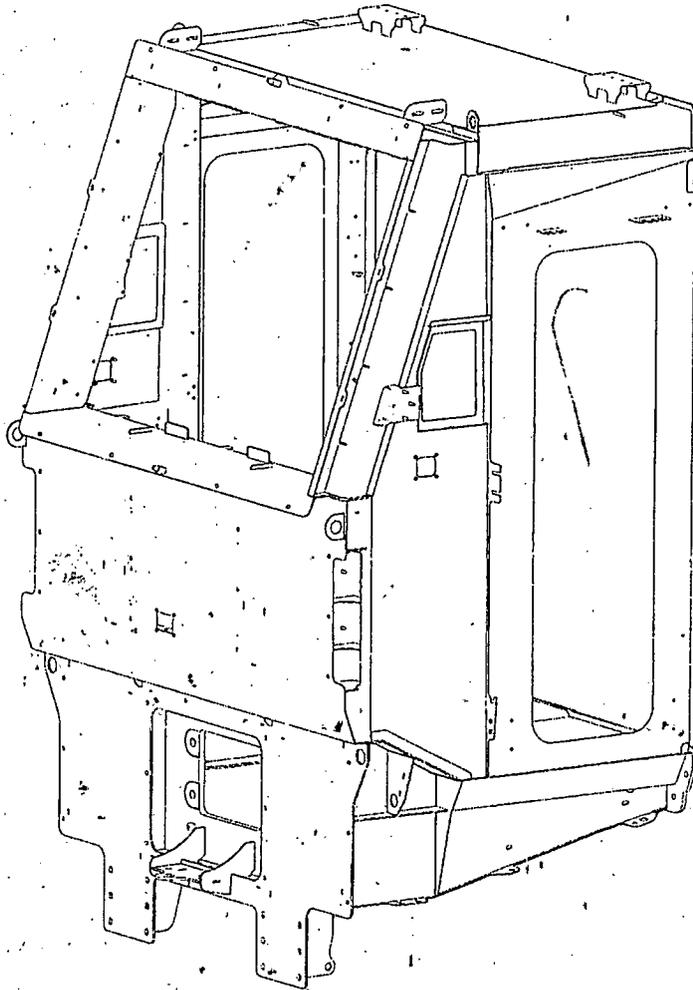


GLOBAL

MANUFACTURING
SOLUTIONS



CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 456

WEIGHT: 1483 Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	05/02/24	178247 104525 01	LP49402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	14/02/24	178820 104640 01	P300091 F205272	
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegasus	28/02/24	178488 104640 01	P300091 P300091	
RCS 355	20 mm					

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

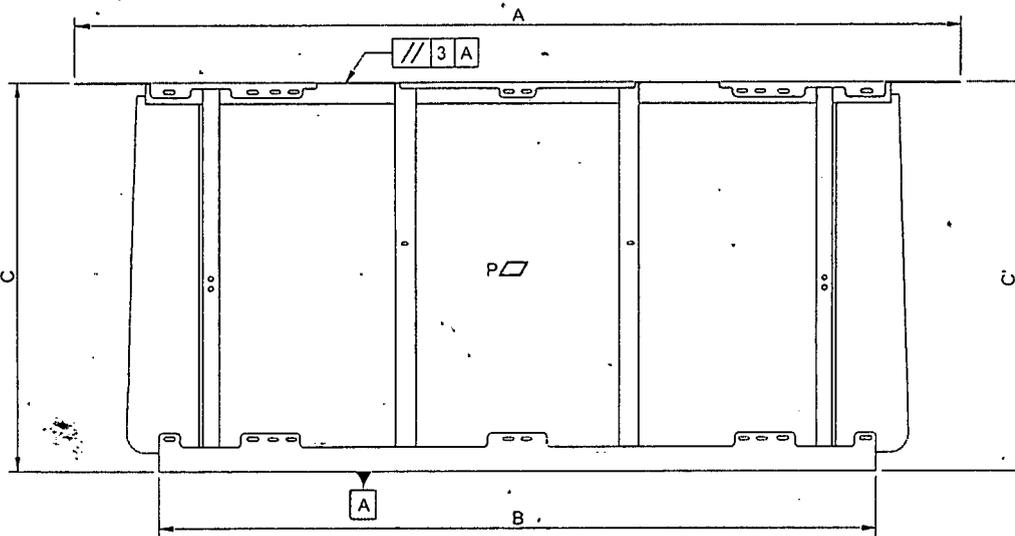
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	08/02/24	178489 104640 01	VHC35578	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	14/02/24	178815 104640 01	F207905 VHC28402	
RCS 450	6 mm					
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	22/11/23	175569 102206 01	F207906 VHS 58432	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

Cabin Roof Assembly: GN002839

Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DYLAN DAVIDS	Assembly Date:	20 24 / 03 / 16		
Sign:		Wire Batch No.:	10723820		



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	Leon	Sign:		Date:	20 24 / 03 / 16

Dimensional Control

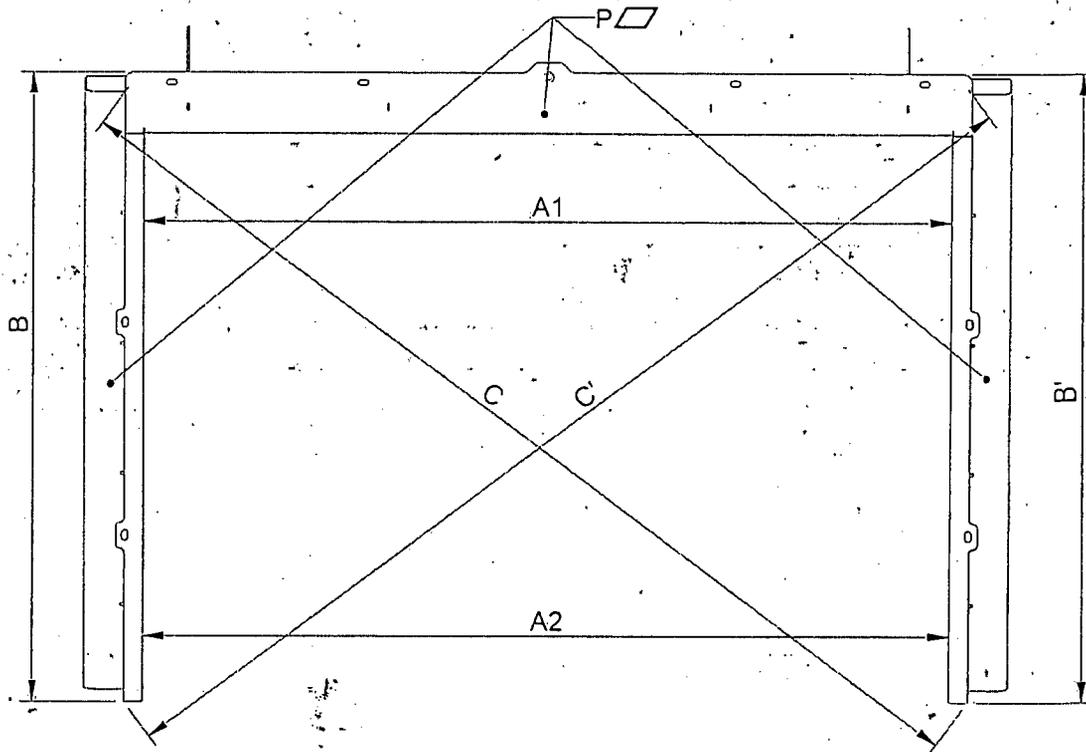
Rep	Toler.	Dimension measured	Measuring Equipment	Observations	
A	+5/-0	2216	Tape Measure	Accepted	
B	± 4	1801		Accepted	
C	+2/-3	975 - 976		Accepted	
QC Inspector:	Leon	Sign:		Date:	20 24 / 03 / 16

Geometrical Control

Nature of Checks	Dimension Measured	Measuring Equipment	Observations		
Planarity, P	6 mm	Ruler	Accepted		
// 3 A	Passes	Set Square	Accepted		
QC Inspector:	Leon	Sign:		Date:	20 24 / 03 / 16

Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator: Ramelo G. Chan	Assembly Date:	2024/03/16			
Sign: <i>[Signature]</i>	Wire Batch No.:	552033			



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
QC Inspector: Leon	Sign: <i>[Signature]</i>	Date:	2024/03/16		

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	1910	± 2	1911		Tape Measure	Acceptable
A2	1910		1911			
B	1475	± 1	1474	1474		
C	Diagonals C - C' ≤ 3		2476	2475		
QC Inspector: Leon		Sign: <i>[Signature]</i>		Date:		2024/03/16

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P: Planeity	4 mm	Ruler	Acceptable
QC Inspector: Leon		Sign: <i>[Signature]</i>	
		Date: 2024/03/16	

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

Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Xander</i>	Assembly Date:	2024/03/12			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

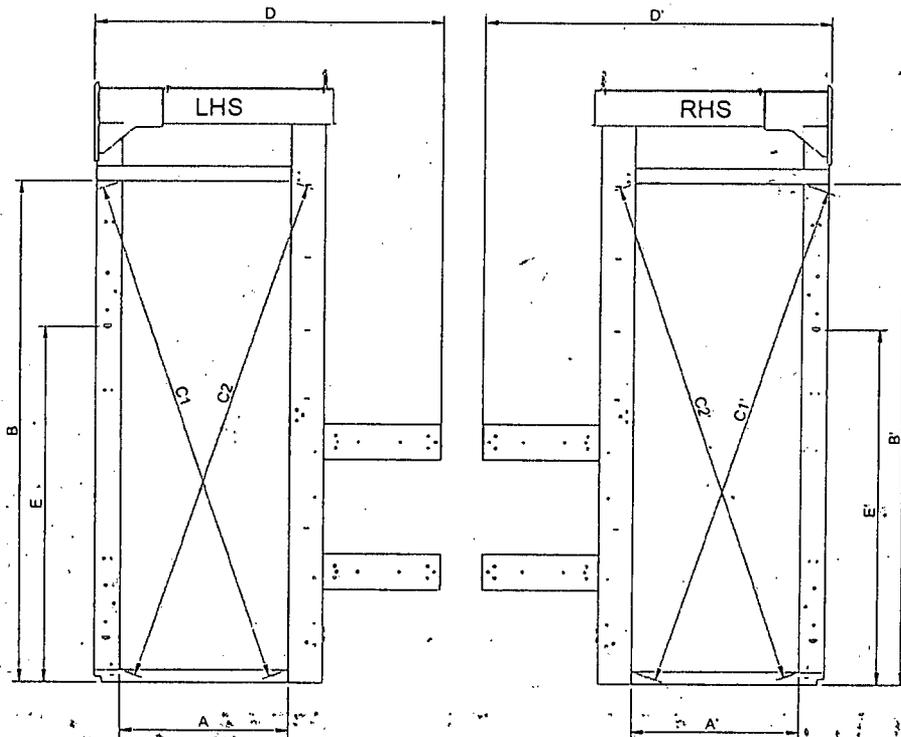
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Glenn	Assembly Date:	2024/03/08			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Glenn	Assembly Date:	2024/03/08			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

Cabin LHS/RHS Door Frame Assembly GN002839

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Glenn	Assembly Date:	2024/03/11			
Sign:	<i>Glenn</i>	Wire Batch No.:	552033			



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Leon	Sign:	<i>Leon</i>	Date:	2024/03/12	

Dimensional Control

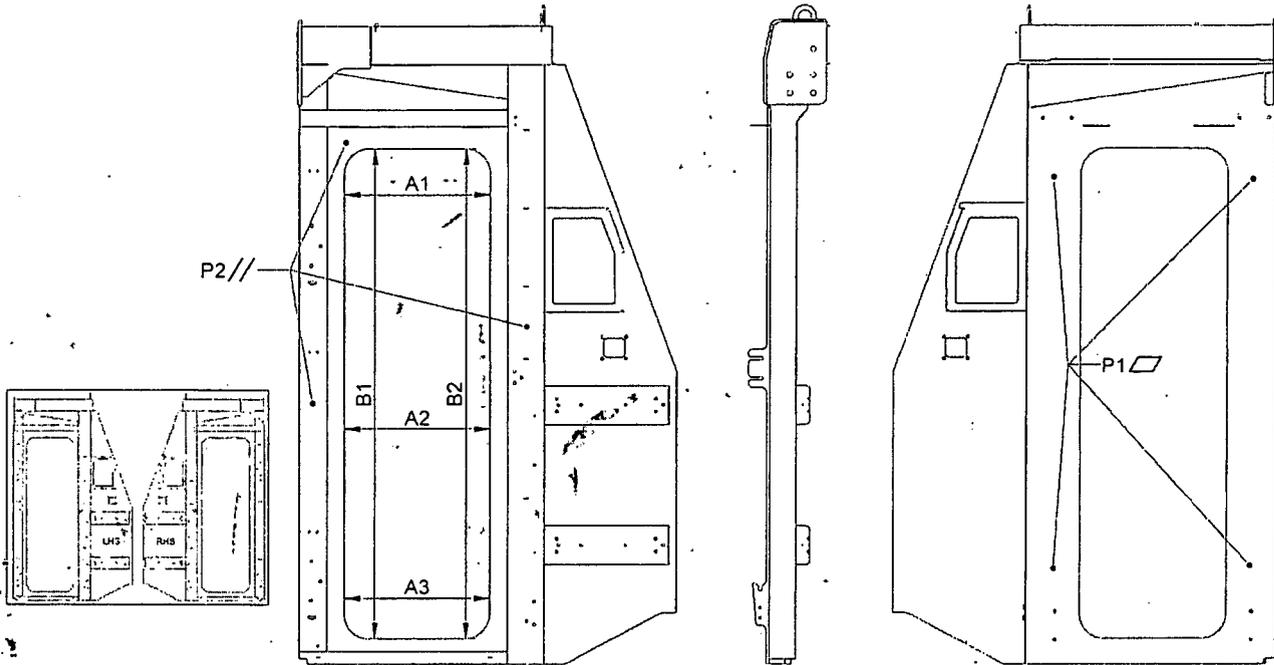
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	695	696	Tape Measure	Acceptable
B	2086	+1/-3	2086	2085		Acceptable
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2152	2153		Acceptable
C1 - C2			2152	2151		Acceptable
D	1438	+2/-3	1437	1438		Acceptable
E			1484	1485		Acceptable
QC Inspector:		Leon	Sign:		<i>Leon</i>	Date: 2024/03/12

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	Ruler	Acceptable
QC Inspector:		Leon	Date: 2024/03/12

Gabin LHS/RHS Side Assembly: GN002838/GN002837

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>Pomila</i>	Assembly Date:	2024/03/11	
Sign:	<i>[Signature]</i>	Wire Batch No.:	559037	



Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date: 20_24/03/16

Dimensional Control

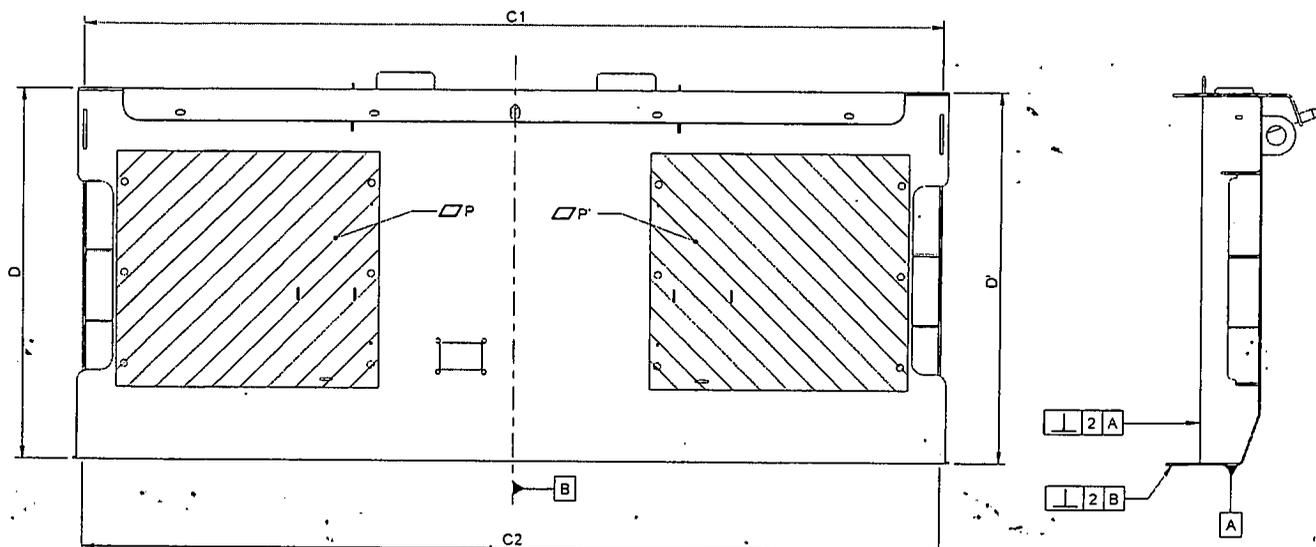
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1			559	558	Tape Measure	<i>Acceptable</i>
A2	560	± 2	559	560		<i>Acceptable</i>
A3			559	560		<i>Acceptable</i>
B1	1900	± 2	1898	1898		<i>Acceptable</i>
B2			1898	1898		<i>Acceptable</i>
QC Inspector:		<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/03/16

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1: Planeity	4 mm	<i>Pass</i>	<i>Acceptable</i>
P2: Planeity	2 mm	<i>Pass</i>	<i>Acceptable</i>
QC Inspector:		<i>Leon</i>	Sign: <i>[Signature]</i> Date: 2024/03/16

Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>SCVAN JAVENHILL</i>	Assembly Date:	2024/03/16			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			



Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Leon</i>	Sign:	<i>[Signature]</i>	Date:	2024/03/16	

Dimensional Control

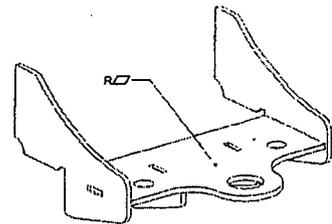
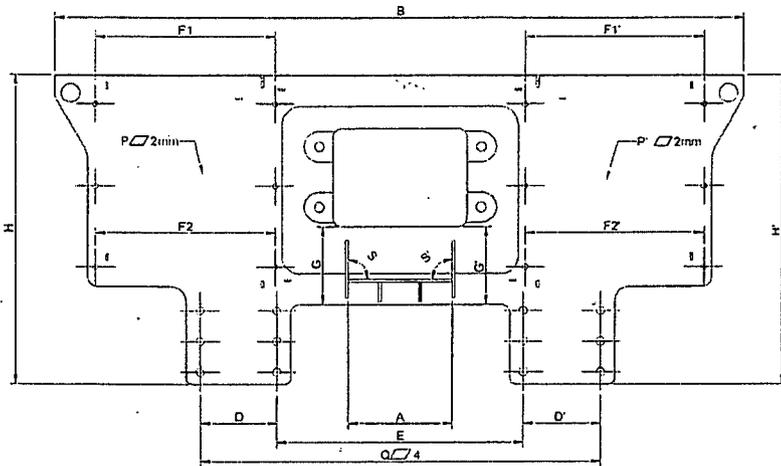
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	<i>2212</i>	<i>2212</i>	Tape Measure	<i>Accepted</i>
D / D'	956	± 2	<i>958</i>	<i>958</i>		
QC Inspector:	<i>Leon</i>		Sign:	<i>[Signature]</i>	Date:	2024/03/16

Geometrical Control

Nature of Checks		Dimension Measured		Measuring Equipment	Observations	
Planarity P' / P'	2 mm	<i>Pass</i>		Ruler	<i>Accepted</i>	
Perpendicularity	2 A	<i>Pass</i>		Set Square	<i>Accepted</i>	
	2 B	<i>Pass</i>		Set Square	<i>Accepted</i>	
QC Inspector:	<i>Leon</i>		Sign:	<i>[Signature]</i>	Date:	2024/03/16

Cabin Front Headstock Assembly: GN002841

Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator: <i>TK BOLL</i>	Assembly Date:	2024/03/11			
Sign: <i>[Signature]</i>	Wire Batch No.:	2202152			



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector: <i>LEON</i>	Sign: <i>[Signature]</i>	Date:		2024/03/13	

Dimensional Control

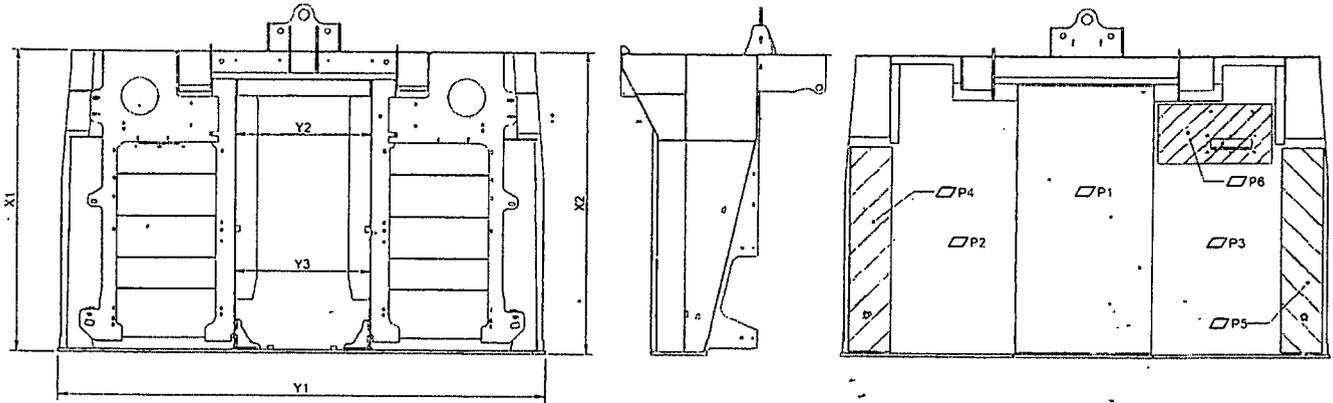
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	±1	339		Tape Measure	Acceptable
B	2240	±4	2243			Acceptable
D/D'	250	±1	250.5 - 250.5			Acceptable
E	808	±2	808			Acceptable
F1/F1'	580	±1	581	581		Acceptable
F2/F2'			581	581		Acceptable
G/G'	258	±1	257	258.5		Acceptable
H/H'	1019	±2	1020	1020		Acceptable
QC Inspector: <i>LEON</i>	Sign: <i>[Signature]</i>	Date:		2024/03/13		

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
O: Planity of global assembly	4 mm - Passed	Ruler	Acceptable
P/P': Planity	2 mm - Passed	Ruler	Acceptable
Q: Planity Surface of Supports	4 mm - Passed	Ruler	Acceptable
R: Planity Coupler Support	2 mm - Passed	Ruler	Acceptable
S: Perpendicularity coupler	1mm - Passed	Square	
QC Inspector: <i>LEON</i>	Sign: <i>[Signature]</i>	Date: 2024/03/12	

Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator: <i>Michael Wood</i>	Assembly Date: 2024/03/16			
Sign: <i>[Signature]</i>	Wire Batch No.: 2202192			



Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector: <i>Leon</i>	Sign: <i>[Signature]</i>	Date: 2024/03/16		

Dimensional Control

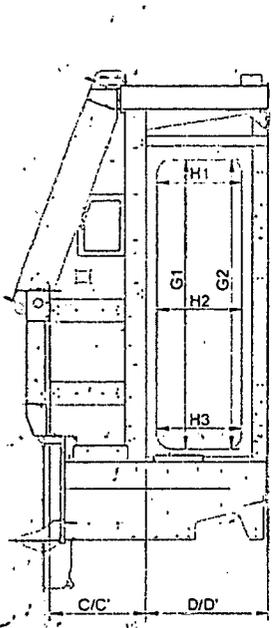
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1485	1486	Tape Measure	Acceptable
Y1	2354	± 3	2351			Acceptable
Y2 / Y3	666	± 1	666	667		Acceptable
QC Inspector: <i>Leon</i>		Sign: <i>[Signature]</i>	Date: 2024/03/16			

Geometrical Control

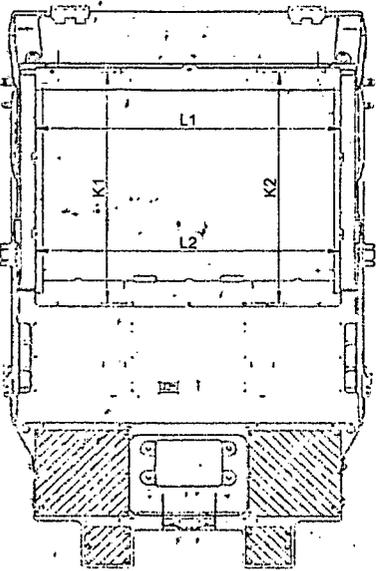
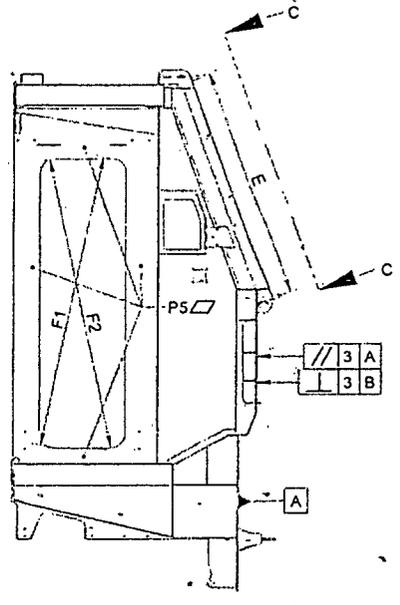
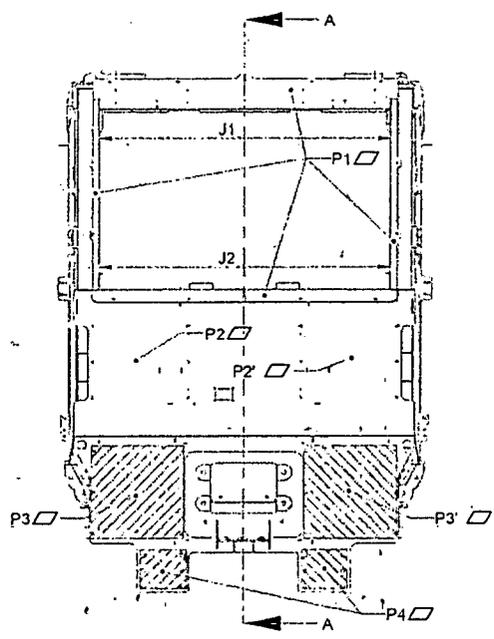
Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planarity	4 mm	Ruler	Acceptable
P2 / P3 : Planarity	4 mm	Ruler	Acceptable
P4 / P5 : Planarity	2 mm	Ruler	Acceptable
P6 : Planarity	2 mm	Ruler	Acceptable
QC Inspector: <i>Leon</i>		Sign: <i>[Signature]</i>	Date: 2024/03/16

Cabin Structure Assembly: GN002834

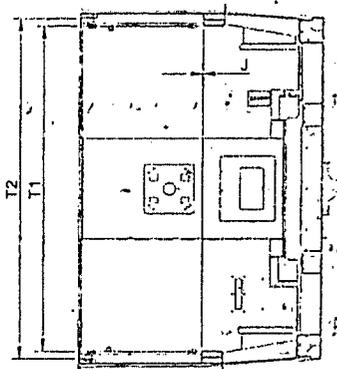
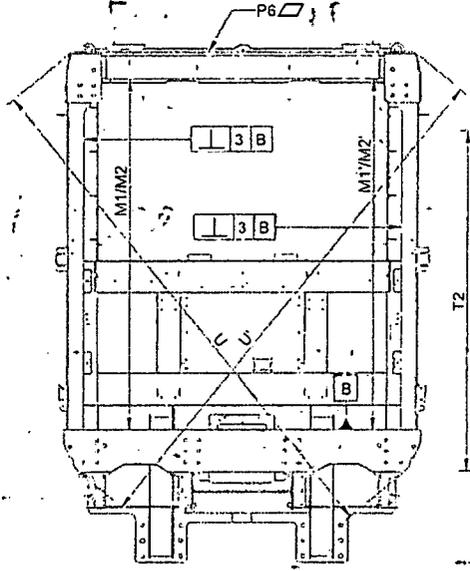
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>CHARL BLOEM</i>	Assembly Date:	20 28 / 03 / 16			
Sign:		Wire Batch No.:	220252			



SECTION A-A



AUX VIEW: C



SECTION B-B

Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042	Confirmed	Yes	No
QC Inspector: Riccardo	Sign: 	Date: 2024/03/22	

Dimensional Control

Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations
C / C'	625	± 2	624	625	acceptable
D / D'	813	± 2,5	813	813	acceptable
E	1531.5	± 3	1530		acceptable
G1 / G'1	Height 1900	+1	1898	1899	acceptable
G2 / G'2		-3	1899	1898	acceptable
H1 / H'1	Width 560	+1	560	559	acceptable
H2 / H'2		-3	559	559	acceptable
H3 / H'3			559	559	acceptable
F1 / F'1	Diagonals 1939		1935	1935	acceptable
F2 / F'2			1936	1936	acceptable
Difference	F1-F2 / F'1-F'2	≤ 4	1	1	acceptable
J	Gap of Doors	± 1,5			acceptable
K1 / K2	1515	± 3	1513	1514	acceptable
L1 / L2	1996	± 3	1995	1996	acceptable
M1 / M'1	2306	± 3	2406	2406	acceptable
M2 / M'2			2408	2406	acceptable
T1 / T'1	2130 Top/Bottom	± 3	2127	2127	acceptable
T2 / T'2	2230 Top/Bottom		2130	2131	acceptable
Difference	U - U' (3522)	≤ 4mm	3520	3521	

QC Inspector: Riccardo	Sign: 	Date: 2024/03/22
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Geometrical Control

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

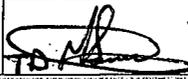
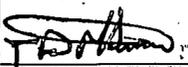
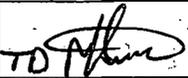
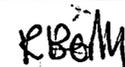
QC Inspector: Riccardo	Sign: 	Date: 2024/03/22
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Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Pamela</i>	Assembly Date:	2026/05/22			
Sign:	<i>[Signature]</i>	Wire Batch No.:	220252			

Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>[Signature]</i>	Assembly Date:	20 __/__/__			
Sign:	<i>[Signature]</i>	Wire Batch No.:				

Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Fasteners positioned in all Rivnuts and Bosses		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Masked as per GMS-SOS-GIBELA-CABIN-001		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DAVID	Sign:			
Date:	20 24 / 04 / 13				
Record of Shot Blasting					
Operator:		Date:	20 24 / 04 / 13		
Start Time:	08 H 13	End Time:	09 H 50		
Temperature ($\geq 15^\circ$):	19-01 $^\circ\text{C}$	Humidity ($\leq 75\%$):	62-04 %		
Shot Blasting Self-Inspection					
Interior of Cabin: Sa 1 - Light Stripping		Confirmed	Yes	<input checked="" type="checkbox"/>	No
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping		Confirmed	Yes	<input checked="" type="checkbox"/>	No
		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DAVID	Sign:			
Date:	20 24 / 04 / 13				
Shot Blasting Cleaning					
Cabin free of all sand		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DAVID	Sign:			
Date:	20 24 / 04 / 13				
Shot Blasting Control					
Temperature $\geq 15^\circ$:	20-03 $^\circ\text{C}$	Humidity $\leq 75\%$:	66-01 %		
Internal Roughness $3.2 \leq Ra \leq 12.5$	10.572	External Roughness $3.2 \leq Ra \leq 12.5$	10.586		
QC Inspector:	Rouas	Sign:			
Date:	13 / 04 / 24				

Record of Priming							
Start Time:		13:00		End Time:		15:00	
Temperature ≥ 15°:		29°C		Humidity ≤ 75%:		42%	
Paint Batch No.:		7978267		Paint Expiry Date:		06/25	
Hardener Batch No.:		733119		Hardener Expiry Date:		01-11-24	
Desolvation Start Time:		15:00		Desolvation End Time:		15:15	
Stoving Start Time:		15:15		Stoving End Time:		16:15	
Stoving Temp:		60°C					
Operator:		musa		Sign:			
Date:		20/24/06/13				musa	
Priming Control							
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 42.8	5: 56.4	1: 69.7	5: 63.8	1: 73.7	5: 45.1	1: 44.8	5: 74.1
2: 65.3	6: 73.2	2: 52.4	6: 41.2	2: 54.6	6: 63.9	2: 64.0	6: 62.7
3: 64.5	7: 71.8	3: 44.8	7: 81.6	3: 46.4	7: 63.7	3: 59.9	7: 63.9
4: 69.5	8: 74.6	4: 69.3	8: 56.4	4: 68.5	8: 69.5	4: 64.5	8: 77.1
Min:	42.18	Min:	41.2	Min:	45.1	Min:	44.8
Max:	74.6	Max:	81.6	Max:	69.5	Max:	77.1
Average:	64.76	Average:	59.9	Average:	60.05	Average:	63.92
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 60.9	5: 44.5	1: 69.7	5: 61.8	1: 62.9	5: 44.8	1: 73.7	5: 68.1
2: 68.2	6: 42.7	2: 58.0	6: 52.7	2: 69.5	6: 59.6	2: 67.7	6: 63.8
3: 54.6	7: 62.5	3: 45.0	7: 52.8	3: 51.7	7: 52.0	3: 49.3	7: 81.8
4: 76.4	8: 53.8	4: 50.3	8: 50.4	4: 42.3	8: 61.9	4: 52.7	8: 79.8
Min:	42.7	Min:	45.0	Min:	42.3	Min:	49.3
Max:	76.4	Max:	69.7	Max:	69.5	Max:	81.8
Average:	57.95	Average:	55.08	Average:	55.58	Average:	67.11
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 71.1	5: 81.6	1: 74.6	5: 64.1	1: 54.9	5: 62.8	1: 78.3	5: 84.9
2: 43.6	6: 76.1	2: 79.6	6: 51.5	2: 64.6	6: 70.6	2: 41.3	6: 69.3
3: 53.4	7: 83.1	3: 45.1	7: 45.0	3: 68.7	7: 35.1	3: 73.7	7: 78.2
4: 54.1	8: 71.6	4: 49.8	8: 54.2	4: 54.5	8: 72.5	4: 81.6	8: 77.0
Min:	43.6	Min:	45.0	Min:	35.1	Min:	41.3
Max:	83.1	Max:	74.6	Max:	70.6	Max:	84.9
Average:	62.92	Average:	57.98	Average:	60.46	Average:	73.03
Primer has been inspected and is free of defects				Confirmed		Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>	
QC Inspector:		14 Apr 2024		Sign:			
Date:		Zottule				Houal	

Record of Painting NCSS3010 R90B

Start Time:	09:00	End Time:	10:00
Temperature ≥ 15°:	29°C	Humidity ≤ 75%:	62%
Paint Batch No.:	8196598	Paint Expiry Date:	23-02-2025
Hardener Batch No.:	8138195113	Hardener Expiry Date:	11/26
Desolvation Start Time:	10:00	Desolvation End Time:	10:15
Stoving Start Time:	10:15	Stoving End Time:	11:15
Stoving Temp:	60°C		
Operator:	Musea	Sign:	MUSEA
Date:	2024/04/17		

Painting NCSS3010 R90B Control

DFT Interior Door Aperture RHS		DFT Interior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test, (attach test tape)	
1: 119	5: 934	1: 126	5: 104		
2: 124	6: 916	2: 139	6: 106		
3: 987	7: 120	3: 104	7: 129		
4: 109	8: 123	4: 990	8: 108		
Min: 916		Min: 990			
Max: 124		Max: 139			
Average: 109.46		Average: 113.62			
Painting NCSS3010 R90B has been inspected and is free of defects					
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	81.6
QC Inspector:	Zothile			Sign:	[Signature]
Date:	18 Apr 2024				

Record of Painting Blue NCSS1565 B				
Start Time:	13:00	End Time:	14:00	
Temperature $\geq 15^{\circ}$:	28 $^{\circ}$ C	Humidity $\leq 75\%$:	46%	
Paint Batch No.:	8176318	Paint Expiry Date:	02-02-2025	
Hardener Batch No.:	8139195113	Hardener Expiry Date:	11/26	
Desolvation Start Time:	14:00	Desolvation End Time:	14:15	
Stoving Start Time:	14:15	Stoving End Time:	15:15	
Stoving Temp:	60 $^{\circ}$ C			
Operator:	musa	Sign:	musa.	
Date:	20 24/04/17			
Painting Blue NCSS1565 B Control				
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)
1: 102	5: 136	1: 94.3	5: 129	
2: 125	6: 87.4	2: 108	6: 101	
3: 92.3	7: 111	3: 126	7: 92.6	
4: 133	8: 97.7	4: 112	8: 91.1	
Min:	87.4	Min:	91.1	
Max:	136.	Max:	129	
Average:	110.55	Average:	107.58	
Painting NCSS3010 R90B has been inspected and is free of defects*		Confirmed	Yes	
GMS-SOS-GIBELA-PS-002 Gloss Test		Value	91.2	
QC Inspector:	Zotnik	Sign:	[Signature]	
Date:	19 Apr 2017			

Record of RAL7012			
Start Time:	09:00	End Time:	11:00
Temperature ≥ 15°:	30°C	Humidity ≤ 75%:	37%
Paint Batch No.:	9196598	Paint Expiry Date:	23-02-2025
Hardener Batch No.:	9138195 M3	Hardener Expiry Date:	11/26
Desolvation Start Time:	11:00	Desolvation End Time:	11:15
Stoving Start Time:	11:15	Stoving End Time:	13:15
Stoving Temp:	60°C		
Operator:	musa	Sign:	musa
Date:	2024/04/16		

RAL7012 Control

DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 100	5: 118	1: 116	5: 138	1: 83.3	5: 134	1: 134	5: 159
2: 101	6: 124	2: 116	6: 120	2: 122	6: 126	2: 147	6: 162
3: 102	7: 109	3: 129	7: 114	3: 129	7: 131	3: 128	7: 145
4: 94.3	8: 115	4: 110	8: 122	4: 104	8: 94.7	4: 131	8: 140
Min: 94.3		Min: 65		Min: 83.3		Min: 128	
Max: 124		Max: 148		Max: 134		Max: 162	
Average: 108.66		Average: 115.25		Average: 115.5		Average: 143	

DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 119	5: 127	1: 159	5: 127	1: 103	5: 120	1: 114	5: 153
2: 127	6: 119	2: 88.9	6: 85.7	2: 188	6: 140	2: 76.8	6: 82.5
3: 131	7: 150	3: 72.9	7: 75.8	3: 94.4	7: 134	3: 151	7: 119
4: 104	8: 125	4: 166	8: 112	4: 129	8: 110	4: 87.8	8: 75.4
Min: 104		Min: 72.8		Min: 78.8		Min: 75.4	
Max: 150		Max: 166		Max: 140		Max: 153	
Average: 125.25		Average: 110.9		Average: 113.65		Average: 107.43	

DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 81.3	5: 123	1: 81.3	5: 76.8				
2: 102	6: 93.4	2: 77.9	6: 96.4				
3: 111	7: 112	3: 77.1	7: 96.3				
4: 124	8: 106	4: 79.2	8: 81.9				
Min: 87.3		Min: 76.8					
Max: 124		Max: 96.3					
Average: 107.33		Average: 83.23					

Painting NCSS3010 R90B has been inspected and is free of defects	Confirmed	Yes	<input checked="" type="checkbox"/>	No
GMS-SOS-GIBELA-PS-002 Gloss Test	Value	348		
QC Inspector:	Zothile			
Date:	19 Apr 2024			
	Sign:			

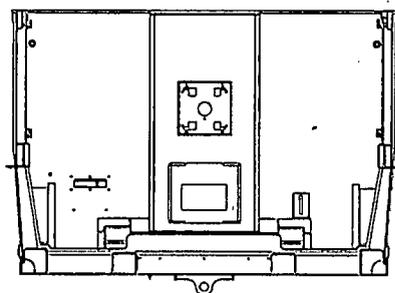
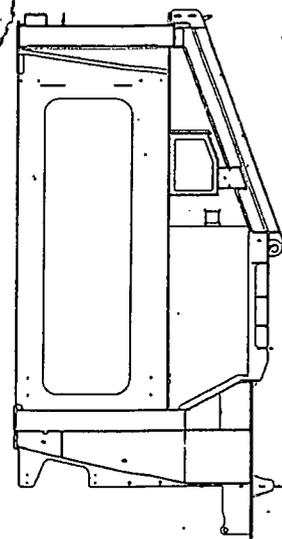
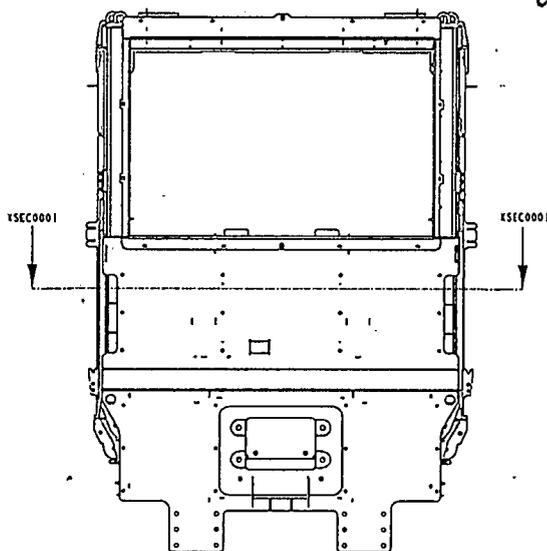
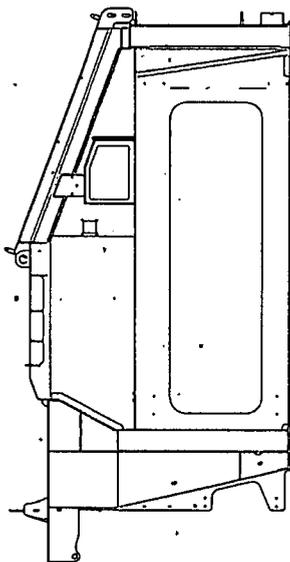
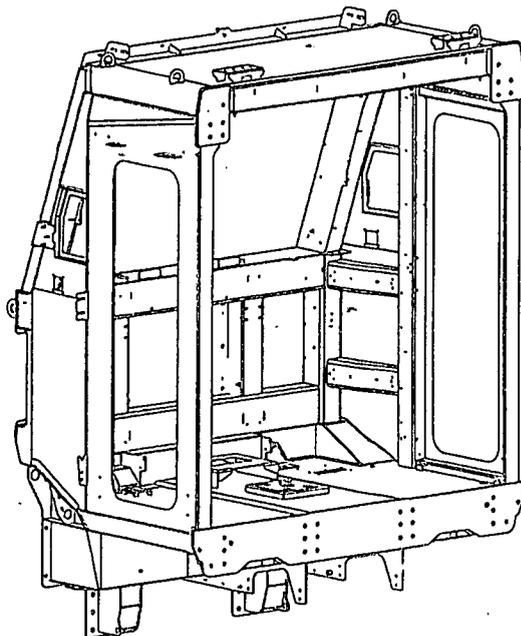
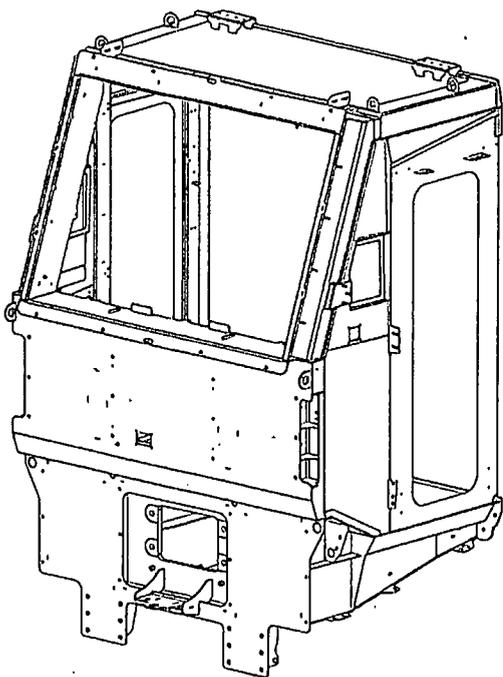
SEALING OF CABIN

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

CLOCK No:	2400	OPERATOR SIGN:	APHILA	DATE:	20/04/2024
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REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)







CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	0456	Checks Updated:	2022/08/26

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

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

Quality approval for release	CO. NO.	DATE
	2022	20/04/2024