

CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:	L	Updated By:	Jonathan Chetty
Frame No.:	439	Checks Updated:	2021/07/07

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

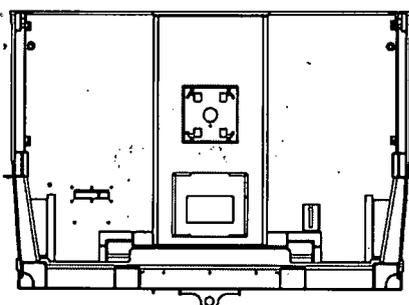
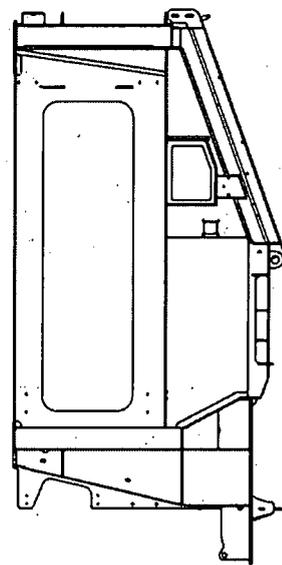
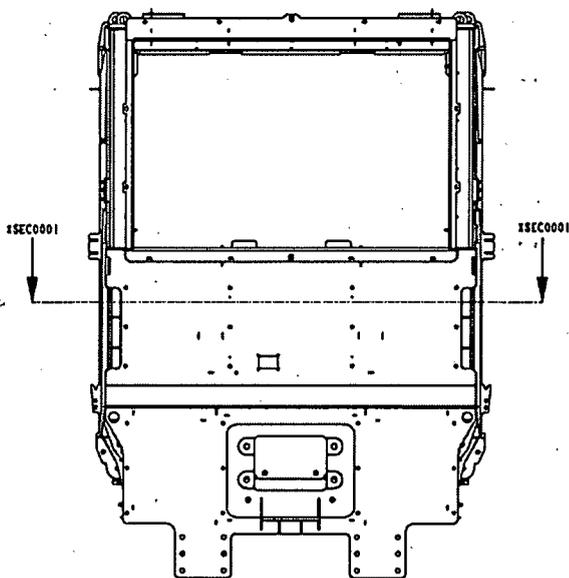
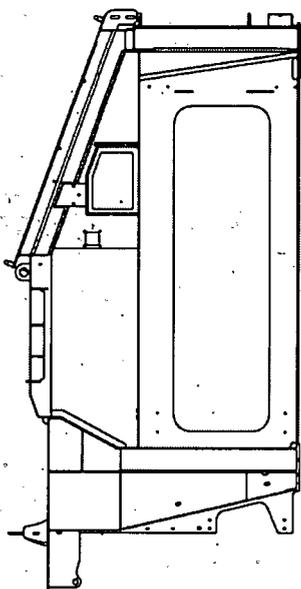
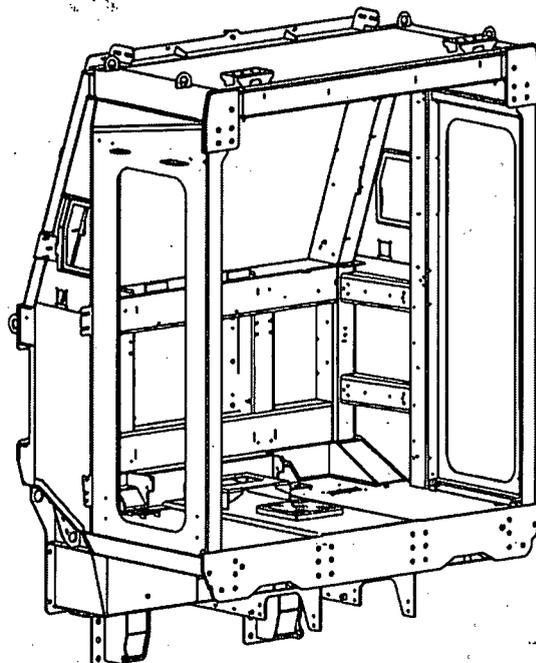
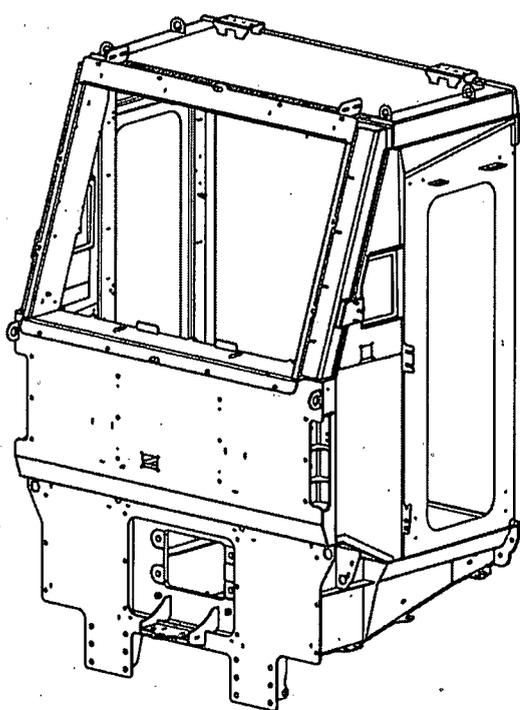
No.	Description of inspection	Disposition	Validation after rework		Sign
			Repairer	Disposition	
1	WELDS ARE CLOSED	0			
2	NO PIN HOLES ON CAB STRUCTURE	0			
3	SEALANT IS APPLIED CORRECTLY <ul style="list-style-type: none"> • JOINTS ARE CLOSED • NO BREAKS IN THE SEALANT • CORRECT BEAD 	0			
4	RIVET NUTS ARE PROPERLY CRIMPED <ul style="list-style-type: none"> • RIVETS ARE MARKED • CORRECT GRIP RANGE USED 	0			
5	NO MISS WELDS PRESENT AFTER SANDBLASTING	0			
6	NO VISUAL MISS WELDS (INSPECTION AFTER SEALING)	0			
7					
8					
9					
10					
11					
12					
13					
14					

Quality approval for release Signature	CO. NO:	DATE
	2291	09/03/24

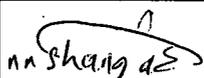


REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)



Record of RAL 7012

Start Time:	03:00	End Time:	05:00
Temperature ≥ 15°:	29°C	Humidity ≤ 75%:	32%
Paint Batch No.:	8156853	Paint Expiry Date:	06.02.2025
Hardener Batch No.:	7502112121	Hardener Expiry Date:	12/24
Desolvation Start Time:	05:00	Desolvation End Time:	05:15
Stoving Start Time:	05:15	Stoving End Time:	06:15
Stoving Temp:	160°C		
Operator:	Mfuthuko	Sign:	
Date:	2024/03/08		

RAL 7012 Control

DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 129	5: 142	1: 119	5: 124	1: 960	5: 126	1: 869	5: 914
2: 145	6: 132	2: 120	6: 146	2: 117	6: 104	2: 101	6: 942
3: 139	7: 138	3: 125	7: 133	3: 125	7: 113	3: 89.6	7: 122
4: 146	8: 154	4: 138	8: 141	4: 131	8: 128	4: 127	8: 100
Min:	129	Min:	120	Min:	960	Min:	86.9
Max:	154	Max:	146	Max:	131	Max:	127
Average:	140.6	Average:	130.8	Average:	117.5	Average:	101.5
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 138	5: 98.2	1: 143	5: 153	1: 122	5: 127	1: 145	5: 105
2: 100	6: 115	2: 120	6: 118	2: 131	6: 148	2: 129	6: 138
3: 104	7: 109	3: 131	7: 122	3: 140	7: 128	3: 121	7: 126
4: 126	8: 127	4: 116	8: 142	4: 126	8: 119	4: 118	8: 135
Min:	98.2	Min:	116	Min:	119	Min:	105
Max:	138	Max:	153	Max:	148	Max:	138
Average:	114.7	Average:	130.6	Average:	130	Average:	133.4
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 157	5: 153	1: 99.3	5: 87.0				
2: 143	6: 141	2: 102	6: 99.4				
3: 150	7: 137	3: 94.2	7: 110				
4: 148	8: 151	4: 113	8: 115				
Min:	137	Min:	87.0				
Max:	153	Max:	115				
Average:	147.5	Average:	102.5				

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	38.4			
QC Inspector:	Zatule	Sign:			
Date:	08 Mar				

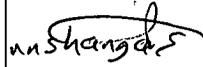
SEALING OF CABIN

All areas where there is no welding has been sealed with SIKA	Confirmed	YES	<input type="checkbox"/>	NO	<input type="checkbox"/>
All sealants have been neatly applied along joints	Confirmed	YES	<input type="checkbox"/>	NO	<input type="checkbox"/>

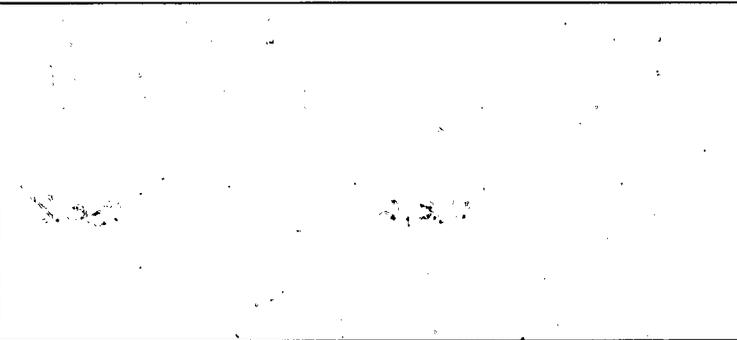
SIGN OFF

CLOCK No:	OPERATOR SIGN:	DATE:
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Record of Painting Blue NCSS1565 B

Start Time:	23:00	End Time:	23:30
Temperature ≥ 15°:	26°C	Humidity ≤ 75%:	46%
Paint Batch No.:	8176318	Paint Expiry Date:	02.02.2025
Hardener Batch No.:	7502115121	Hardener Expiry Date:	12/24
Desolvation Start Time:	23:30	Desolvation End Time:	23:45
Stoving Start Time:	23:45	Stoving End Time:	00:45
Stoving Temp:	60°C		
Operator:	Ntuthu ko	Sign:	
Date:	20 24/03/06		

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: 129	5: 111	1: 127	5: 141			
2: 128	6: 132	2: 104	6: 138			
3: 110	7: 136	3: 97.4	7: 126			
4: 108	8: 151	4: 121	8: 100			
Min: 104	Max: 142	Min: 100	Max: 137			
Average: 124.6	Average: 118.1					
Painting NCSS3010 R90B has been inspected and is free of defects						
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	90.4	
QC Inspector:		Zothile		Sign:		
Date:		08 Mar 2024				

Record of Painting NCSS3010 R90B

Start Time:	20:00	End Time:	20:30
Temperature ≥ 15°:	29°C	Humidity ≤ 75%:	43%
Paint Batch.No.:	8156903	Paint Expiry Date:	23.01.2025
Hardener Batch No.:	7802115121	Hardener Expiry Date:	12/24
Desolvation Start Time:	20:30	Desolvation End Time:	20:45
Stoving Start Time:	20:45	Stoving End Time:	21:45
Stoving Temp:	60°C		
Operator:	NEUTUKO	Sign:	[Signature]
Date:	2024/03/06		

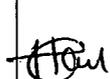
Painting NCSS3010 R90B Control

DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)		
1: 122	5: 112	1: 137	5: 116	[Adhesion Test Results]		
2: 135	6: 128	2: 129	6: 114			
3: 119	7: 135	3: 121	7: 108			
4: 104	8: 142	4: 120	8: 100			
Min: 106	Min: 97.4					
Max: 151	Max: 141					
Average: 127.6	Average: 118.6					
Painting NCSS3010 R90B has been inspected and is free of defects						
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	358	
QC Inspector:	[Signature]			Sign:	[Signature]	
Date:	08 Mar 2024					

Record of Priming

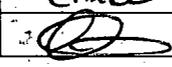
Start Time:	4:40	End Time:	6:05
Temperature ≥ 15°:	25°	Humidity ≤ 75%:	49%
Paint Batch No.:	7878267	Paint Expiry Date:	06/25
Hardener Batch No.:	2331119	Hardener Expiry Date:	01/11/24
Desolvation Start Time:	6:05	Desolvation End Time:	6:20
Stoving Start Time:	6:20	Stoving End Time:	6:20
Stoving Temp:	60°		
Operator:	2333	Sign:	
Date:	2024/03/06		

Priming Control

DFT Interior RHS **		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 65.3	5: 59.5	1: 62.0	5: 42.7	1: 61.6	5: 68.5	1: 43.3	5: 69.5
2: 71.1	6: 64.2	2: 73.8	6: 52.8	2: 46.2	6: 59.2	2: 68	6: 56.8
3: 42.7	7: 61.4	3: 63.7	7: 6.7	3: 103	7: 89	3: 47.6	7: 58.6
4: 53.0	8: 63.8	4: 94.2	8: 82.9	4: 107	8: 62.4	4: 43.8	8: 77.9
Min:	15.3	Min:	42.7	Min:	46.2	Min:	43.3
Max:	76.1	Max:	94.2	Max:	107	Max:	77.9
Average:	58.9	Average:	66.7	Average:	60	Average:	59.2
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 103	5: 101	1: 69.5	5: 69.9	1: 85.5	5: 124	1: 52.1	5: 73.8
2: 75.9	6: 66.5	2: 61.6	6: 84.4	2: 67	6: 94.1	2: 74.7	6: 58.6
3: 79.9	7: 81.9	3: 58.2	7: 46.6	3: 32.5	7: 85.4	3: 69.9	7: 51.0
4: 62.6	8: 61.1	4: 110	8: 106	4: 51.4	8: 53.4	4: 63.0	8: 59
Min:	61.1	Min:	46.6	Min:	32.5	Min:	51.0
Max:	103	Max:	110	Max:	124	Max:	74.7
Average:	82.3	Average:	75.8	Average:	70.4	Average:	62.8
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 74.3	5: 70.4	1: 112	5: 61.1	1: 81.9	5: 72.5	1: 41.6	5: 63.4
2: 72.7	6: 69.5	2: 69.5	6: 85.4	2: 75.8	6: 69	2: 72.3	6: 67.7
3: 64.8	7: 72.2	3: 90	7: 69.5	3: 65.3	7: 73.4	3: 55.2	7: 82.5
4: 78.5	8: 81.1	4: 46.2	8: 47.6	4: 72.1	8: 44.2	4: 61.6	8: 58.6
Min:	31.1	Min:	46.2	Min:	44.2	Min:	41.6
Max:	78.5	Max:	112	Max:	81.9	Max:	82.5
Average:	66.7	Average:	72.7	Average:	69.3	Average:	62.9
Primer has been inspected and is free of defects				Confirmed	Yes	No	
QC Inspector:	Zettile			Sign:			
Date:	08 Mar 2024						

Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Fasteners positioned in all Rivnuts and Bosses	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Masked as per GMS-SOS-GIBELA-CABIN-001	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID		Sign:		TD [Signature]
Date:	2024/03/06				
Record of Shot Blasting					
Operator:		Date:	2024/03/06		
Start Time:	08 H 15	End Time:	15 H 00		
Temperature ($\geq 15^\circ$):	21-03 $^\circ\text{C}$	Humidity ($\leq 75\%$):	68-07%		
Shot Blasting Self-Inspection					
Interior of Cabin: Sa 1 - Light Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID		Sign:		TD [Signature]
Date:	2024/03/06				
Shot Blasting Cleaning					
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID		Sign:		TD [Signature]
Date:	2024/03/06				
Shot Blasting Control					
Temperature $\geq 15^\circ$:	19-03 $^\circ\text{C}$	Humidity $\leq 75\%$:	69-04%		
Internal Roughness $3.2 \leq \text{Ra} \leq 12.5$	10.684	External Roughness $3.2 \leq \text{Ra} \leq 12.5$	07.695		
QC Inspector:	Leon		Sign:		[Signature]
Date:	06/03/24				

Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	/	No	
Operator:	CHUCK BLOEM	Assembly Date:	20 24/02/18			
Sign:		Wire Batch No.:	220252-			

Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes		No	
Operator:		Assembly Date:	20 __/__/__			
Sign:		Wire Batch No.:				

Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042

Confirmed

Yes

No

QC Inspector: Leon

Sign:

A

Date:

2024 / 02 / 13

Dimensional Control

Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations
C / C'	625	± 2	625	625	Acceptable
D / D'	813	± 2,5	812	812	Acceptable
E	1531.5	± 3	1530		Acceptable
G1 / G'1	Height 1900	+1	1897	1897	Acceptable
G2 / G'2		-3	1898	1898	Acceptable
H1 / H'1	Width 560	+1	559	560	Acceptable
H2 / H'2		-3	559	560	Acceptable
H3 / H'3			559	560	Acceptable
F1 / F'1	Diagonals 1939		1936	1936	Acceptable
F2 / F'2			1935	1934	Acceptable
Difference	F1-F2 / F'1-F'2	≤ 4	1	2	Acceptable
J	Gap of Doors	± 1,5	1		Acceptable
K1 / K2	1515	± 3	1513	1514	Acceptable
L1 / L2	1996	± 3	1997	1997	Acceptable
M1 / M'1	2306	± 3	2467	2467	Acceptable
M2 / M'2			2478	2477	Acceptable
T1 / T'1	2130 Top/Bottom	± 3	2127	2127	Acceptable
T2 / T'2	2230 Top/Bottom		2231	2231	Acceptable
Difference	U - U' (3522)	≤ 4mm	3521	3521	Acceptable

QC Inspector:

Leon

Sign:

A

Date:

2024 / 02 / 13

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:

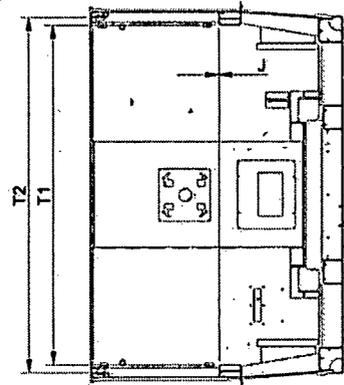
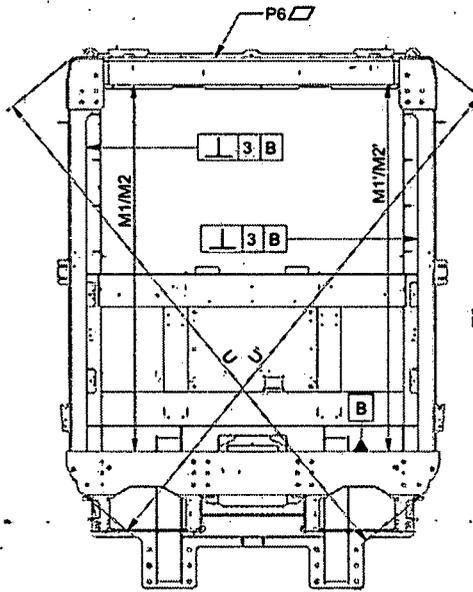
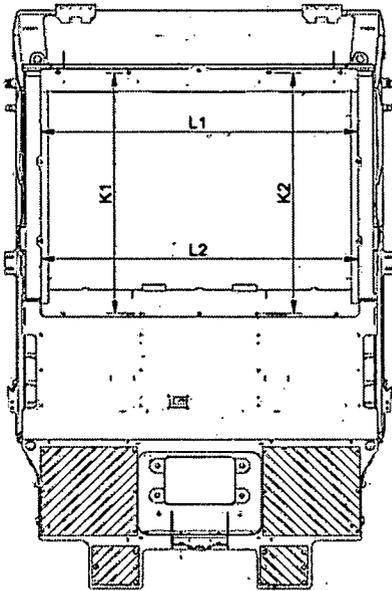
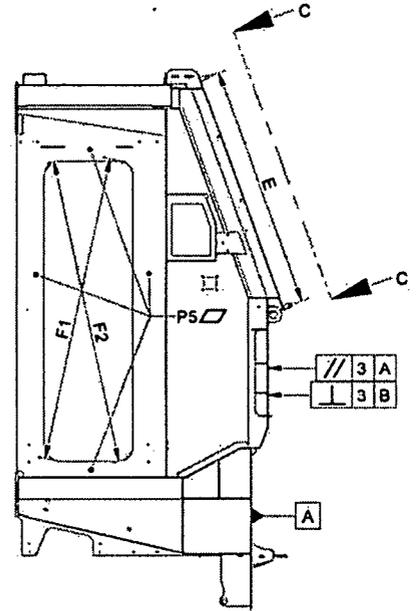
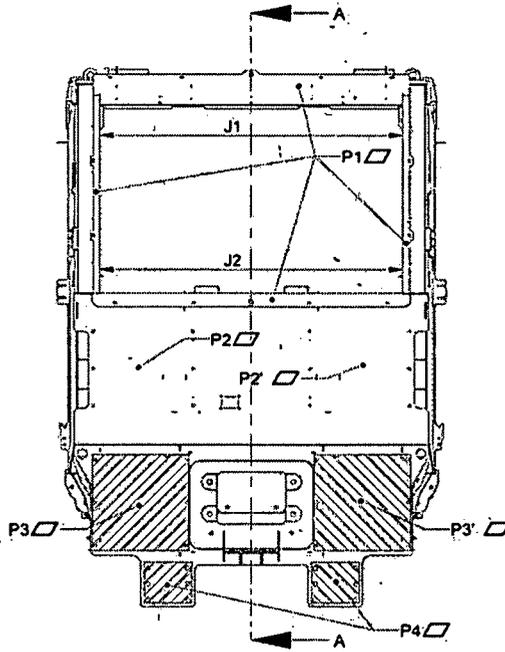
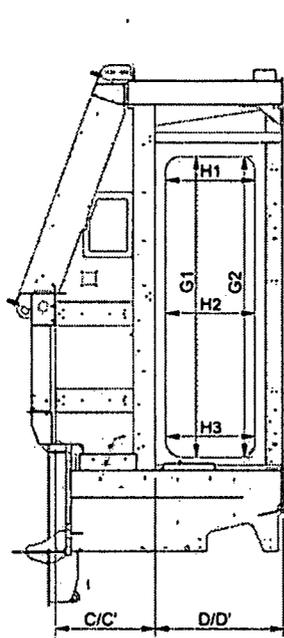
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Date:

2024 / 02 / 13

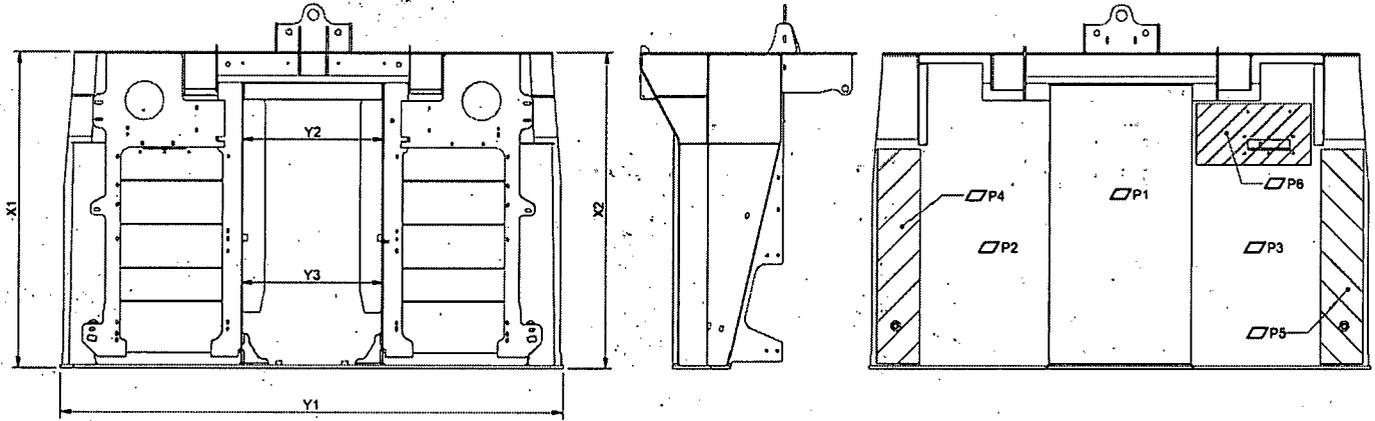
Cabin Structure Assembly: GN002834

Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>CHALL BLOOM</i>	Assembly Date:	20 24 / 02 / 09	
Sign:		Wire Batch No.:	220252	



Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	2024/02/09	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152	



Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date: 2024/02/09

Dimensional Control

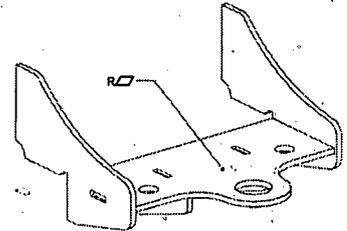
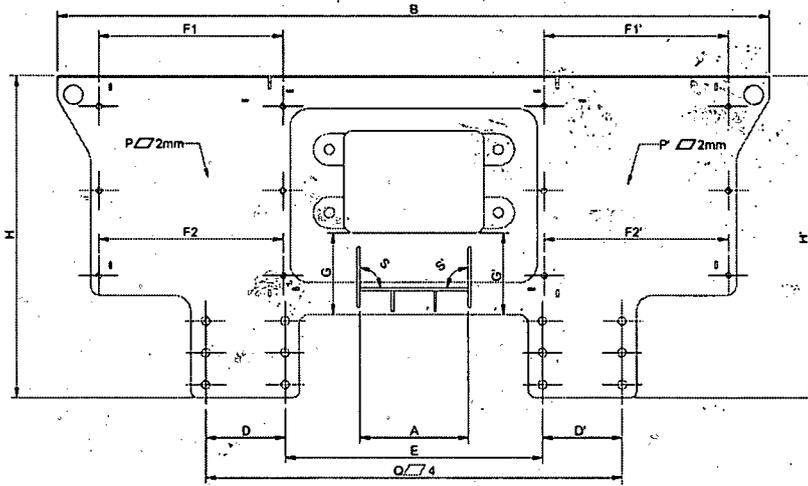
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1486	1485	Tape Measure	<i>Accepted</i>
Y1	2354	± 3	2352			<i>Accepted</i>
Y2 / Y3	666	± 1	664	668		<i>Accepted</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/09	

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Ruler	<i>Accepted</i>
P2 / P3 : Planeity	4 mm	Ruler	<i>Accepted</i>
P4 / P5 : Planeity	2 mm	Ruler	<i>Accepted</i>
P6 : Planeity	2 mm	Ruler	<i>Accepted</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>
			Date: 2024/02/09

Cabin Front Headstock Assembly: GN002841

Assembly Completed as per WI/SOS MD_0019	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator: TK BOON	Assembly Date:	2024/02/06			
Sign:	Wire Batch No.:	2207165			



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:	2024/02/06					

Dimensional Control

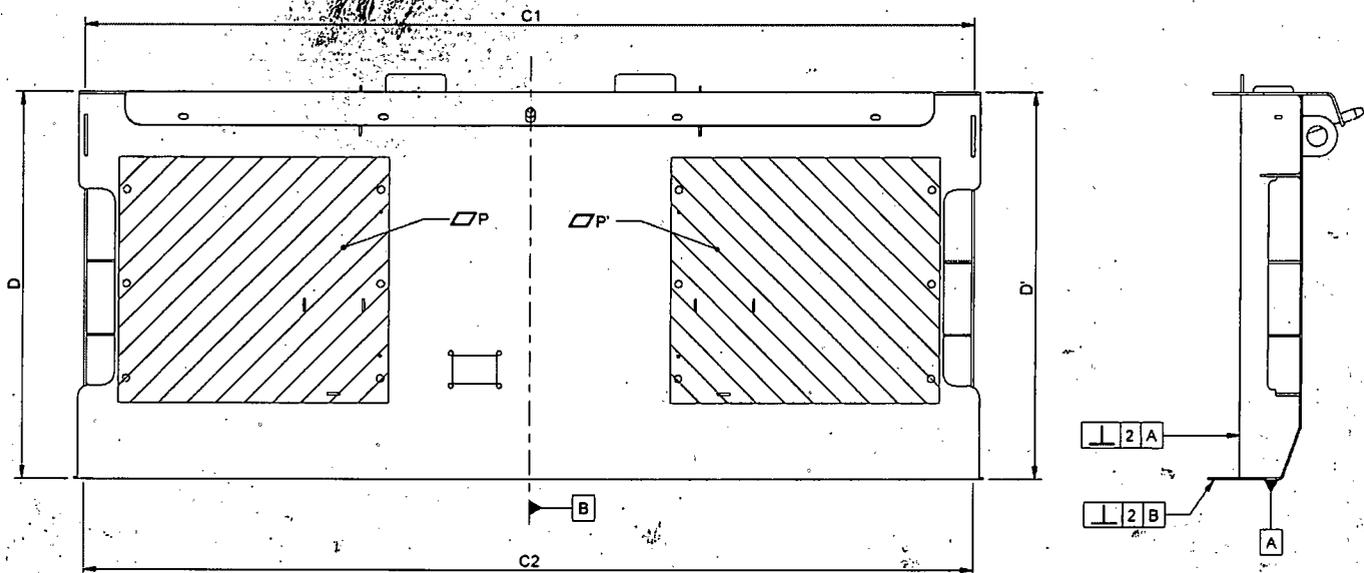
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations				
A	340	±1	340		Tape Measure	Acceptable				
B	2240	±4	2243,5			Acceptable				
D / D'	250	±1	250.5	250.5		Acceptable				
E	808	±2	807			Acceptable				
F1 / F1'	580	±1	581	581		Acceptable				
F2 / F2'			581	581		Acceptable				
G / G'	258	±1	259	258		Acceptable				
H / H'	1019	±2	1020	1020		Acceptable				
QC Inspector:	LEON	Sign:			Date:	2024/02/06				

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations							
O: Planeity of global assembly	4 mm	Ruler	Passed							
P / P': Planeity	2 mm	Ruler	Passed							
Q: Planeity Surface of Supports	4 mm	Ruler	Passed							
R: Planeity Coupler Support	2 mm	Ruler	Passed							
S: Perpendicularity coupler	1mm	Square	Passed							
QC Inspector:	LEON	Sign:			Date:	2024/02/06				

Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	BEVAN DAVENHILL	Assembly Date:	2024/02/06		
Sign:		Wire Batch No.:	2202152		



Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	LEON	Sign:		Date:	2024/02/09

Dimensional Control

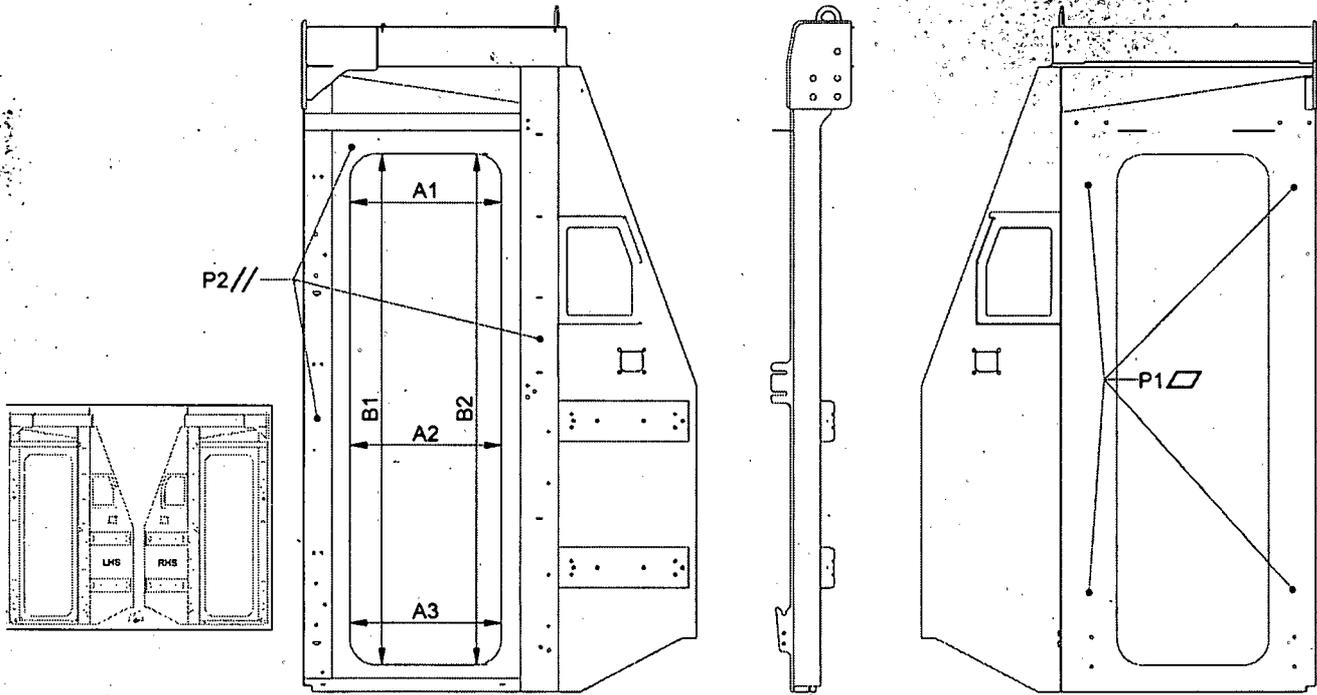
Rep	Theoretical Dim	Tolerf	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2214	2212	Tape Measure	Acceptable
D / D'	956	± 2	955	955		Acceptable
QC Inspector:	LEON		Sign:		Date:	2024/02/09

Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planarity, P / P'	2 mm		Passes		Ruler	Acceptable
Perpendicularity	2	A	Passes		Set Square	Acceptable
	2	B	Passes		Set Square	Acceptable
QC Inspector:	LEON		Sign:		Date:	2024/02/09

Cabin LHS/RHS Side Assembly: GN002838/GN002837

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	<i>Xander</i>	Assembly Date:	2024/02/02		
Sign:	<i>[Signature]</i>	Wire Batch No.	2202165		



Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/10

Dimensional Control

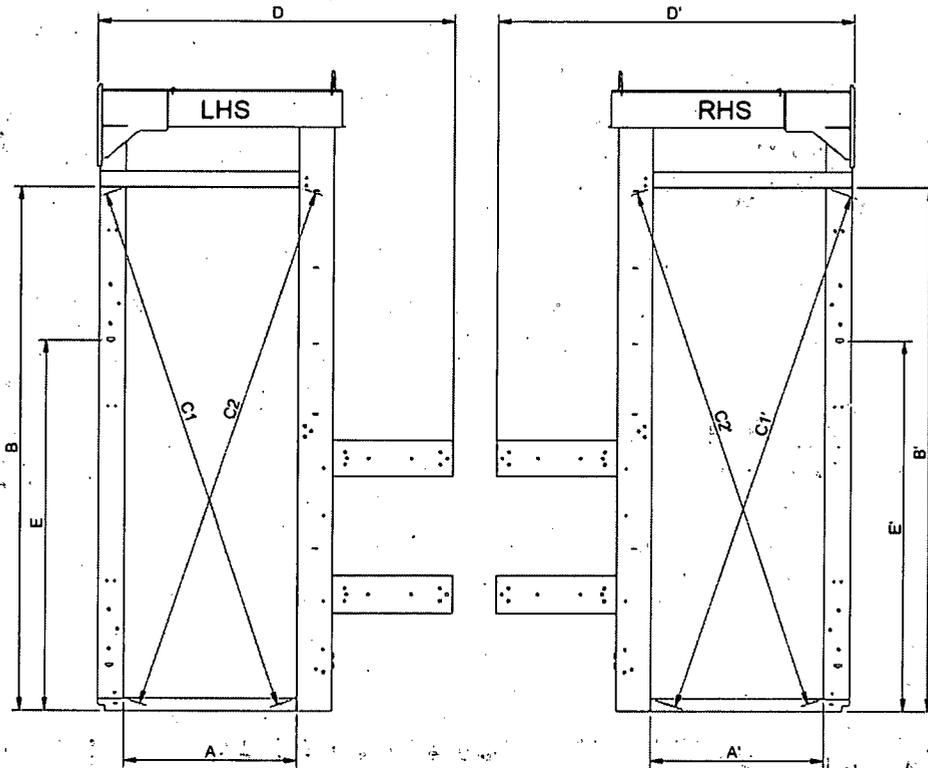
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	558	558	Tape Measure	<i>Acceptable</i>
A2			559	559		<i>Acceptable</i>
A3			559	559		<i>Acceptable</i>
B1	1900	± 2	1898	1898		<i>Acceptable</i>
B2			1898	1898		<i>Acceptable</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/10	

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4-mm	Ruler	<i>Acceptable</i>
P2 : Planeity	2 mm	Ruler	<i>Acceptable</i>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>
Date:	2024/02/10		

Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	No
Operator:	Glenn	Assembly Date:	20 <u>24</u> / <u>01</u> / <u>30</u>	
Sign:	<i>Glenn</i>	Wire Batch No.:	2202152	



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	No
QC Inspector:	Loran	Sign:	<i>L</i>	Date: 20 <u>24</u> / <u>02</u> / <u>06</u>

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	695	696	Tape Measure	Accepted
B	2086	+1/-3	2086	2086		Accepted
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2152	2152		Accepted
C1 - C2			2151	2152		Accepted
D	1438	+2/-3	1439	1439		Accepted
E			1484	1483	Accepted	
QC Inspector:		Loran	Sign:		<i>L</i>	Date: 20 <u>24</u> / <u>02</u> / <u>06</u>

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations	
P1 : planeity of 2 edges	4 mm	Pass	Accepted	
QC Inspector:		Loran	Sign: <i>L</i> Date: 20 <u>24</u> / <u>02</u> / <u>06</u>	

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

Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>Xander</i>	Assembly Date:	2024/01/31			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202165			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

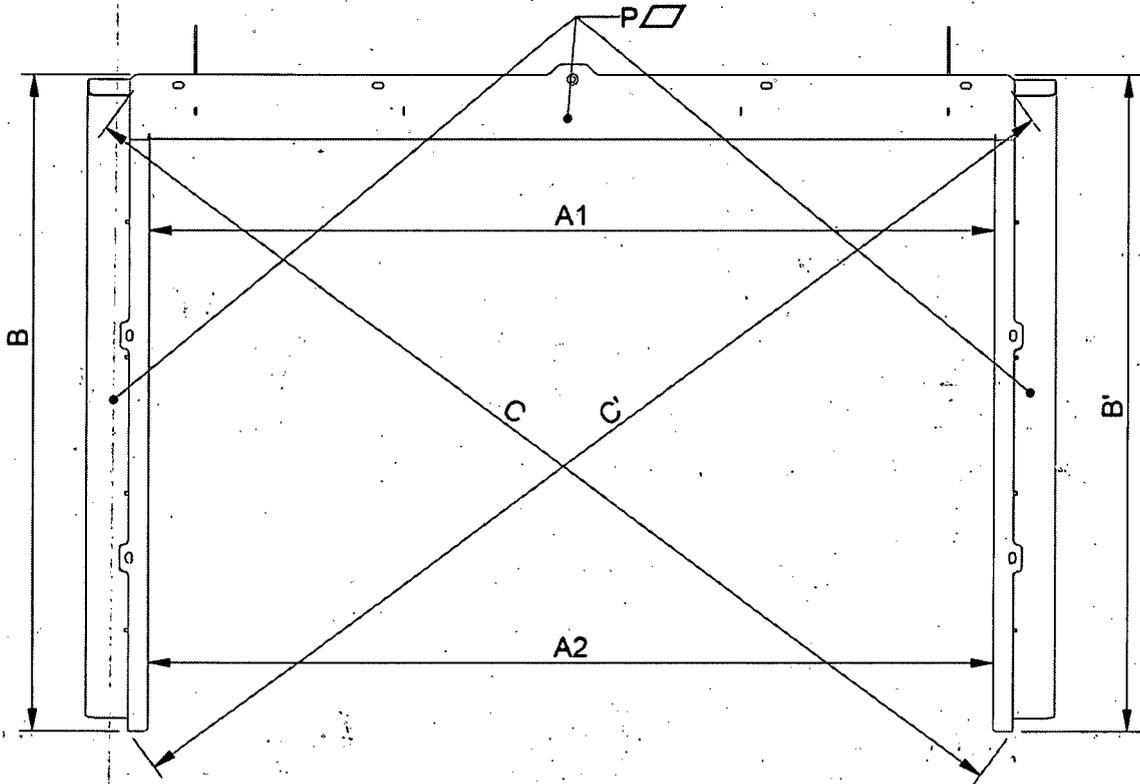
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>Glenn</i>	Assembly Date:	2024/01/29			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>Glenn</i>	Assembly Date:	2024/01/29			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Ramelo Galian</i>	Assembly Date:	2024/02/02			
Sign:	<i>[Signature]</i>	Wire Batch No.:	220210S2			



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Rudley</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/02	

Dimensional Control

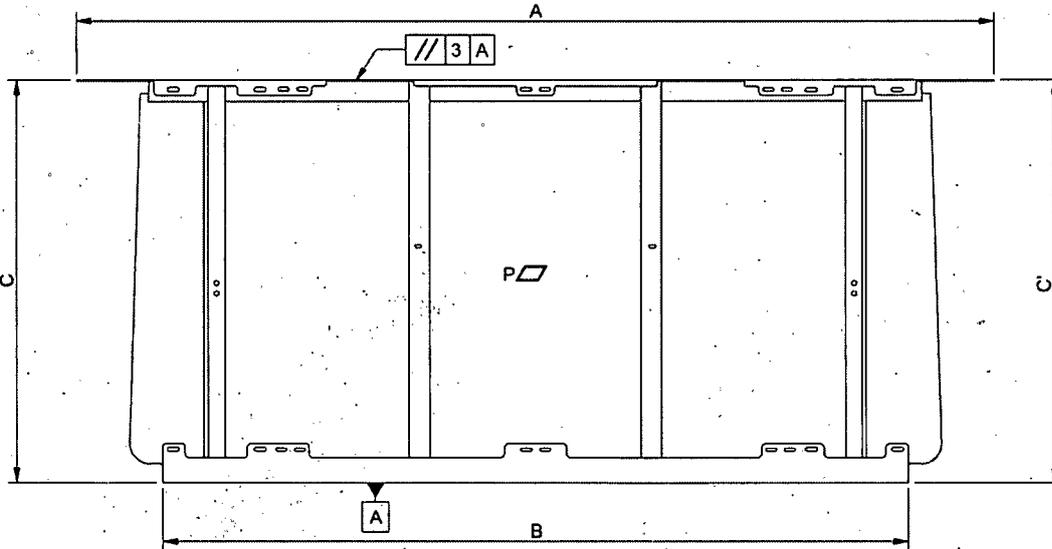
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	1910	± 2	1912		Tape Measure	<i>Acceptable</i>
A2	1910		1911			
B	1475	± 1	1475	1475		
C	Diagonals C - C' ≤ 3		2479	2478		
QC Inspector:			Sign:			Date: 20__/__/__

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P : Planeity	4 mm	<i>Passed</i>	Ruler
QC Inspector:	<i>Rudley</i>	Sign:	<i>[Signature]</i>
		Date:	2024/02/02

Cabin Roof Assembly: GN002839

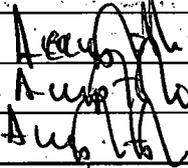
Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	DYLAN DAVIDS	Assembly Date:	2024/02/10			
Sign:		Wire Batch No.:	107238201			



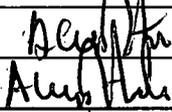
Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Leon	Sign:		Date:	2024/02/10	

Dimensional Control

Rep	Toler.	Dimension measured		Measuring Equipment	Observations	
A	+5/-0	2216		Tape Measure	 Accepted Accepted Accepted	
B	± 4	1800				
C	+2/-3	976	975			
QC Inspector:	Leon	Sign:		Date:	2024/02/10	

Geometrical Control

Nature of Checks		Dimension Measured	Measuring Equipment	Observations		
Planeity P	6 mm	Pass	Ruler	 Accepted Accepted		
//	3 A	Pass	Set Square			
QC Inspector:	Leon	Sign:		Date:	2024/02/10	

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm					
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm					
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm					
RCS 355	20 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm					
RCS 355	30 mm					

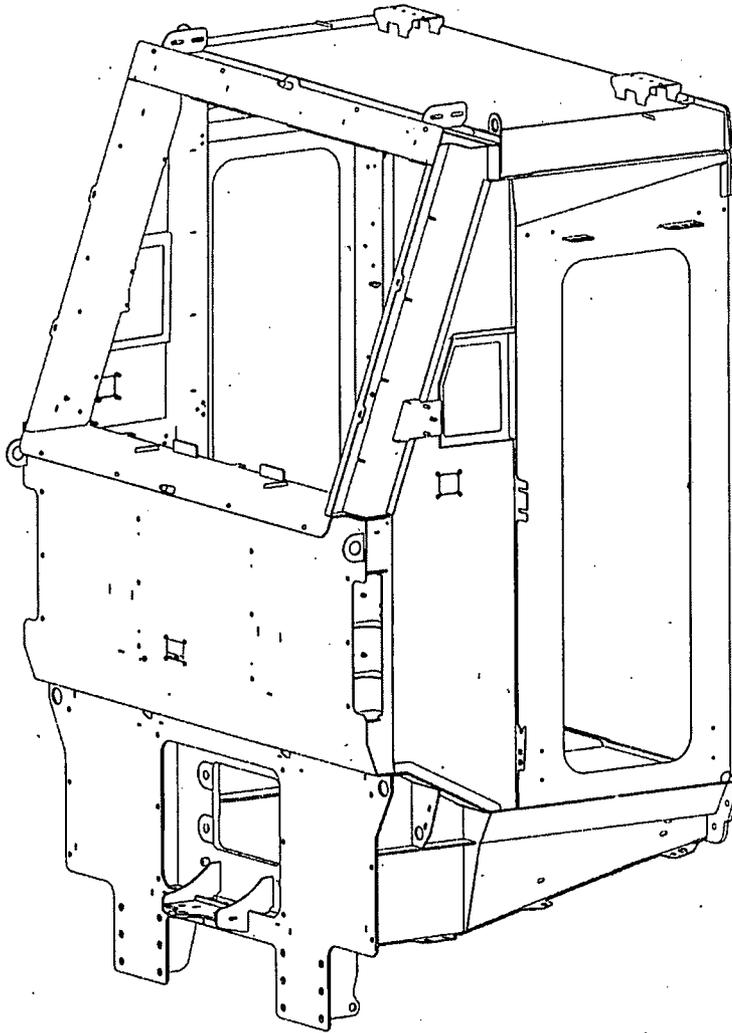
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm					
RCS 450	6 mm					
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

GLOBAL

MANUFACTURING
SOLUTIONS



CABIN STRUCTURE QUALITY CARD

CAB No.: CAB439__

WEIGHT: 1488 Kg