brackets)

: Operator (Name&sign):

S. M. A. P. M.

(C-rails, Luggage and earth bushes)

: Operator (Name&sign):

S. M. A. P. M.

T. M. A. P. M.

T. M. A. P. M.

T. M. A. P. M.

T. M. A. P. M.

T. M. A. P. M.

T. M. A. P. M.

T. M. A. P. M.

T. M. A. P. M.

#### ENDS


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

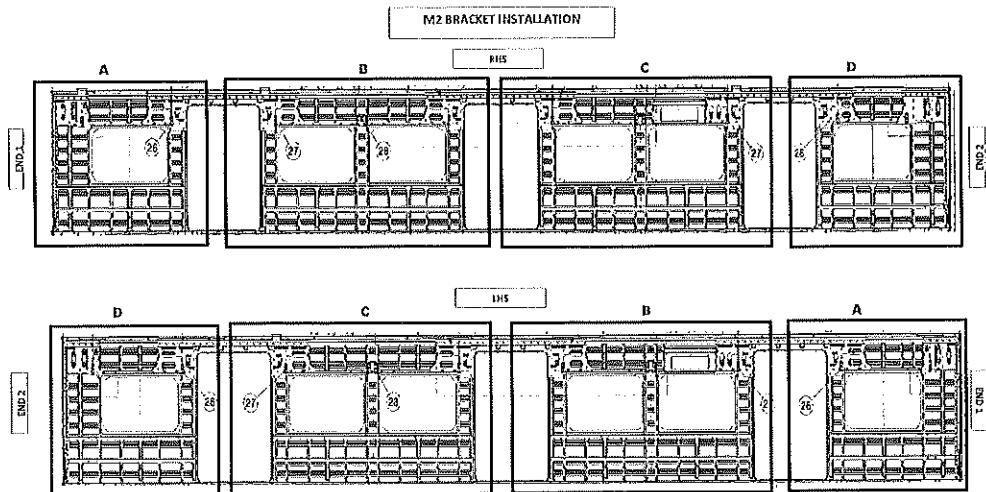
T. M. A. P. M.

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

T. M. A. P. M.



	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB2220.276.V29
		29	
		Date	
		28/10/2023	



QUANTITIES (M2)

RHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	8	✓	
	B	9	✓	
	C	8	✓	
	D	2	✓	
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: Teelo

T.M.

LHS

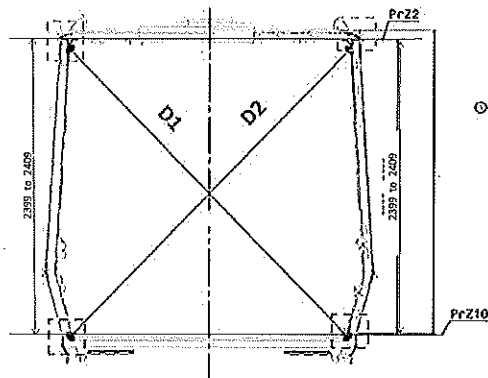
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	8	✓	
	B	11	✓	
	C	11	✓	
	D	12	✓	
SEAT BRACKETS	A	12	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	3	✓	
	B	7	✓	
	C	9	✓	
	D	2	✓	

ROOF ENDS:

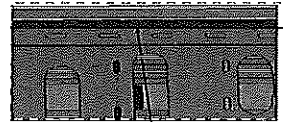
CRAILS 2 OFF EACH END  
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: Teelo

T.M.



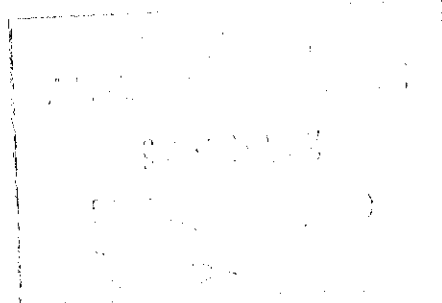
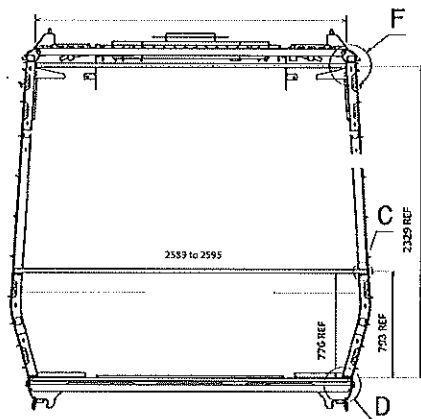
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



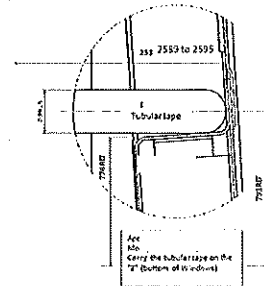
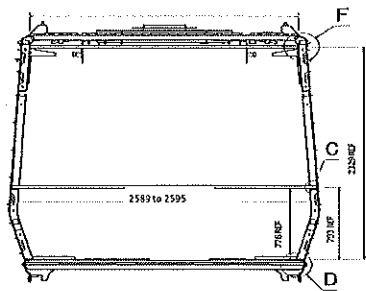


CARBODYSHELL M2 ASSEMBLY DTR31374497/2

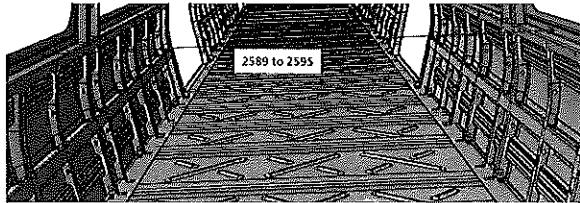
Rev.  
29  
Date  
28/10/2023

Project PRASA

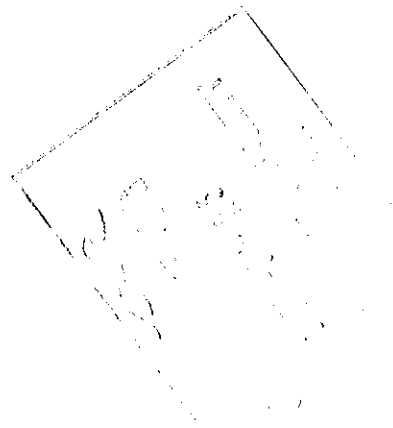
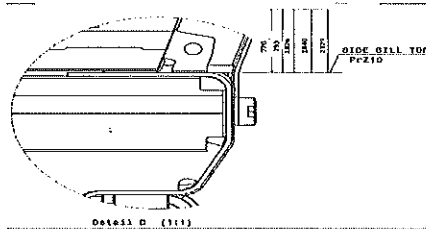
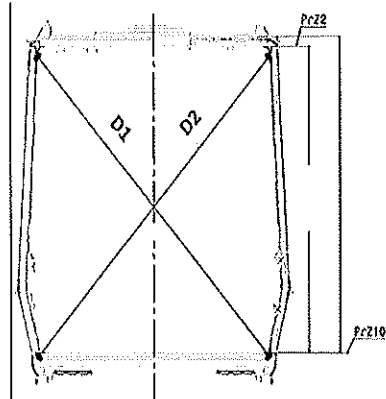
SI.CB2220.276.V29



Detail C

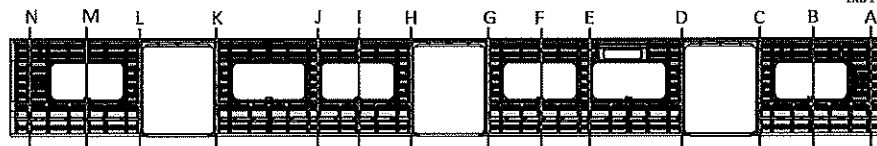


Take measurement close to  
radius



**CBS measurement**

END 2


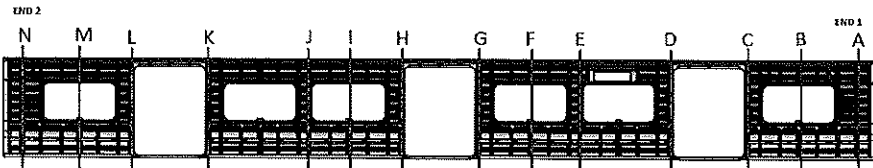


END 1

**BEFORE WELDING**

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3298	3296	2	-
B	3265	3267	2	-
C	3297	3295	2	-
D	3295	3296	1	-
E	3265	3267	2	-
F	3267	3268	1	-
G	3295	3298	3	-
H	3296	3297	1	-
I	3265	3267	2	-
J	3268	3266	2	-
K	3295	3297	2	-
L	3297	3299	2	-
M	3265	3267	2	-
N	3295	3296	1	-

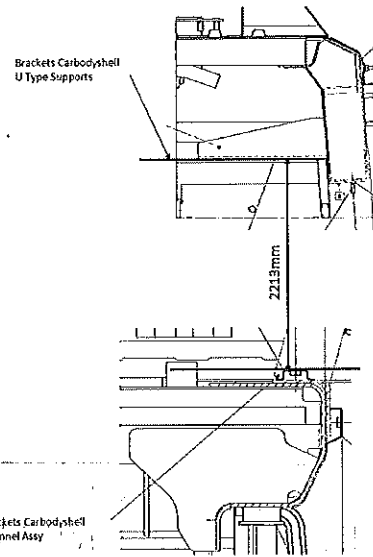
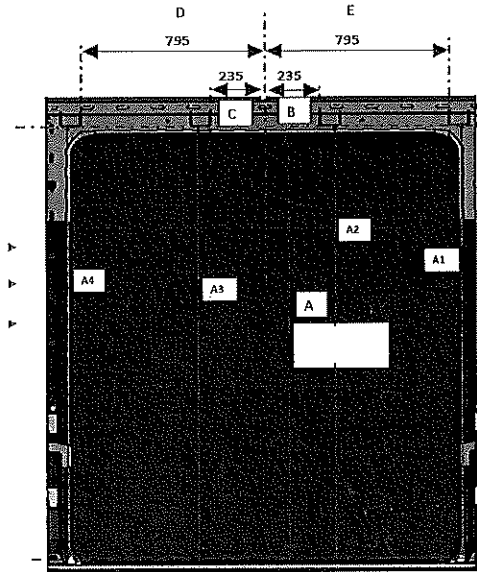


	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRASA SI.CB2220.276.V29
		29	
		Date	
		26/10/2023	
CBS measurement			
			

AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3295	3296	1	2590
B	3267	3268	1	2591
C	3296	3297	1	2592
D	3295	3296	1	2591
E	3265	3267	2	2590
F	3268	3269	1	2591
G	3297	3298	1	2592
H	3295	3296	1	2589
I	3268	3268	2	2591
J	3269	3267	2	2592
K	3296	3294	2	2591
L	3297	3295	2	2590
M	3268	3266	2	2591
N	3296	3298	2	2592

Specifications of Details for CBS measurement CB1220



DOOR 1 - LHS

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

DOOR 2 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2230
A2	2230 to 2232	2231
A3	2230 to 2232	2231
A4	2230 to 2232	2231
B	234 to 236	235
C	234 to 236	238
D	794 to 796	796
E	794 to 796	795

DOOR 3 - LHS

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

DOOR 1 - RHS

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

DOOR 2 - RHS

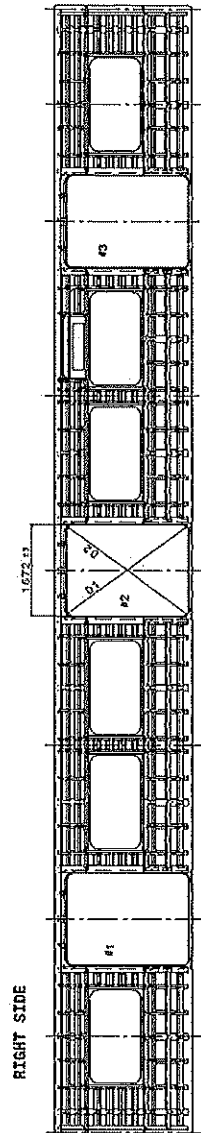
	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2231
A3	2230 to 2232	2232
A4	2230 to 2232	2230
B	234 to 236	235
C	234 to 236	235
D	794 to 796	796
E	794 to 796	795

DOOR 3 - RHS

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

Specifications of Details for CBS measurement CB1220

End #2



RIGHT SIDE

End #1

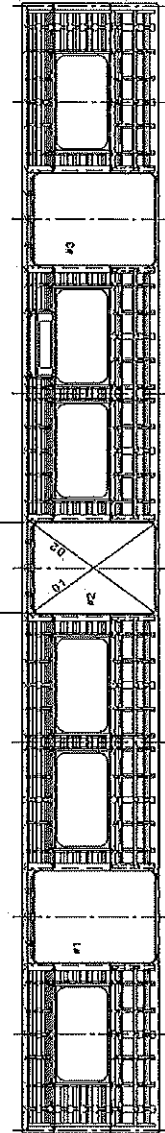
Doors diagonal D1-D2 maximum difference ≤4mm

	#1	#2	#3
D1	2751	2752	2749
D2	2749	2751	2751
D1-D2	2	1	2

Doors Length - 1672 ±3mm

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

End #1



LEFT SIDE

End #2

4mm


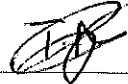
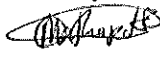
	#1	#2	#3
D1	2746	2750	2751
D2	2751	2752	2752
D1-D2	2	2	1

Vão de Portas - 1672 ±3mm

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





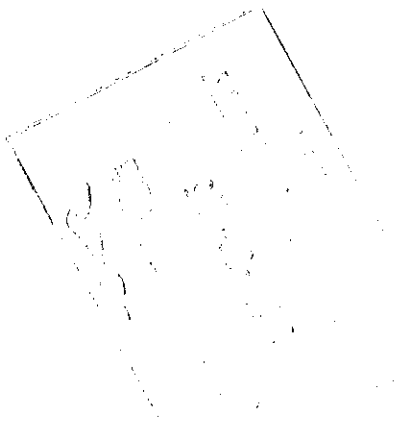
		CARBODYSHELL M2 ASSEMBLY DTR31374497/2		Rev. 29	Project: PRASA  SI.CB2220.276.V29	
				Date 28/10/2023		
		Self Inspection - Final Result				
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)				DATE	NAME	SIGNATURE
HOLD POINT	✓	GO	(If activities are not complete, the missing activities must not impact the next stage)	21/06/24	Tete b Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party	21/06/24	Richmond Industrial Quality	
			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	


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 Operations

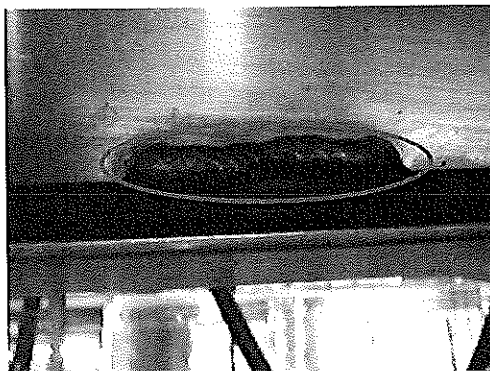
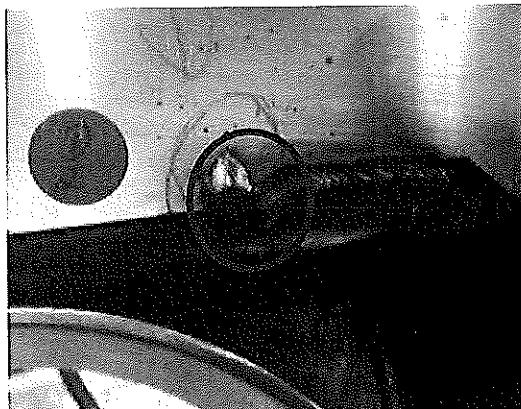
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 Quality



 <b>GIBELQ</b>	CARBODYSHELL M2 ASSEMBLY DTR31374497/2	Rev.	Project: PRA5A
		29	
		Date	
		28/10/2023	
		SI.CB2220.276.V29	

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



APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

# SELF INSPECTION SHEET

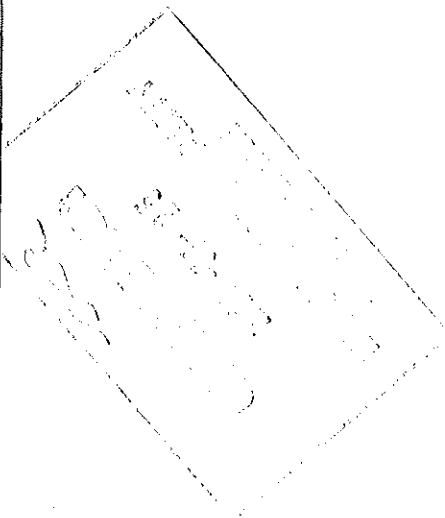
**CONFIDENTIAL INFORMATION**

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"/>	AA000001374497	AA00001413329	CARBODYSHELL M2 ASSEMBLY	CB1230				X			PRA.CB1230.AA0000013 74497.V20	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												
<input type="checkbox"/>												

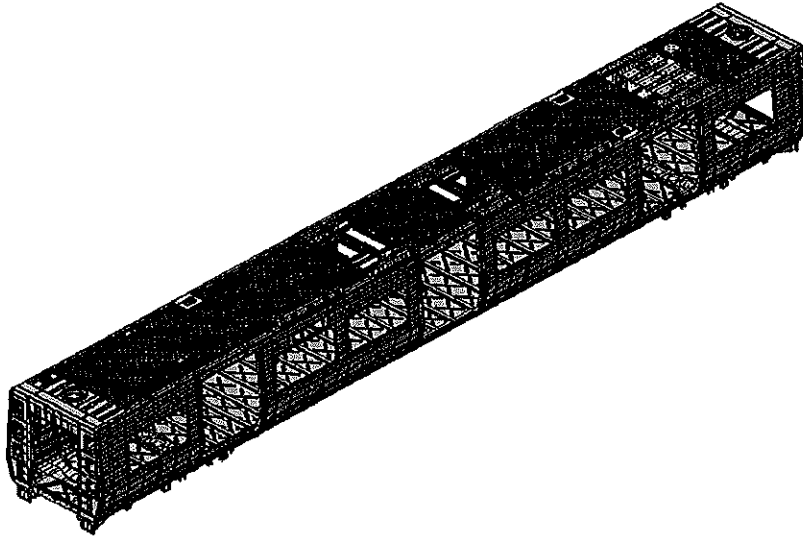
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	2018/08/02	GIBELA NEW CREATION	APPROVER	Philippe Marques	2018/08/02
			CHECKER	Nosizo Pindela	2018/08/02
			COMPILER	Nosizo Pindela	2018/08/02
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	30/5/2018
			CHECKER	Nosizo Pindela	30/5/2018
			REVISED BY	Nosizo Pindela	30/5/2018
2	2018/05/07	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	2018/05/07
			CHECKER	Nosizo Pindela	2018/05/07
			REVISED BY	Ramokone Motama	2018/05/07
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			REVISED BY	Vanessa Ntuli	24/01/2019
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Vanessa Ntuli	13/03/2019
10	23/03/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	23/08/2019
			CHECKER	Nosizo Pindela	23/08/2019
			REVISED BY	Nosizo Pindela	23/08/2019
	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbombhni	20/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbombhni	14/06/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
27	26/07/2022	Threshold measurement addition	APPROVER	Collins Mbombhni	27/07/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
28	17/10/2022	Addition of traceability for sealant application	APPROVER	Collins Mbombhni	17/10/2022
			CHECKER	Ntokoza Zwane	
			REVISED BY	Amogelang Mohlampe	
29	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokoza Zwane	
			REVISED BY	Amogelang Mohlampe	
30	06/11/2023	Added traceability on thresholds for boiler makers and welders	APPROVER	Ngobeni Tyson	06/11/2023
			CHECKER	Andani Muthelo	
			REVISED BY	Ntokoza Zwane	
TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
234	M02	Mmamahapelo 112004	28/06/24	SI.CB1230.277.V29	11



	<b>CARBODYSHELL M2 ASSEMBLY AA00001374497</b>	Rev. 30	<b>Project: PRASA</b>  <b>SI.CB1230.277.V29</b>
		Date	
		06/11/2023	
Car:	NCR:	Work station: CB1230	



Safety Related



## I - Documentation and Instruments Control

### I.1 - Documentation Control

Document	Type of car						Revision	Obsevation	OK		Signature/Date (Operations)	Signature/Date (Quality)
	TC1	M1	M2	M3	M4	TC2						
PRA.CB1230.AA00001374497			✓						✓	N/A	22/06/24	22/06/24

### I.2 - Instruments Control

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

Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Operations)	Signature/Date (Quality)
tubular	22113	26/06/24	✓		22/06/24	22/06/24
Measuring Tape	4180794	25/04/24	✓		22/06/24	22/06/24
Combination square	4180022	27/07/24	✓		22/06/24	

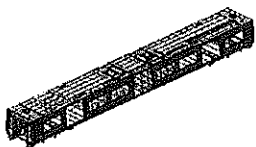
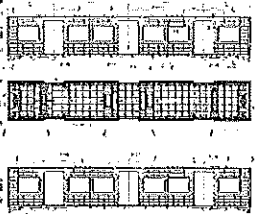
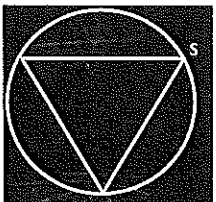
### 1.3 Consumables

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

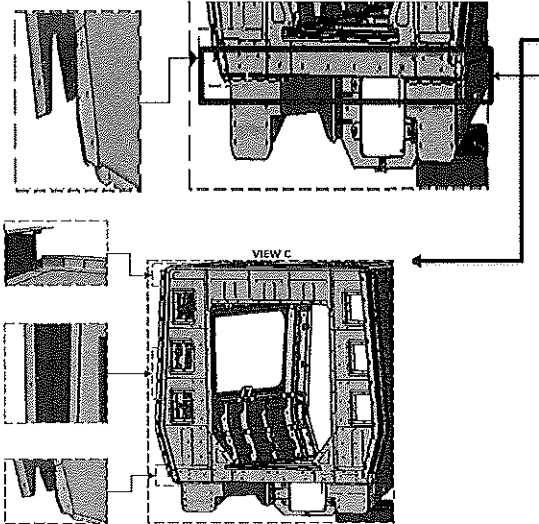
Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
308 LSi	373719	MIG	✓		22/06/24	22/06/24

## II - Self Inspection - Items to Check

### II.1 - Items to check

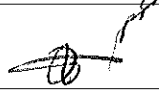
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK			Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.AA00001374497 Verification of fitment for all brackets.	PRA.CB1230.AA00001374497	✓			M. S. da 22/06/24	M. S. da 22/06/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓			M. S. da 22/06/24	M. S. da 22/06/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓			M. S. da 22/06/24	M. S. da 22/06/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓			M. S. da 22/06/24	M. S. da 22/06/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			M. S. da 22/06/24	M. S. da 22/06/24
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.	✓			M. S. da 22/06/24	M. S. da 22/06/24
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 (1) Min-Max 10°C - 35°C Relative humidity Min - Max (1) Min-Max 25% - 60%	Sealant Batch No: 112240 Exp Date: 4 / Aug / 2024 Actuals Temperature: 10,5°C Humidity: 60%	✓			M. S. da 22/06/24	M. S. da 22/06/24
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.	✓			M. S. da 22/06/24	M. S. da 22/06/24

## AREA 1

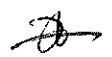


## END 2 SEALANT


OPERATOR  
(Name & sign):

Leroy 

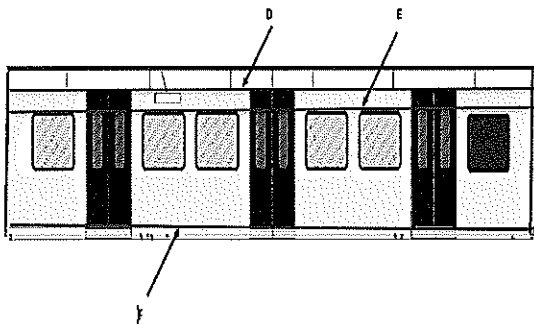
OPERATOR  
(Name & sign):

Lerato 

OPERATOR  
(Name & sign):

Leroy 

H




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

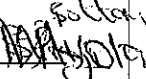
Operator (Name &amp; sign):

LHS (Koltan)  
F, H, I

RHS (Koltan)  
F, H, I

Operator (Name &amp; sign):

Buhle 

Buhle 

Operator (Name &amp; sign):

D, E, G, H, I

D, E, G, H, I

Operator (Name &amp; sign):

Sihle

Sihle

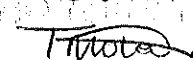
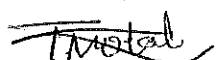
Operator (Name &amp; sign):




Operator (Name &amp; sign):

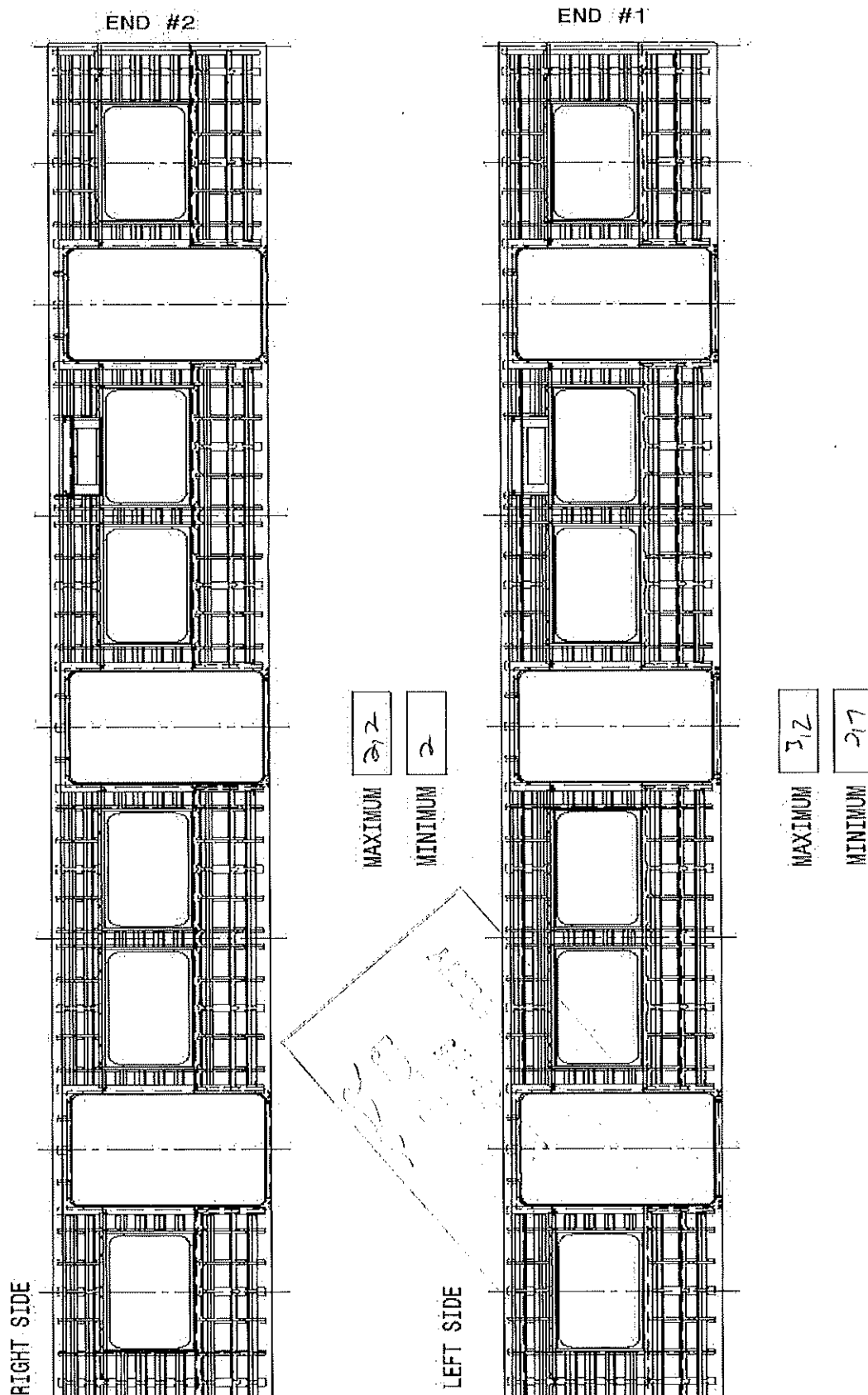
Tshendo


Tshendo

## Specifications of Details for CBS measurement CB1230

atness 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.



	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA
		Date 06/11/2023	

END #1

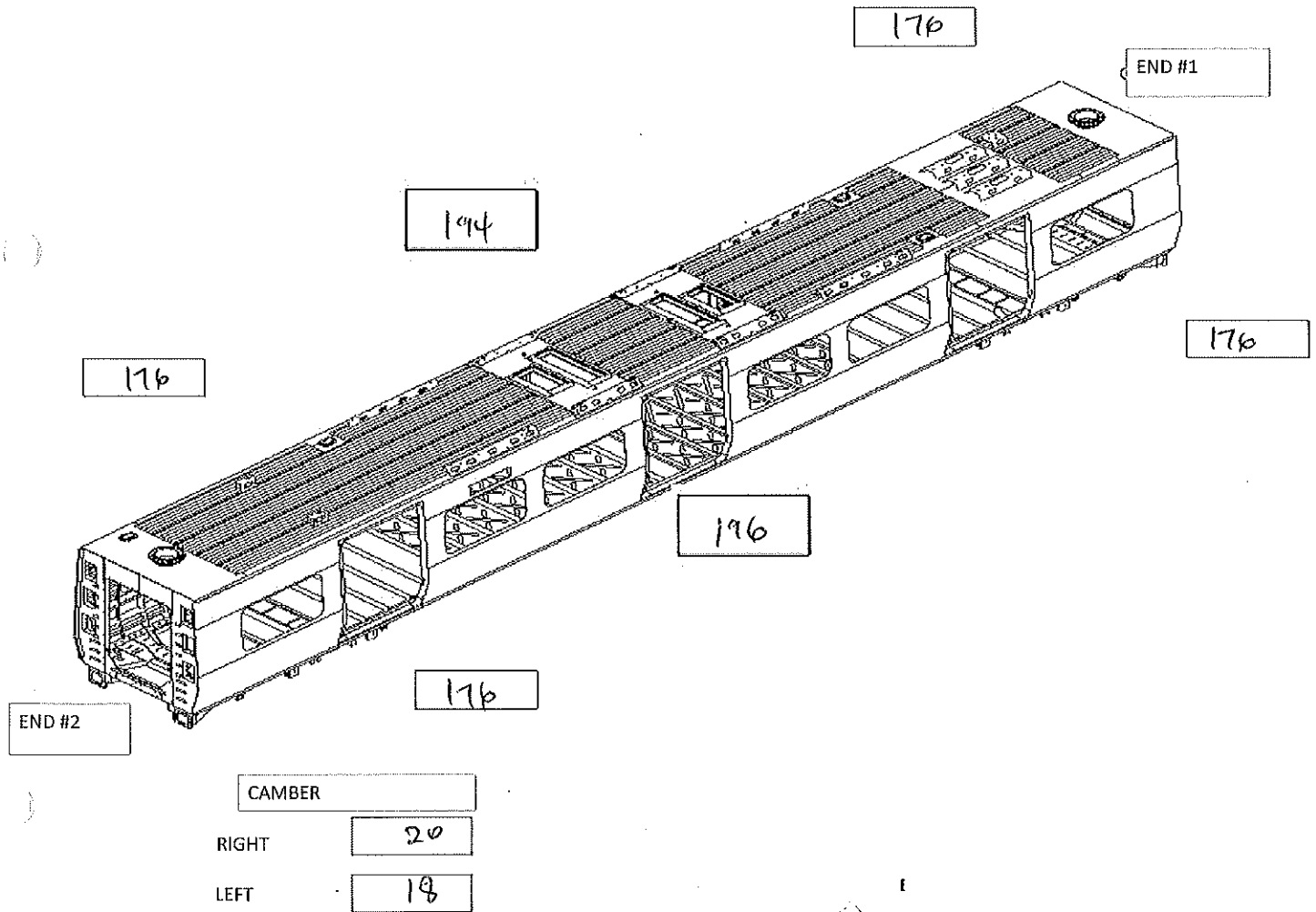
END #2

Stamp: 31-07-2023



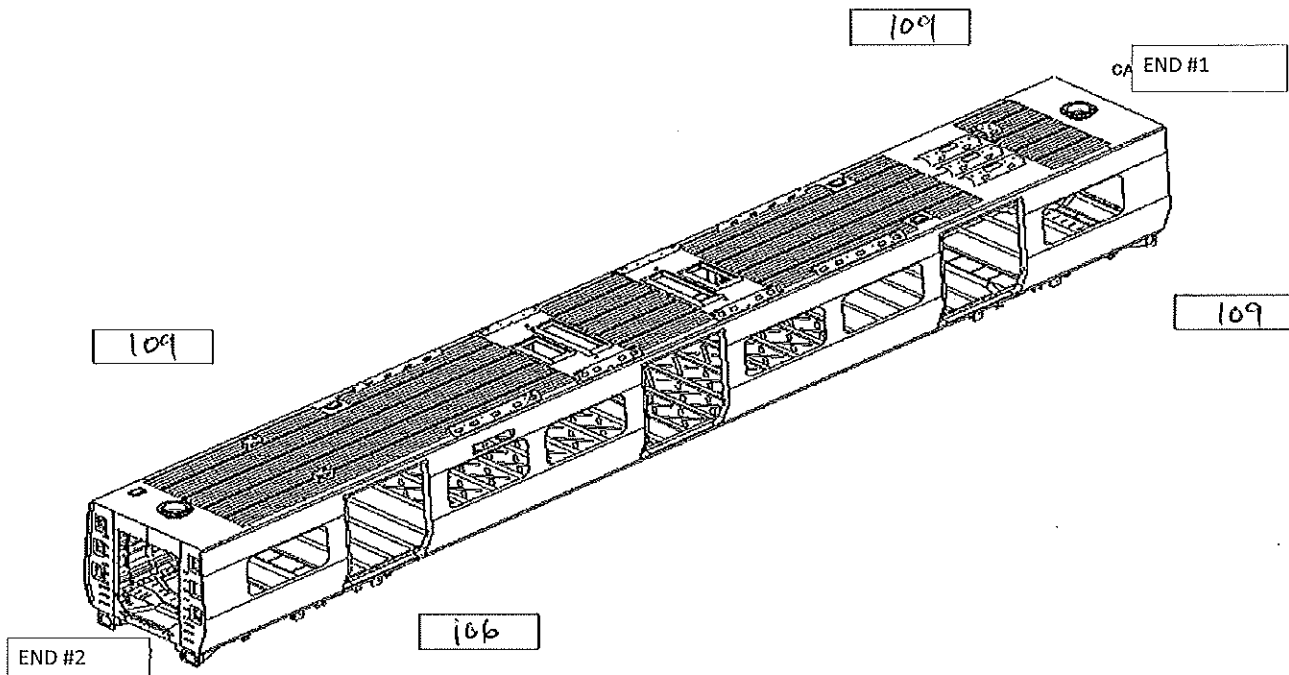
Specifications of Details for CBS measurement CB1230

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



## 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

3

TWIST FOUND ON END 2

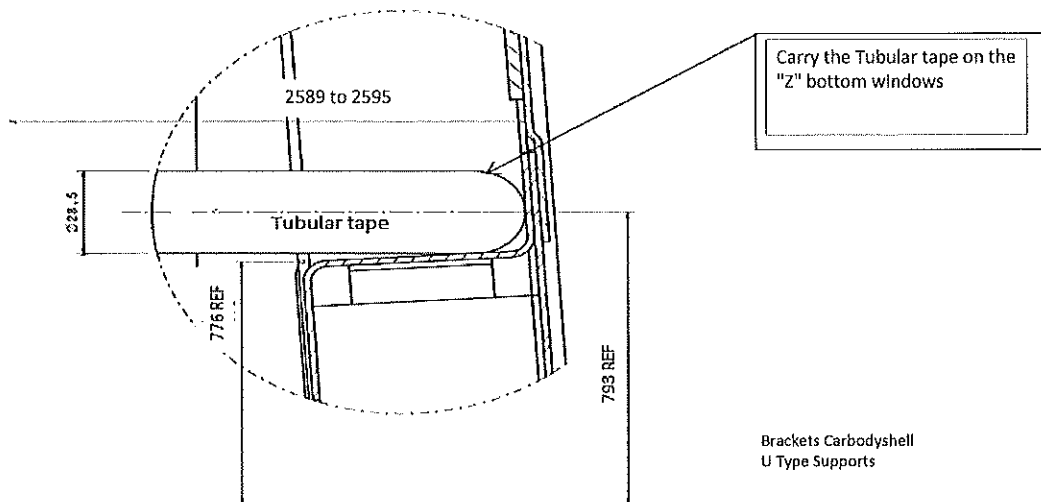
TRANVERSE

3

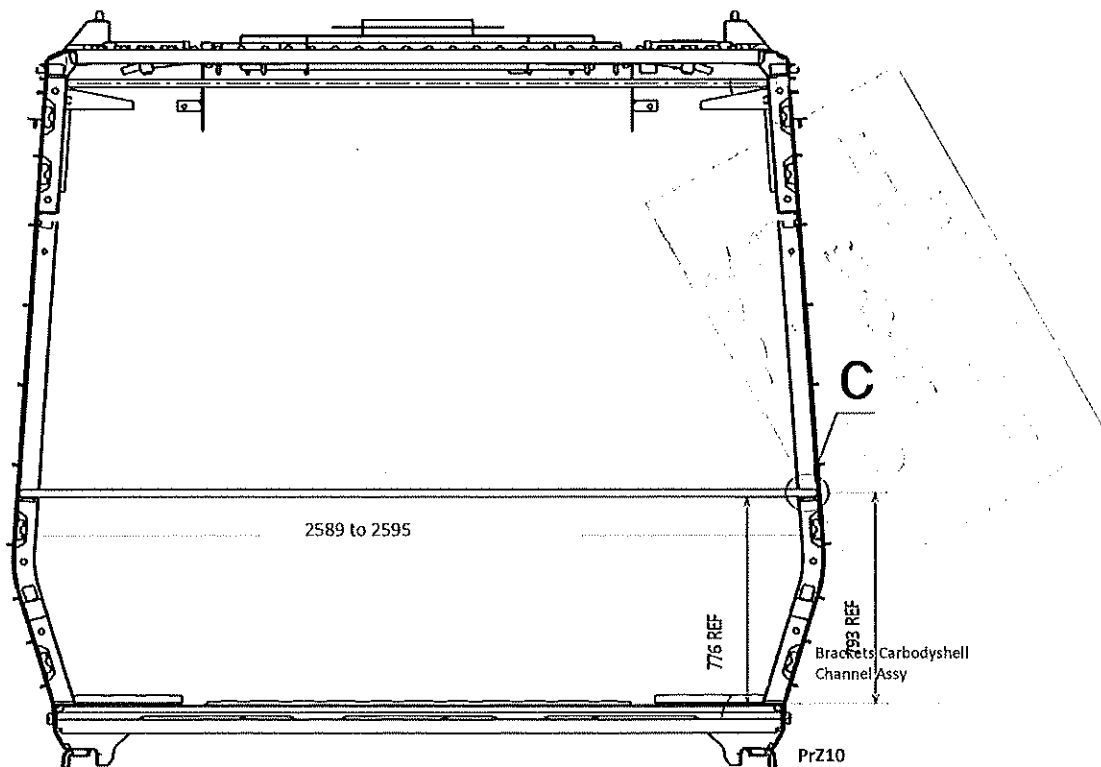
LONGITUDINAL

0

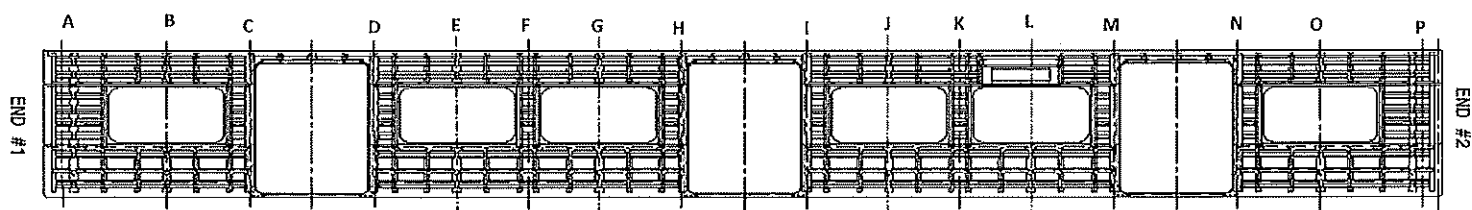
Specifications of Details for CBS measurement CB1230



Detail C

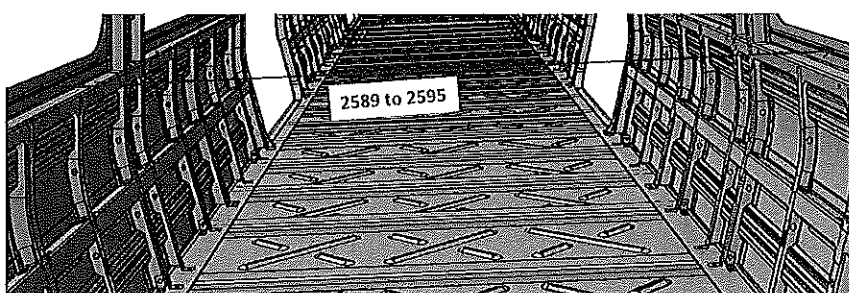


## Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	2595
B	2593
C	2589
D	2590
E	2591
F	2591
G	2594
H	2595
I	2591
J	2589
K	2592
L	2590
M	2589
N	2593
O	2598
P	2595



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

BOILER MAKER:

Kopraso

WELDER:

m-ma-hapero

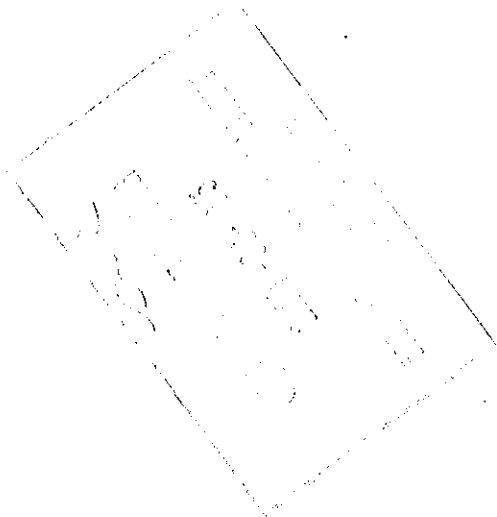
Masda



CARBODYSHELL M2 ASSEMBLY AA00001374497

Rev.  
30  
Date  
06/11/2023

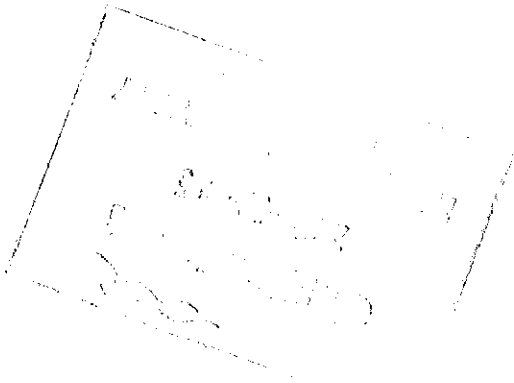
Project: PRASA  
SI.CB1230.277.V29



	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB1230.277.V29
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Dye penetrant test

Dye-penetration test to be performed by quality personnel





[illegible]

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

	CARBODYSHELL M2 ASSEMBLY AA00001374497	Rev. 30	Project: PRASA  SI.CB1230.277.V29
		Date 06/11/2023	

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)	22/06/24	4183004 mmathapero Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	22/06/24	Richmond Industrial Quality	
		NO GO	There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)		Operations	
			There are non-conformities impact the quality of the product and there is no corrective action defined yet)		Industrial Quality	

In case of "NO GO", describe blocking problems

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

Item	Description	Responsible	Due date	Status

Operations

Quality

