

CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 4 7 3

WEIGHT: 1 4 7 9 Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	24/05/2024	178247 104895 01	F305031	
RCS 355	2 mm				V1-E99055	
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	24/05/2024	183653 107087 01	F207906	
RCS 355	3 mm				VHE 73052	
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegasus	24/05/2024	178488 104640 01	P310150	
RCS 355	20 mm				VPR03512	


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegasus	26/05/2024			
RCS 355	30 mm					

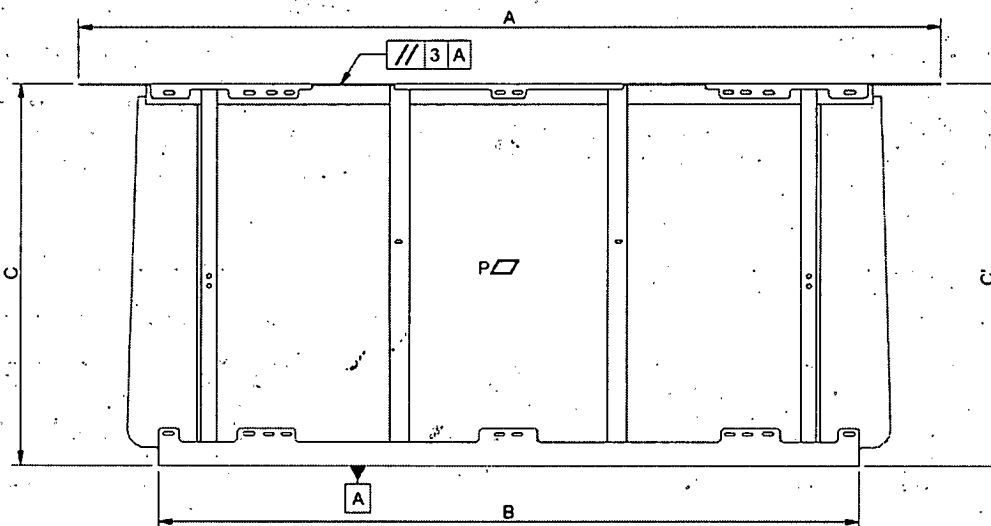
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	24/05/2024	182739 107087 01	F207906	
RCS 450	4 mm				VHL4703	
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	24/05/2024	183446 107087 01	F207907	
RCS 450	6 mm				VHS 62375	
RCS 450	6 mm					


GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	24/05/2024	183451 107087 01	F305031	
RCS 450	8 mm				VHS 62365	
RCS 450	8 mm					
RCS 450	8 mm					

Cabin Roof Assembly: GN002839


Assembly Completed as per WI/SOS MD_0046	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator: DYLAN DAVIDS	Assembly Date:	2024/04/30			
Sign: 	Wire Batch No.:	167238201			




Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042	Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector: Riccardo	Sign: 	Date:	2024/04/30		

Dimensional Control

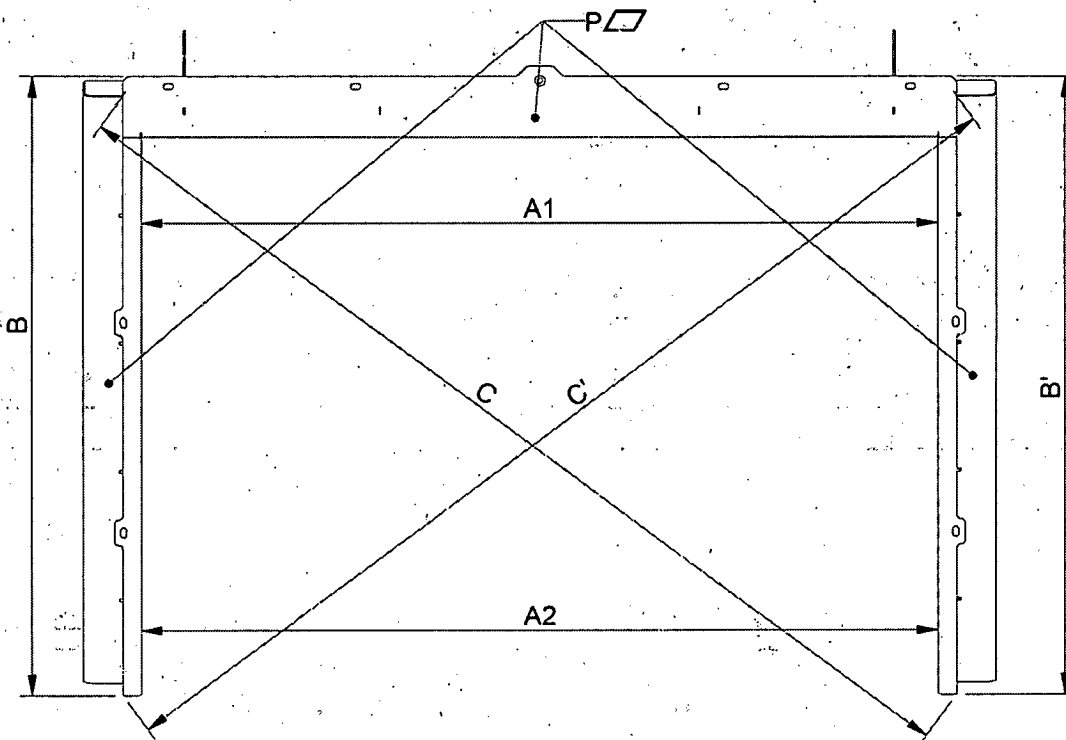
Rep	Toler.	Dimension measured	Measuring Equipment	Observations
A	2216	+5/-0	2216	Tape Measure acceptable acceptable acceptable
B	1800	± 4	1800	
C	976	+2/-3	976	
QC Inspector: Riccardo	Sign: 	Date:	2024/04/30	

Geometrical Control

Nature of Checks			Dimension Measured	Measuring Equipment	Observations	
Planeity P		6 mm	Passed	Ruler	acceptable acceptable	
//	3	A	Passed	Set Square		
QC Inspector:		Ricardo		Sign:		Date: 2024/09/30

Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Ramiro Garcia	Assembly Date:	2024/05/03			
Sign:	<i>[Signature]</i>	Wire Batch No.:	SS-2033			



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>[Signature]</i>	Sign:	<i>[Signature]</i>	Date:	2024/05/03	

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	1910	± 2	1912		Tape Measure	Acceptable	
A2	1910		1911			Acceptable	
B	1475	± 1	1475	1475		Acceptable	
C	Diagonals C - C' ≤ 3		2475	2473		Acceptable	
QC Inspector:		[Signature]		Sign:	[Signature]	Date:	202405103

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P : Planity	4 mm	<i>[Signature]</i>	Ruler	Acceptable
QC Inspector:	<i>[Signature]</i>	Sign:	<i>[Signature]</i>	Date: 2024/05/03

Cabin LHS/RHS Wing Mirror Plate Assembly: GN002846/GN002844

Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	TK Bootu	Assembly Date:	2024/04/09			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

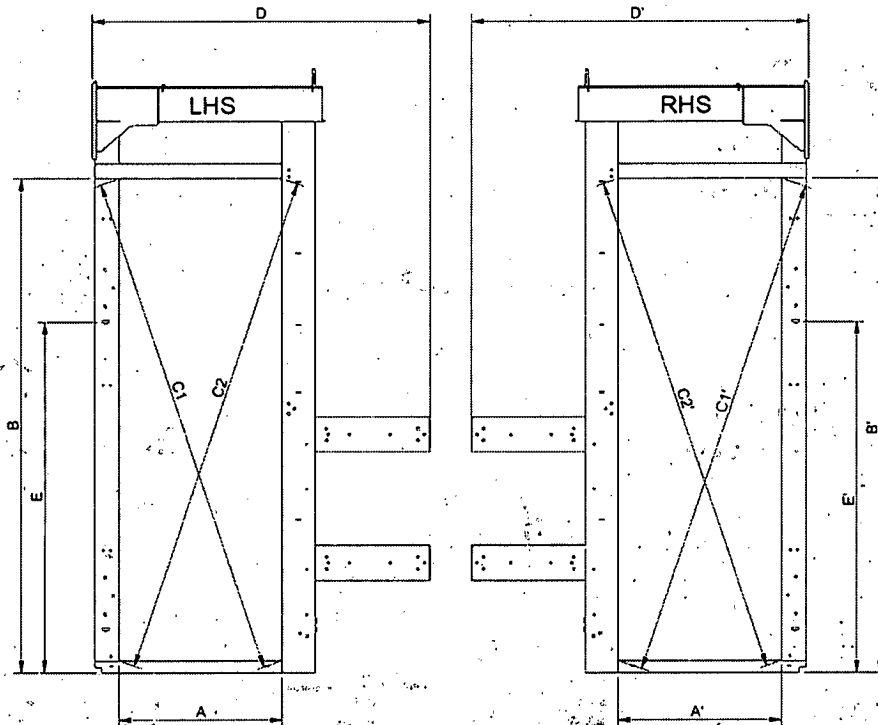
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	2024/04/17			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	2024/04/17			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Glenn	Assembly Date:	2024/04/18			
Sign:	Glenn	Wire Batch No.:	552033			



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
QC Inspector:	Riccardo	Sign:	Riccardo	Date:	2024/04/26	

Dimensional Control

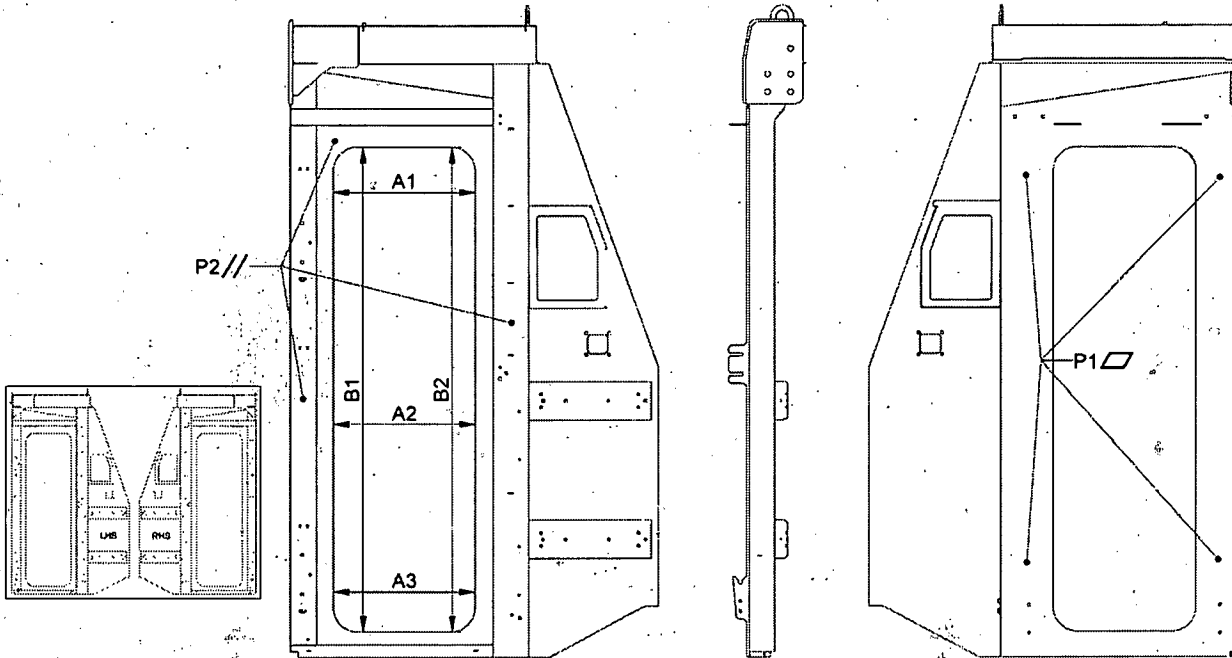
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	696	Tape Measure	acceptable
B	2086	+1/-3	2085	2085		acceptable
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2154	2154		acceptable
C1 - C2			2154	2153		acceptable
D	1438	+2/-3	1438	1438		acceptable
E			1484	1484		acceptable
QC Inspector:	Riccardo	Sign:	Riccardo	Date:	2024/04/26	

Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	Passed	Ruler	acceptable
QC Inspector:	Riccardo	Sign:	Riccardo	Date: 2024/04/26

Cabin LHS/RHS Side Assembly: GN002838/GN002837


Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	No
Operator:	TK BOOTH	Assembly Date:	2024/04/29	
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033	



Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	No
QC Inspector:	Riccardo	Sign:	<i>[Signature]</i>	Date: 2024/04/30

Dimensional Control

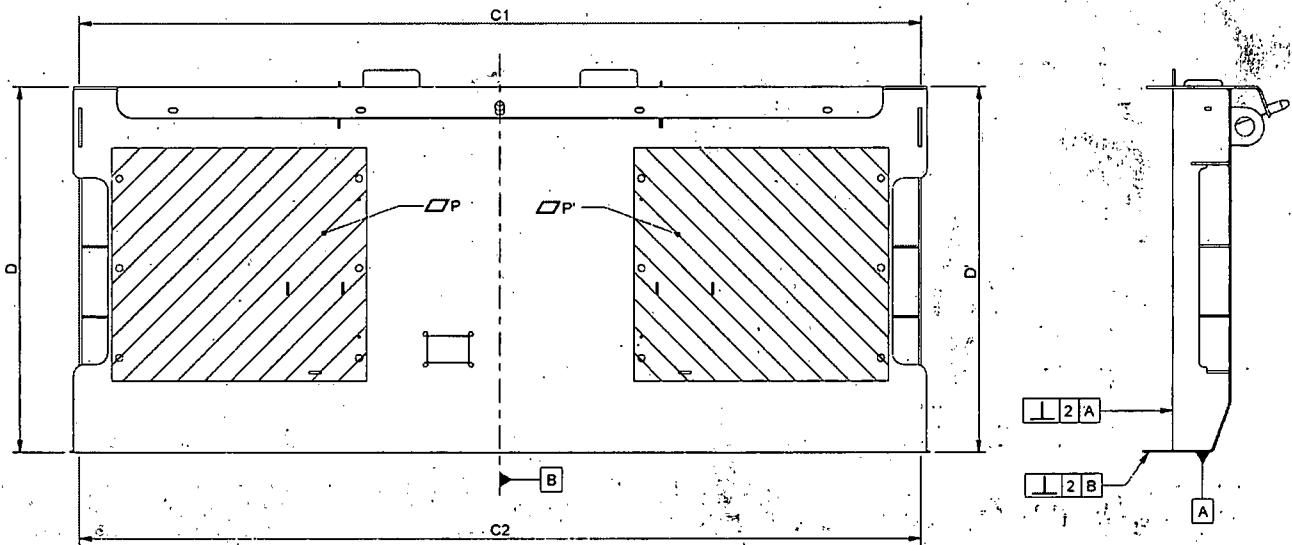
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	560	± 2	558	558	Tape Measure	acceptable	
A2			560	560		acceptable	
A3			560	560		acceptable	
B1	1900	± 2	1898	1898		acceptable	
B2			1898	1898		acceptable	
QC Inspector:		Riccardo		Sign:		Date:	2024/04/30

Geometrical Control

Nature of checks		Dimension Measured		Measuring Equipment	Observations
P1 : Planeity	4 mm	PASSED		Ruler	acceptable
P2 : Planeity	2 mm	PASSED		Ruler	acceptable
QC Inspector:		Riccardo	Sign:	<i>[Signature]</i>	Date: 2024/04/30

Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Raimelo C. C. Lima</i>	Assembly Date:	2024/05/03			
Sign:	<i>[Signature]</i>	Wire Batch No.:	SS 2038			



Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Ridley</i>	Sign:	<i>[Signature]</i>	Date:	2024/05/03	


Dimensional Control

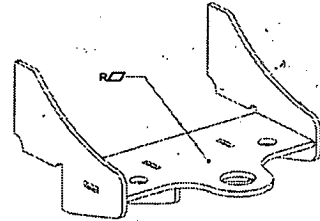
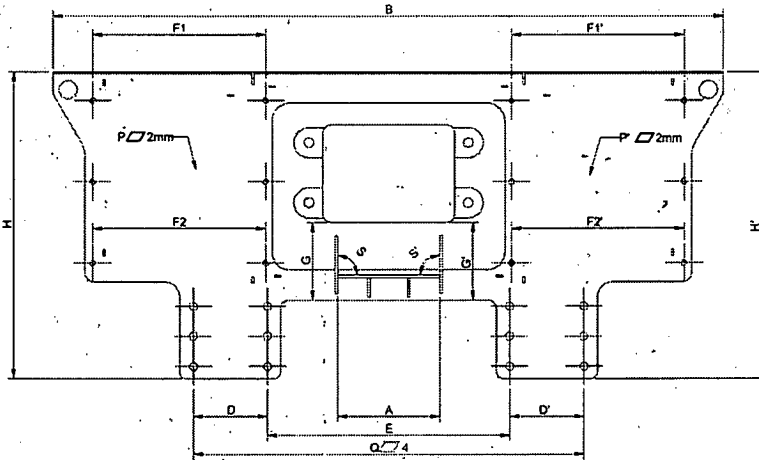
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2212	2213	Tape Measure	Acceptable
D / D'	956	± 2	956	956		Acceptable
QC Inspector:	<i>Ridley</i>	Sign:	<i>[Signature]</i>	Date:	2024/05/03	

Geometrical Control


Nature of Checks				Dimension Measured	Measuring Equipment	Observations
Planeity P / P'		2	mm	<i>Pass</i>	Ruler	Acceptable
Perpendicularity		2	A	<i>Pass</i>	Set Square	Acceptable
		2	B	<i>Pass</i>	Set Square	Acceptable
QC Inspector:	<i>Ridley</i>	Sign:	<i>[Signature]</i>	Date:	2024/05/03	

Cabin Front Headstock Assembly: GN002841

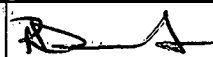
Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	TK BOC	Assembly Date:	2024/04/25			
Sign:		Wire Batch No.:	552033			




Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042.		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Riccardo	Sign:		Date:	2024/04/25	

Dimensional Control

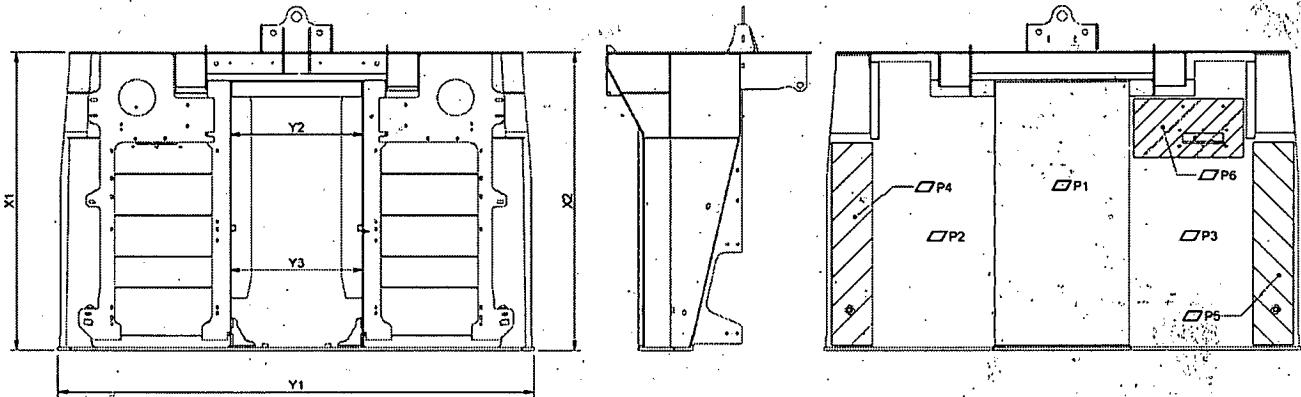
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	340	±1	340		Tape Measure	acceptable	
B	2240	±4	2244			acceptable	
D / D'	250	±1	250	250		acceptable	
E	808	±2	808			acceptable	
F1 / F1'	580	±1	580	580		acceptable	
F2 / F2'			580	580		acceptable	
G / G'	258	±1	258	258		acceptable	
H / H'	1019	±2	1020	1020		acceptable	
QC Inspector:		Riccardo		Sign:		Date:	2024/04/25

Geometrical Control

Nature of checks		Dimension Measured		Measuring Equipment	Observations	
O: Planeity of global assembly	4 mm	Passed		Ruler	acceptable	
P / P': Planeity	2 mm	Passed		Ruler	acceptable	
Q: Planeity Surface of Supports	4 mm	Passed		Ruler	acceptable	
R: Planeity Coupler Support	2 mm	Passed		Ruler	acceptable	
S: Perpendicularity coupler	1mm	Passed		Square	acceptable	
QC Inspector:	Riccardo	Sign:		Date:	2024/04/25	

Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	<i>Michael Wood</i>	Assembly Date:	2024/04/30		
Sign:	<i>[Signature]</i>	Wire Batch No.:	SS 20 33		



Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/04/30

Dimensional Control

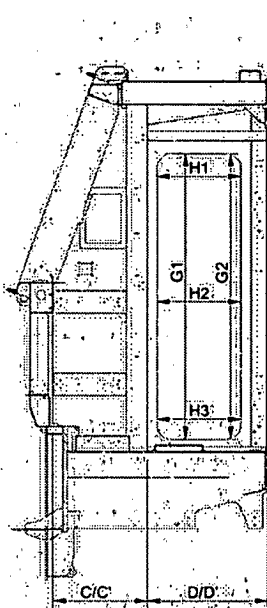
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
X1 / X2	1485	+5 / -2	1489	1487	Tape Measure	<i>[Signature]</i>	
Y1	2354	± 3	2352			<i>[Signature]</i>	
Y2 / Y3	666	± 1	667	667		<i>[Signature]</i>	
QC Inspector:		<i>Riccardo</i>	Sign:		<i>[Signature]</i>	Date:	2024/04/30

Geometrical Control

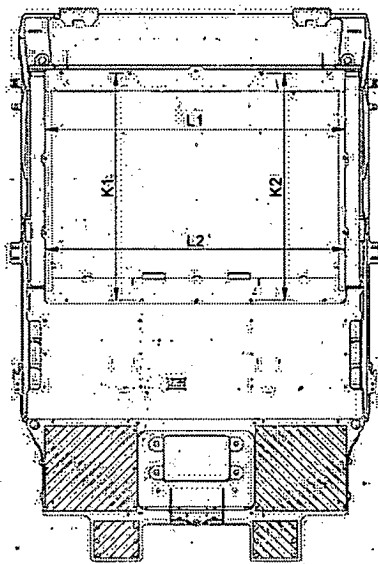
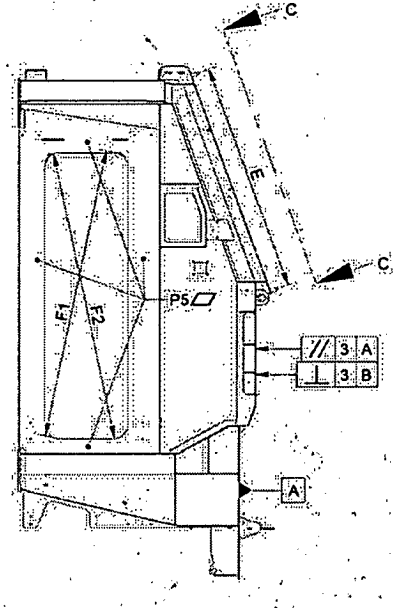
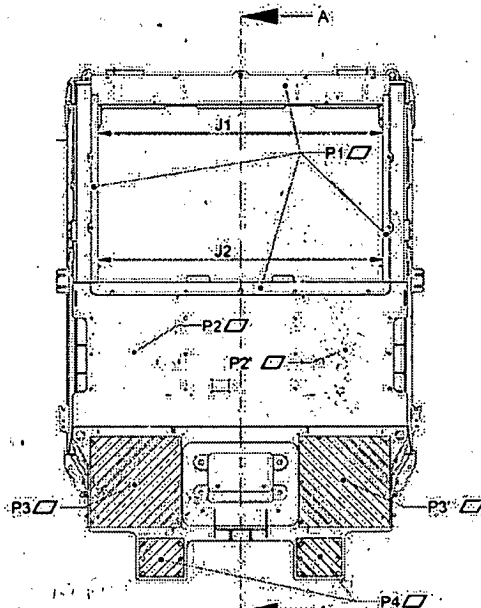
Nature of checks	Dimension Measured	Measuring Equipment	Observations		
P1 : Planeity	4 mm	<i>[Signature]</i>	Ruler	<i>[Signature]</i>	
P2 / P3 : Planeity	4 mm	<i>[Signature]</i>	Ruier	<i>[Signature]</i>	
P4 / P5 : Planeity	2 mm	<i>[Signature]</i>	Ruler	<i>[Signature]</i>	
P6 : Planeity	2 mm	<i>[Signature]</i>	Ruler	<i>[Signature]</i>	
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/04/30

Cabin Structure Assembly: GN002834

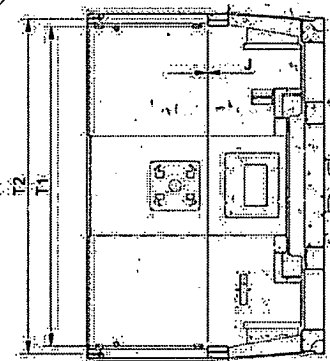
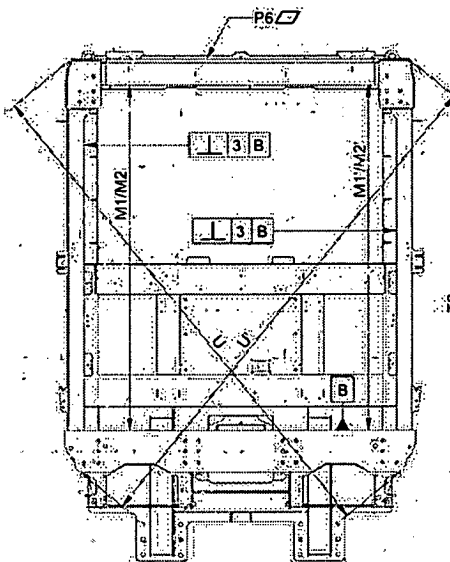
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/> No	
Operator:	<i>Damien</i>	Assembly Date:	<i>2024-10-10-08</i>		
Sign:	<i>[Signature]</i>	Wire Batch No.:	<i>502033</i>		



SECTION A-A



AUX VIEW: C



SECTION B-B

Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042				Confirmed		Yes	<input checked="" type="checkbox"/> No		
QC Inspector:		LEON		Sign:				Date:	2024/05/08
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	626	626	Acceptable				
D / D'	813	± 2,5	812	811,5	Acceptable				
E	1531,5	± 3	1531		Acceptable				
G1 / G'1	Height 1900	+1	1897	1897	Acceptable				
G2 / G'2		-3	1898	1898	Acceptable				
H1 / H'1	Width 560	+1			Acceptable				
H2 / H'2		-3	559	559	Acceptable				
H3 / H'3			559	559	Acceptable				
F1 / F'1	Diagonals 1939		1937	1937	Acceptable				
F2 / F'2			1934	1934	Acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	3	3	Acceptable				
J	Gap of Doors	± 1,5	0,5		Acceptable				
K1 / K2	1515	± 3	1515	1512	Acceptable				
L1 / L2	1996	± 3	1997	1995	Acceptable				
M1 / M'1	2306	± 3	2467	2468	Acceptable				
M2 / M'2			2478	2477	Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2128	2128	Acceptable				
T2 / T'2	2230 Top/Bottom		2080	2229	Acceptable				
Difference	U - U' (3522)	≤ 4mm	3519	3519	Acceptable				
QC Inspector:		LEON		Sign:				Date:	2024/05/08
Geometrical Control									
Nature of checks				Toler.	LHS / Dimension Measured / RHS		Observations		
P1 / P'1	Planeity			2 mm	PASSED		Acceptable		
P2 / P'2	Planeity			2 mm	PASSED		Acceptable		
P3 / P'3	Planeity			4 mm	PASSED		Acceptable		
P4 / P'4	Planeity			4 mm	PASSED		Acceptable		
P5 / P'5	Planeity			4 mm	PASSED		Acceptable		
P6 Roof	Planeity			6 With 2m Ruler	PASSED		Acceptable		
Shield	//	3	A	3	PASSED		Acceptable		
Shield	⊥	3	A	3	PASSED		Acceptable		
Door Post	⊥	3	A	Front	PASSED		Acceptable		
				Back	PASSED		Acceptable		
QC Inspector:		LEON		Sign:				Date:	2024/05/08

Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Damien</i>	Assembly Date:	2024/05/28			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Seamus</i>	Assembly Date:	2024/05/28			
Sign:	<i>[Signature]</i>	Wire Batch No.:				


Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Fasteners positioned in all Rivnuts and Bosses	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Masked as per GMS-SOS-GIBELA-CABIN-001	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Johnson	Sign:			
Date:	2024/05/25				
Record of Shot Blasting					
Operator:	Johnson	Date:	2024/05/25		
Start Time:	09:00 AM	End Time:	09:00 AM		
Temperature ($\geq 15^\circ$):	27 $^\circ\text{C}$	Humidity ($\leq 75\%$):	64 %		
Shot Blasting Self-Inspection					
Interior of Cabin: Sa 1 - Light Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Johnson	Sign:			
Date:	2024/05/25				
Shot Blasting Cleaning					
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Johnson	Sign:			
Date:	2024/05/25				
Shot Blasting Control					
Temperature $\geq 15^\circ$:		Humidity $\leq 75\%$:			
Internal Roughness $3.2 \leq Ra \leq 12.5$	Ra 7,448 Rz 42,115	External Roughness $3.2 \leq Ra \leq 12.5$	Ra 8,104 Rz 45,578		
QC Inspector:	2473	Sign:			
Date:	25/5/24				

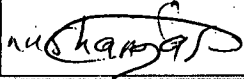
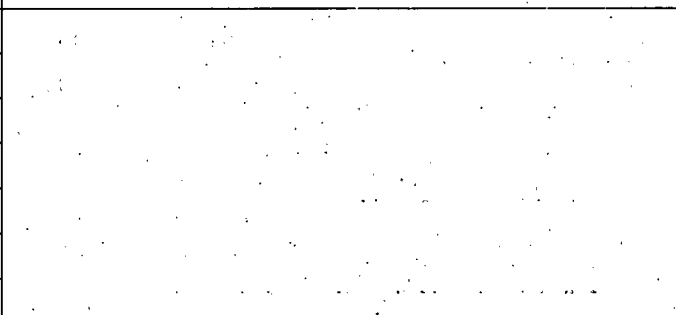

Ra 5,614
 8,181
 8,248
 7,897
 6,442
 6,272
 4,746
 6,793
 5,945
 7,448



Rz 32,528
 41,455
 43,811
 41,164
 37,627
 40,415
 29,759
 38,943
 36,279
 42,115

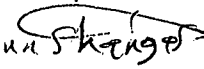

Ra 6,303
 7,082
 5,184
 4,292
 6,573
 6,592
 8,104
 7,642
 7,360
 6,982

Rz 40,021
 35,652
 29,356
 28,362
 42,049
 43,506
 45,578
 46,339
 42,581
 39,544

Record of Priming							
Start Time:		21:00		End Time:		23:30	
Temperature $\geq 15^{\circ}$:		26 $^{\circ}$ C		Humidity $\leq 75\%$:		48 $\%$	
Paint Batch No.:		80/6059		Paint Expiry Date:		08/25	
Hardener Batch No.:		73/1119		Hardener Expiry Date:		01/11/24	
Desolvation Start Time:		23:30		Desolvation End Time:		23:45	
Stoving Start Time:		23:45		Stoving End Time:		22:45	
Stoving Temp:		60 $^{\circ}$ C					
Operator:		NTUTUKO		Sign:		NTUTUKO	
Date:		2024/65/					
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 61.2	5: 61.7	1: 81.7	5: 63.2	1: 78.9	5: 69.1	1: 59.5	5: 74.5
2: 43.9	6: 48.6	2: 43.0	6: 51.2	2: 66.5	6: 52.2	2: 58.2	6: 50.8
3: 61.8	7: 59.9	3: 47.3	7: 74.6	3: 46.8	7: 73.4	3: 61.3	7: 47.9
4: 65.2	8: 55.2	4: 40.6	8: 51.9	4: 48.7	8: 45.0	4: 72.4	8: 68.2
Min:	43.9	Min:	40.6	Min:	45.0	Min:	47.9
Max:	61.8	Max:	81.7	Max:	79.4	Max:	74.5
Average:	55.9	Average:	61.1	Average:	60.2	Average:	61.6
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 54.1	5: 56.7	1: 41.7	5: 44.6	1: 57.9	5: 46.7	1: 62.7	5: 46.1
2: 55.3	6: 79.4	2: 58.8	6: 65.0	2: 56.3	6: 73.4	2: 56.6	6: 41.8
3: 62.9	7: 67.1	3: 42.5	7: 35.8	3: 66.2	7: 49.6	3: 58.9	7: 74.2
4: 60.0	8: 76.4	4: 66.4	8: 51.3	4: 46.0	8: 75.1	4: 60.4	8: 67.3
Min:	54.1	Min:	41.7	Min:	46.0	Min:	41.8
Max:	79.4	Max:	66.4	Max:	73.4	Max:	74.2
Average:	63.9	Average:	50.7	Average:	58.9	Average:	58.14
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 40.5	5: 77.2	1: 44.9	5: 42.7	1: 66.1	5: 76.8	1: 78.5	5: 50.9
2: 76.4	6: 56.7	2: 71.6	6: 72.0	2: 79.5	6: 56.8	2: 36.7	6: 68.2
3: 59.0	7: 60.3	3: 38.9	7: 74.5	3: 75.2	7: 40.6	3: 61.5	7: 44.1
4: 63.8	8: 46.1	4: 59.6	8: 64.3	4: 73.4	8: 81.4	4: 54.8	8: 67.9
Min:	40.5	Min:	38.9	Min:	40.6	Min:	36.7
Max:	77.2	Max:	74.5	Max:	81.4	Max:	78.5
Average:	60.0	Average:	58.15	Average:	68.7	Average:	57.8
Primer has been inspected and is free of defects				Confirmed		Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>	
QC Inspector:		Zothile		Sign:			
Date:		08 Jun 2024					

Record of Painting NCSS3010 R90B				
Start Time:	23:00		End Time:	23:30
Temperature $\geq 15^{\circ}$:	21°C		Humidity $\leq 75\%$:	55%
Paint Batch No.:	82/6294		Paint Expiry Date:	04.04.2025
Hardener Batch No.:	8187506 024		Hardener Expiry Date:	02/27
Desolvation Start Time:	23:36		Desolvation End Time:	23:45
Stoving Start Time:	23:45		Stoving End Time:	00:45
Stoving Temp:	60°C			
Operator:	Ntuthuko		Sign:	
Date:	2024/06/04			
Painting NCSS3010 R90B Control				
DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS		GMS-SOS-GIBELA-PS-001: Adhesion Test (attach test tape)
1: 119	5: 113	1: 927	5: 102	
2: 120	6: 826	2: 102	6: 961	
3: 108	7: 828	3: 128	7: 108	
4: 8515	8: 978	4: 112	8: 9513	
Min:	826	Min:	927	
Max:	120	Max:	128	
Average:	101	Average:	103	
Painting NCSS3010 R90B has been inspected and is free of defects				
GMS-SOS-GIBELA-PS-002 Gloss Test:				Value
QC Inspector:	Zothile			Sign: 
Date:	08 Jun 2024			

Record of Painting Blue NCSS1565-B			
Start Time:	04:00	End Time:	04:30
Temperature $\geq 15^{\circ}$:	23 $^{\circ}$ C	Humidity $\leq 75\%$:	61%
Paint Batch No.:	8216288	Paint Expiry Date:	27-03-2025
Hardener Batch No.:	8187506024	Hardener Expiry Date:	02/27
Desolvation Start Time:	04:30	Desolvation End Time:	04:45
Stoving Start Time:	04:45	Stoving End Time:	05:45
Stoving Temp:	60 $^{\circ}$ C		
Operator:	Ntuthu/CO	Sign:	
Date:	2024/06/25		
Painting Blue NCSS1565 B Control			
DFT-Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS	
		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)	
1: 117	5: 944	1: 746	5: 100
2: 108	6: 114	2: 813	6: 7516
3: 101	7: 125	3: 125	7: 751
4: 104	8: 944	4: 840	8: 9018
Min:	944	Min:	746
Max:	125	Max:	125
Average:		Average:	8910
Painting NCSS3010 R90B has been inspected and is free of defects		Confirmed	Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	
QC Inspector:	Zathle	Sign:	
Date:	08 Jun 2024		

Record of RAL 7012							
Start Time:		21:00		End Time:		23:00	
Temperature $\geq 15^{\circ}$:		26 $^{\circ}$ C		Humidity $\leq 75\%$:		51%	
Paint Batch No.:		8216273		Paint Expiry Date:		13.03.2025	
Hardener Batch No.:		8187506024		Hardener Expiry Date:		02/27	
Desolvation Start Time:		23:00		Desolvation End Time:		23:15	
Stoving Start Time:		23:15		Stoving End Time:		00:15	
Stoving Temp:		60 $^{\circ}$ C					
Operator:		Mituthuko		Sign:			
Date:		2024/06/06					
RAL 7012 Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 104	5: 9319	1: 6311	5: 840	1: 140	5: 117	1: 9613	5: 108
2: 9817	6: 9214	2: 9110	6: 9819	2: 103	6: 872	2: 155	6: 129
3: 114	7: 126	3: 9210	7: 190	3: 924	7: 131	3: 9714	7: 97.4
4: 911	8: 9816	4: 8417	8: 9443	4: 100	8: 986	4: 129	8: 168
Min:	911	Min:	6311	Min:	872	Min:	963
Max:	126	Max:	190	Max:	140	Max:	168
Average:	101	Average:	917	Average:	108	Average:	122
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 118	5: 9116	1: 108	5: 101	1: 112	5: 136	1: 77.5	5: 89.5
2: 107	6: 818	2: 110	6: 9513	2: 105	6: 114	2: 103	6: 79.5
3: 131	7: 103	3: 951	7: 167	3: 8614	7: 146	3: 9616	7: 69.7
4: 156	8: 811	4: 9012	8: 105	4: 185	8: 148	4: 9714	8: 79.5
Min:	811	Min:	9012	Min:	8614	Min:	69.7
Max:	156	Max:	167	Max:	185	Max:	103
Average:	109	Average:	108	Average:	127	Average:	85.5
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 114	5: 7412	1: 828	5: 101				
2: 100	6: 7010	2: 8813	6: 9812				
3: 9814	7: 158	3: 8310	7: 7918				
4: 8817	8: 988	4: 101	8: 9911				
Min:	7010	Min:	7918				
Max:	158	Max:	101				
Average:	100	Average:	9116				
Painting NCSS3010 R90B has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No
GMS-SOS-GIBELA-PS-002 Gloss Test				Value			
QC Inspector:		Zathile		Sign:			
Date:		08 Jun 2024					
SEALING OF CABIN							
All areas where there is no welding has been sealed with SIKA				Confirmed	YES	<input checked="" type="checkbox"/>	NO
All sealants have been neatly applied along joints				Confirmed	YES	<input checked="" type="checkbox"/>	NO
SIGN OFF							
CLOCK No:	2490	OPERATOR SIGN:	ATHILE	DATE:	8/6/24		

CABIN IS WAXED				Confirmed		YES	<input checked="" type="checkbox"/> NO
SIGN OFF							
CLOCK No	2450	OPERATOR SIGN	APRILE	DATE	8/6/24		

Confirmed

YES

NO

SIGN OFF

CLOCK No.

2400

OPERATOR SIGN

APHILE

DATE _____

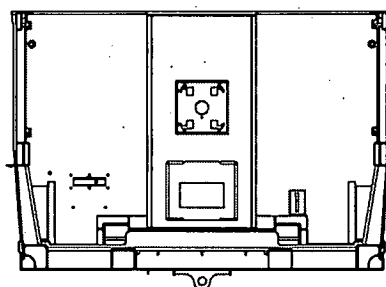
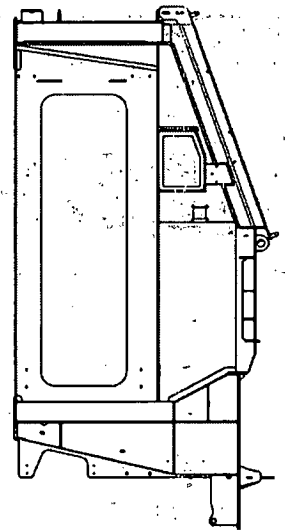
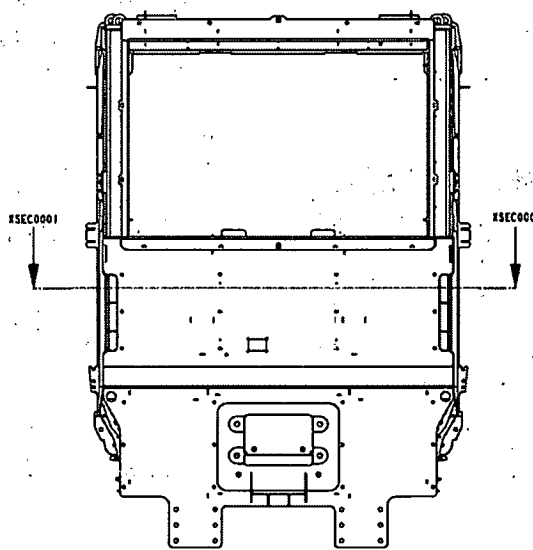
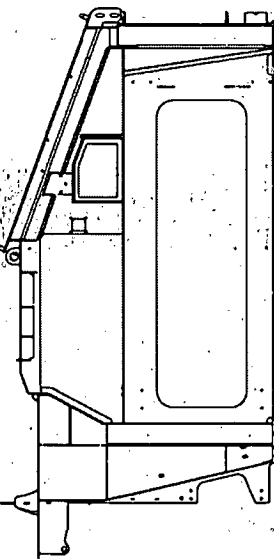
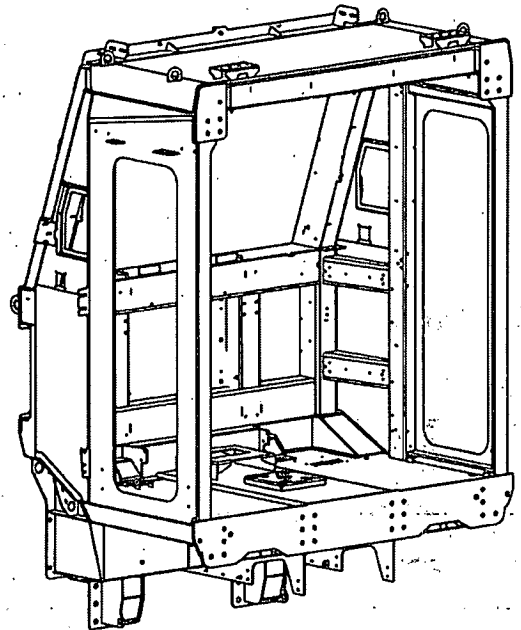
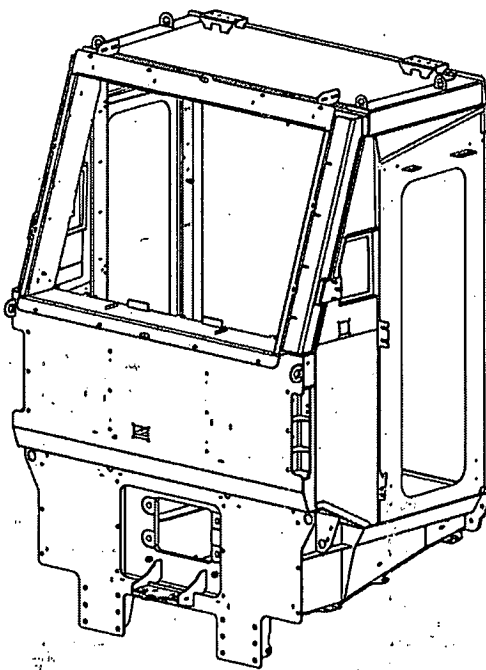
8/6/24

Request for Weld Repair

[illegible]

REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)



FAULT TRACKING

[illegible]

REMINDERS / COMMENTS

[illegible]



CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	0473	Checks Updated:	2022/08/26

Disposition Key:	0	Pass
	X	Fail (Concession required)
	Δ	Rework required

No.	Description of inspection	Disposition	Validation after rework		Sign
			Repairer	Disposition	
1	WELDS ARE CLOSED	○			
2	NO PIN HOLES ON CAB STRUCTURE	○			
3	SEALANT IS APPLIED CORRECTLY <ul style="list-style-type: none">JOINTS ARE CLOSEDNO BREAKS IN THE SEALANTCORRECT BEAD	○			
4	RIVET NUTS ARE PROPERLY CRIMPED <ul style="list-style-type: none">RIVETS ARE MARKEDCORRECT GRIP RANGE USED	○			
5	NO MISS WELDS PRESENT AFTER SANDBLASTING	○			
6	NO VISUAL MISS WELDS (INSPECTION AFTER SEALING)	○			
7	NO PAINT IN THREADS	○			
8					
9					
10					
11					
12					
13					
14					

Quality approval for release Signature	CO. NO:	DATE
	2285	0810612024