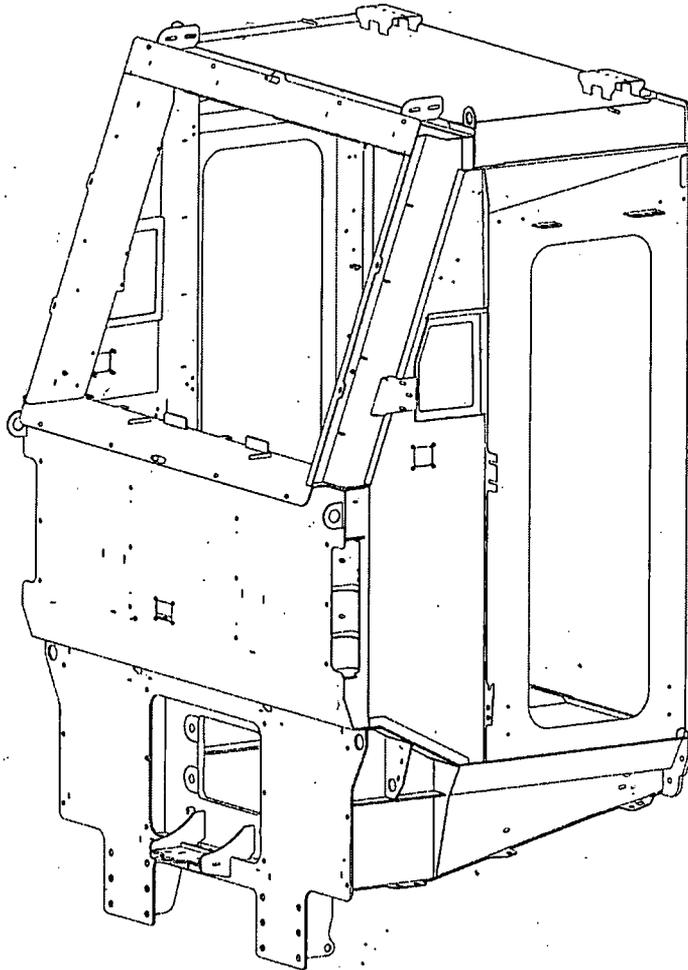


# GLOBAL

MANUFACTURING  
SOLUTIONS



## CABIN STRUCTURE QUALITY CARD

CAB No.: CAB446 \_

WEIGHT: 1491 Kg

## RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	01/02/24	178247 104825 01	LP49402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	14/02/24	178620 104640 01	F205212	
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegasus	28/02/24	178488 104640 01	P200091	
RCS 355	20 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegasus	12/02/24			
RCS 355	30 mm					

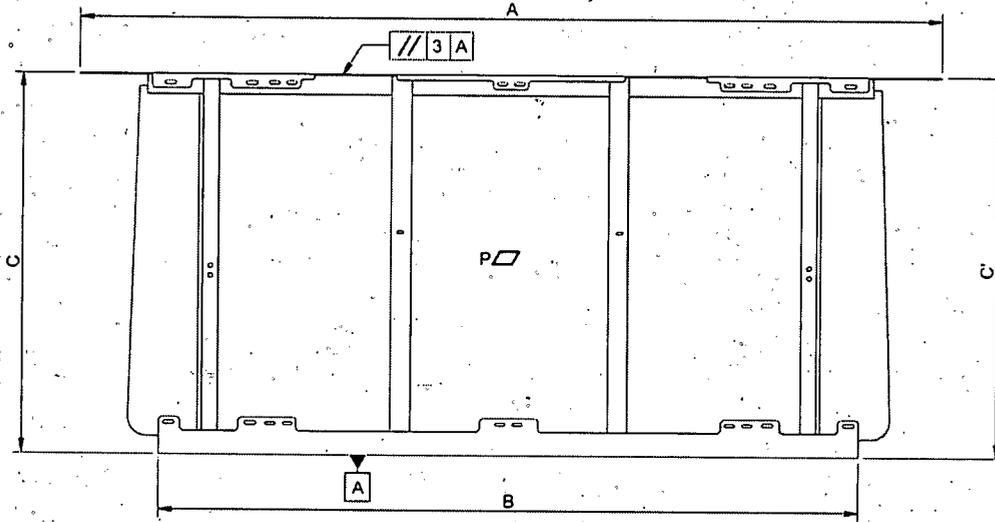
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	08/02/24	178489 104640 01	VHL 35578	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	14/02/24	178815 104640 01	F207905 VHL 28402	
RCS 450	6 mm					
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	22/11/23	175919 102200 01	FV07906 VHSS8432	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

## Cabin Roof Assembly: GN002839

Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<b>DYLAN DAVIDS</b>	Assembly Date:	2024/02/23			
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:	<b>Leow</b>	Sign:		Date:	20__/__/__	

### Dimensional Control

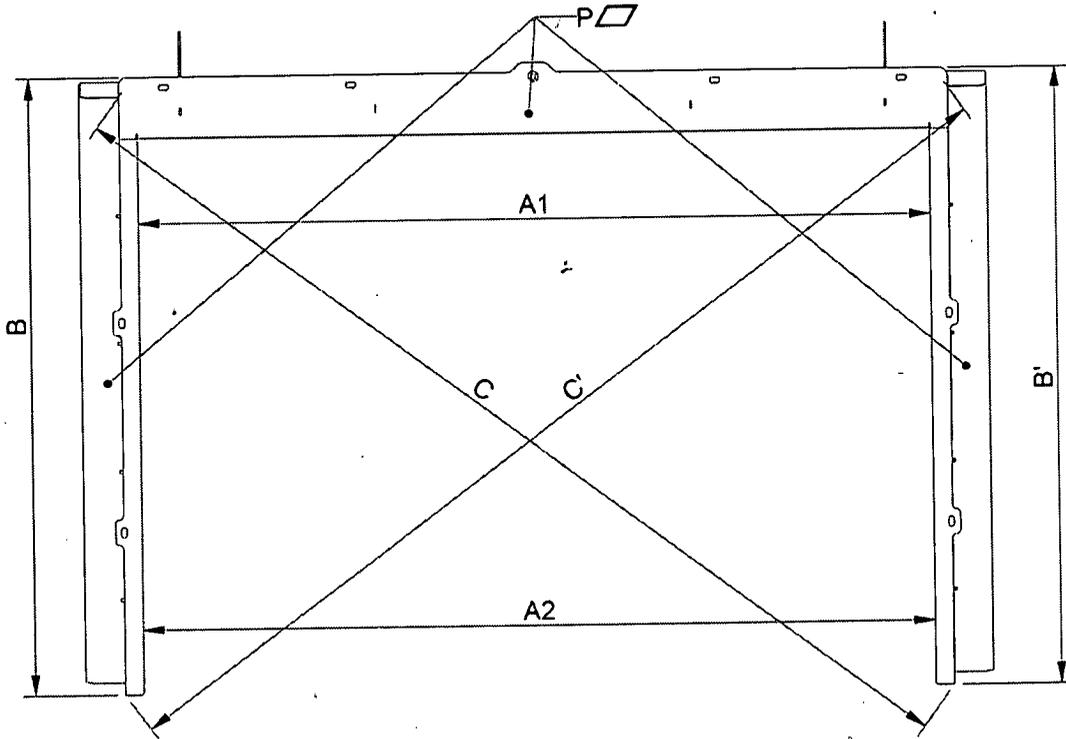
Rep.	Toler.	Dimension measured		Measuring Equipment	Observations
A	2216	+5/-0	<b>2216</b>	Tape Measure	<b>Acceptable</b>
B	1800	± 4	<b>1800</b>		<b>Acceptable</b>
C	976	+2/-3	<b>978</b> <b>977</b>		<b>Acceptable</b>
QC Inspector:	<b>Leow</b>	Sign:		Date:	<b>2024/02/23</b>

### Geometrical Control

Nature of Checks		Dimension Measured	Measuring Equipment	Observations	
Planarity P	6 mm	<b>Pass</b>	Ruler	<b>Acceptable</b>	
//	3 A	<b>Pass</b>	Set Square	<b>Acceptable</b>	
QC Inspector:	<b>Leow</b>	Sign:		Date:	<b>2024/02/23</b>

## Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	Rambelo Garcia	Assembly Date:	2024/02/23	
Sign:		Wire Batch No.:	2202-152	



### 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:	Leow	Sign:		Date: 2024/02/23

### Dimensional Control

Rep	Theoretical Dim\}	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	1910	± 2	1911		Tape Measure	Accepted
A2	1910		1910			Accepted
B	1475	± 1	1474	1474		Accepted
C	Diagonals  C - C'  ≤ 3		2474	2476		Accepted
QC Inspector:	Leow		Sign:		Date: 2024/02/23	

### Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations	
P: Planeity	4 mm	Pass	Ruler	Accepted	
QC Inspector:	Leow		Sign:		Date: 2024/02/23

**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>Kander</i>	Assembly Date:	2024/02/14			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

**Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907**

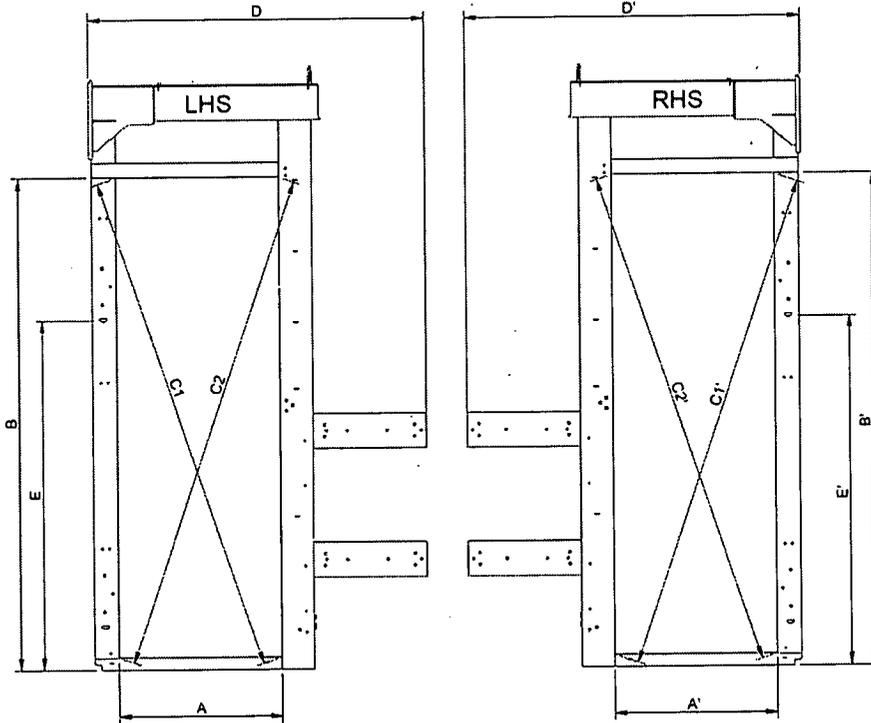
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>Glenn</i>	Assembly Date:	2024/02/14			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

**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:	2024/02/14			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

## Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	No
Operator:	<b>Glenn</b>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>19</u>	
Sign:		Wire Batch No.:	2202152	



### 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:	<b>LEON</b>	Sign:	<i>(Signature)</i>	Date:	20 <u>24</u> / <u>02</u> / <u>19</u>

### Dimensional Control

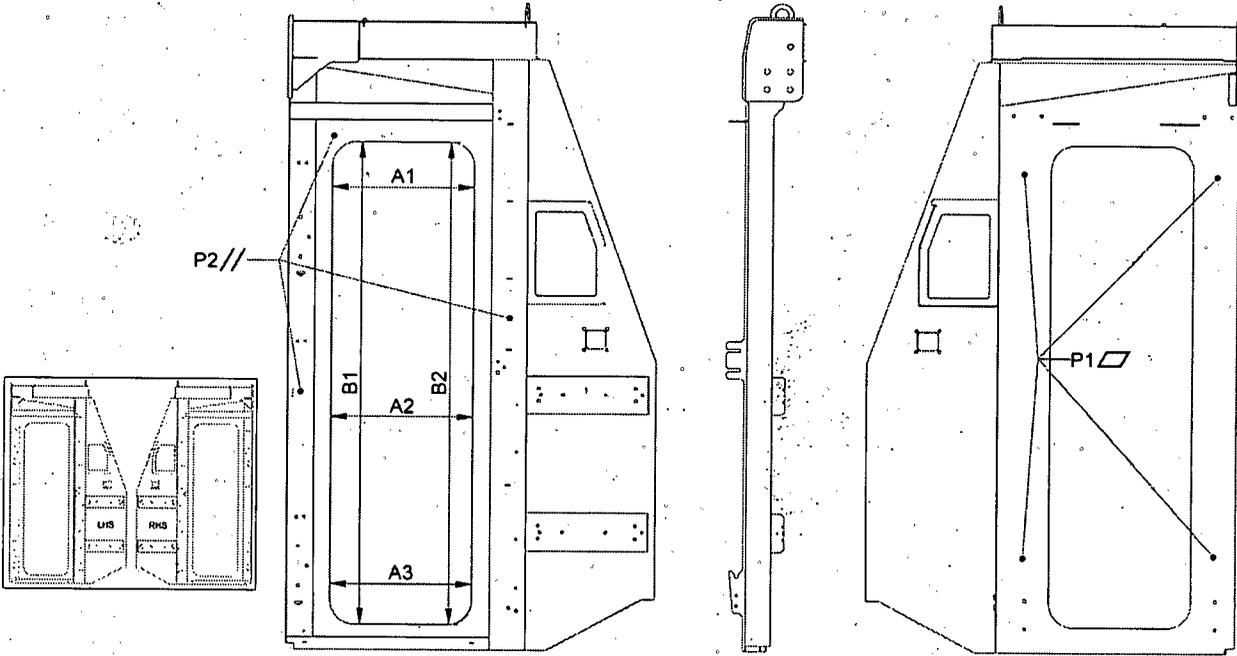
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A	695	± 2	696	696	Tape Measure	Acceptable	
B	2086	+1/-3	2087	2087		Acceptable	
C1 / C2	Difference of diagonals $ C1 - C2  \leq 3$		2155	2154		Acceptable	
C1 - C2			2155	2152		Acceptable	
D	1438	+2/-3	1436	1436		Acceptable	
E							
QC Inspector:		<b>LEON</b>	Sign:		<i>(Signature)</i>	Date:	20 <u>24</u> / <u>02</u> / <u>19</u>

### Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	<i>(Signature)</i>	Ruler
QC Inspector:		<b>LEON</b>	Sign:
		<i>(Signature)</i>	Date:
			20 <u>24</u> / <u>02</u> / <u>19</u>

## 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:	2024/02/19		
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152		



### Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>Leou</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/23

### Dimensional Control

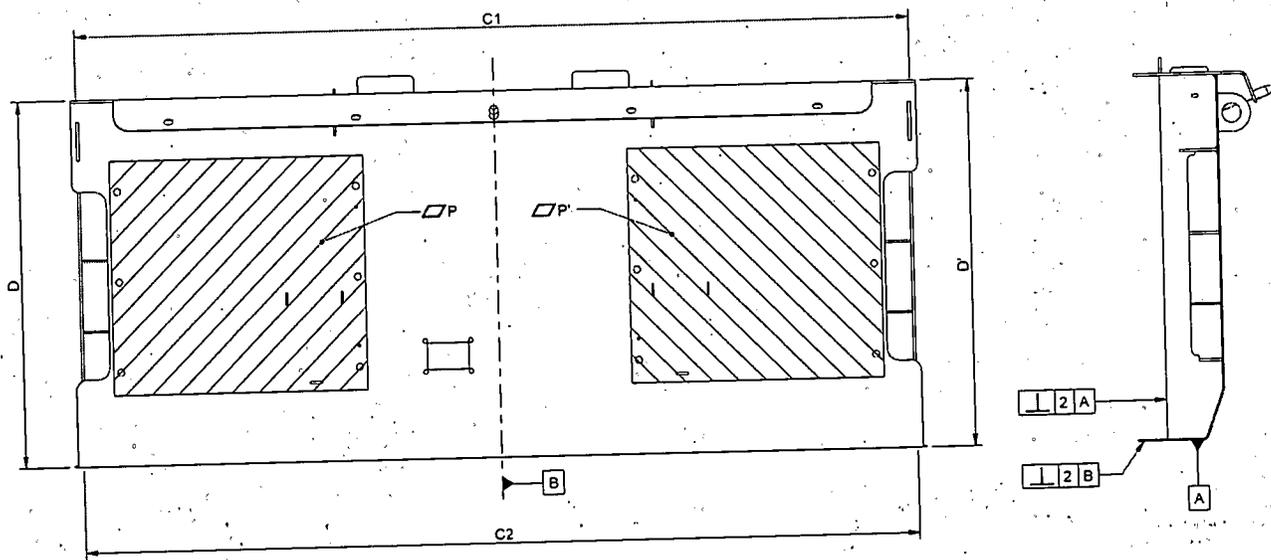
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations	
A1	560	± 2	558	557	Tape Measure	<i>[Signature]</i>	
A2			559	558		<i>[Signature]</i>	
A3			560	559		<i>[Signature]</i>	
B1	1900	± 2	1898	1898		<i>[Signature]</i>	
B2			1897	1898		<i>[Signature]</i>	
QC Inspector:			Sign:				Date:

### Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations				
P1 : Planicity	4 mm	Ruler	<i>[Signature]</i>				
P2 : Planicity	2 mm	Ruler	<i>[Signature]</i>				
QC Inspector:			Sign:			Date:	2024/02/23

## Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Raimundo G. Cinan</i>	Assembly Date:	2024/02/23			
Sign:	<i>[Signature]</i>	Wire Batch No.:	9202152			



### Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Low</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/23	

### Dimensional Control

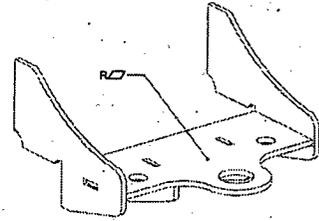
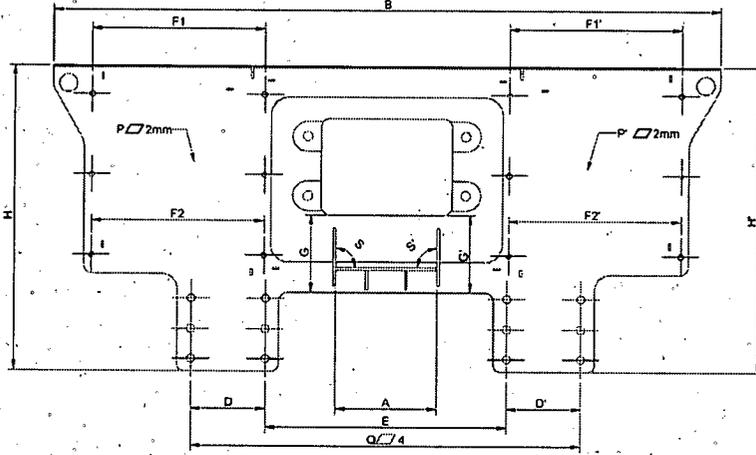
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	<i>2214</i>	<i>2213</i>	Tape Measure	<i>Acceptable</i>
D / D'	956	± 2	<i>955</i>	<i>956</i>		<i>Acceptable</i>
QC Inspector:	<i>Low</i>		Sign:	<i>[Signature]</i>	Date:	2024/02/23

### Geometrical Control

Nature of Checks		Dimension Measured		Measuring Equipment	Observations	
Planeity P / P'		2 mm	<i>Passes</i>	Ruler	<i>Acceptable</i>	
Perpendicularity		2 A	<i>Passes</i>	Set Square	<i>Acceptable</i>	
		2 B	<i>Passes</i>	Set Square	<i>Acceptable</i>	
QC Inspector:	<i>Low</i>		Sign:	<i>[Signature]</i>	Date:	2024/02/23

## Cabin Front Headstock Assembly: GN002841

Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	<i>K. Booth</i>	Assembly Date:	2024/02/23		
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202/SZ		



### Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/20

### Dimensional Control

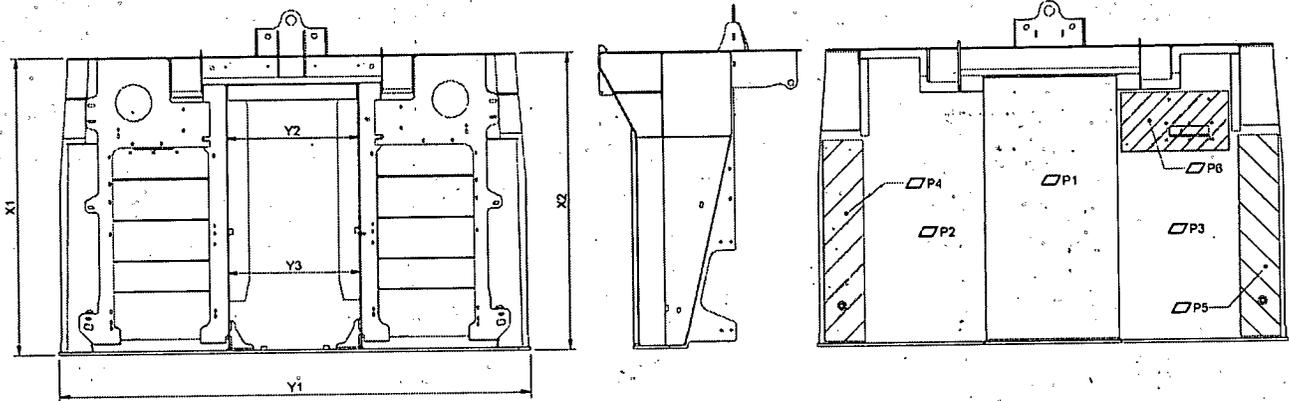
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	±1	339		Tape Measure	Acceptable
B	2240	±4	2244			Acceptable
D / D'	250	±1	250.5	250.5		Acceptable
E	808	±2	807			Acceptable
F1 / F1'	580	±1	581	581		Acceptable
F2 / F2'			581	581		Acceptable
G / G'	258	±1	258	258		Acceptable
H / H'	1019	±2	1020	1020		Acceptable
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/20	

### Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
O: Planeity of global assembly	4 mm	Ruler	Acceptable
P / P': Planeity	2 mm	Ruler	Acceptable
Q: Planeity Surface of Supports	4 mm	Ruler	Acceptable
R: Planeity Coupler Support	2 mm	Ruler	Acceptable
S: Perpendicularity coupler	1mm	Square	Acceptable
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>
			Date: 2024/02/20

## Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	20 <u>24</u> / <u>02</u> / <u>21</u>	
Sign:	<i>[Signature]</i>	Wire Batch No.:	22 02152	



### Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date: 20 <u>24</u> / <u>02</u> / <u>21</u>

### Dimensional Control

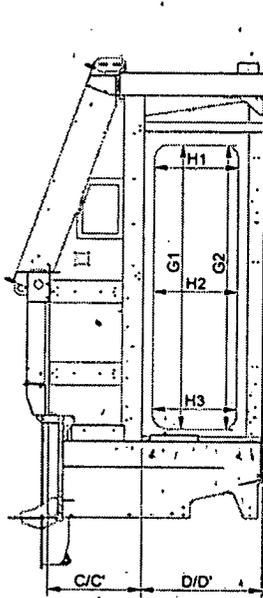
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1488	1486	Tape Measure	<i>[Signature]</i>
Y 1	2354	± 3	2353			<i>[Signature]</i>
Y2 / Y3	666	± 1	667	667		<i>[Signature]</i>
QC Inspector:		<i>LEON</i>	Sign:		<i>[Signature]</i>	Date: 20 <u>24</u> / <u>02</u> / <u>21</u>

### Geometrical Control

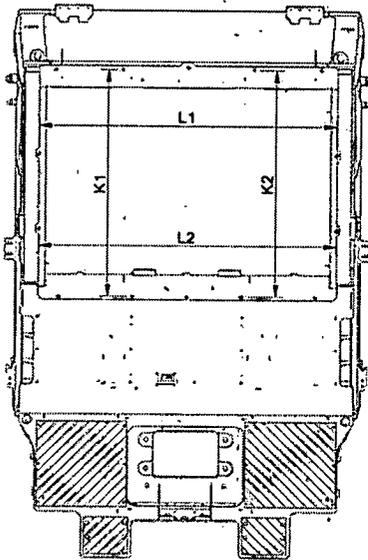
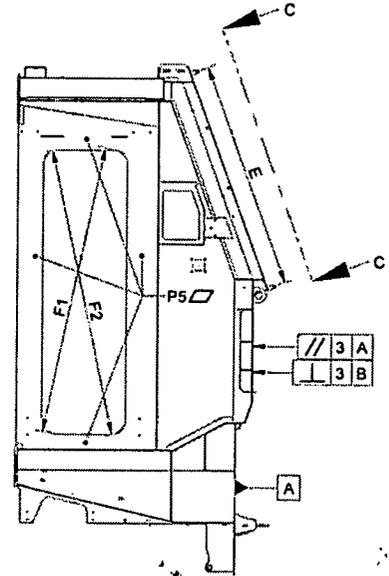
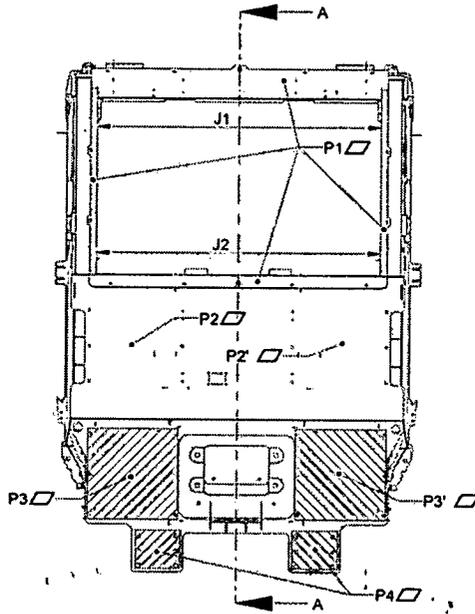
Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Ruler	<i>[Signature]</i>
P2 / P3 : Planeity	4 mm	Ruler	<i>[Signature]</i>
P4 / P5 : Planeity	2 mm	Ruler	<i>[Signature]</i>
P6 : Planeity	2 mm	Ruler	<i>[Signature]</i>
QC Inspector:		<i>LEON</i>	Date: 20 <u>24</u> / <u>02</u> / <u>21</u>

# Cabin Structure Assembly: GN002834

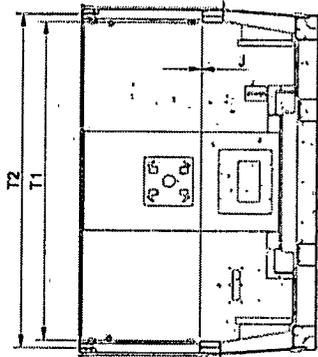
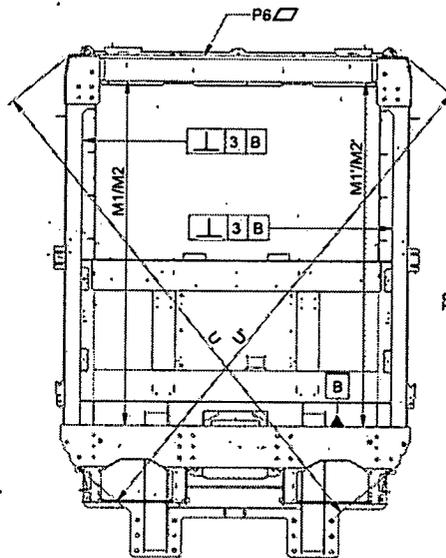
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	<i>Dumina</i>	Assembly Date:	20 <i>24</i> / <i>02</i> / <i>25</i>		
Sign:	<i>[Signature]</i>	Wire Batch No.:	<i>2202152</i>		



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  No

QC Inspector: LEW Sign:  Date: 2024/02/28

**Dimensional Control**

Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations
C / C'	625	± 2	626	625	Acceptable
D / D'	813	± 2,5	811	812	Acceptable
E	1531.5	± 3	1530		Acceptable
G1 / G'1	Height 1900	+1	1898	1897	Acceptable
G2 / G'2		-3	1899	1898	Acceptable
H1 / H'1	Width 560	+1	557	558	Acceptable
H2 / H'2		-3	558	558	Acceptable
H3 / H'3			558	559	Acceptable
F1 / F'1	Diagonals 1939		1936	1937	Acceptable
F2 / F'2			1937	1935	Acceptable
Difference	F1-F2 / F'1-F'2	≤ 4	1	2	Acceptable
J	Gap of Doors	± 1,5	1		Acceptable
K1 / K2	1515	± 3	1515	1513	Acceptable
L1 / L2	1996	± 3	1998	1996	Acceptable
M1 / M'1	2306	± 3	2468	2468	Acceptable
M2 / M'2			2478	2478	Acceptable
T1 / T'1	2130 Top/Bottom	± 3	2127	2127	Acceptable
T2 / T'2	2230 Top/Bottom		2230	2230	Acceptable
Difference	U - U' (3522)	≤ 4mm	3523	3520	Acceptable

QC Inspector: LEW Sign:  Date: 2024/02/28

**Geometrical Control**

Nature of checks				Toler.	LHS / Dimension Measured / RHS	Observations
P1 / P'1	Planeity			2 mm	Pass	Acceptable
P2 / P'2	Planeity			2 mm	Pass	Acceptable
P3 / P'3	Planeity			4 mm	Pass	Acceptable
P4 / P'4	Planeity			4 mm	Pass	Acceptable
P5 / P'5	Planeity			4 mm		Acceptable
P6 Roof	Planeity			6 With 2m Ruler	Pass	Acceptable
Shield	//	3	A	3	Pass	Acceptable
Shield	⊥	3	A	3	Pass	Acceptable
Door Post	⊥	3	A	Front	Pass	Acceptable
				Back	Pass	Acceptable

QC Inspector: LEW Sign:  Date: 2024/02/28

**Cabin Bracket Assembly: GN002833**

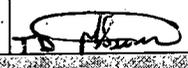
Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>Damien</i>	Assembly Date:	2024/02/28			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

**Cabin Rivnut Assembly: GN002832**

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>JEMMYN</i>	Assembly Date:	2024/03/19			
Sign:	<i>[Signature]</i>	Wire Batch No.:				

## Shot Blasting

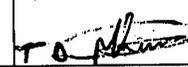
### Shot Blasting Pre-Inspection

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:	DAVID		Sign:		
Date:	2024/03/19				

### Record of Shot Blasting

Operator:		Date:	2024/03/19
Start Time:	07 H 13	End Time:	11 H 05
Temperature (≥ 15°):	20-04°C	Humidity (≤ 75%):	67-02%

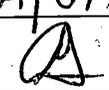
### Shot Blasting Self Inspection

Interior of Cabin: Sa 1 - Light Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID		Sign:		
Date:	2024/03/19				

### Shot Blasting Cleaning

Cabin free of all sand.	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID		Sign:		
Date:	2024/03/19				

### Shot Blasting Control

Temperature ≥ 15°:	21-08°C	Humidity ≤ 75%:	69-06%
Internal Roughness 3.2 ≤ Ra ≤ 12.5	<del>0.73</del> 10.973	External Roughness 3.2 ≤ Ra ≤ 12.5	09/07.776
QC Inspector:	Low	Sign:	
Date:	19/03/24		

Record of Priming			
Start Time:	19:00	End Time:	20:00
Temperature ≥ 15°:	25°	Humidity ≤ 75%:	65%
Paint Batch No.:	7978267	Paint Expiry Date:	06/25
Hardener Batch No.:	7331119	Hardener Expiry Date:	01-11-24
Desolvation Start Time:	20:00	Desolvation End Time:	20:15
Stoving Start Time:	20:15	Stoving End Time:	21:15
Stoving Temp:	60°		
Operator:	NTUTUKHO	Sign:	
Date:	2024/03/19		NTUTUKHO

Priming Control									
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front			
1: 64.3	5: 57.1	1: 56.0	5: 63.8	1: 77.0	5: 54.6	1: 60.4	5: 55.4		
2: 51.5	6: 79.9	2: 75.2	6: 59.2	2: 81.4	6: 72.8	2: 63.9	6: 78.3		
3: 49.9	7: 78.7	3: 50.1	7: 52.6	3: 73.2	7: 67.5	3: 56.7	7: 74.0		
4: 45.7	8: 84.8	4: 62.6	8: 76.8	4: 53.3	8: 58.1	4: 50.7	8: 61.5		
Min:	45.7	Min:	50.1	Min:	53.3	Min:	50.7		
Max:	84.8	Max:	76.8	Max:	81.4	Max:	78.3		
Average:	63.9	Average:	62.0	Average:	67.2	Average:	62.6		
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside			
1: 81.1	5: 64.8	1: 73.3	5: 64.9	1: 45.3	5: 64.8	1: 62.0	5: 83.7		
2: 68.7	6: 71.1	2: 58.1	6: 73.4	2: 64.4	6: 75.0	2: 71.9	6: 81.1		
3: 42.7	7: 55.8	3: 44.9	7: 77.1	3: 58.3	7: 69.3	3: 79.3	7: 72.2		
4: 58.7	8: 49.9	4: 68.5	8: 83.2	4: 71.4	8: 60.9	4: 85.6	8: 78.6		
Min:	42.7	Min:	44.9	Min:	45.3	Min:	63.0		
Max:	81.1	Max:	83.2	Max:	75.0	Max:	85.5		
Average:	61.5	Average:	67.9	Average:	63.6	Average:	76.9		
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS			
1: 63.2	5: 41.9	1: 78.5	5: 63.0	1: 84.3	5: 72.3	1: 65.3	5: 68.9		
2: 76.6	6: 65.5	2: 75.8	6: 72.3	2: 78.7	6: 65.5	2: 79.2	6: 73.6		
3: 51.8	7: 79.8	3: 63.3	7: 59.6	3: 69.2	7: 79.6	3: 71.4	7: 65.8		
4: 47.1	8: 44.3	4: 77.8	8: 72.6	4: 81.9	8: 72.1	4: 83.5	8: 81.0		
Min:	41.9	Min:	59.6	Min:	65.5	Min:	65.3		
Max:	79.8	Max:	78.5	Max:	84.3	Max:	83.5		
Average:	58.7	Average:	70.3	Average:	75.4	Average:	73.5		
Primer has been inspected and is free of defects				Confirmed		Yes <input checked="" type="checkbox"/>		No <input type="checkbox"/>	
QC Inspector:	ZOMLE			Sign:					
Date:	20 Mar 2024								

**Record of Painting NCSS3010 R90B**

Start Time:	1:00	End Time:	2:00
Temperature ≥ 15°:	29°C	Humidity ≤ 75%:	42%
Paint Batch No.:	8156903	Paint Expiry Date:	23-01-25
Hardener Batch No.:	7502115121	Hardener Expiry Date:	12-24
Desolvation Start Time:	2:00	Desolvation End Time:	2:15
Stoving Start Time:	2:15	Stoving End Time:	3:15
Stoving Temp:	60°C		
Operator:	Ntuthuko	Sign:	Ntuthuko
Date:	2024/03/20		

**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: 136.9	5: 100	1: 74	5: 126.9		
2: 108	6: 113	2: 130.8	6: 96.8		
3: 79.8	7: 98	3: 102.9	7: 113.4		
4: 104	8: 84.6	4: 116.7	8: 102.2		
Min: 79.8		Min: 74			
Max: 136.9		Max: 130.8			
Average: 103		Average: 107			
Painting NCSS3010 R90B has been inspected and is free of defects					
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	46.8
QC Inspector:		Reece		Sign: 	
Date:		2/03/24			

**Record of Painting Blue NCSS1565 B**

Start Time:	4:00	End Time:	5:00
Temperature $\geq 15^{\circ}$ :	28 $^{\circ}$ C	Humidity $\leq 75\%$ :	46%
Paint Batch No.:	8176318	Paint Expiry Date:	02-02-2025
Hardener Batch No.:	7802115121	Hardener Expiry Date:	12/24
Desolvation Start Time:	5:00	Desolvation End Time:	5:15
Stoving Start Time:	5:15	Stoving End Time:	6:15
Stoving Temp:	60 $^{\circ}$ C		
Operator:	Ntuthuko	Sign:	Ntuthuko
Date:	2024/03/20		

**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: 127.6	5: 104.9	1: 116.8	5: 116.8								
2: 102.6	6: 131.8	2: 102.4	6: 112.3								
3: 111.3	7: 104.2	3: 113.8	7: 116.8								
4: 141.8	8: 100.6	4: 103.2	8: 150.4								
Min: 100.6	Min: 102.4										
Max: 127.6	Max: 150.4										
Average: 115.6	Average: 117										
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	90.1			
QC Inspector:	Peece						Sign:	Peece			
Date:	2/03/24										

**Record of RAL 7012**

Start Time:	16:00	End Time:	18:00
Temperature ≥ 15°:	20°C	Humidity ≤ 75%:	70%
Paint Batch No.:	8156853	Paint Expiry Date:	06-02-2025
Hardener Batch No.:	7502115 121	Hardener Expiry Date:	12-24
Desolvation Start Time:	18:00	Desolvation End Time:	18:15
Stoving Start Time:	18:15	Stoving End Time:	19:15
Stoving Temp:	60°C		
Operator:	Musa	Sign:	Musa
Date:	2024/03/20		

**RAL 7012 Control**

DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 82.3	5: 90.8	1: 113.8	5: 102.3	1: 93.2	5: 103.6	1: 130.6	5: 102.9
2: 83.2	6: 116.8	2: 121.8	6: 112.6	2: 110.6	6: 87.8	2: 116.3	6: 103.6
3: 118.2	7: 140.8	3: 108.3	7: 108.9	3: 151.8	7: 99.8	3: 108.6	7: 118.4
4: 109.8	8: 84.6	4: 116.8	8: 113.6	4: 108.3	8: 86.9	4: 124.1	8: 113.6
Min: 83.2		Min: 102.3		Min: 86.9		Min: 102.9	
Max: 140.8		Max: 116.8		Max: 151.8		Max: 130.6	
Average: 112		Average: 111		Average: 100		Average: 114.8	
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 96.8	5: 102.9	1: 122.6	5: 124.8	1: 110.8	5: 107.4	1: 124.6	5: 102.6
2: 102.4	6: 113.8	2: 80.6	6: 131.8	2: 102.3	6: 99.8	2: 79.8	6: 116.8
3: 123.8	7: 116.6	3: 113.9	7: 124.3	3: 84.3	7: 90.6	3: 86.4	7: 131.8
4: 130.6	8: 108.4	4: 108.6	8: 114.8	4: 89.6	8: 127.6	4: 104.8	8: 116.8
Min: 96.8		Min: 80.6		Min: 84.6		Min: 86.4	
Max: 130.6		Max: 131.8		Max: 127.6		Max: 131.8	
Average: 112		Average: 112		Average: 101		Average: 93.9	
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 126	5: 98.6	1: 124.3	5: 104.6				
2: 113.8	6: 108.6	2: 126.8	6: 113.6				
3: 108.6	7: 124.6	3: 104.8	7: 114.9				
4: 118	8: 114.6	4: 113.6	8: 169.8				
Min: 98.6		Min: 104.6					
Max: 124.6		Max: 169.8					
Average: 111		Average: 121					

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	45.3			
QC Inspector:	Peece		Sign:	Peece	
Date:	21/03/24				

**SEALING OF CABIN**

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

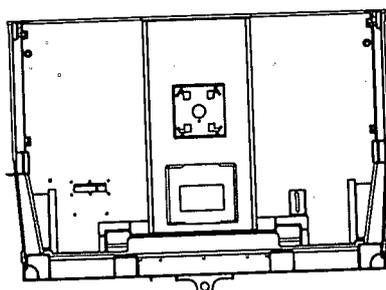
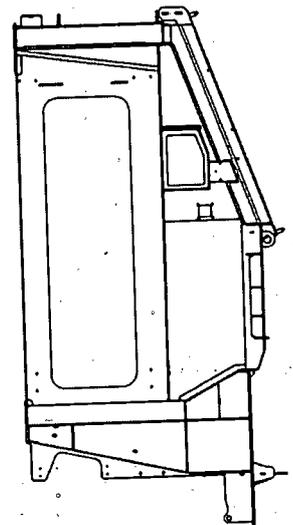
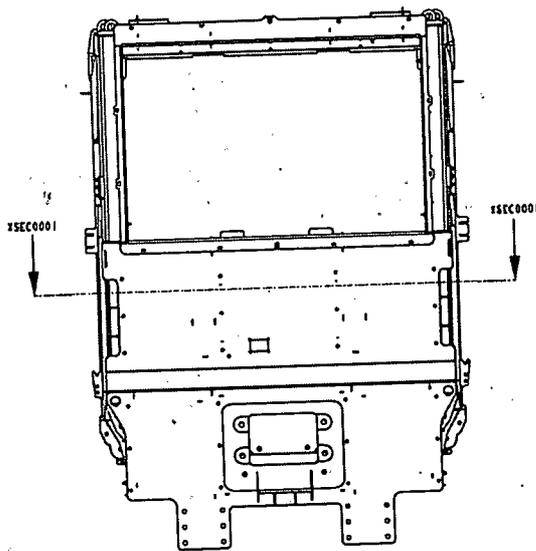
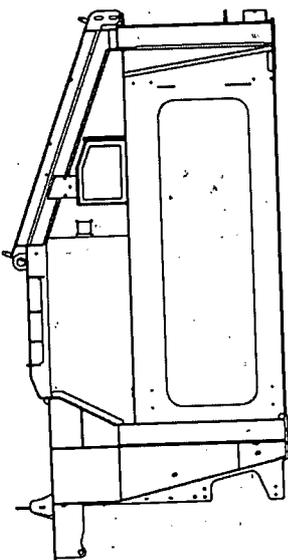
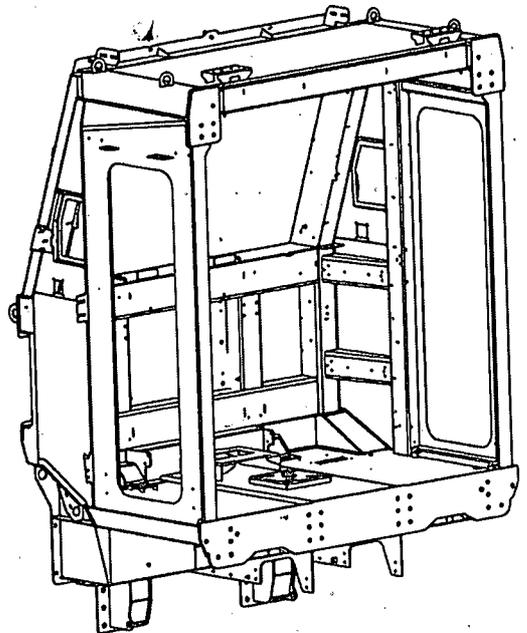
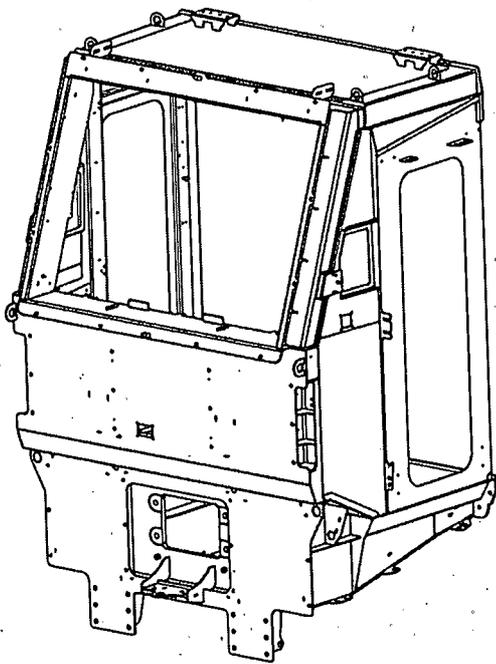
**SIGN OFF**

CLOCK No	2400	OPERATOR SIGN	Aprile	DATE	21/03/24
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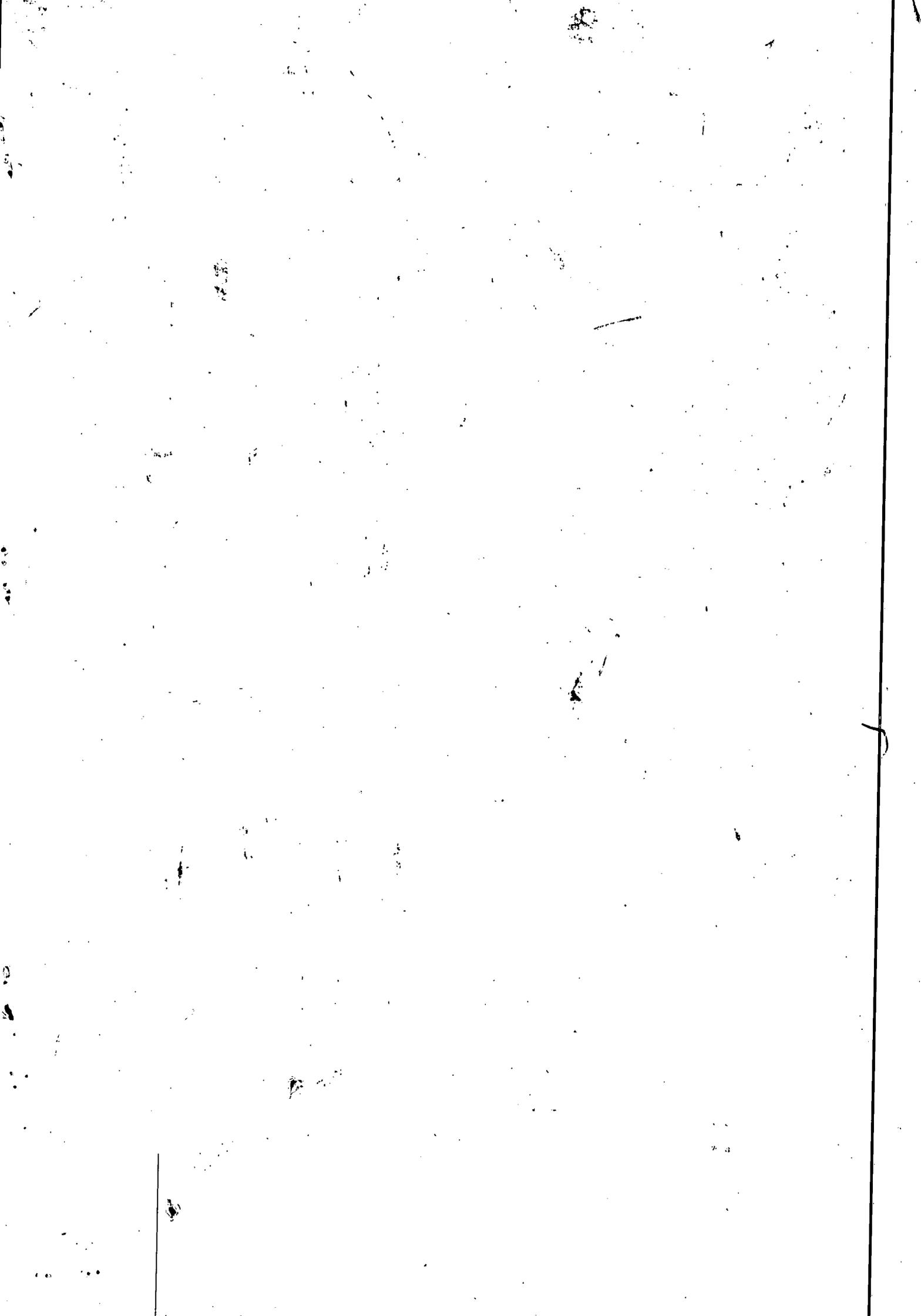


# REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)









# CABIN STRUCTURE QUALITY HOT CHECKLIST

<b>Running No.:</b>		<b>Updated By:</b>	Jonathan Chetty
<b>Frame No.:</b>	0446	<b>Checks Updated:</b>	2022/08/26

<b>Disposition Key</b>	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"> <li>JOINTS ARE CLOSED</li> <li>NO BREAKS IN THE SEALANT</li> <li>CORRECT BEAD</li> </ul>	○			
4	RIVET NUTS ARE PROPERLY CRIMPED <ul style="list-style-type: none"> <li>RIVETS ARE MARKED</li> <li>CORRECT GRIP RANGE USED.</li> </ul>	○			
5	NO MISS WELDS PRESENT AFTER SANDBLASTING	○			
6	NO VISUAL MISS WELDS (INSPECTION AFTER SEALING)	○			
7					
8					
9					
10					
11					
12					
13					
14					

<b>Quality approval for release Signature</b>	<b>CO NO.</b>	<b>DATE</b>
	2291	21/03/24