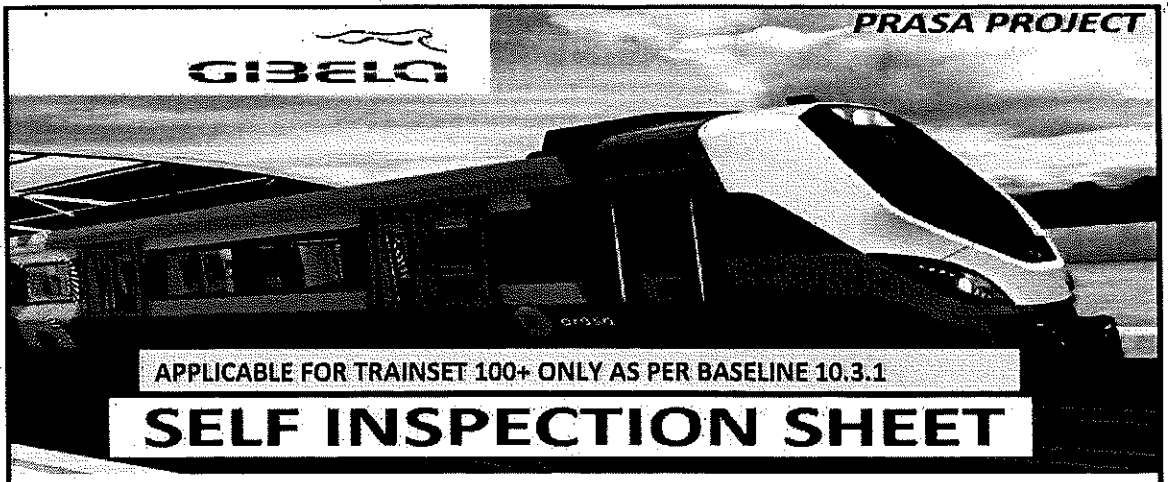
GIBELA

PRASA PROJECT



APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

APPLICATION REFERENCE

	MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE TC1	MC	M1	M2	M1	TC2	WORK INSTRUCTION	SAFETY ?
☐	DTR3000152645	AAD0001241093	Carshell Assembly TC	CB1210	(X)					X	PRA.CB1210.DTR3022331 9/3.V25	YES
☐												

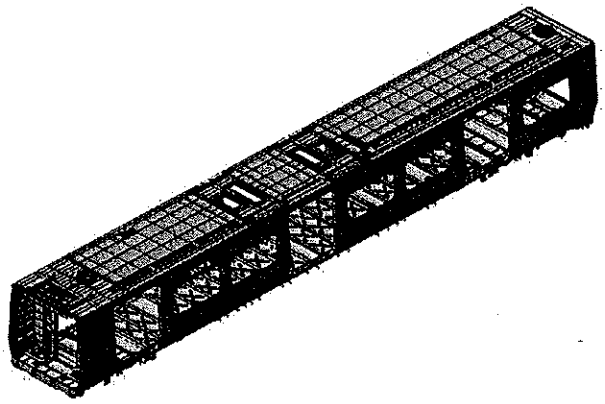
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	09/04/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	09/04/2018
			CHECKER	Nosizo Pindela	09/04/2018
			COMPILER	Thanyani Mathegu	06/04/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motama	2018/05/18
2	2018/06/18	MODIFICATION CONTENT	APPROVER	Itumeleng Modiba	2018/06/18
			CHECKER	Nosizo Pindela	2018/06/18
			REVISED BY	Ramokone Motama	2018/06/18
3	2018/12/12	Additional checkpoints	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	2019/11/03	Record D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	2019/11/03
			CHECKER	Nosizo Pindela	2019/11/03
			REVISED BY	Nosizo Pindela	2019/11/03
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	21/08/2019
			CHECKER	Nosizo Pindela	21/08/2019
			REVISED BY	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
20	19/04/2020	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi Collins	17/08/2021
			CHECKER	Mpho Mulaudzi	
			REVISED BY	Mpho Mulaudzi	
25	21/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombhi Collins	21/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlampe Amogelang	
			REVISED BY	Mohlampe Amogelang	
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023
			CHECKER	Mathapo Kelebone	
			REVISED BY	Mohlampe Amogelang	
28	07/11/2023	Addition of welding traceability	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Andani Muthelo	
			REVISED BY	Ntokozo Zwane	

TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
226	TC1	LUNGA 471491	06/05/24	SI.CB1210.322.V28	16

GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

Car: TC1 & TC2	NCR:	Work station: CB1210

Safety Related



I - Documentation and Instruments

I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK			Signature/Date (Manufacturing)	Signature/Date (Quality)
	52	53	54	55	56	57							
DTR30223319/3	X								✓		N/A		06/05/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

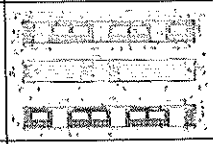
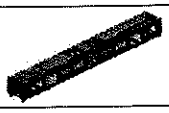
Instruments	Validation	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
TURBO LAR	52823-2	15/03/24 - 15/03/25	✓		06/05/24	
30 M TAPE	GIBTP0084	14/03/24 - 14/03/25	✓		06/05/24	
LASER TAPE	1254239241	08/01/24 - 08/01/25	✓		06/05/24	

I.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
AUTROD 308LSi	E221880	MIG	✓		06/05/24	
ER 309 LSi	518396	MIG	✓		06/05/24	06/05/24

GIBELO	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

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)	DT00000284980	✓			06/05/24	06/05/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓			06/05/24	06/05/24
03		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			06/05/24	06/05/24
04	REFER TO ANNEXURE A	Spot Welding inspected and approved according procedure	**IND-SAL-WMS-016 e DTD0000210675**	✓			06/05/24	06/05/24
05	REFER TO ANNEXURE B	Arc Welding inspected and approved according procedure.	**IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000**	✓			06/05/24	06/05/24
06		Cleaning of all Stainless Steel Surface	**According TO GIB-WEL - PROC-0002**	✓			06/05/24	06/05/24
07	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658	✓			06/05/24	06/05/24

GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
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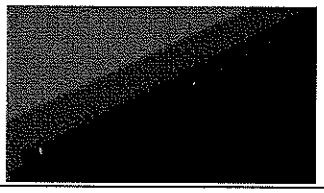
Welder traceability

Roof ring welds



LHS

Boiler maker (Name & Sign): LUNGA Welder (Name & Sign): KEITU K.McD

RHS

Boiler maker (Name & Sign): LUNGA Welder (Name & Sign): KEITU K.McD

END 1

LHS

Boiler maker (Name & Sign): LUNGA Welder (Name & Sign): KEITU K.McD

RHS

Boiler maker (Name & Sign): LUNGA Welder (Name & Sign): KEITU K.McD

END 2

LHS

Boiler maker (Name & Sign): LUNGA

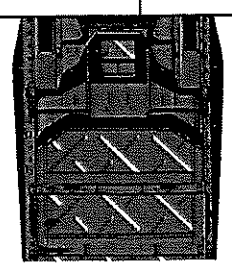
Welder (Name & Sign): MTHOKOZISI

RHS

Boiler maker (Name & Sign): LAURENCE

Welder (Name & Sign): MTHOKOZISI

EUF Reinforcement Plates

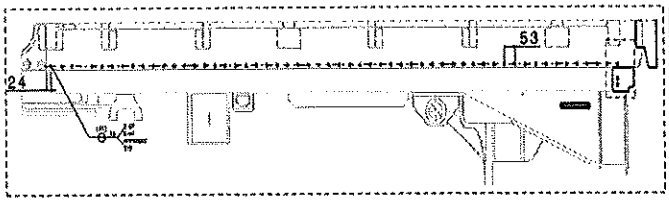


Underneath the CAR

END 2

Boiler maker (Name & Sign): MALATJI

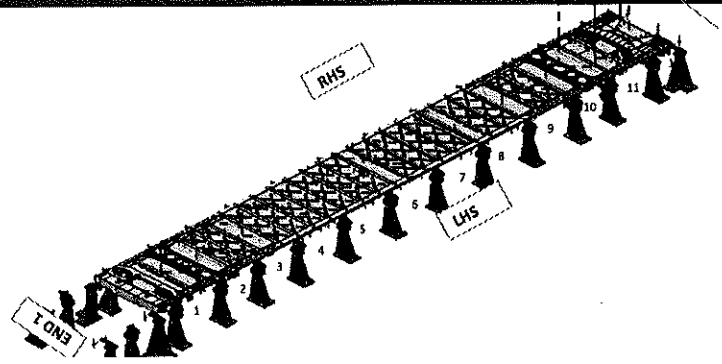
Welder (Name & Sign): Thabang Edeff



FEDOLI

Operator: WINGA

Specifications of Details for CBS measurement



GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

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

Fill in the gap foundon each jig pillars / chair and underframe should be 0mm.

After Loading Underframe and Clamping.

	1	2	3	4	5	6	7	8	9	10	11	12
Left Hand Side	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

Signature Operations: Date: 06/05/24

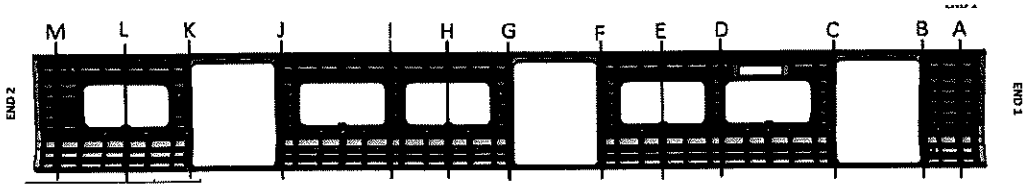
After Welding.

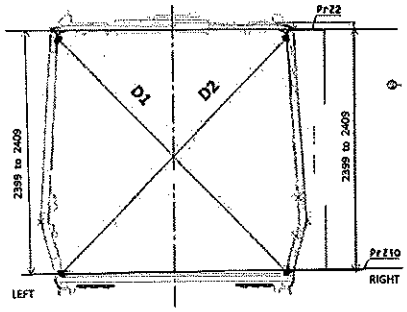
	1	2	3	4	5	6	7	8	9	10	11	12
Left Hand Side	0	0	0	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	0	0	0	0	0	0	0	0	0

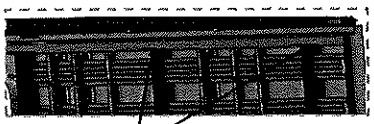
Signature Industrial Quality: Date: 06/05/24

GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

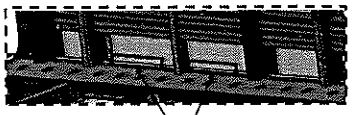
Specifications of Details for CBS measurement



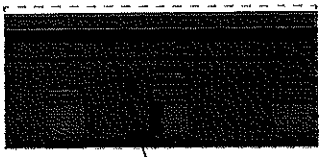




Measurement positions on roof rail and sidewall/centre corner



Measurement positions on sidewall and sidesill corner

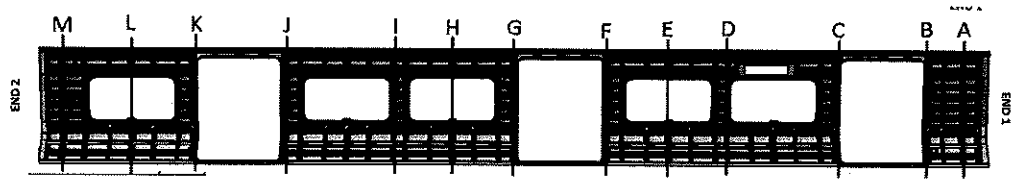


Reinforcement area measurement positions on roof reinforcement area

GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

Specifications of Details for CBS measurement

BEFORE WELDING



PME: The difference in Height values measured on the LHS and RHS should be ≤2MM on each point.

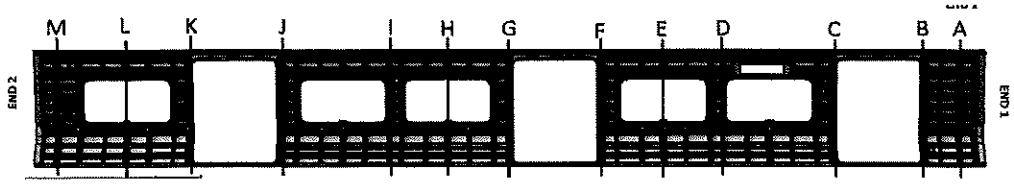
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3269	3268	1	2405	2404	1
B	3268	3268	0	2407	2406	1
C	3269	3268	1	2405	2407	2
D	3266	3265	1	2406	2406	0
E	3268	3266	2	2405	2406	1
F	3266	3268	2	2407	2405	2
G	3269	3267	2	2406	2404	2
H	3264	3265	1	2405	2405	0
I	3266	3266	0	2406	2407	1
J	3267	3269	0	2405	2406	1
K	3267	3268	1	2405	2405	0
L	3269	3265	4	2406	2407	1
M	3268	3268	0	2408	2405	0

06/05/24

GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

Specifications of Details for CBS measurement

AFTER WELDING



PME: The difference in Height values measured on the LHS and RHS should be ≤2MM on each point.

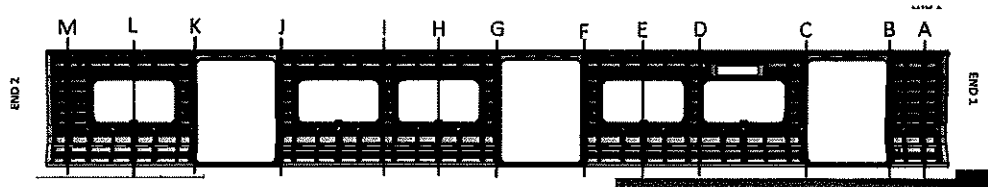
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3268	3269	1	2405	2405	0
B	3295	3295	0	2406	2405	1
C	3296	3295	1	2404	2406	2
D	3265	3265	0	2405	2405	0
E	3264	3265	1	2406	2407	1
F	3295	3295	0	2406	2404	2
G	3294	3296	2	2405	2406	1
H	3265	3266	1	2406	2406	0
I	3266	3265	1	2404	2405	1
J	3294	3296	2	2405	2407	2
K	3295	3295	0	2406	2406	0
L	3265	3268	3	2405	2407	2
M	3295	3296	1	2408	2407	1

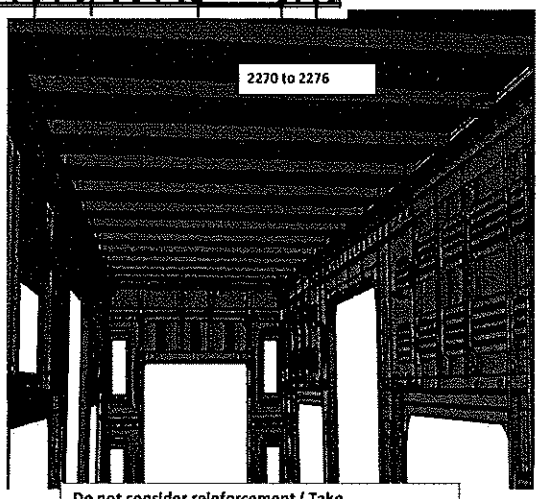
06/05/24

GIBELO	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

CBS measurement

BEFORE WELDING



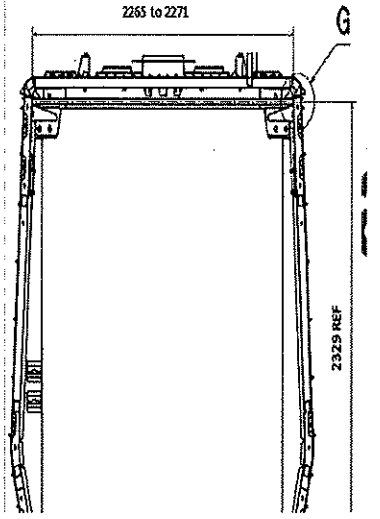


Do not consider reinforcement (Take measurements top area of zee profile

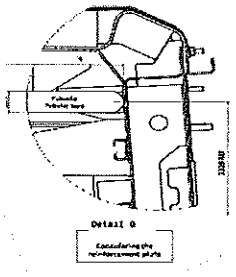
2270 to 2276

2268 & 2274

A	2274
B	2272
C	2274
D	2276
E	2276
F	2274
G	2272
H	2276
I	2277
J	2270
K	2273
L	2274
M	2271



2265 to 2271

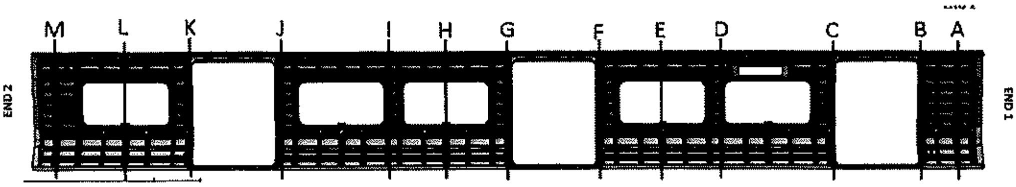


06/05/24

GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

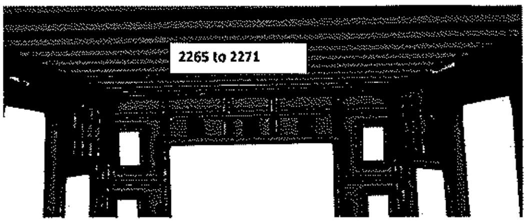
Specifications of Details for CBS measurement

AFTER WELDING

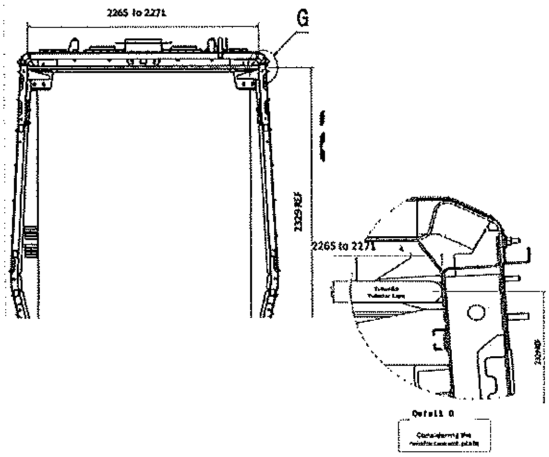


	2265 to 2271	2270 to 2276
A	NA	2274
B	2268	NA
C	2265	NA
D	NA	2276
E	NA	2274
F	2266	NA
G	2269	NA
H	NA	2275
I	NA	2276
J	2270	NA
K	2268	NA
L	NA	2274
M	2269	NA

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



Take measurement close to radius (considering reinforcement)

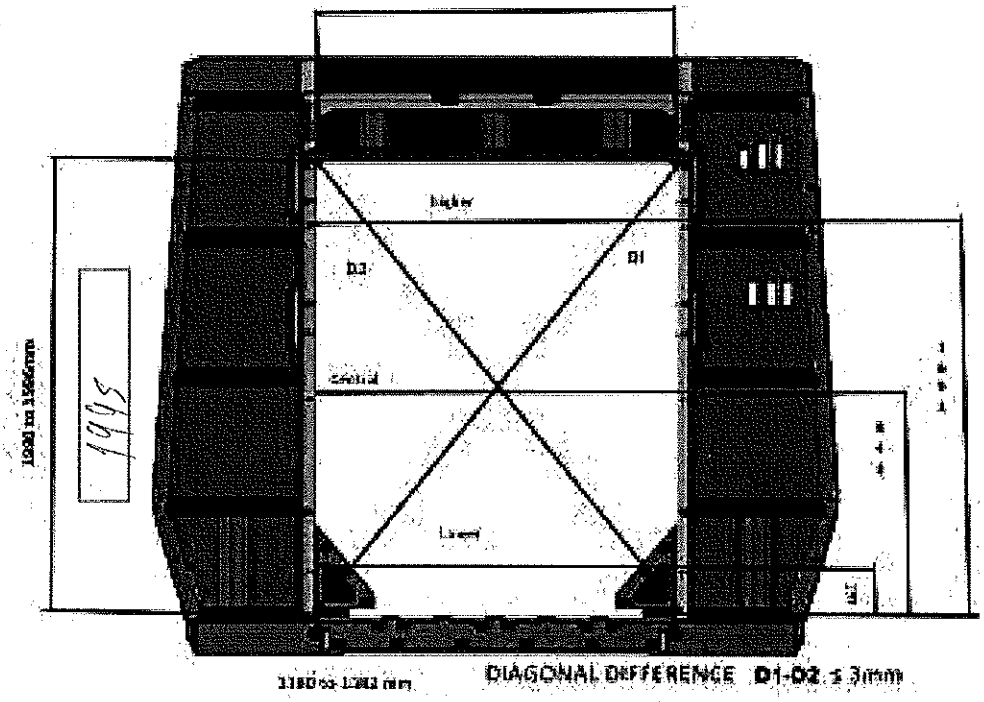


06/05/24

GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

Specifications of Details for CBS measurement

Endframe 2



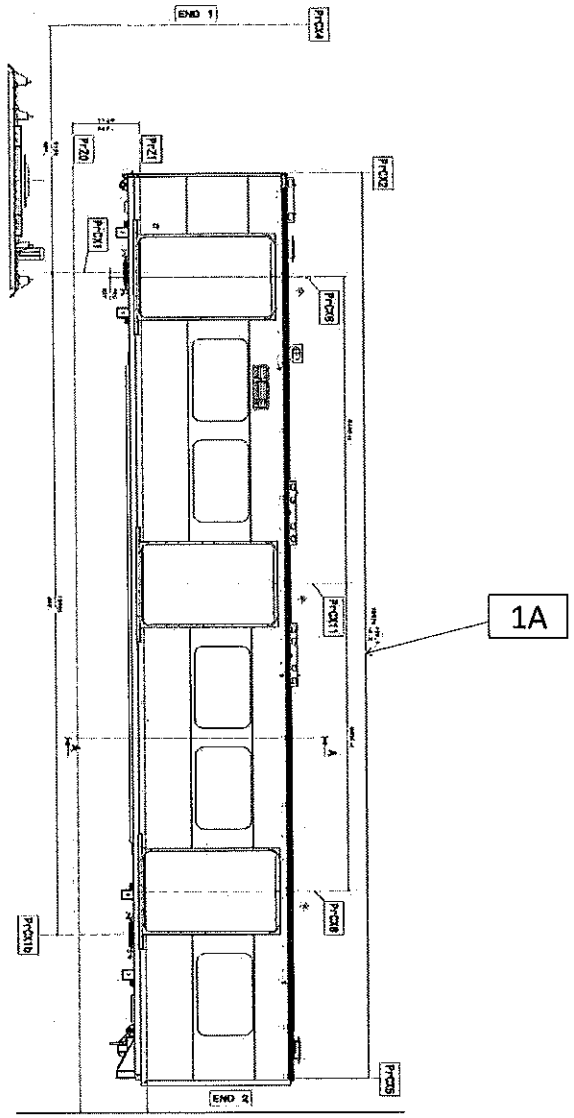
DIAGONAL DIFFERENCE D1-D2 ± 3mm

Higher Dimension	1387	D1	2414
Central Dimension	1387	D2	2413
Lower Dimension	1380	D1-D2	1

06/05/24

GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

Specifications of Details for CBS measurement



	LEFT SIDE	
	SPECIFICATION SIZE	ACTUAL SIZE
1A	18870 +10.5 -4.5	18871

	RIGHT SIDE	
	SPECIFICATION SIZE	ACTUAL SIZE
1A	18870 +10.5 -4.5	18871

Dye penetrant test

Dye-penetration test to be performed by quality personnel

GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28 Date- 07/11/2023	Project: PRASA SI.CB1210.322.V28

Item	Description of the Issue	Qty	Signature/Date (Manufacturing)	Signature/Date (Quality)

II.2 - Check List REX

Check List Items

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

GIBELO	DTR30223319/3 Carshell Assembly TC	Rev. V28 Date- 07/11/2023	Project: PRASA SI.CB1210.322.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!	26/05/24	Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	26/05/24	Quality	
			There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)		Operations	
			There are non-conformities impact the quality of the product and there is no corrective action defined yet)		Quality	

In case of "NO GO", describe blocking problems

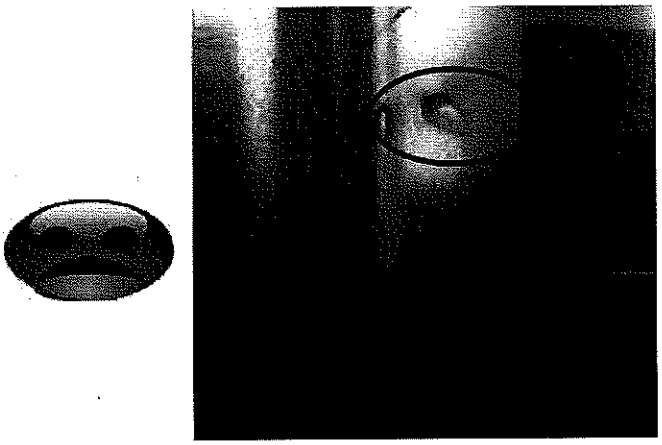
In case of "NO GO", the operations manager must define below action plan to ensure "GO":

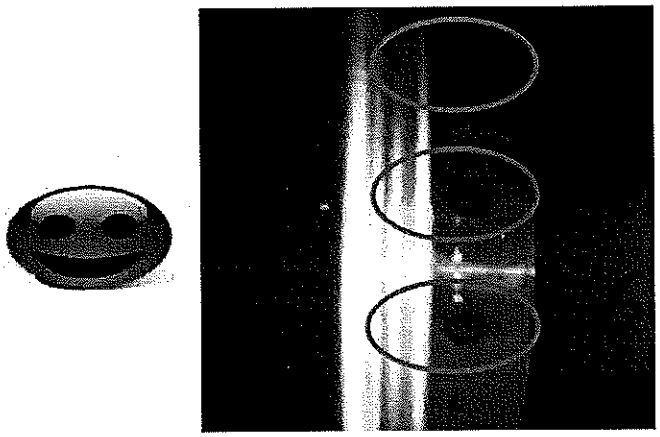
Item	Description	Action	Responsible	Due date	Status

Operations

Quality

ANNEXURE A: Spot Welding Quality Acceptance Standard





GIBELA

PRASA PROJECT

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

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

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE TC1	M1	M2	P1	P2	TC2	WORK INSTRUCTION	SAFETY?
DTR3000152664	AADD0001241013	Carshell Assembly TC	CB1230	X					X	PRA.CB1220.DTR30223 319/2.V20	YES

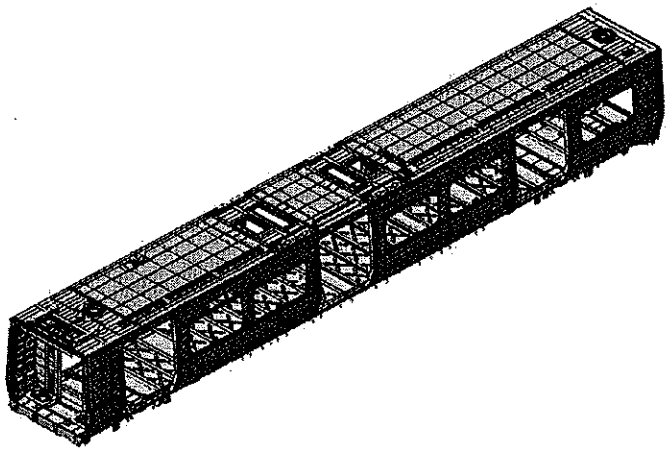
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	09/04/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	09/04/2018
			CHECKER	Nosizo Pindela	09/04/2018
			COMPILER	Thanyani Mathegu	06/04/2018
1	23/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	23/05/2018
			CHECKER	Nosizo Pindela	23/05/2018
			REVISED BY	Ramokone Motama	23/05/2018
2	05/07/2018	Certain dimensional checks added and others moved to CB1210 and CB1230	APPROVER	Itumeleng Modiba	05/07/2018
			CHECKER	Nosizo Pindela	05/07/2018
			COMPILER	Ramokone Motama	05/07/2018
3	2018/06/12	Certain dimensional checks added and others moved to CB1210 and CB1230	APPROVER	Itumeleng Modiba	2018/06/12
			CHECKER	Nosizo Pindela	2018/06/12
			COMPILER	Ramokone Motama	2018/06/12
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			COMPILER	Vanessa Ntuli	24/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection Remove length measurements	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			COMPILER	Nosizo Pindela	13/03/2019
7	20/05/2019	Removed roof width	APPROVER	Itumeleng Modiba	20/05/2019
			CHECKER	Nosizo Pindela	20/05/2019
			REVISED BY	Nosizo Pindela	20/05/2019
10	22/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	22/08/2019
			CHECKER	Nosizo Pindela	22/08/2019
			REVISED BY	Nosizo Pindela	22/08/2019
15	08/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
20	19/04/2021	New Baseline 10.2.6	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	Mulaudzi Mpho	
			REVISED BY	Mulaudzi Mpho	
25	20/02/2022	New Baseline 10.2.6	APPROVER	Mbhombhi Collins	20/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Mbhombhi Collins	14/06/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
27	17/10/2022	Addition of traceability for sealant application and welding.	APPROVER	Mbhombhi 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	Mathapo Kelebone	
			REVISED BY	Amogelang Mohlampe	

TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
226	TC1	Mashuma 410041	07/05/24	SI.CB1220.323.V29	17

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29

Carro Car: TC1, TC2	NCR:	Work station: CB1220

Safety Related



I - Documentation and Instruments

I.1 - Documentation Control

Document	Type of car TC1	M1	M2	M3	M4	TC	Revision	Observation	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
DTR30223319/2	✓						29		✓	N/A	01/03/24	01/03/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Validation	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
Tukula	32823-3	15/03/2025	✓		01/03/24	01/03/24
Measuring tape	GIBMA0299	16/04/2025	✓		01/03/24	01/03/24

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
308 1.0mm		MIG	✓		01/03/24	01/03/24

GIBELO	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
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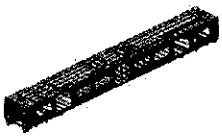
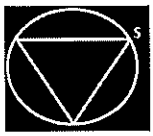
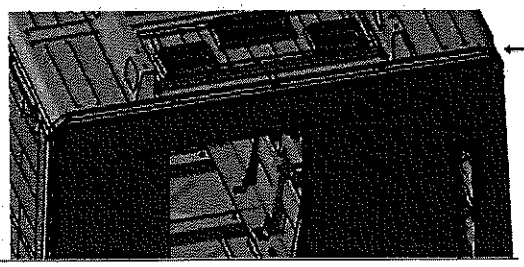
II - Control Activities of Prodution

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.	DTR30223319/2	✓			07/05/24	07/05/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓			07/05/24	07/05/24
03	REFER TO ANNEXURE A	Spot Welding inspected and approved according procedure	**IND-SAL-WMS-016 e DTD0000210675**	✓			07/05/24	07/05/24
04	REFER TO ANNEXURE B	Arc Welding inspected and approved according procedure.	**IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000**	✓			07/05/24	07/05/24
05		Cleaning of all Stainless Steel Surface	**According TO GIB-WEL - PROC-0002**	✓			07/05/24	07/05/24
06	N/A	Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			07/05/24	07/05/24
07 		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	✓			07/05/24	07/05/24
08	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: 2004935P Exp Date: ____ / 06/24 Actuals Temparature: 26 Humidity: 25	✓			07/05/24	07/05/24
09	NA	Verification of sealant application in certain regions in the drawing.	AAD0001241033	✓			07/05/24	07/05/24

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29 Date- 28/10/2023	Project: PRASA SI.CB1220.323.V29					
10	NA	Verification of sealant application on the roof and sidewall finishers	Sealant must be: -Applied straight and even (1.5mm) -Free of gaps,cracks,damage and debris (flashes, dirt, dust) **Refer to Annexure B**	✓			~~[illegible]~~ 07/04/24	~~[illegible]~~ 07/04/24

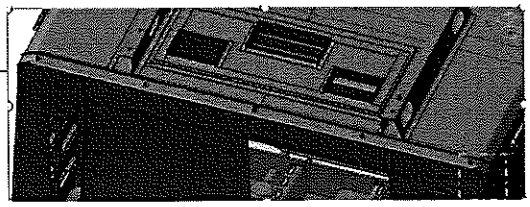
GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29



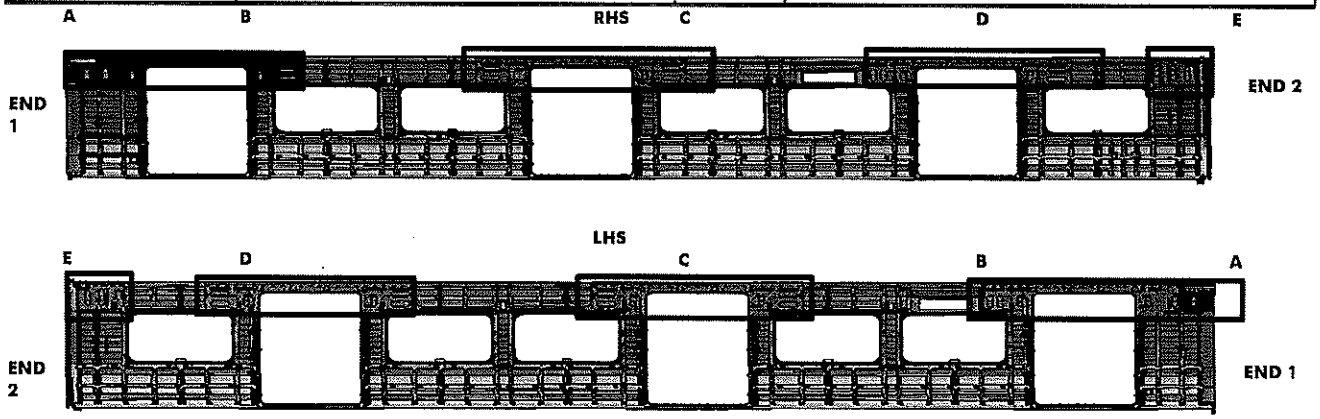
END 1 SEALANT

OPERATOR (Name & sign): Mthokozisi

OPERATOR (Name & sign): Mthokozisi



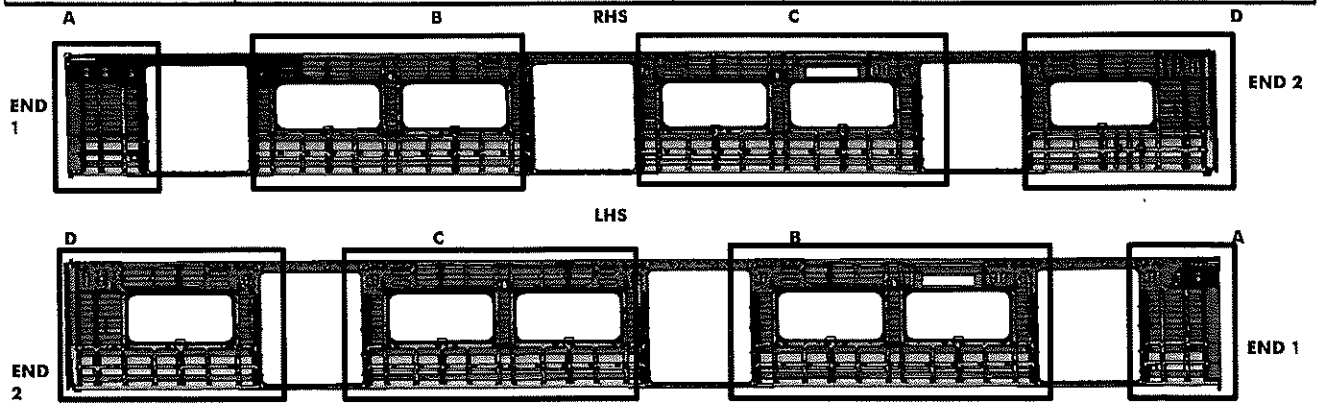
GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29



REINFORCEMENT WELDING

AREA		LHS	RHS
A	Operator (Name&sign):		
B	Operator (Name&sign):		
C	Operator (Name&sign):		
D	Operator (Name&sign):		
E	Operator (Name&sign):		

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29



BRACKETING

INSTALLATION

C-RAILS:	Operator:	Priscilla
	Operator:	
DOOR MECHANISMS:	Operator:	Mashuda
	Operator:	
TAPPING PADS	Operator:	Priscilla
	Operator:	

INSTALLATION & VERIFICATION

SEAT & LUGGAGE BRACKETS:	Operator:	I
	Operator:	
SEAT BRACKETS VERIFICATION:	Operator:	
	Operator:	

WELDING

AREA		LHS	RHS
A (Seat brackets)	: Operator (Name&sign):	N/A	N/A
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	N/A	N/A
B (Seat brackets)	: Operator (Name&sign):		
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):		
C (Seat brackets)	: Operator (Name&sign):		
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	THULANI	
D (Seat brackets)	Operator (Name&sign):	THULANI	THULANI
(C-rails, Luggage and earth bushes)	: Operator (Name&sign):	THULANI	

ENDS

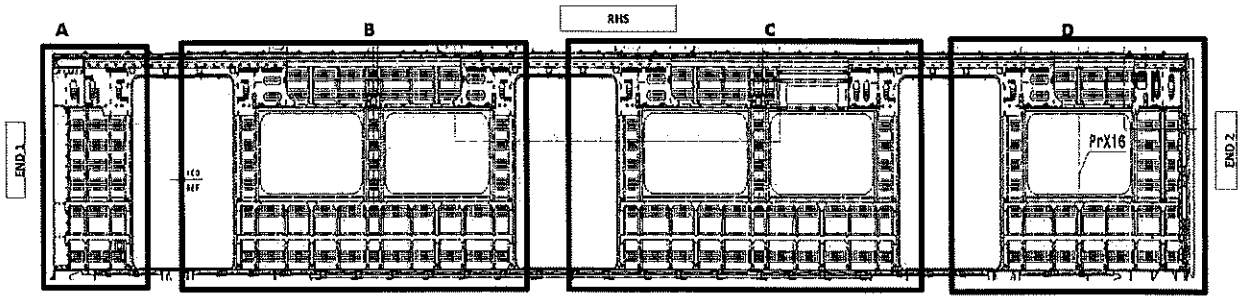
END 1 TAPPING PADS WELDING: **Operator (Name&sign):** N/A

END 2 TAPPING PADS WELDING: **Operator (Name&sign):** THULANI

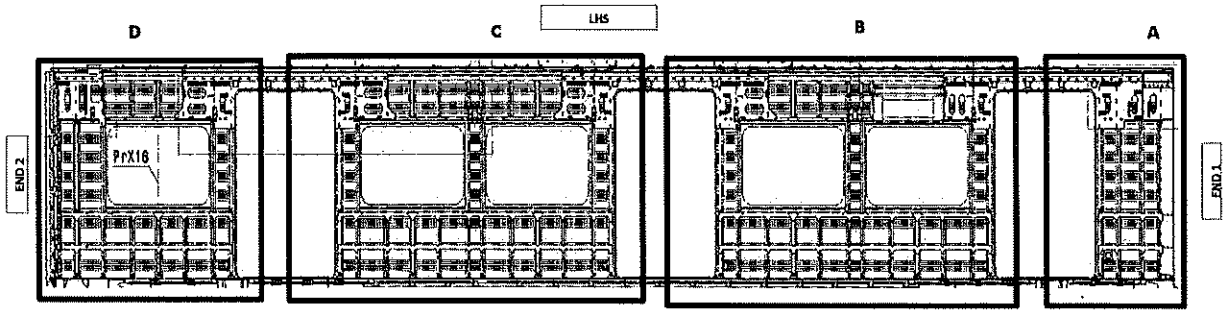
GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29

TC BRACKET INSTALLATION

RHS



LHS



QUANTITIES (TC)

RHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	4	✓	
	B	4	✓	
	C	8	✓	
	D	12	✓	
SEAT BRACKETS	A	0	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	1	✓	
	B	4	✓	
	C	5	✓	
	D	4	✓	

ROOF ENDS:

CRAILS 2 OFF END 2
EARTH BUSH 4 OFF END 2

VERIFICATION BY: Mashudu

LHS

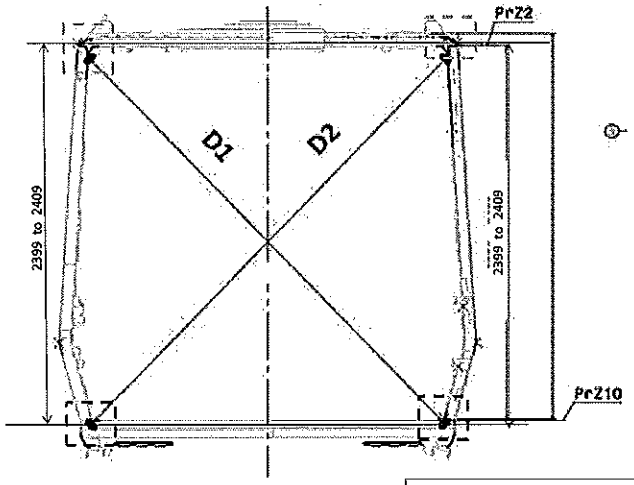
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	4	✓	
	B	8	✓	
	C	4	✓	
	D	6	✓	
SEAT BRACKETS	A	0	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	1	✓	
	B	4	✓	
	C	4	✓	
	D	2	✓	

ROOF ENDS:

CRAILS 2 OFF END 2
EARTH BUSH 4 OFF END 2

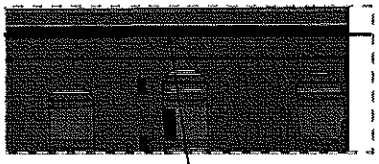
VERIFICATION BY: Mashudu

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29



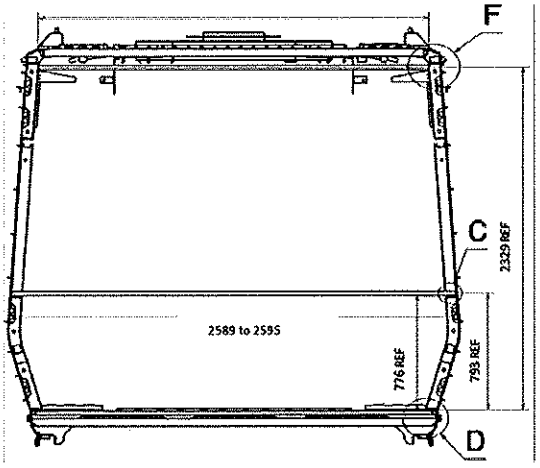
Take measurement close to radius

Measurement positions on roof rail and sidewall omega corner.



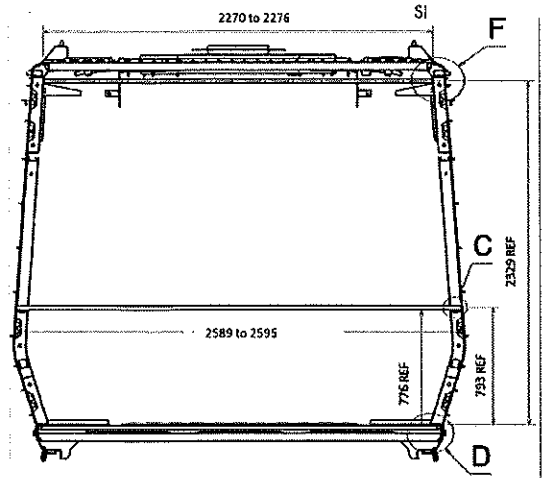
Reinforcement area measurement positions on roof reinforcement area.

Measurement positions on sidewall and side sill corner.

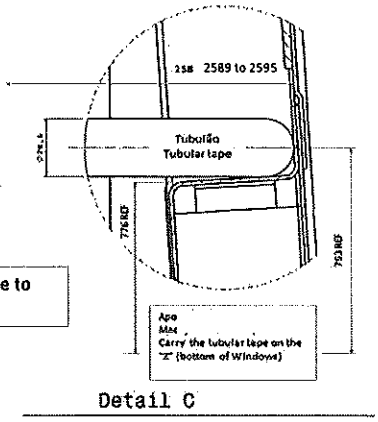


Take measurement close to radius

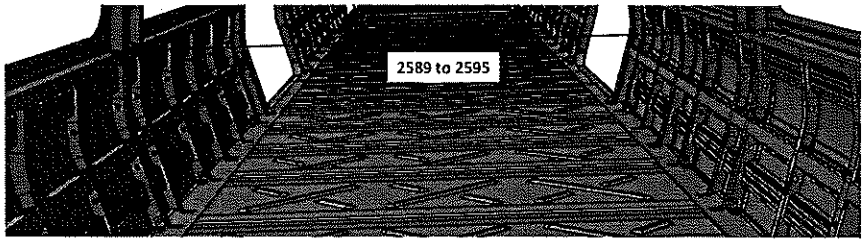
GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29

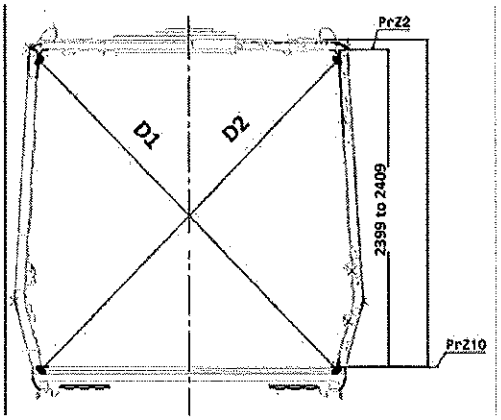


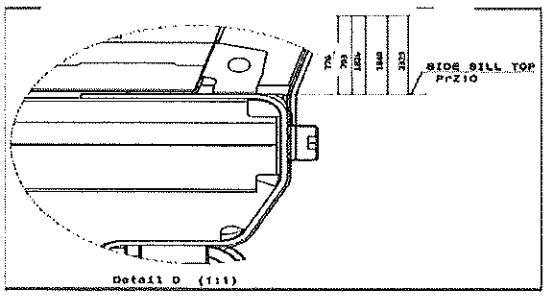
Take measurement close to radius



Detail C

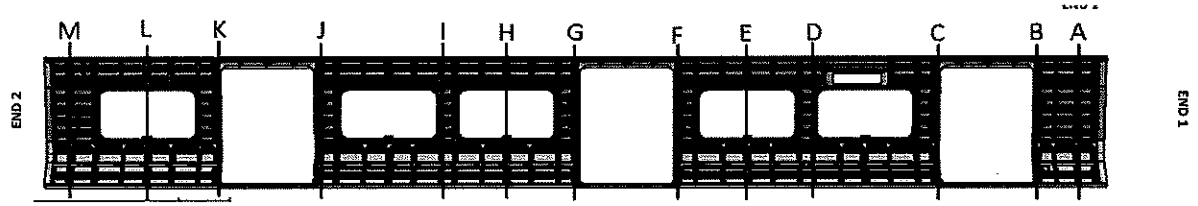






Detail D (1:1)

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29



BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3268	3264	4	—
B	3297	3294	3	—
C	3294	3294	0	—
D	3265	3265	0	—
E	3264	3266	2	—
F	3297	3296	1	—
G	3300	3295	5	—
H	3265	3264	1	—
I	3268	3266	2	—
J	3295	3298	3	—
K	3296	3298	2	—
L	3268	3267	1	—
M	3298	3303	4	—

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
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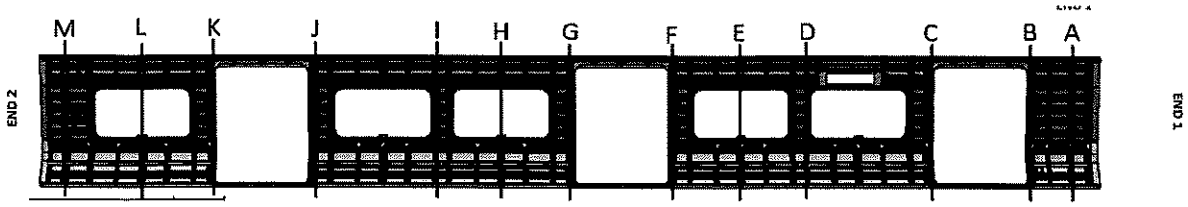
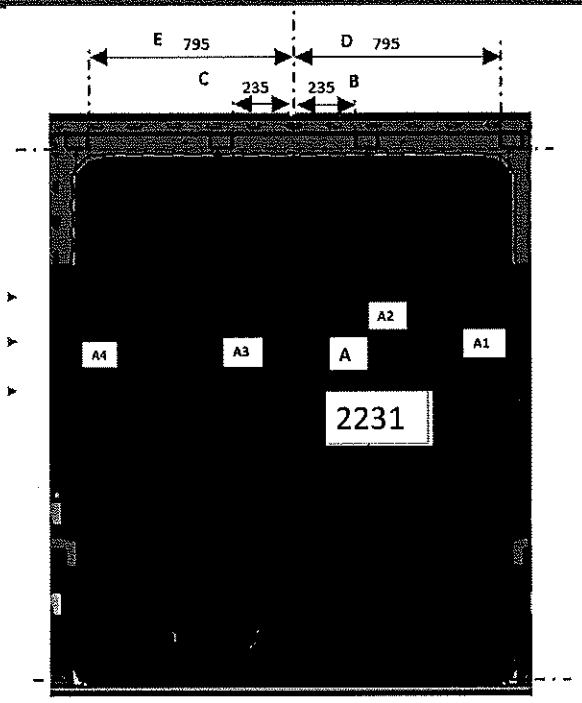


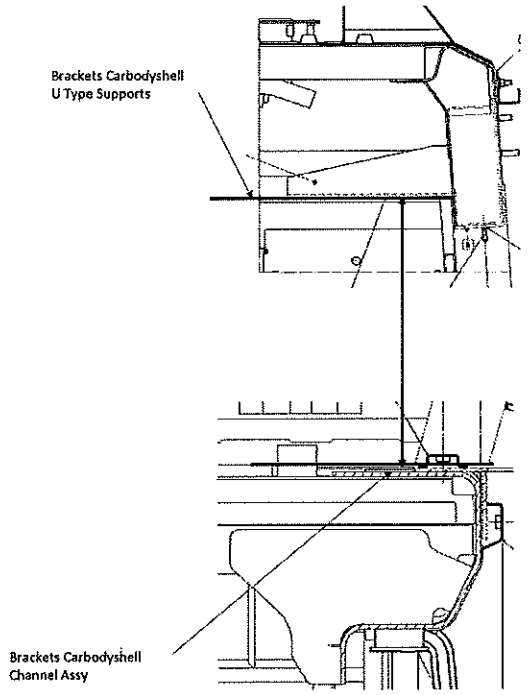
AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3297	3295	2	2594
B	3296	3294	2	2591
C	3295	3294	1	2590
D	3267	3265	2	2594
E	3266	3265	1	2592
F	3296	3297	1	2589
G	3299	3300	1	2590
H	3264	3267	3	2595
I	3267	3269	2	2591
J	3297	3295	2	2592
K	3297	3296	1	2594
L	3267	3265	2	2593
M	3299	3302	3	2594

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29

Specifications of Details for CBS measurement





DOOR 1 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2233
A2	2230 to 2232	2232
A3	2230 to 2232	2232
A4	2230 to 2232	2233
B	234 to 236	235
C	234 to 236	235
D	794 to 796	796
E	794 to 796	795

DOOR 2 - LHS

	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2232
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 3 - LHS

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

DOOR 1 - RHS

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

DOOR 2 - RHS

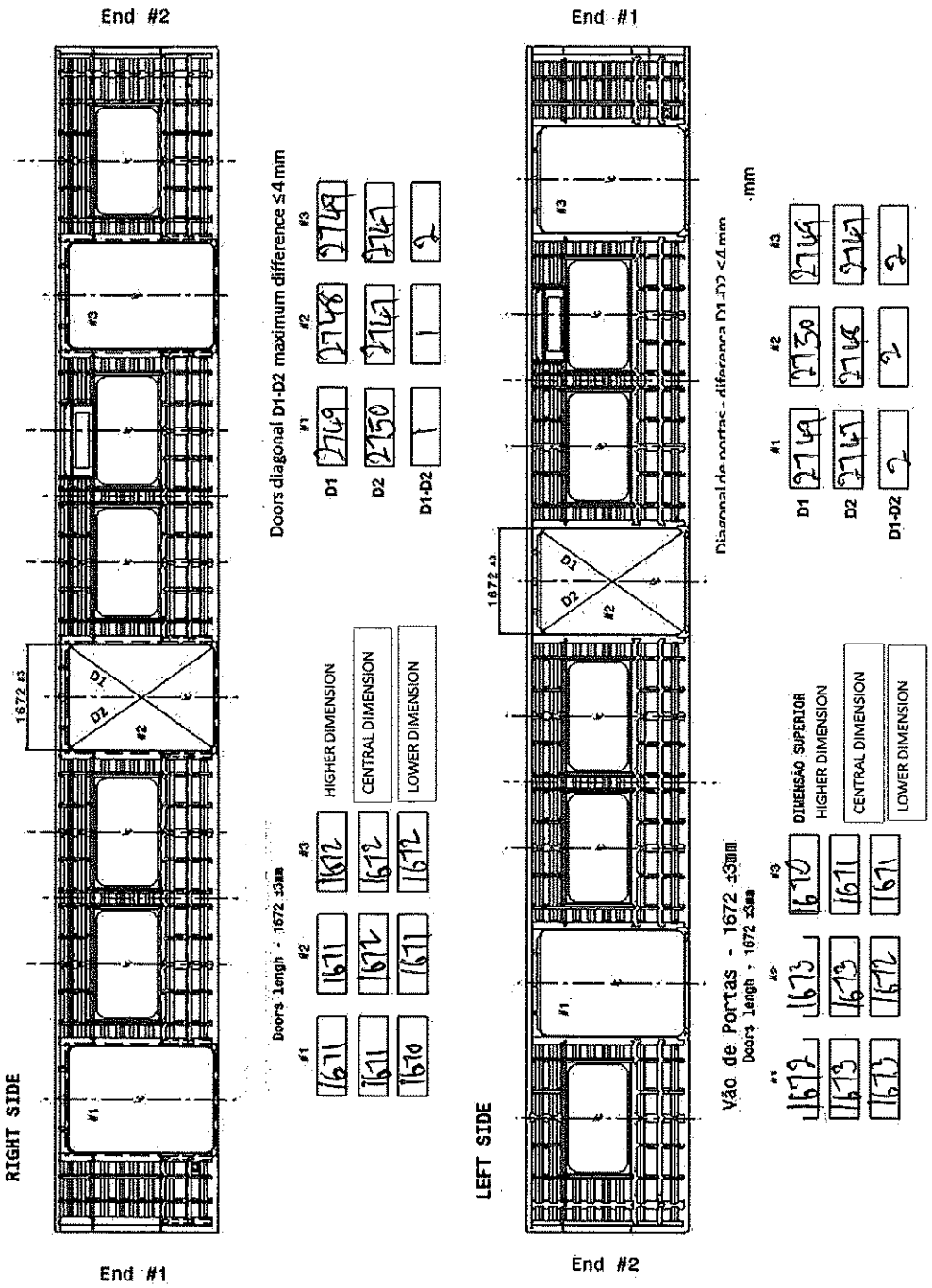
	VALUE	ACTUAL
A1	2230 to 2232	2232
A2	2230 to 2232	2231
A3	2230 to 2232	2231
A4	2230 to 2232	2232
B	234 to 236	235
C	234 to 236	235
D	794 to 796	795
E	794 to 796	796

DOOR 3 - RHS

	VALUE	ACTUAL
A1	2230 to 2232	2234
A2	2230 to 2232	2232
A3	2230 to 2232	2232
A4	2230 to 2232	2233
B	234 to 236	235
C	234 to 236	235
D	794 to 796	795
E	794 to 796	796

GIBELA	DTR30223319/2 Carsheil Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB1220.323.V29

Specifications of Details for CBS measurement



GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29 Date- 28/10/2023	Project: PRASA SI.CB1220.323.V29

Specifications of Details for CBS measurement

Dye penetrant test

Dye-penetration test to be performed by quality personnel

Item	Description of the issue	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)

II.2 - Check List REX

Check List Items

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

GIBELA	DTR30223319/2 Carshell Assembly TC	Rev. 29 Date- 28/10/2023	Project: PRASA SI.CB1220.323.V29

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!	07/05/2024	Mashudu Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	07/05/2024	Andani Industrial Quality	
			There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)		Operations	
			There are non-conformities impact the quality of the product and there is no corrective action defined yet)		Industrial Quality	

In case of "NO GO", describe blocking problems

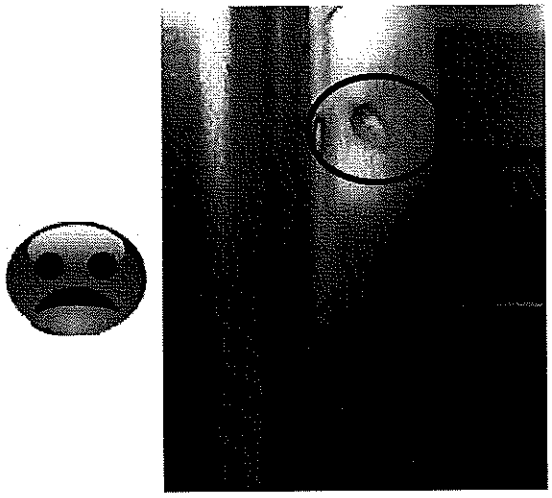
In case of "NO GO", the operations manager must define below action plan to ensure "GO":

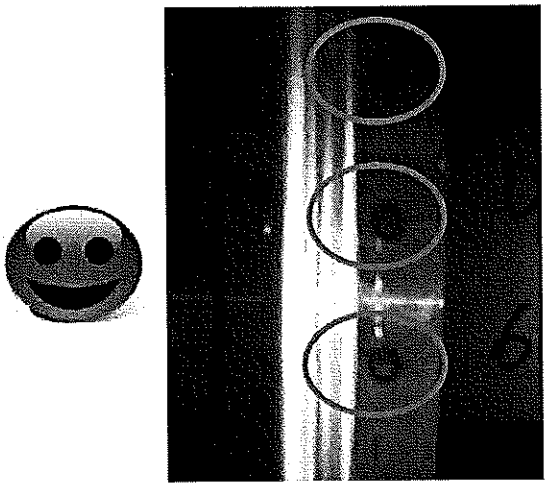
Item	Description	Action	Responsible	Due date	Status

Operations

Quality

ANNEXURE A: Spot Welding Quality Acceptance Standard





PRASA PROJECT

GIBELA

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 TC1	M1	M3	M2	M0	TC	WORK INSTRUCTION	SAFETY
DT000012331	AAD00131531	DT000012331 Carbody Assembly TC	CB2230	X					X	PRA.CB2230.DT0000012 23319.V20	YES

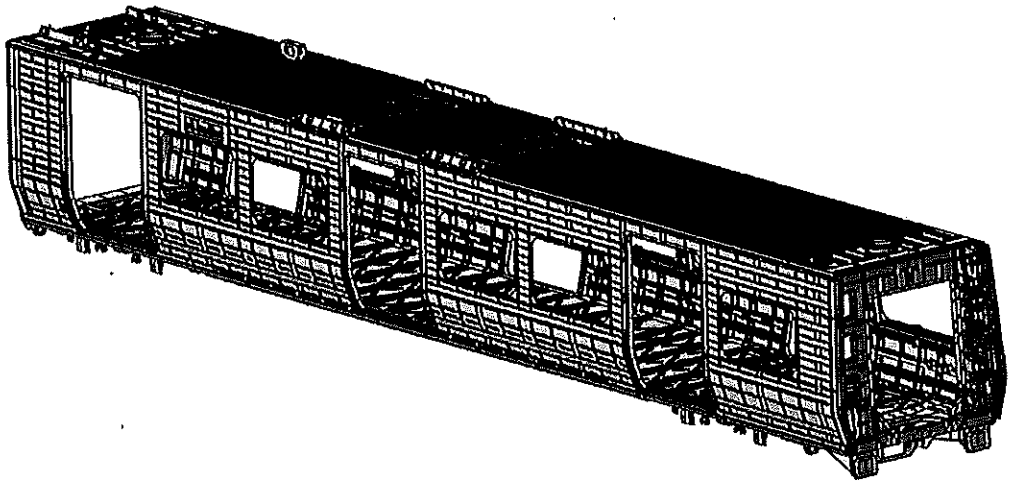
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	06/04/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	07/04/2018
			CHECKER	Nosizo Pindela	09/04/2018
			COMPILER	Itanyani Mathego	06/04/2018
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PMC Manager to Quality manager	APPROVER	Itumeleng Modiba	30/5/2018
			CHECKER	Nosizo Pindela	30/5/2018
			REVISED BY	Nosizo Pindela	30/5/2018
2	05/07/2018	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	05/07/2018
			CHECKER	Nosizo Pindela	05/07/2018
			COMPILER	Ramokone Matama	05/07/2018
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			REVISED BY	Vanessa Nuh	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
			COMPILER	Nosizo Pindela	13/03/2019
7	17/09/2019	Added Cab Fire Barrier Flatness Measurements	APPROVER	Itumeleng Modiba	17/09/2019
			CHECKER	Nosizo Pindela	17/09/2019
			COMPILER	Nosizo Pindela	17/09/2019
10	20/09/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	20/09/2019
			CHECKER	Nosizo Pindela	20/09/2019
			COMPILER	Nosizo Pindela	20/09/2019
15	28/01/2021	New Baseline 10.2.6	APPROVER	Timothy Mabmela	28/01/2021
			CHECKER	Bongane Masina	28/01/2021
			COMPILER	Bongane Masina	28/01/2021
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Mabmela	13/04/2021
			CHECKER	Bongane Masina	19/04/2021
			COMPILER	Bongane Masina	19/04/2021
25	20/04/2022	New Baseline change 10.3.1	APPROVER	Collins Mthombeni	20/07/2022
			CHECKER	Andani Mathelo	20/07/2022
			COMPILER	Andani Mathelo	20/07/2022
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mthombeni	14/06/2022
			CHECKER	Andani Mathelo	
			COMPILER	Andani Mathelo	
27	27/07/2022	Threashold measurements addition	APPROVER	Collins Mthombeni	27/07/2022
			CHECKER	Andani Mathelo	
			COMPILER	Andani Mathelo	
28	19/10/2022	Addition of traceability for sealant application	APPROVER	Collins Mthombeni	19/10/2022
			CHECKER	Nkosazo Zwane	
			COMPILER	Amogelang Mohlampe	
29	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Nuh	14/04/2023
			CHECKER	Nkosazo Zwane	
			COMPILER	Amogelang Mohlampe	
30	06/11/2023	Added threashold traceability for boiler makers and welders	APPROVER	Tyson Ngobeni	06/11/2023
			CHECKER	Andani Mathelo	
			COMPILER	Nkosazo Zwane	

TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
226	TC1	Zaneke 482774	08/08/23	SI.CB2230.324.V29	12

GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30 Date- 06/11/2023	Project: PRASA SI.CB2230.324.V29

Carro Car.	NCR:	Work station: CB2230

Safety Related



I - Documentation and Instruments

I.1 - Documentation Control

Document	Type of car TC1	MT	M2	M3	M4	TC2	Revision	Observation	OK	NOK	Rework	Signature/Date (Operations)	Signature/Date (Quality)
DT00000223319	X						30		X		N/A	08/05/24	08/05/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Validation	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
Tubular	TB-22 713	26/06/24	X		08/05/24	08/05/24
Combination Square	GIB6794	25/04/25	X		08/05/24	08/05/24
Tape measurement	GIB01916	27/07/24	X		08/05/24	08/05/24

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 CSi	373179	Mig	X		08/05/24	08/05/24
ISK 70-03	ISK 70-03	Tig	X		08/05/24	08/05/24

II - Control Activities of Prodution

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 nº DT00000223319	DT00000223319	✓			08/05/24	08/05/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓			08/05/24	08/05/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 DTD0000210675				08/05/24	08/05/24
04	N/A	Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			08/05/24	08/05/24
05	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	✓			08/05/24	08/05/24
06	N/A	Before appplication of sealant record the expiry date and make sure that the room temperature and humidity are withion 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% - 80%	Sealant Batch No: FA0335014051 Exp Date: 15 /06 /24 Actuals Temperature: 15°C Humidity: 50%	✓			08/05/24	08/05/24
07	N/A	Verification of sealant application in regions of roof and sideframe finishers.	Sealant must be: -Applied straight and even (1.5mm) -Free of gaps,cracks,damage and debris (flashes, dirt, dust) Refer to Annexure B	✓			08/05/24	08/05/24

GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
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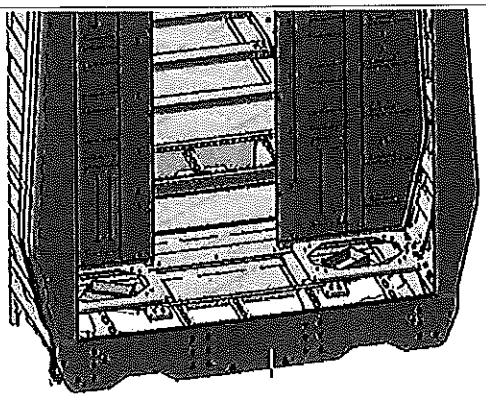
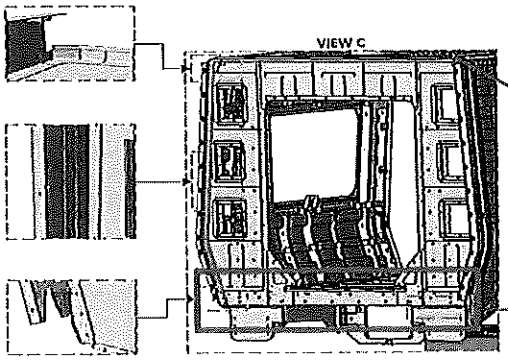
VIEW A



END 1 SEALANT

OPERATOR (Name & sign): Eyvie

OPERATOR (Name & sign): Boikumelo

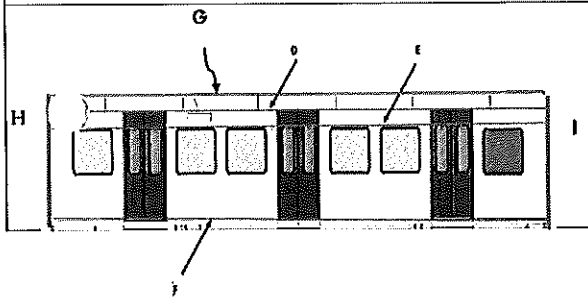


END 2 SEALANT (VIEW C)

OPERATOR (Name & sign): Leroy

OPERATOR (Name & sign): Leroy

OPERATOR (Name & sign): Derrick



Area D,E,F,G,H,I	LHS	RHS
Operator(Name & sign) :	D,E,F,G,H,I	D,E,F,G,H,I
Operator (Name & sign) :	Eyvie	Eyvie
Operator (Name & sign) :	Boikumelo	Boikumelo
Operator (Name & sign) :		
Operator (Name & sign) :		
Operator (Name & sign) :		

	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
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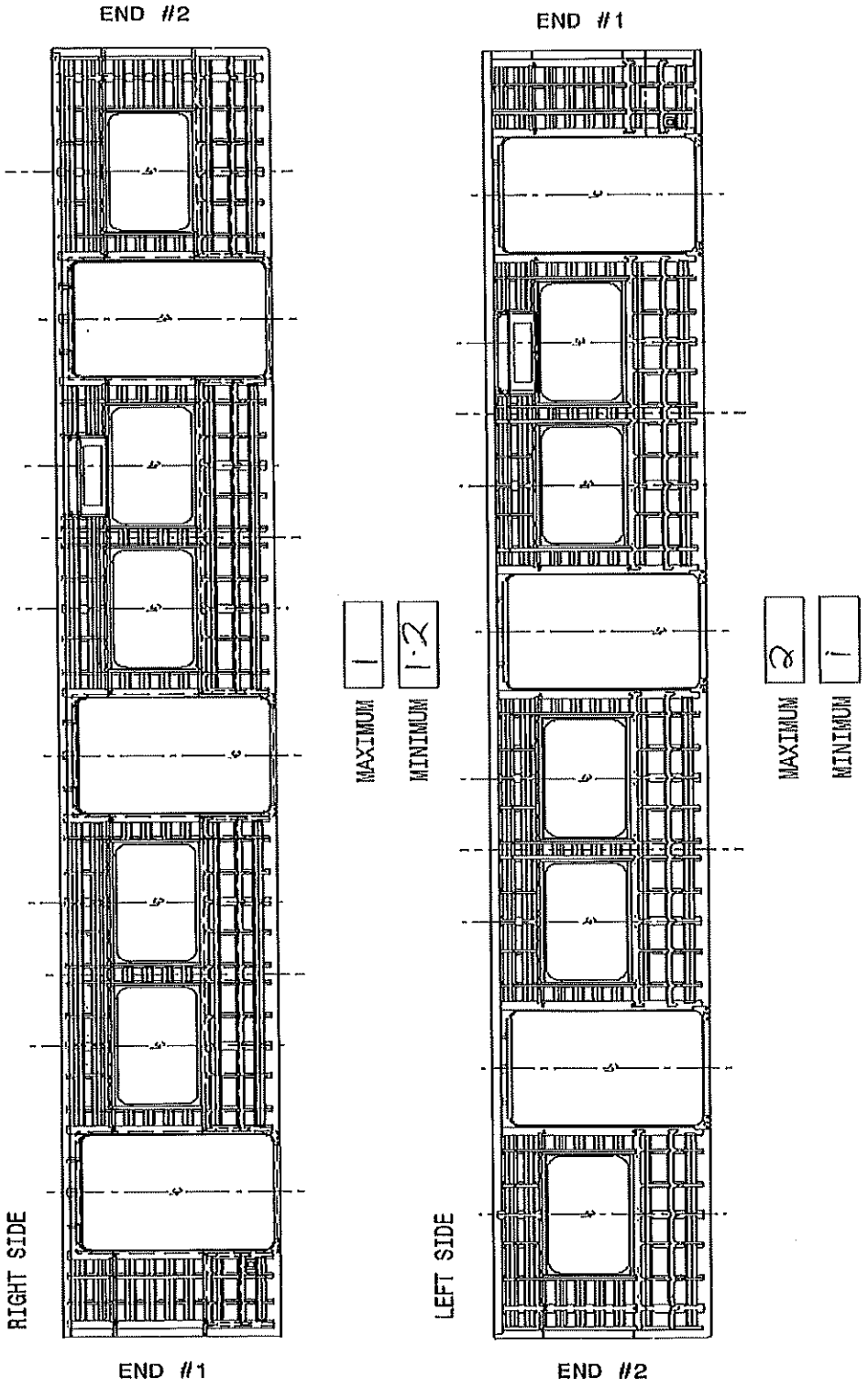
Specifications of Details for CBS measurement CB2230

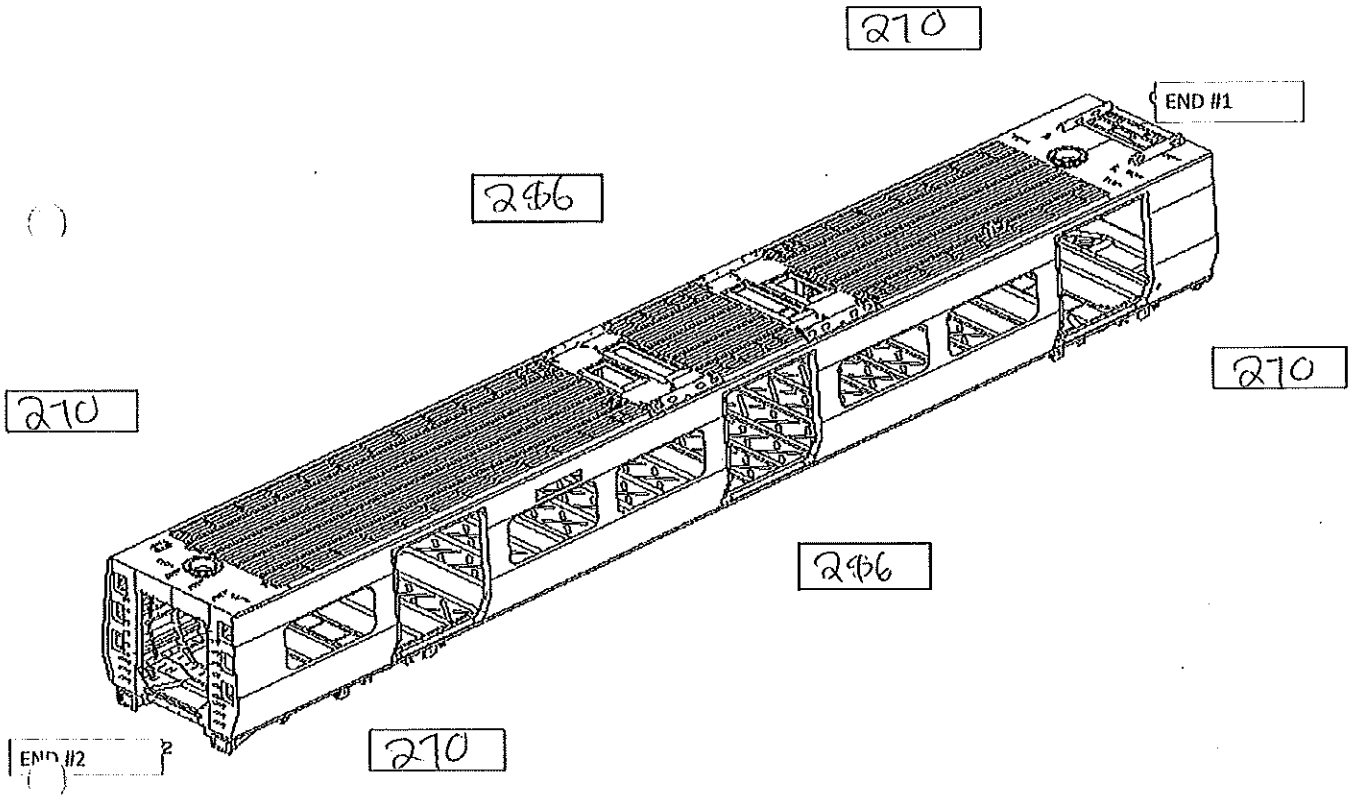
Flatness side left and right maximum of 2mm in the valley to peak measured in 900mm.
Recod the maximum and minimum value foundand indicate the corresponding region.



GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
		Date- 06/11/2023	SI.CB2230.324.V29

Specifications of Details for CBS measurement CB2230

Specified Camber for car out of jig is 16mm (-0mm + 2mm)



MEASURED CAMBER VALUES	
RIGHT	16
LEFT	16

GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
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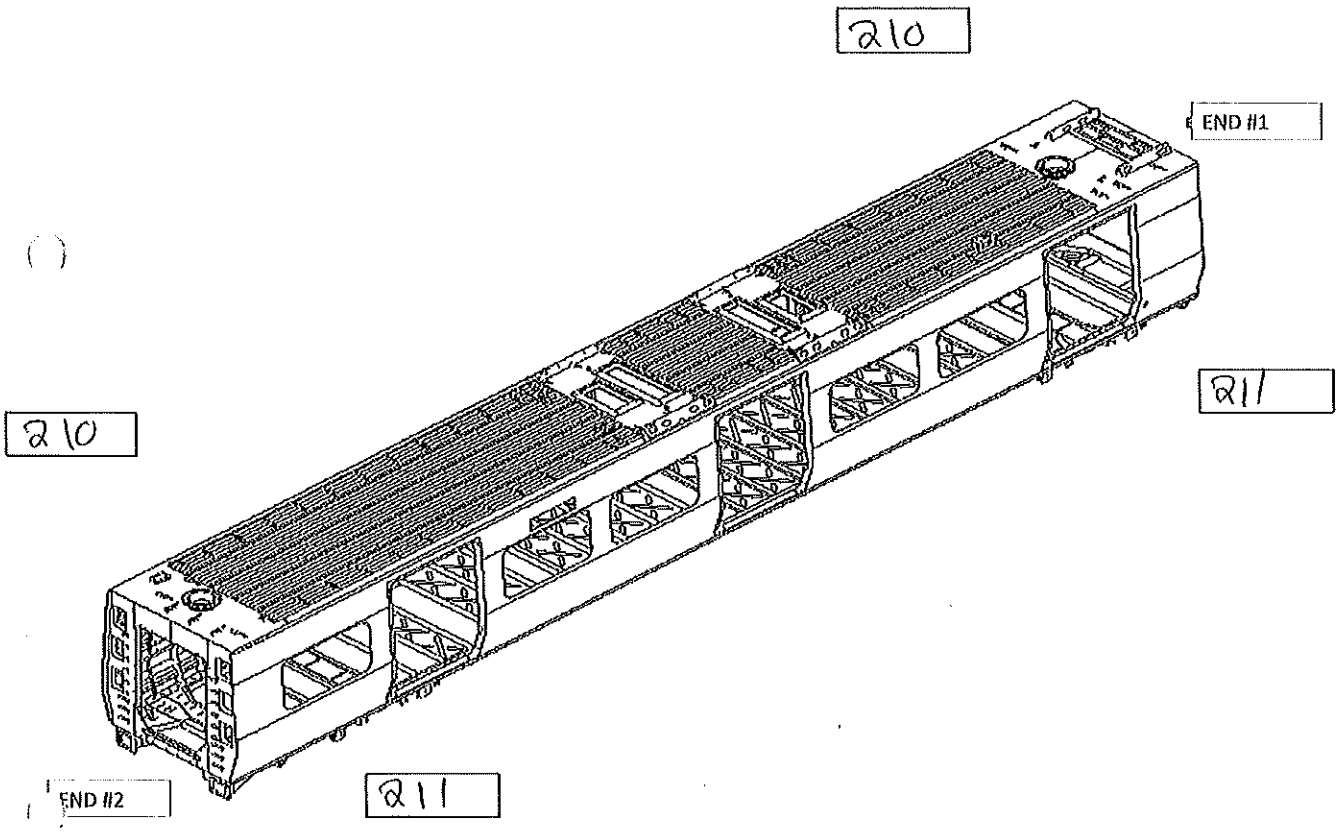
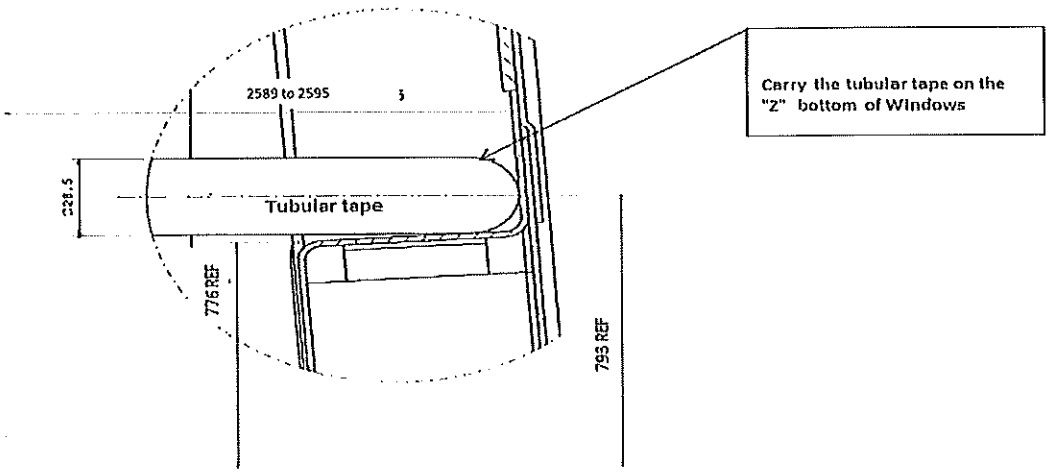
Specifications of Details for CBS measurement CB2230

Twist measured in transversal and longitudinal = Maximum 3mm. Measure twist on air spring plates (LHS and RHS), both End 1 and End 2 folllowing twist measurement document.

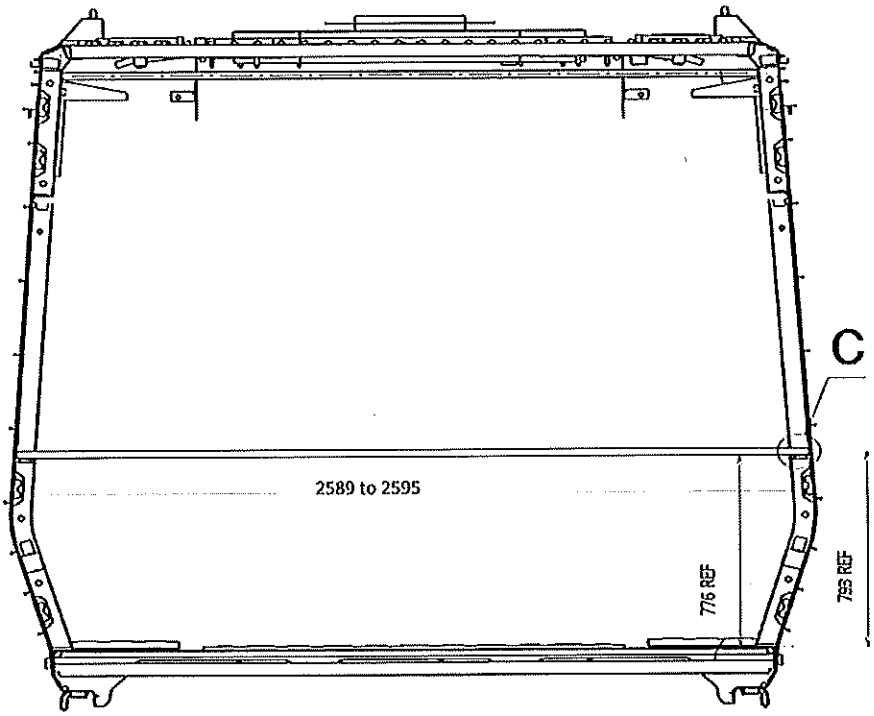


MEASURED TWIST VALUES END 1		MEASURED TWIST VALUES END 2	
LATERAL	1	LATERAL	1
LONGITUDINAL	0	LONGITUDINAL	0

Details for measuring on the CB1230 stage, after completion of activities

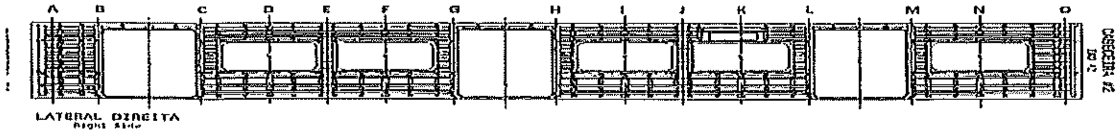


Detail C



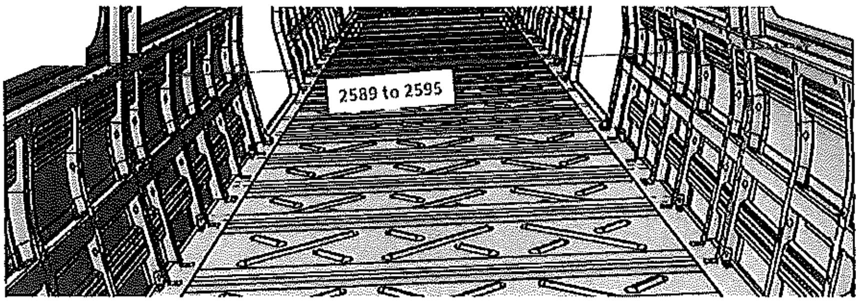
GIBELA	DT00000223310 Carshell Assembly TC	Rev. 30 Date- 06/11/2023	Project: PRASA SI.CB2230.324.V29

Specifications of Details for CBS measurement



2589 to 2595mm

A	2596
B	2591
C	2589
D	2595
E	2595
F	2590
G	2590
H	2592
I	2591
J	2591
K	2589
L	2590
M	2594
N	2593
O	2595



Threashold verification

Nominal value :38

Door 1		Door 2		Door 3	
L	R	L	R	L	R
38	38	38	38	38	38

Door 4		Door 5		Door 6	
L	R	L	R	L	R
38	38	38	38	38	38

BOILER MAKER: Kyo130

WELDER: mmathapelo

GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
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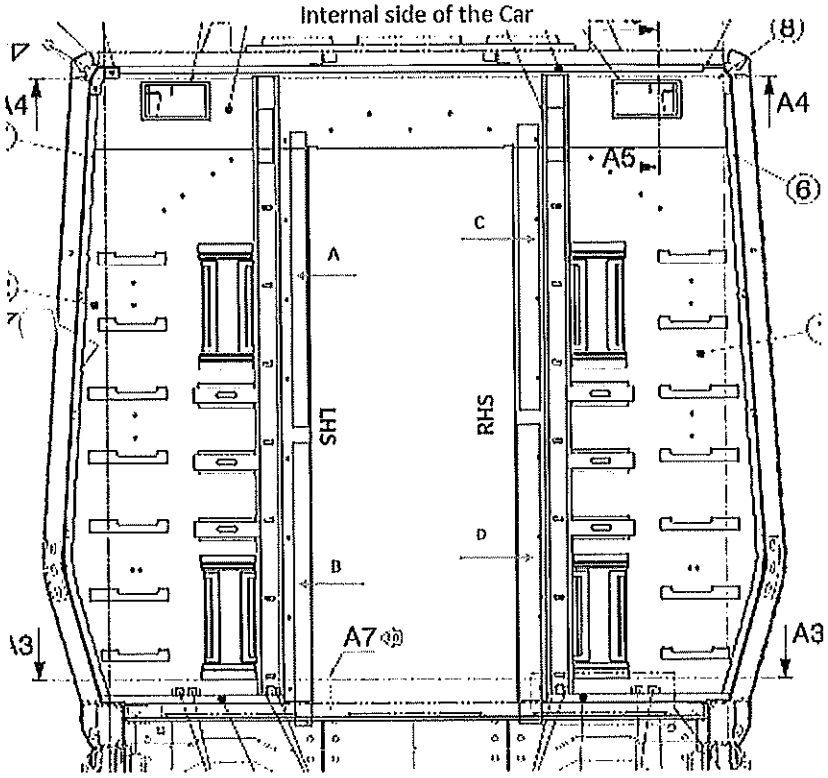
Specifications of Details for CBS measurement

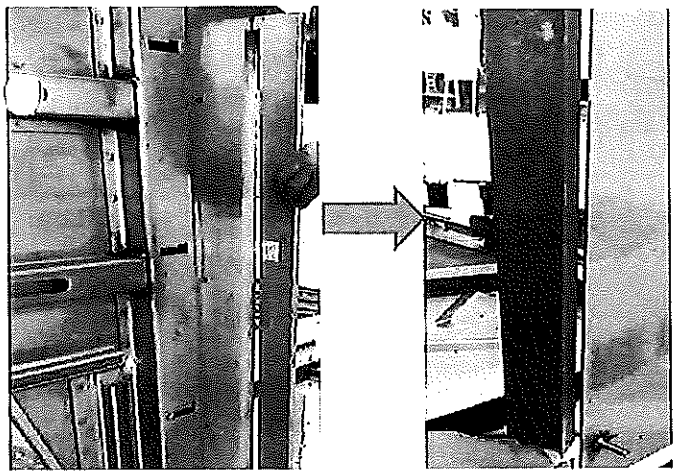
Measure the flatness on the Cab Fire Barrier after installation and welding. Measure positions A, B,C and D using 1000mm flatness ruler and taper gauge.

Specified Maximum Flatness deviation on Cab Fire Barrier = 2mm

Internal side of the Car



	Measured Values		
	Minimum	Maximum	Deviation
A	9.2	10.1	1.9
B	9.2	9.6	0.4
C	10.1	11.2	1.1
D	11.1	11.8	0.7



GIBELO	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
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Dye penetrant test

Dye-penetration test to be performed by quality personnel

Item	Description of the Issue	OK	Signature/Date (Operations)	Signature/Date (Quality)

II.2 - Check List REX

Check List Items

Item	Picture/Drawing	Description	Criteria /Record	OK	NOK	Rework	Signature/Date (Team Leader)	Signature/Date (Quality Technician
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX					

GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
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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!	08/06/24	Zanele Mahlangu Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	08/06/24	Industrial Quality	
	( )	NO GO	There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)		Operations	
			There are non-conformities impact the quality of the product and there is no corrective action defined yet)		Industrial Quality	

In case of "NO GO", describe blocking problems

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

Item	Description	Action	Responsible	Due date	Status

( ) _____ Operations

_____ Quality