

GIBELA

PRASA PROJECT



APPLICABLE FROM TRAINSET 100+ 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	M1	M2	M3	Tc2				
<input type="checkbox"/>	DTR30225487/3	AAD0001278565	CARBODYSHELL M1 ASSEMBLY	CB1210			X				PRA.CB1210.DTR30225487/3.V25	YES

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018
			CHECKER	Nosizo Pindela	10/01/2018
			COMPILER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motama	2018/05/18
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230	APPROVER	Itumeleng Modiba	2018/07/04
			CHECKER	Nosizo Pindela	2018/07/04
			REVISED BY	Ramokone Motama	2018/07/04
3	2018/12/12	Added dimensional check points to CB1210	APPROVER	Itumeleng Modiba	2018/12/12
			CHECKER	Nosizo Pindela	2018/12/12
			REVISED BY	Ramokone Motama	2018/12/12
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	22/01/2019
			CHECKER	Nosizo Pindela	22/01/2019
			REVISED BY	Vanessa Ntuli	22/01/2019
6	13/03/2019	Added D1 and D2 on Self-Inspection	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	21/08/2019
			CHECKER	Nosizo Pindela	21/08/2019
			REVISED BY	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			REVISED BY	Bongane Masina	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISED BY	Mpho Mulaudzi	17/08/2021
25	19/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	19/02/2022
			CHECKER	Andani Muthelo	19/02/2022
			REVISED BY	Andani Muthelo	19/02/2022
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlampe Amogelang	14/04/2023
			REVISED BY	Mohlampe Amogelang	14/04/2023
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023
			CHECKER	Zwane Ntokozi	27/07/2023
			REVISED BY	Mohlampe Amogelang	27/07/2023
28	07/11/2023	Addition of welding traceability	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Andani Muthelo	07/11/2023
			REVISED BY	Ntokozi Zwane	07/11/2023

TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
TS001	M1	Poniso	08/04/24	SI.CB1210.254.V28	17

409964



CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev. 28
Date 07/11/2023

Project: PRASA
SI.CB1210.254.V28

Car: M1

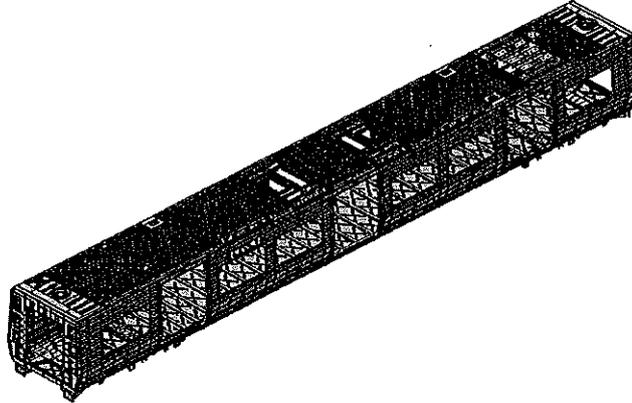
NCR:

Work station:

CB1210



Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	TC1	MI	MC	ME	MA	CS					
DTR30225487/3	X						V28		✓	[Signature]	07/11/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULAR	32803-2	15/03/25	✓	[Signature]	[Signature]
LASER TAPE	105425904	02/01/05	✓	[Signature]	[Signature]
SOM TAPE	01870100	18/11/04	✓	[Signature]	[Signature]

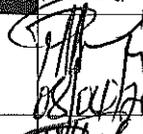
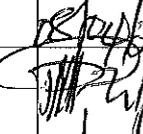
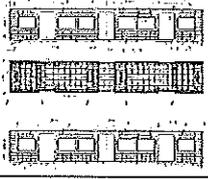
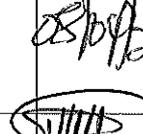
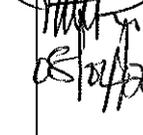
1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSI	314018-74097	MIG	✓	[Signature]	[Signature]
ER 308 L	299687-70500	TIG	✓	[Signature]	[Signature]

GIBELA RAIL TRANSPORT S.p.A. - Via V. V. 111
 IMPRESA KINOVISO
 FITTING QUALITY
 2024-03-15
 Signature

II - Self Inspection - Items to Check

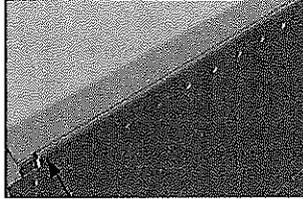
II.1 - Items to check							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls, Endframes, Roof and Underframe)	DT00000311225	✓		 08/04/2024	 08/04/2024
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		 08/04/2024	 08/04/2024
03	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓		 08/04/2024	 08/04/2024
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		 08/04/2024	 08/04/2024
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		 08/04/2024	 08/04/2024
06		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓		 08/04/2024	 08/04/2024
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.	✓		 08/04/2024	 08/04/2024

GIBELQ RAIL TRANSPORT CONSTRUCTION (PTY) LTD
 Mphahlele Khanyiso
 FITTING QUALITY
2024-03-15
 Signature

	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

Welder Traceability

Roof ring welds



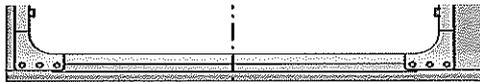
LHS	Boiler maker (Name & Sign): <u>Lawrence Joliso</u>	Welder (Name & Sign): <u>Keita K. Meeb</u>
RHS	Boiler maker (Name & Sign): <u>Poniso</u>	Welder (Name & Sign): <u>Thabang Katsi</u>

END 1

LHS	Boiler maker (Name & Sign): <u>Lawrence Joliso</u>	Welder (Name & Sign): <u>Keita K. Meeb</u>
RHS	Boiler maker (Name & Sign): <u>Poniso</u>	Welder (Name & Sign): <u>Thabang Katsi</u>

END 2

Door ring welds



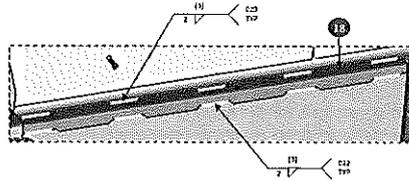
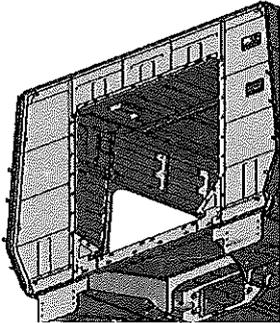
LHS	Boiler maker (Name & Sign): <u>Poniso</u>
	Welder (Name & Sign): <u>Keita K. Meeb</u>

RHS	Boiler maker (Name & Sign): <u>Poniso</u>
	Welder (Name & Sign): <u>Keita K. Meeb</u>

SIGNATURE
 2024-08-15
 Signature

	CARBODYSHELL M1 ASSEMBLY DTR30226487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

EUF Reinforcement Plates

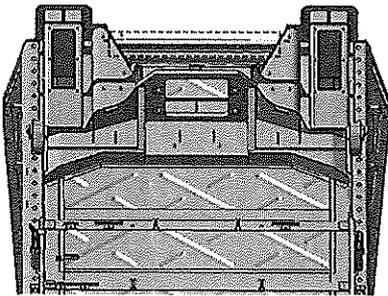


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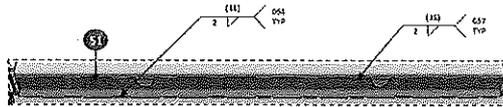
Boiler maker (Name & Sign): Lawrence Ilgou

Welder (Name & Sign): Ketu K. K.

END 2



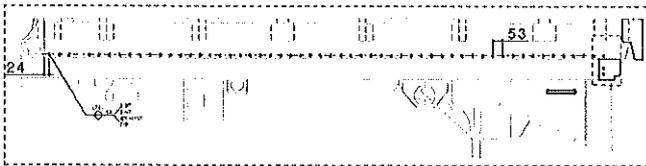
Underneath the CAR



END 2

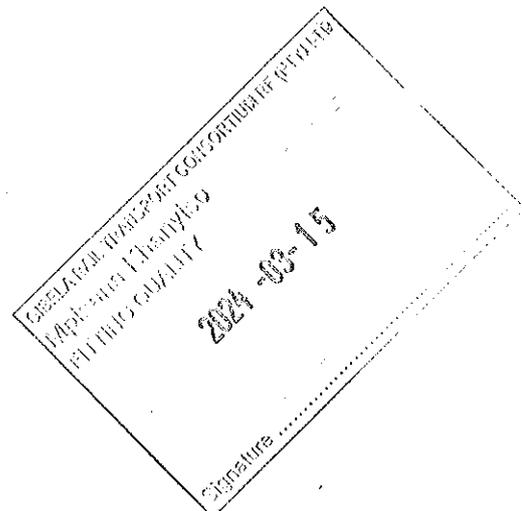
Boiler maker (Name & Sign): Innocent I.

Welder (Name & Sign): Thabang



FEDOLI

OPERATOR: Lawrence Ilgou





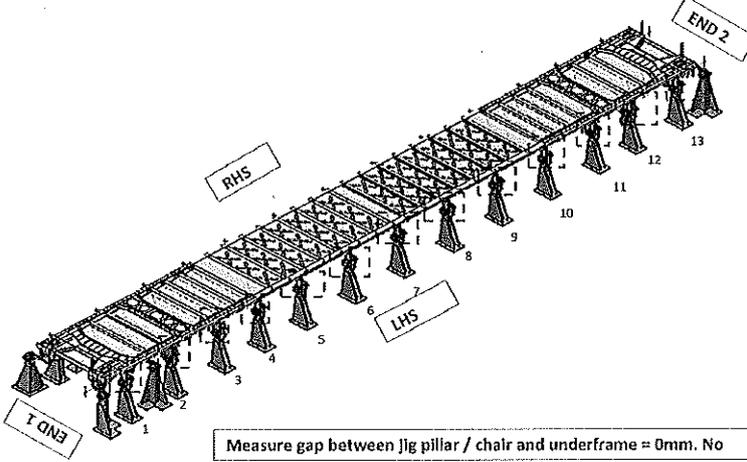
CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev. 28

Date 07/11/2023

Project: PRASA
SI.CB1210.254.V28

Specifications of Details for CBS measurement



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: *[Signature]*

Date: 08/04/24

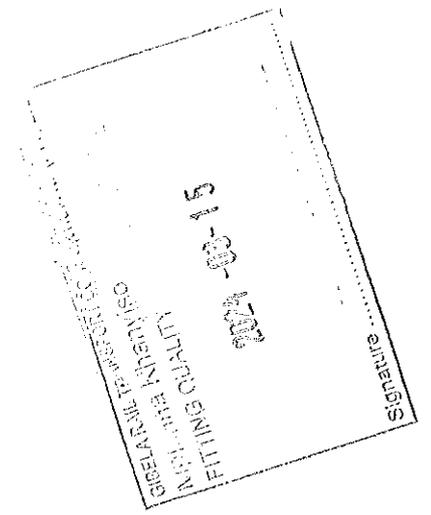
After Welding.

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: *[Signature]*

Date: 08/04/24



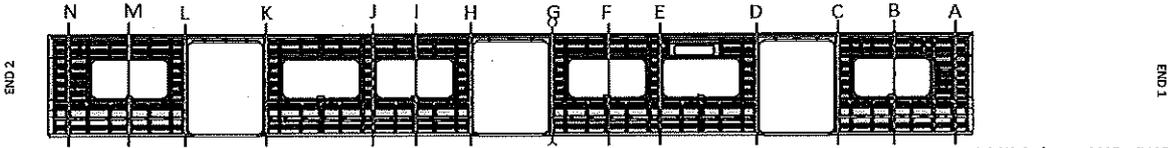


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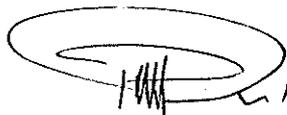
Specifications of Details for CBS measurement



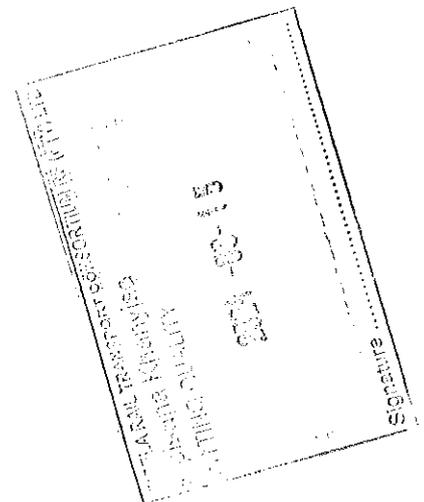
PME Column LHS - RHS should be ≤ 2 MM on each point.

BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5 mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3069	3069	0	2404	2404	0
B	3071	3070	1	2408	2408	1
C	3066	3070	4	2406	2404	2
D	3070	3071	1	2408	2408	0
E	3069	3068	1	2404	2404	0
F	3067	3067	0	2405	2406	1
G	3069	3070	3	2404	2404	0
H	3068	3069	1	2406	2404	2
I	3069	3068	1	2404	2404	0
J	3068	3068	0	2405	2404	1
K	3069	3068	1	2406	2405	1
L	3068	3070	2	2404	2405	1
M	3070	3071	1	2404	2404	0
N	3069	3066	5	2404	2406	2



Handwritten notes: 409964, 08/04/24



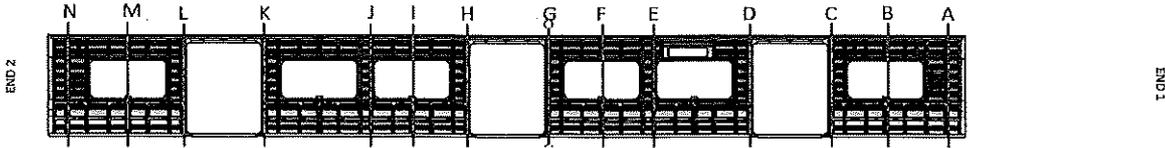


CARBODYSHELL M1 ASSEMBLY DTR30226487/3

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Specifications of Details for GBS measurement



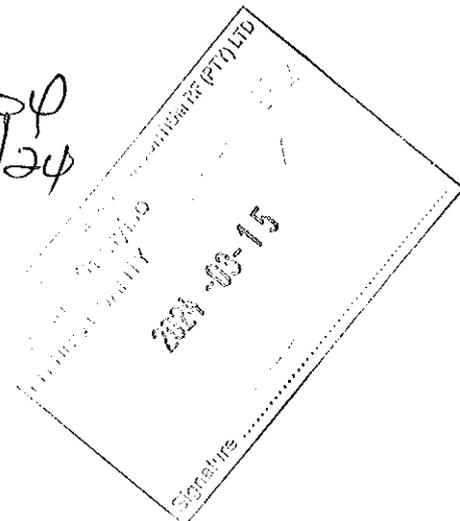
PME Column LHS - RHS should be $\leq 2\text{MM}$ on each point.

AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3296	3298	2	2404	2405	1
B	3269	3269	0	2406	2404	2
C	3298	3299	1	2404	2404	0
D	3296	3298	2	2404	2406	2
E	3269	3270	1	2404	2405	1
F	3270	3270	0	2406	2404	2
G	3296	3299	1	2405	2404	1
H	3298	3299	1	2403	2404	1
I	3268	3268	0	2405	2405	0
J	3269	3269	2	2404	2406	2
K	3296	3299	1	2404	2405	1
L	3296	3296	0	2406	2404	2
M	3270	3271	1	2405	2404	1
N	3295	3295	0	2404	2404	0



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08/04/24





CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev. 28

Date

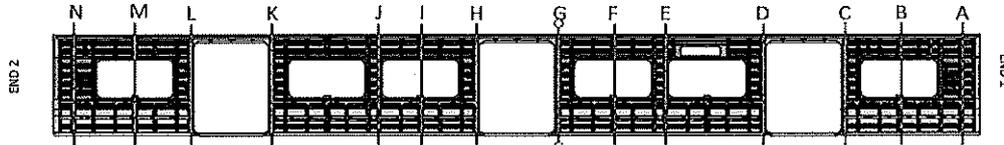
07/11/2023

Project: PRASA

SI.CB1210.254.V28

CBS measurement

BEFORE WELDING



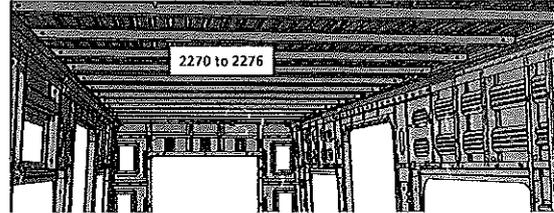
END 2

END 1

2270 to 2276

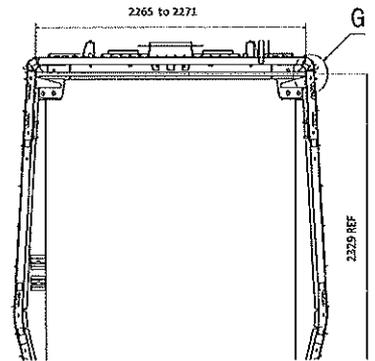
- A 2276
- B 2274
- C 2275
- D 2274
- E 2276
- F 2275
- G 2272
- H 2274
- I 2276
- J 2276
- K 2274
- L 2273
- M 2274
- N 2274

1990 to

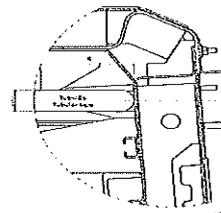


2270 to 2276

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



4087960
08/04/24



Detail 0
Considering the reinforcement plate

Signature

2024-08-15

FITTING QUALITY

Wolsane Khanyisa

CREARAIL TRANSPORTATION SERVICES (PVT) LTD



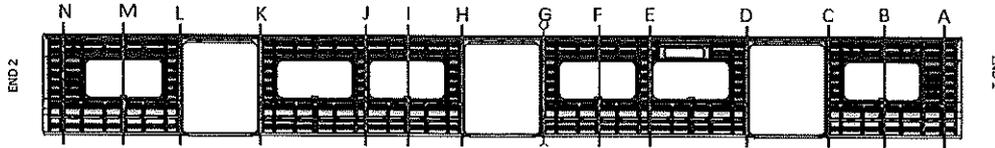
CARBODYSHELL M1 ASSEMBLY DTR30226487/3

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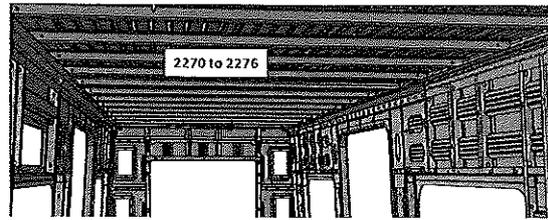
Project: PRASA
SI.CB1210.254.V28

CBS measurement

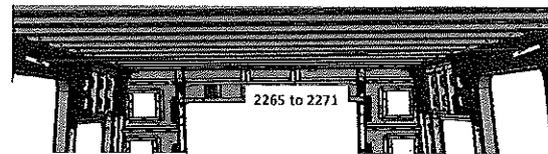
AFTER WELDING



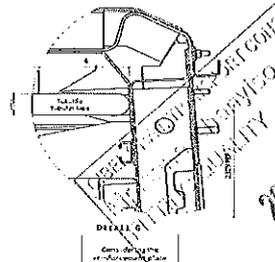
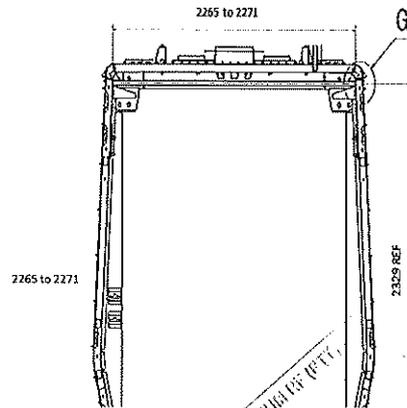
	2265 to 2271	2270 to 2276
A	2269	N/A
B	N/A	2274
C	2265	N/A
D	2268	N/A
E	N/A	2276
F	N/A	2275
G	2265	N/A
H	2267	N/A
I	N/A	2271
J	N/A	2275
K	2268	N/A
L	2269	N/A
M	N/A	2275
N	2269	N/A



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



Take measurement close to radius (considering reinforcement)



409964
0810404

2024-03-15

Signature

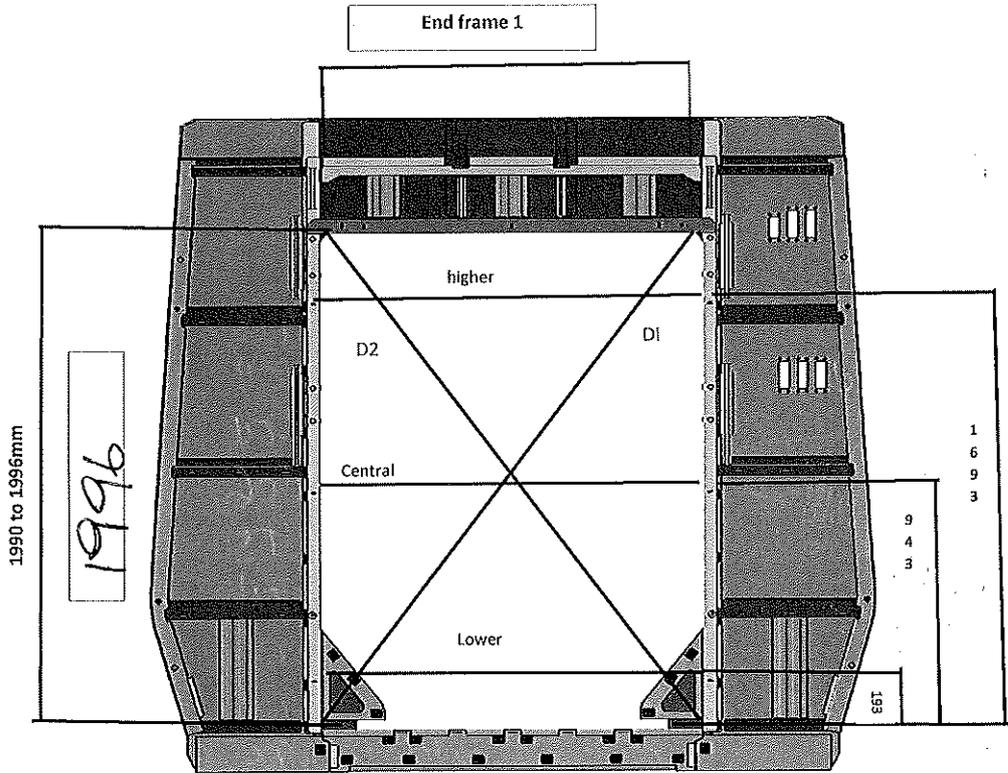


CARBODYSHELL M1 ASSEMBLY DTR30225487/3

Rev. 28
Date 07/11/2023

Project: PRASA
SI.CB1210.254.V28

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3mm$

Higher Dimension

1382

D1

2416

Central Dimension

1382

D2

2416

Lower Dimension

1381

D1-D2

0

(Signature)
409964
08/04/24

GIBELA
Miyama Intertec
FITTING QUALITY
2024-03-15
Signature

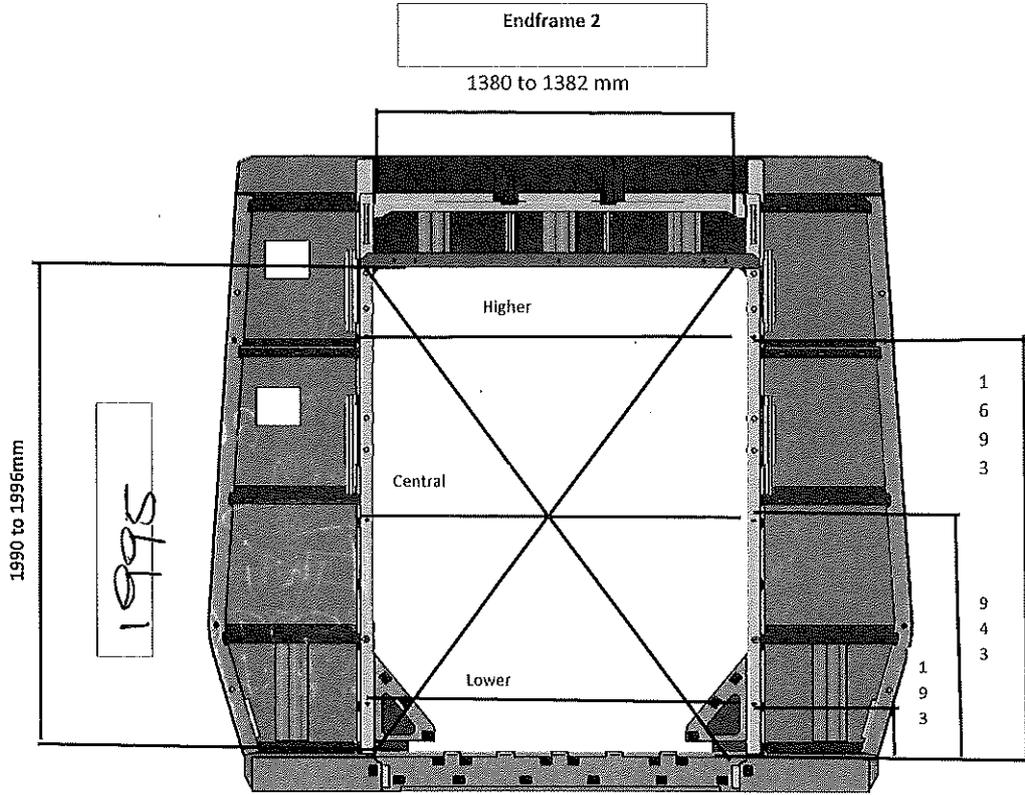


CARBODYSHELL M1 ASSEMBLY DTR30226487/3

Rev. 28
Date 07/11/2023

Project: PRASA
SI.CB1210.254.V28

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE $D1-D2 \leq 3mm$

Higher Dimension	1380	D1	2415
Central Dimension	1381	D2	2416
Lower Dimension	1380	D1-D2	1


 407964
 08/04/24

CONSORCIO DE INVESTIGACIONES Y DESARROLLO TECNOLÓGICO
 CONICYT
 CALIDAD
 2024-03-15
 Signature

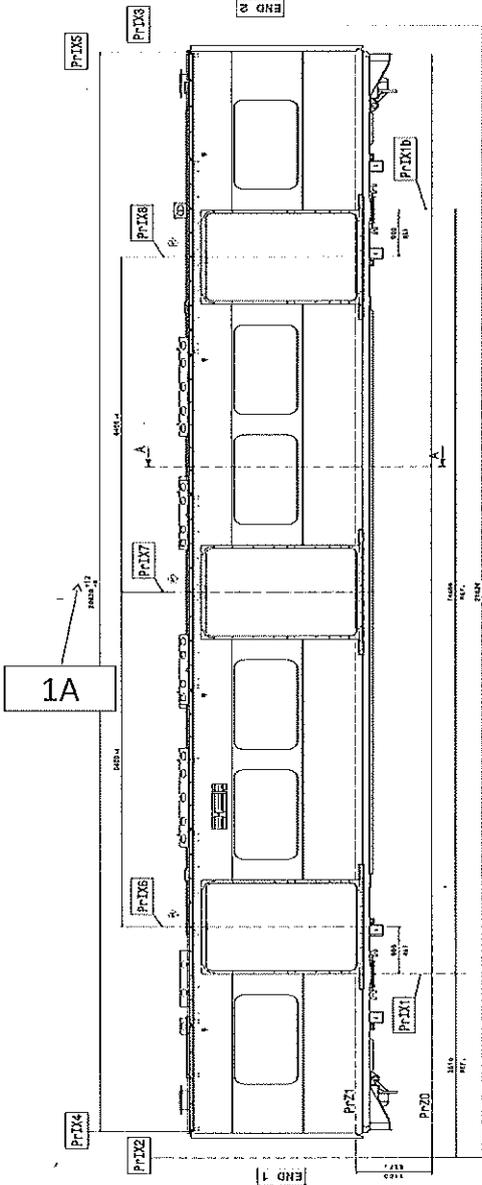


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Specifications of Details for CBS measurement



LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20615

RIGHT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20615

Handwritten signature
 409964
 08/04/24

Dye penetrant test

Dye-penetration test to be performed by quality personnel



GIBELARAH TOH PUSAT UNIT TEKNIK DAN KUALITI
 KUALITI KUALITI
 FITTING QUALITY
 2024-08-15
 Signature



CARBODYSHELL M1 ASSEMBLY DTR30225487/3

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Date 07/11/2023

Project: PRASA
SI.CB1210.254.V28

Self Inspection - Final Result

		DATE	NAME	SIGNATURE	
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)	Panfso Operations		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	Andani Industrial Quality		
	NO GO	There are activities pending 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

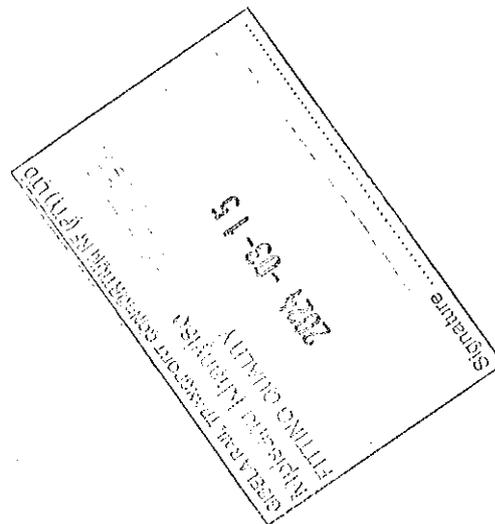
In case of "NO GO", the operations manager must define below action plan to ensure "GO":

Item	Description	Responsible	Due date	Status

Operations

Quality

9





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	MA	H1	H2	H3	TC2		
<input type="checkbox"/>	DIR30225107/2	AD00001278560 CARBODYSHELL F31,F33,F34 ASSEMBLY	CB1220		X	X		X		PRA.CB1220.DIR3022546 7/2.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 DT000336600	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
10	22/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	22/08/2019
			CHECKER	Nosizo Pindela	22/08/2019
			REVISED BY	Nosizo Pindela	22/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021
			CHECKER	Mpho Mulaudzi	
			REVISED BY	Mpho Mulaudzi	
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	19/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Mbhombi Collins	14/06/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
27	17/10/2022	Addition of traceability for sealant application and welding	APPROVER	Mbhombi Collins	17/10/2022
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
29	28/10/2023	Addition of bracket quantity	APPROVER	Ngobeni Tyson	28/10/2023
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	

TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
TS221	RM1	ASAIDA 909979	9-04-24	SI.CB1220.250.V29	14



CARBODYSHELL M1,M3,M4 ASSEMBLY
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Rev.
29
Date
28/10/2023

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Car: M1,M3&M4

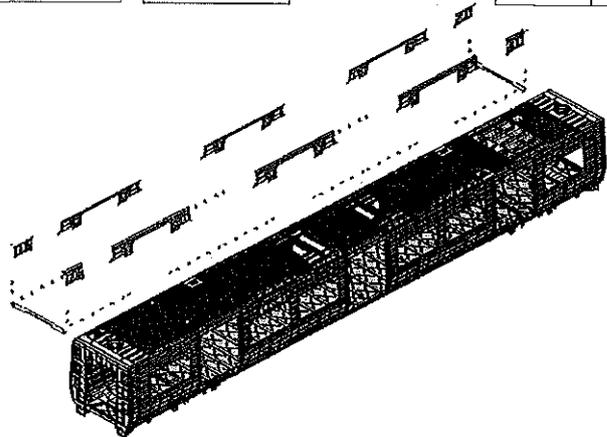
NCR:

Work station:

CB1220



Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	M1	M3	M4	M3&M4	M1&M3	M1&M4					
DTR30225487/2	X						29	28-10-2023	X	N/A	<i>[Signature]</i> 28-01-24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Tubular measuring tape	22316	07/02/2023	X	<i>[Signature]</i> 29-01-24	<i>[Signature]</i> 28-01-24
	518TA023	10/04/2023	X	<i>[Signature]</i> 29-01-24	<i>[Signature]</i> 28-01-24

I.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308	273471	MIG	X	<i>[Signature]</i> 29-01-24	<i>[Signature]</i> 28-01-24



CARBODYSHELL M1,M3,M4 ASSEMBLY
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Project PRASA
SI.CB1220.250.V29

II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA CB1220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB1220.DTR30225487/2	✓	09-04-24 	09/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	09-04-24 	09/04/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	09-04-24 	09/04/24
04		Cleaning of all Stainless Steel Surface	According to GIB-WEL - PROC-0002	✓	09-04-24 	09/04/24
05		Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓	09-04-24 	09/04/24
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.	✓	09-04-24 	09/04/24
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 (°C) Min-Max 10°C - 35°C Relative humidity Min - Max (%) 25% - 60%	Sealant Batch No: 70-03 Exp Date: 04/24 Actuals Temperature: 16°C Humidity: 47%	✓	09-04-24 	09/04/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓	09-04-24 	09/04/24
09		Verification of safety welds	Approved according to DTD000210658 reference and Self inspection	✓	09-04-24 	09/04/24

Handwritten notes and stamps at the bottom left of the page, including a date stamp '28/10/2023' and some illegible text.



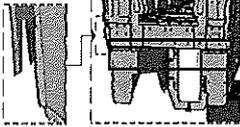
CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

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29
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28/10/2023

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SI.CB1220.250.V29

II - Self Inspection - Items to Check

SEALANT APPLICATION



AREA 1 & 2 END 1

Operator (Name & sign):

M. Theodorou

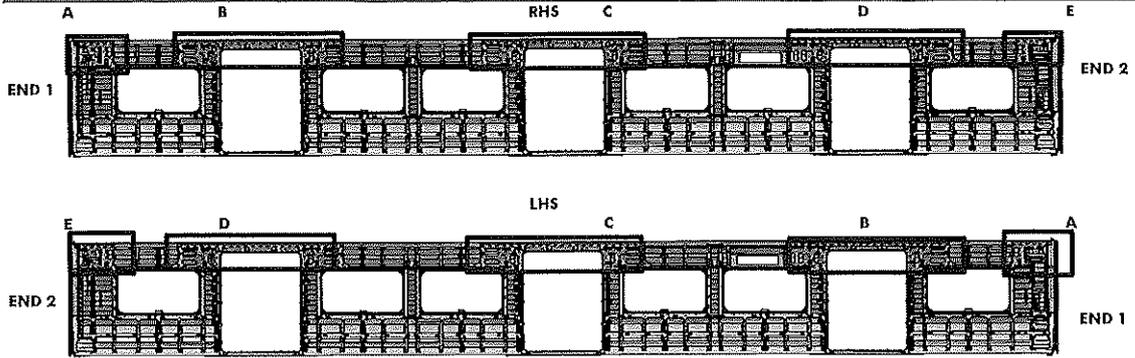
Operator (Name & sign):

M. Theodorou

GIBELO RAIL TRANSPORT SOLUTIONS (PTY) LTD
Mphahlele Industrial Estate
Pretoria, South Africa
2024-09-14
Signature

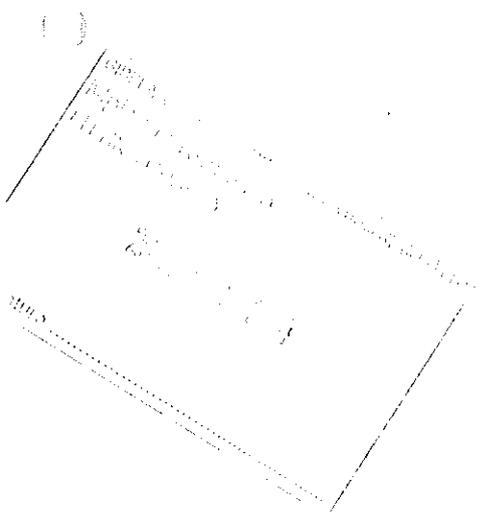
	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR3022548712	Rev.	Project: PRASA
		29	
		Date	SI.CB1220.250.V29
		28/10/2023	

II - Self Inspection - Items to Check

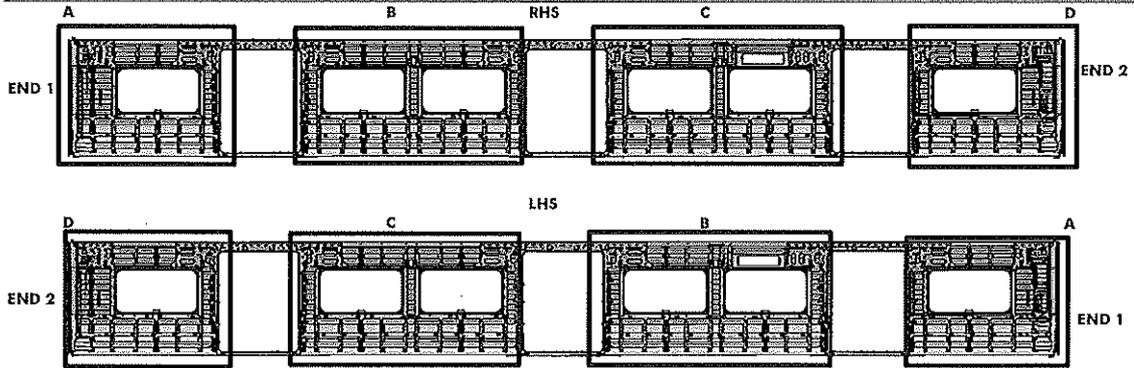


REINFORCEMENT WELDING

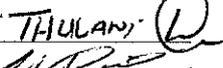
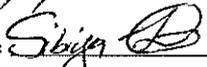
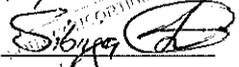
AREA	LHS	RHS
A	Operator (Name&sign): <i>Notikunaga Ogura</i>	<i>[Signature]</i>
B	Operator (Name&sign): <i>Notikunaga Ogura</i>	<i>[Signature]</i>
C	Operator (Name&sign): <i>S. Hatanaka</i>	<i>[Signature]</i>
D	Operator (Name&sign): <i>Sibuya</i>	THULAN <i>[Signature]</i>
E	Operator (Name&sign): <i>Johany</i>	THULAN <i>[Signature]</i>



II - Self Inspection - Items to Check



BRACKETING

INSTALLATION		
C-RAILS:	Operator: <u>Mtsholezi K</u>	
	Operator: _____	
DOOR MECHANISMS:	Operator: <u>Tobelo JPS</u>	
	Operator: _____	
TAPPING PADS	Operator: <u>Puzilla Cassu</u>	
	Operator: _____	
INSTALLATION & VERIFICATION		
SEAT & LUGGAGE BRACKETS:	Operator: <u>Abrandy</u> 	
	Operator: _____	
SEAT BRACKETS VERIFICATION:	Operator: <u>N/A</u>	
	Operator: _____	
WELDING		
AREA	LHS	RHS
A (Seat brackets)	Operator (Name&sign): <u>Nobulungo Dede</u>	Operator (Name&sign): <u>Nobulungo Dede</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>LINDO</u> 	Operator (Name&sign): <u>LINDO</u> 
B (Seat brackets)	Operator (Name&sign): <u>Masela</u>	Operator (Name&sign): <u>Masela</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>LINDO</u> 	Operator (Name&sign): <u>LINDO</u> 
C (Seat brackets)	Operator (Name&sign): <u>THULANI</u> 	Operator (Name&sign): <u>THULANI</u> 
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>Mmasheko Mose</u>	Operator (Name&sign): <u>Mmasheko Mose</u>
D (Seat brackets)	Operator (Name&sign): <u>Sibiga</u> 	Operator (Name&sign): <u>Sibiga</u> 
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>Mmasheko Mose</u>	Operator (Name&sign): <u>Mmasheko Mose</u>
ENDS		
END 1 TAPPING PADS WELDING:	Operator (Name&sign): <u>LINDO</u> 	
END 2 TAPPING PADS WELDING:	Operator (Name&sign): <u>Mmasheko Mose</u>	



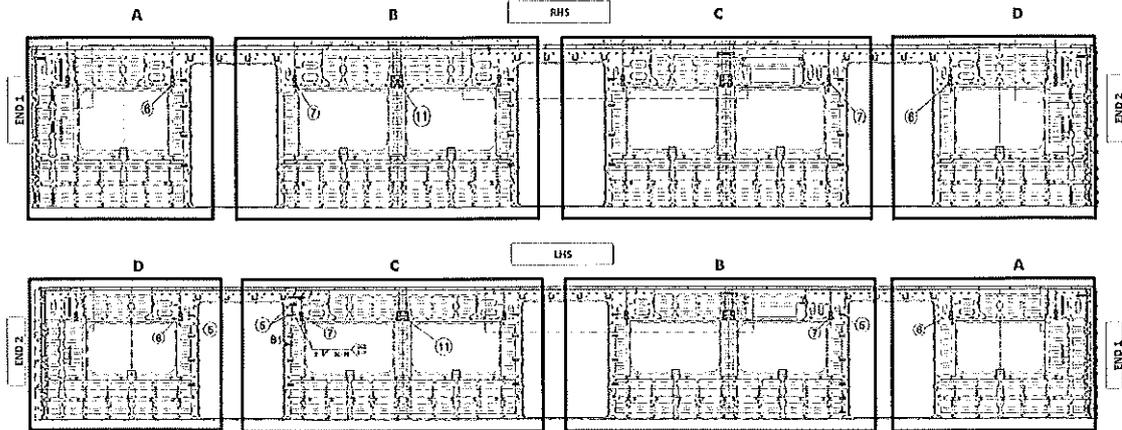
CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30226487/2

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29
Date
28/10/2023

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SI.CB1220.250.V29

II - Self Inspection - Items to Check

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7		
	B	4		
	C	8		
	D	6		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	5		
	C	4		
	D	3		

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

VERIFICATION BY: _____

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	8		
	C	11		
	D	8		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	5		
	C	6		
	D	2		

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

VERIFICATION BY: _____

QUANTITIES (M1)

RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7		
	B	9		
	C	8		
	D	8		
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

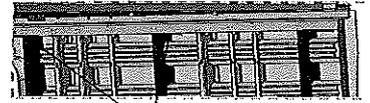
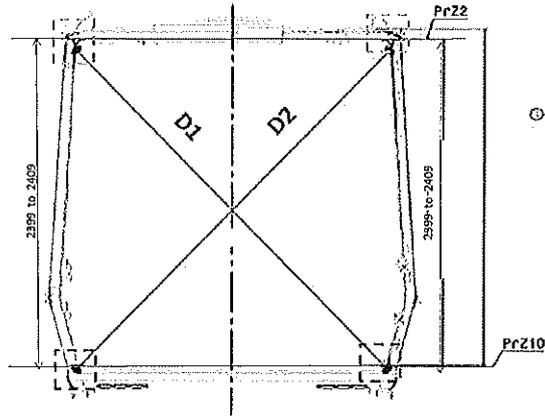
VERIFICATION BY: *ASANDIA*

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	10		
	C	11		
	D	9		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	7		
	C	6		
	D	2		

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

VERIFICATION BY: *ASANDIA*

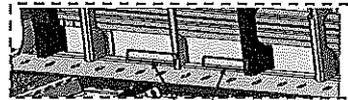
Specifications of Details for CBS measurement



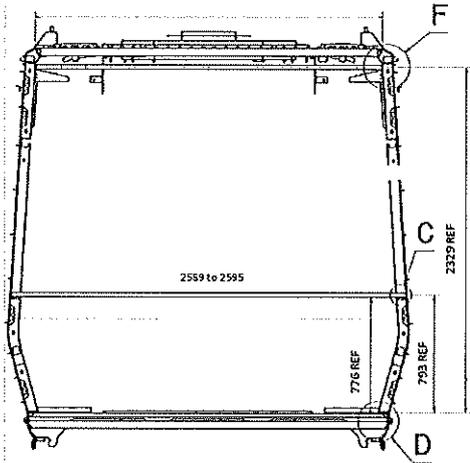
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



Handwritten note:
 Lower part of the drawing is not to be used for measurement.
 2023-10-28
 2023-10-28

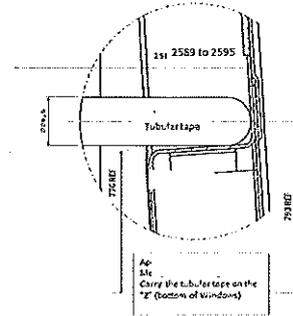
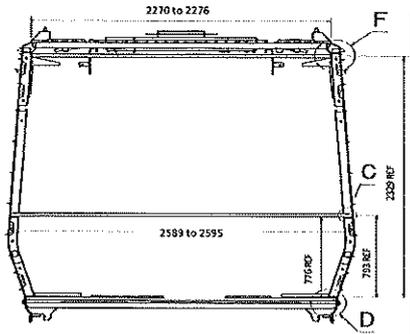


CARBODYSHELL M1,M3,M4 ASSEMBLY
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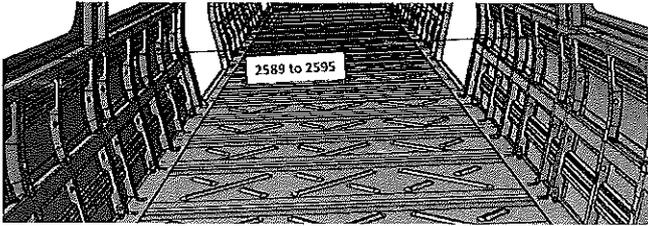
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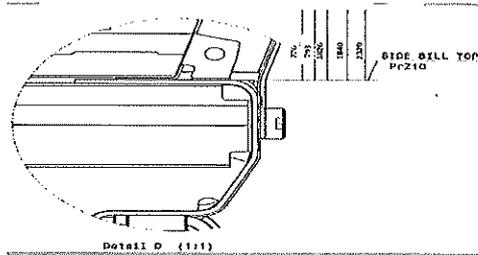
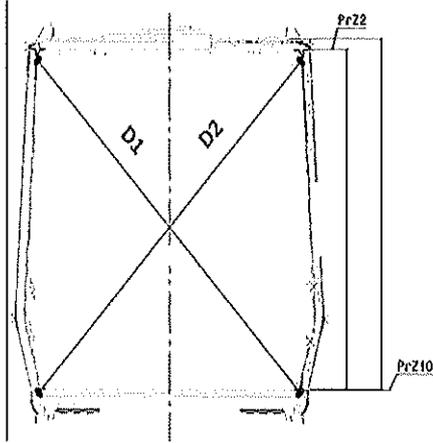
CBS measurement



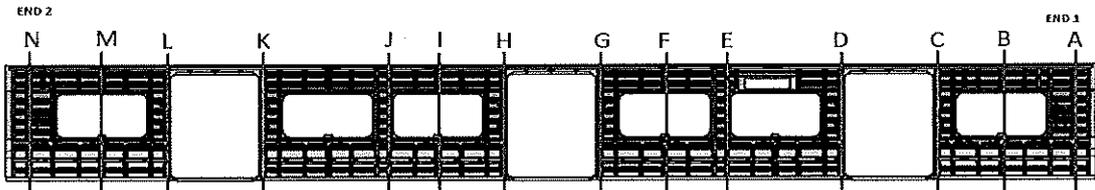
Detail C



Take measurement close to radius



Detail D (1:1)



BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3293	3295	2	-
B	3263	3264	1	-
C	3296	3297	1	-
D	3295	3299	5	-
E	3265	3262	3	-
F	3260	3262	2	-
G	3297	3295	2	-
H	3295	3294	1	-
I	3261	3261	0	-
J	3264	3264	0	-
K	3294	3296	2	-
L	3297	3297	0	-
M	3260	3265	5	-
N	3297	3295	2	-


 9-04-24

2023-10-28
 10:00:00
 10:00:00
 10:00:00

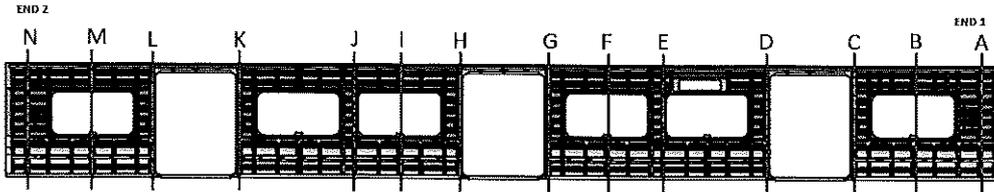


CARBODYSHELL M1,M3,M4 ASSEMBLY
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28/10/2023

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CBS measurement



AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3297	3296	1	2595
B	3264	3265	1	2587
C	3300	3296	4	2590
D	3297	3296	1	2593
E	3264	3263	1	2595
F	3263	3260	3	2595
G	3299	3298	1	2595
H	3293	3295	2	2594
I	3263	3260	3	2593
J	3262	3266	4	2595
K	3300	3296	4	2594
L	3299	3296	3	2593
M	3260	3266	6	2589
N	3295	3300	5	2595

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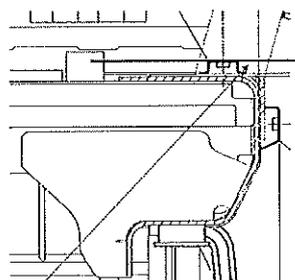
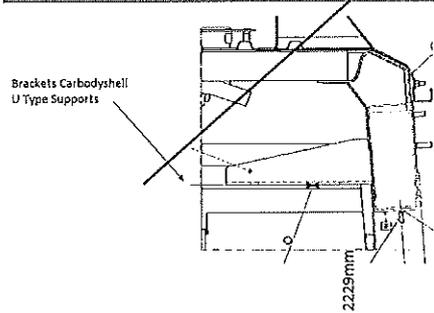
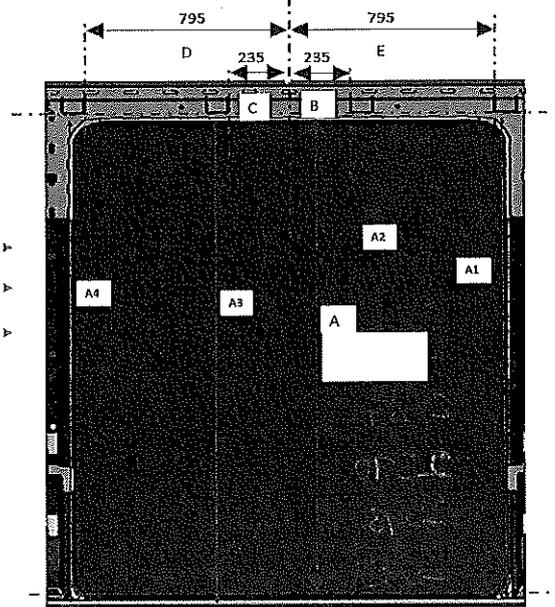


CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30226487/2

Rev.
29
Date
28/10/2023

Project: PRASA
SI.CB1220.250.V29

Specifications of Details for CBS measurement CB1220



Brackets Carbodyshell Channel Assy

DOOR 1 - LHS

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

DOOR 2 - LHS

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

DOOR 2 - RHS

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

DOOR 1 - RHS

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

DOOR 2 - RHS

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

DOOR 3 - RHS

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

[Handwritten Signature]

9-04-24

REVISIONS

NO.	DESCRIPTION	DATE
1	ISSUED FOR MANUFACTURE	28/10/2023

Checked: *[Signature]*



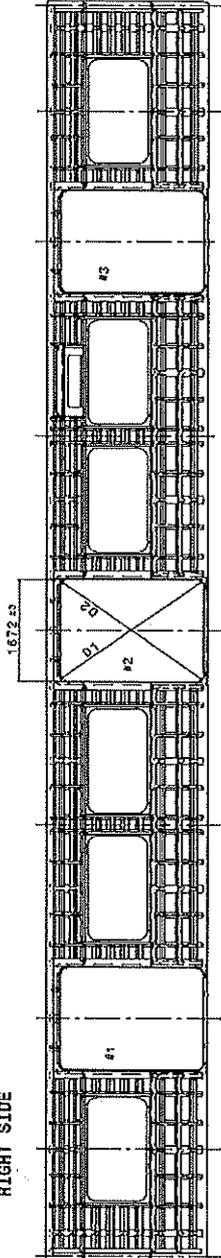
CARBODYSHELL M1,M3,M4 ASSEMBLY
DTR30225487/2

Rev. 29
Date 28/10/2023

Project: PRASA
SI.CB1220.250.V29

Specifications of Details for CBS measurement CB1220

End #2



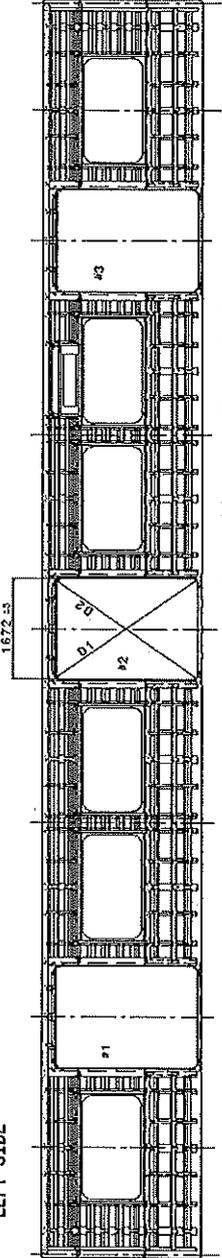
Doors diagonal D1-D2 maximum difference ≤4mm

	#1	#2	#3
D1	2748	2747	2746
D2	2746	2746	2745
D1-D2	2	1	1

Doors Length - 1672 ±3mm

	#1	#2	#3
HIGHER DIMENSION	1670	1672	1673
CENTRAL DIMENSION	1673	1672	1672
LOWER DIMENSION	1672	1672	1671

End #1



Doors diagonal D1-D2 maximum difference ≤4mm

	#1	#2	#3
D1	2747	2744	2748
D2	2746	2745	2745
D1-D2	1	1	3

Doors Length - 1672 ±3mm

	#1	#2	#3
HIGHER DIMENSION	1672	1673	1674
CENTRAL DIMENSION	1672	1673	1672
LOWER DIMENSION	1672	1671	1671

[Handwritten signature]
01-04-24

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB1220.250.V29
		29	
		Date	
		28/10/2023	
Self Inspection - Final Result			

Is the car good to advance to the next workstation/process? (Approval of Operations Manager and Industrial Quality)			DATE	NAME	SIGNATURE	
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage!)	09-09-24	Asanida Operations		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	09/09/24	Arduani Industrial Quality		
		There are activities pending 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

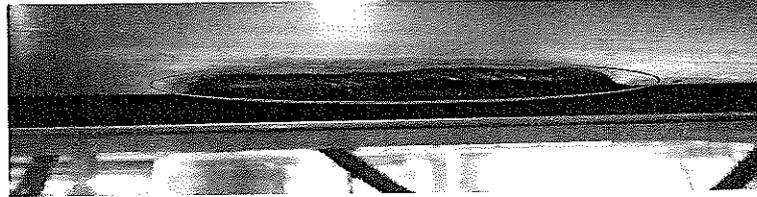
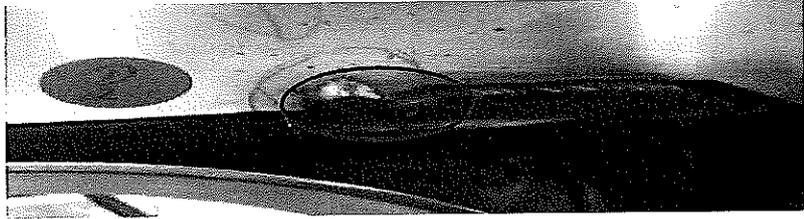
Operations

Quality

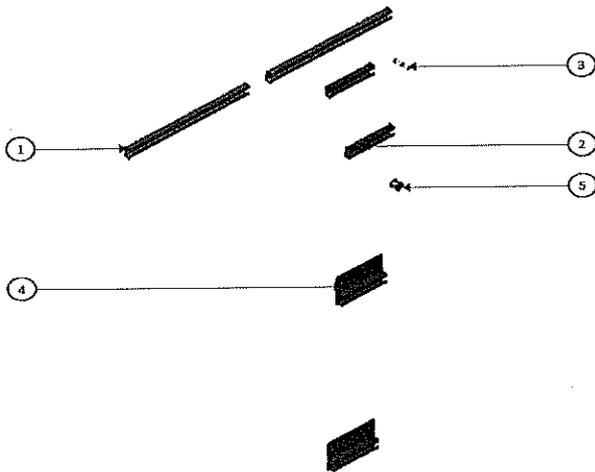
Signature: _____
 Date: _____

	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev.	Project: PRASA SI.CB1220.250.V29
		29	
		Date	
		28/10/2023	

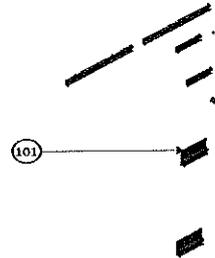
ANNEXURE A: Arc Welding Quality Acceptance Standard

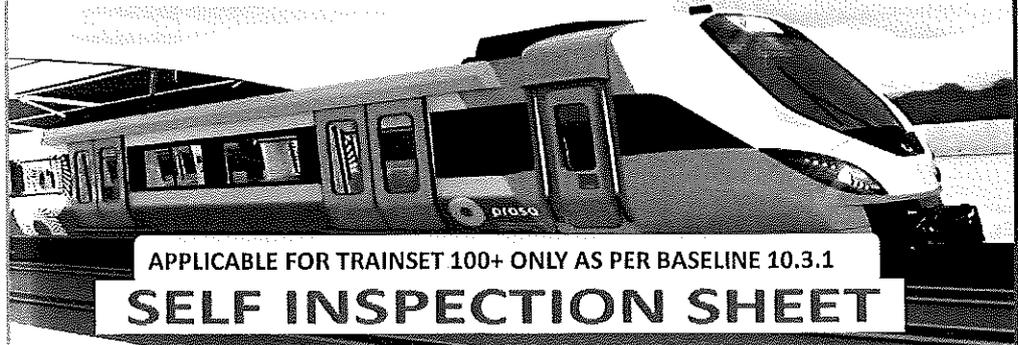


Station: CB1220-004- U108 & U107



PART NO.	ITEM NO.	QTY	DESCRIPTION	MASS (KG)
DTFC002074033	5	6	EARTH STUD 6	0.035
AAC0001201843	4	6	ASSEMBLY SUPPORT	0.271
DTFC000943305	3	12	WELDING STUD ISO13918 PT-K3020-SS2	0.007
AAC0001180424	2	12	ASSEMBLY SUPPORT	0.193
AAC0001184418	1	14	ASSEMBLY SUPPORT	0.522
AAC0001161050	101	6	CARBODYSHELL BRACKETS CARBODY SHELL M1/M3/M4 CAR [SIDE FRAME MODULE END - 099]	12.132





APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

CONFIDENTIAL INFORMATION

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

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ? 	
				TCA	M4	M1	M2	M3	TCA			
<input type="checkbox"/>	DT00000225487	AAD0001278566	CARBODYSHELL M1,M3,M4 ASSEMBLY	CB1230		X	X		X		PRA.CB1230.DT000002 25487.V20	YES
<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	Ramkone Motama	2018/05/07
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			REVISED BY	Vanessa Ntuli	24/01/2019
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	23/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	23/08/2019
			CHECKER	Nosizo Pindela	23/08/2019
			REVISED BY	Nosizo Pindela	23/08/2019
15	06/08/2020	New Baseline 10.2.6	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 Mbhombhi	20/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbhombhi	14/06/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
27	19/10/2022	Addition of traceability for sealant application	APPROVER	Collins Mbhombhi	19/10/2022
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
29	06/11/2023	Added thresholds traceability for boiler makers and welders	APPROVER	Tyson Ngobeni	06/11/2023
			CHECKER	Andani Muthelo	
			REVISED BY	Ntokozo Zwane	

TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
221	M1	Zonele 482774	10/04/24	SI.CB1230.256.V28	11





CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
29

Project: PRASA

Date

06/11/2023

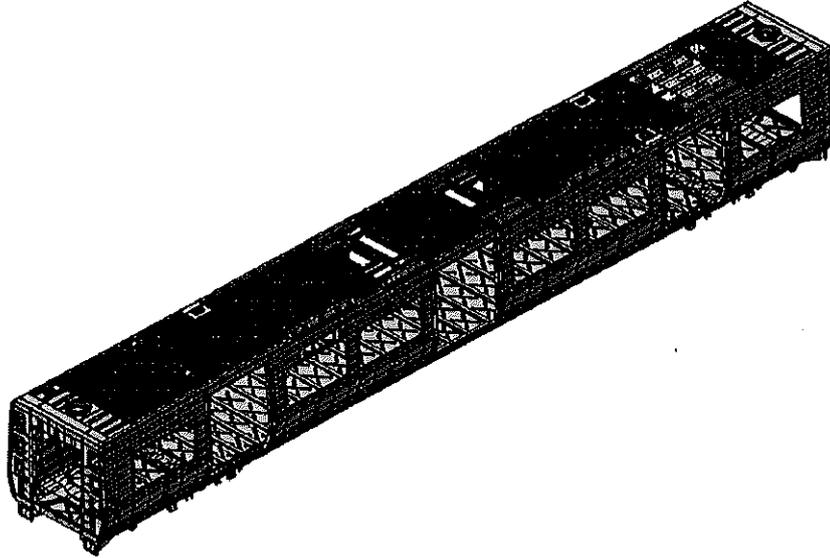
SI.CB1230.256.V28

Car: _____ NCR: _____

Work station: CB1230



Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car					Revision	Observation	OK	NOK	Reason	Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4	TCS							
PRA.CB1230.DT00000225487	X					29		X		N/A	10/04/24	10/04/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
Ticular	22615	2024/10/11	X		10/04/24	10/04/24
Combination Square	GIBCS0137	2024/10/11	X		10/04/24	10/04/24
Tape measurement	GIBTA0394	2024/10/15	X		10/04/24	10/04/24

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308 LSi	E231067	Mig	X		10/04/24	10/04/24



CARBODYSHELL M1,M3,M4 ASSEMBLY
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29

Project: PRASA

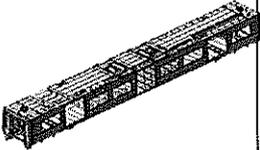
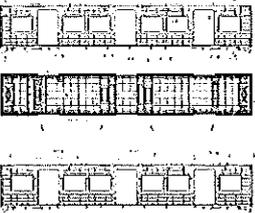
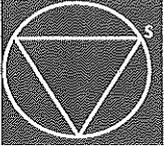
Date

SI.CB1230.256.V28

06/11/2023

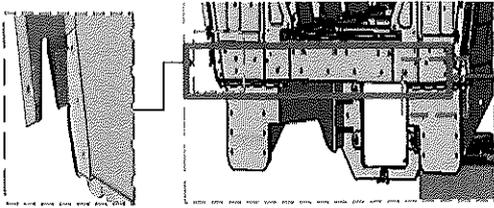
II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOK	REWORK	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1 230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	X			<i>[Signature]</i> 10/04/24	<i>[Signature]</i> 10/04/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	X			<i>[Signature]</i> 10/04/24	<i>[Signature]</i> 10/04/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	X			<i>[Signature]</i> 10/04/24	<i>[Signature]</i> 10/04/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	X			<i>[Signature]</i> 10/04/24	<i>[Signature]</i> 10/04/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	X			<i>[Signature]</i> 10/04/24	<i>[Signature]</i> 10/04/24
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.	X			<i>[Signature]</i> 10/04/24	<i>[Signature]</i> 10/04/24
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: <u>2001945</u> Exp Date: <u>05/24</u> Actuals Temperature: <u>20°C</u> Humidity: <u>35%</u>	X			<i>[Signature]</i> 10/04/24	<i>[Signature]</i> 10/04/24
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.	X			<i>[Signature]</i> 10/04/24	<i>[Signature]</i> 10/04/24

END 2 SEALANT

AREA 1



OPERATOR
(Name & sign):

Boity

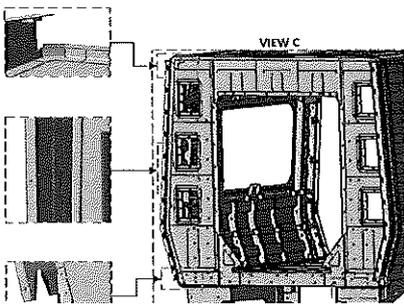
OPERATOR
(Name & sign):

Boity

OPERATOR
(Name & sign):

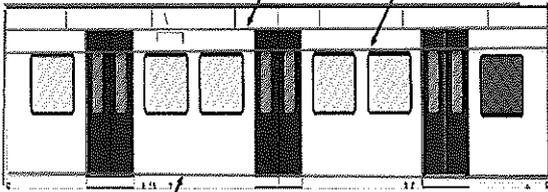
Boity

VIEW C



D

E



H

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

Operator (Name & sign):

LHS
D,E,F, G,H,I

RHS
D,E,F, G, H, I

Operator (Name & sign):

Silve

LIRILO

Operator (Name & sign):

Operator (Name & sign):

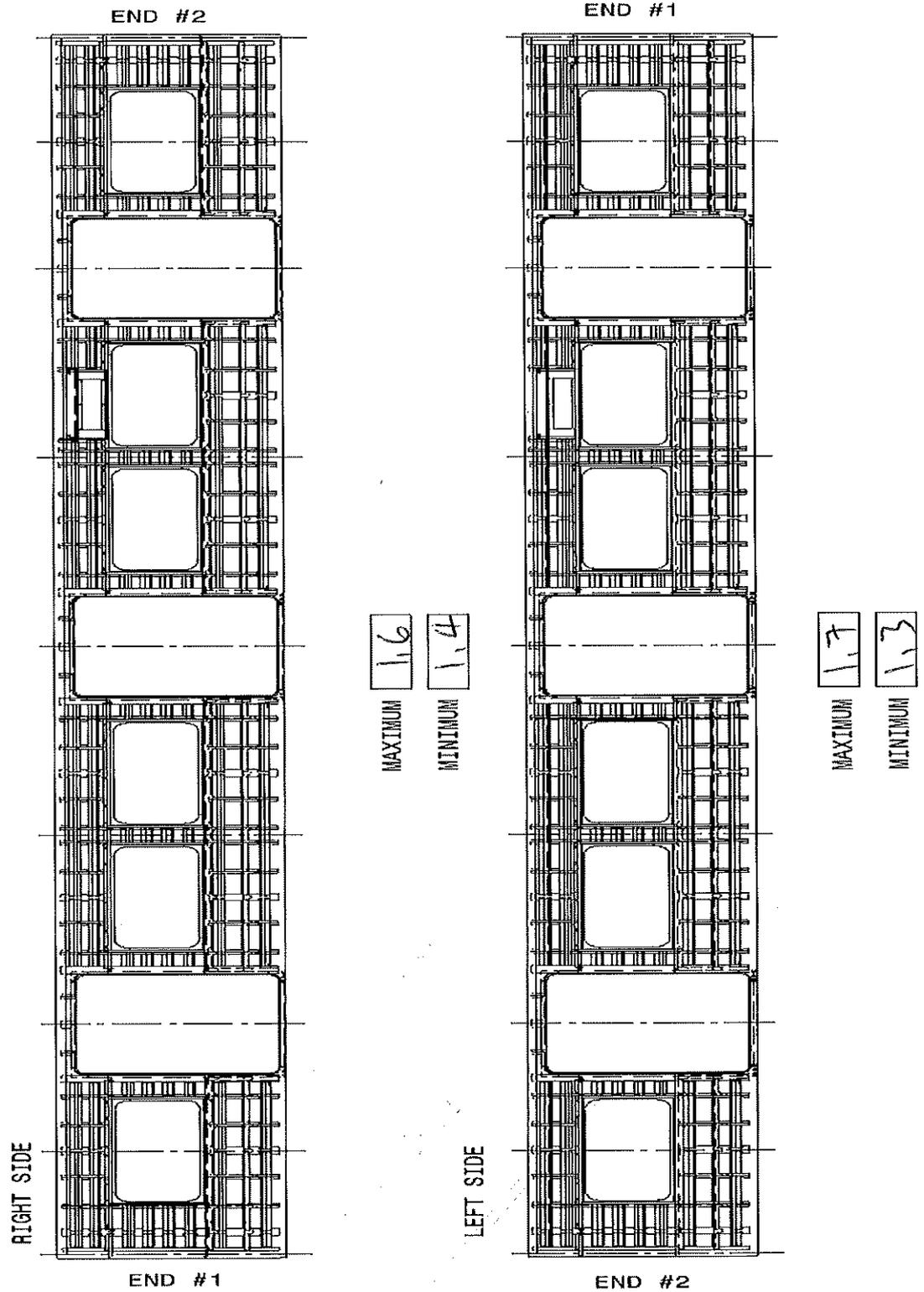
Zenzele

Operator (Name & sign):

Operator (Name & sign):

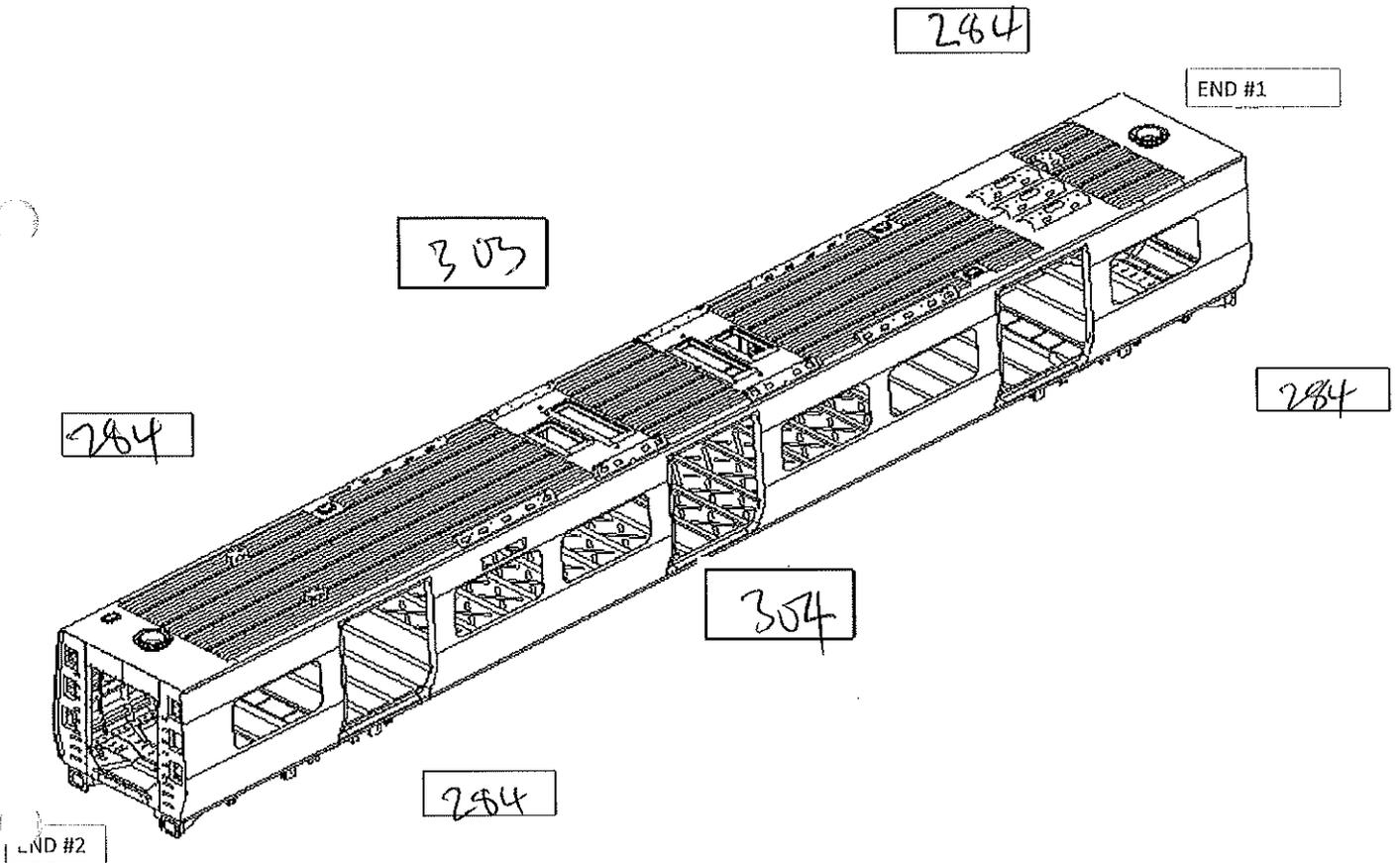
Specifications of Details for CBS measurement CB1230

Flatness side left and right maximum of 2mm in the valley to peak measured in 900mm. Record the maximum and minimum value found and indicate the corresponding region.



Specifications of Details for CBS measurement CB1230

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

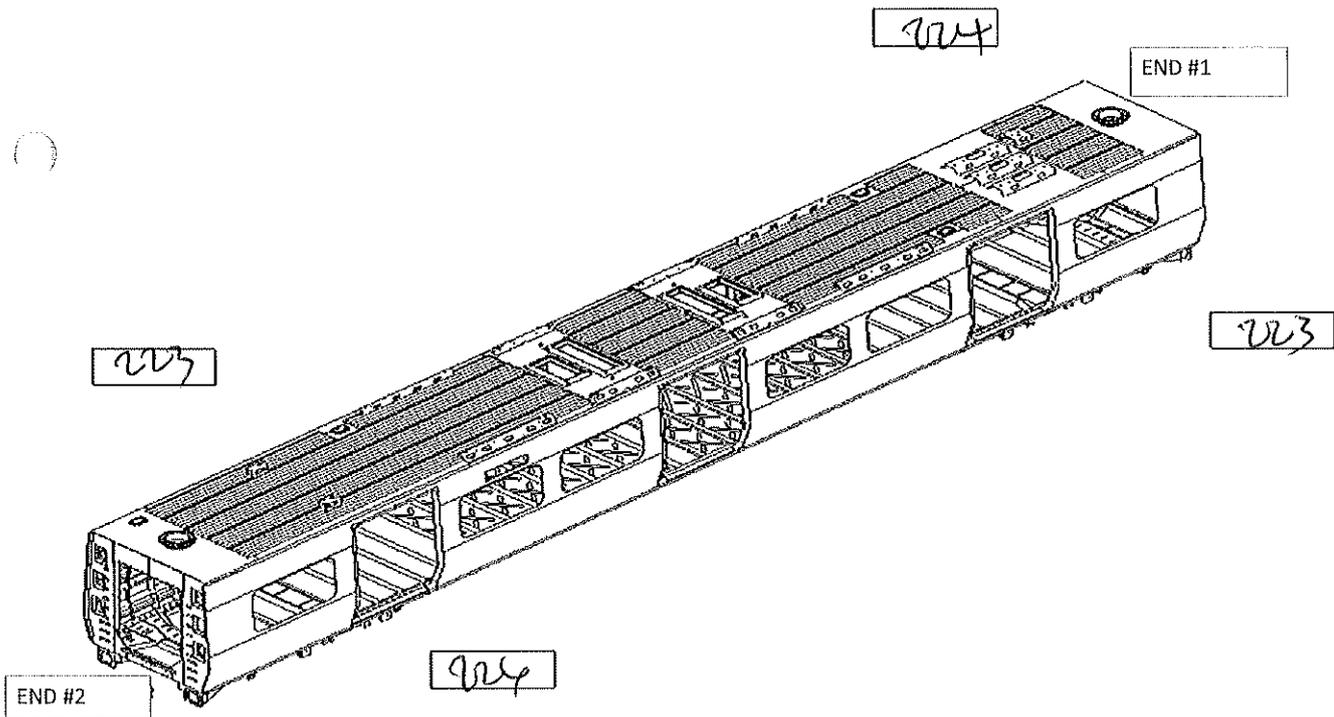


MEASURED CAMBER VALUES

RIGHT	¹	20
LEFT	^{a1}	19

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.



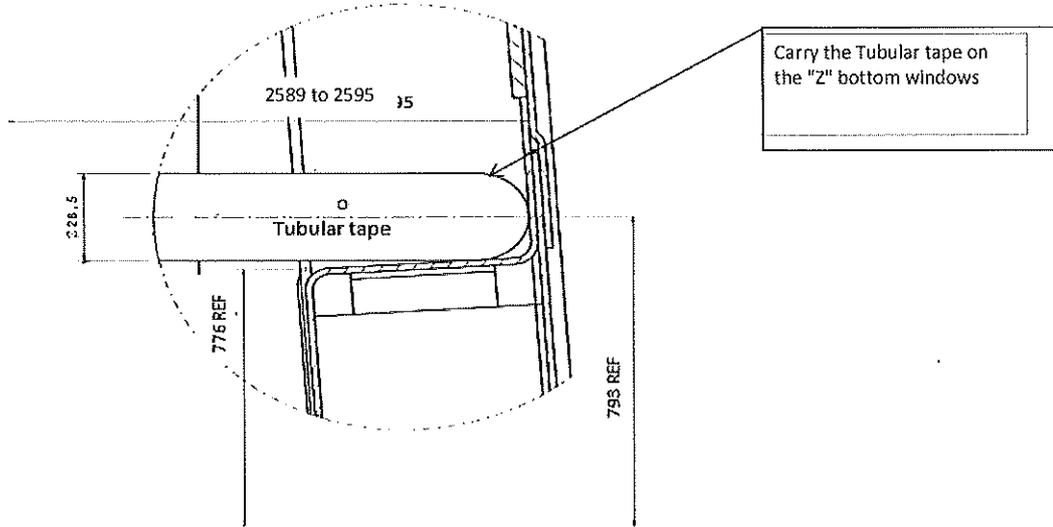
TWIST FOUND ON END 1

TRANVERS
LONGITUDIN

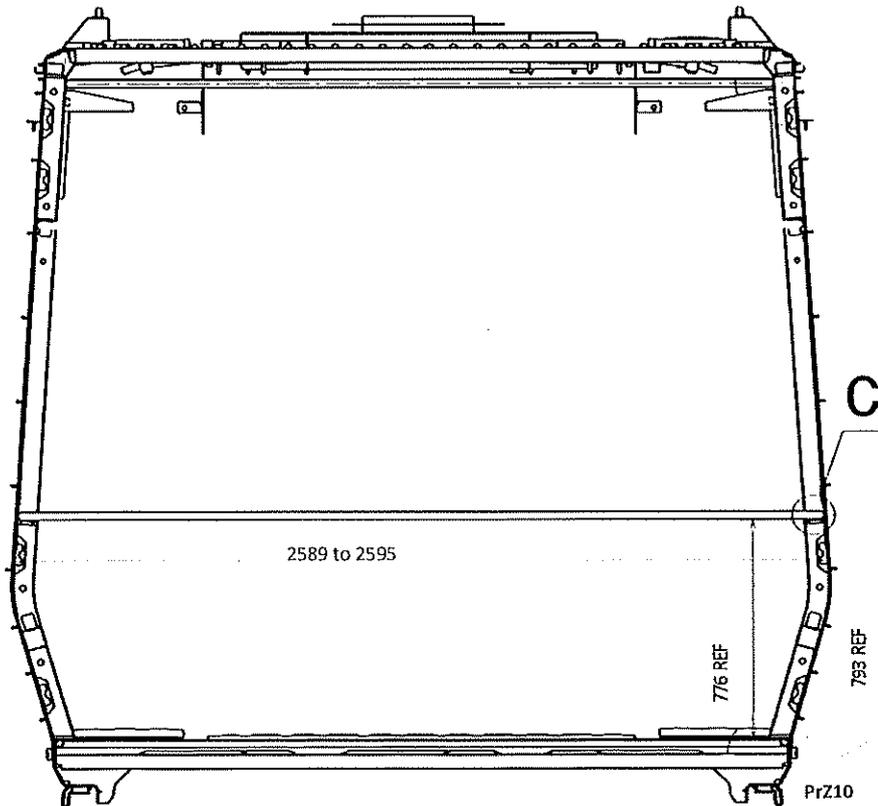
TWIST FOUND ON END 2

TRANVERSE
LONGITUDINAL

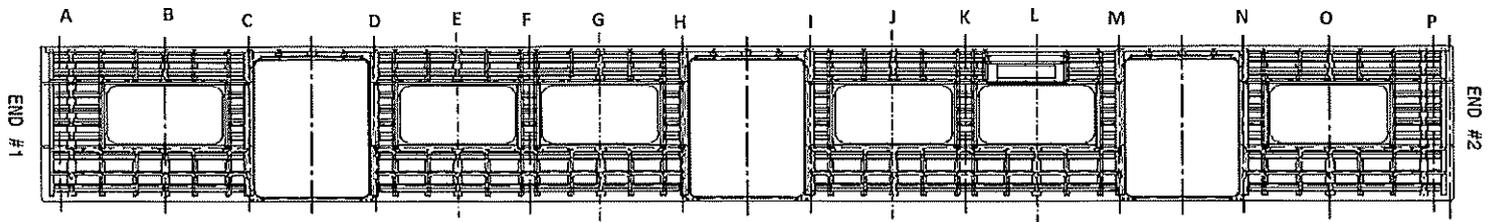
Specifications of Details for CBS measurement CB1230



Detail C

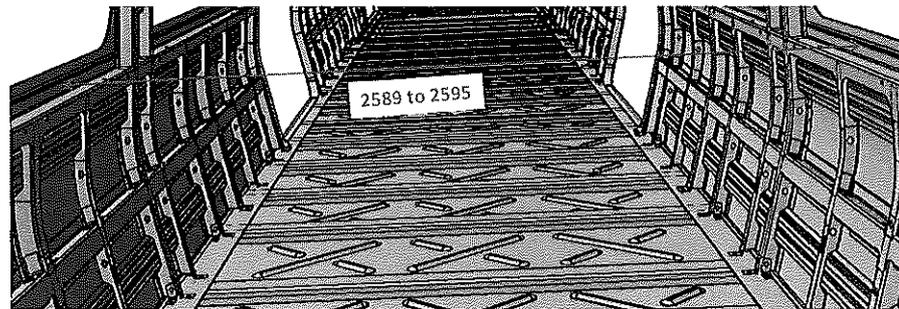


Specifications of Details for CBS measurement CB1230



2589 to 2595mm

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



Threshold verification

Nominal value :38

Door 1		Door 2		Door 3	
L	R	L	R	L	R
38	38	39	38	38	39
Door 4		Door 5		Door 6	
L	R	L	R	L	R
39	38	39	38	38	39

BOILER MAKER: Donkhanha
 Welder mmathapelo



CARBODYSHELL M1,M3,M4 ASSEMBLY
DT00000225487

Rev.
29

Project: PRASA

Date
06/11/2023

SI.CB1230.256.V28

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)	10/4/24	Zanele Mahlangu Operations		
		10/04/24	Ntoleko Industrial Quality		
	NO GO There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			Operations	
				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

