

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						WORK INSTRUCTION	SAFETY ?	
				TC1	M1	M2	M3	M4	TC2			
<input type="checkbox"/>	DTR31374497/3	AAD0001413329	CARBODYSHELL M2 ASSEMBLY	CB1210				X			PRA.CB1210.DTR313744 97/3.V25	YES
<input type="checkbox"/>								✓				

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	12/12/2018
			CHECKER	Nosizo Pindela	12/12/2018
			REVISED BY	Ramokone Motama	12/12/2018
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	
			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	
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	Mbhombi 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	Zwane Ntokozo	
			REVISED BY	Mohlampe Amogelang	
28	07/11/2023	Addition of welder traceability	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Andani Muthelo	
			REVISED BY	Ntokozo Zwane	

TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
15226	MMB	Timothy Maimela	08.05.24	SI.CB1210.247.V28	17



CARBODYSHELL M2 ASSEMBLY DTR31374497/3

Rev.  
28  
Date  
07/11/2023

Project: PRASA  
SI.CB1210.247.V28

**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)	AA00001375051	✓		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	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓		08.05.24	08/05/24
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		08.05.24	08/05/24
05		Cleaning of oil Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		08.05.24	08/05/24
06		Functional 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
	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

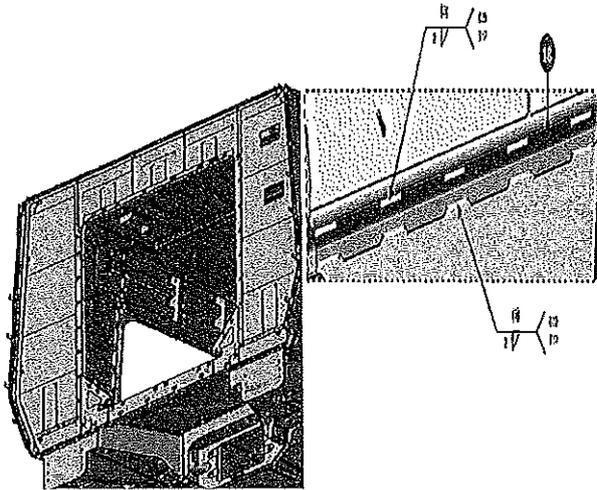


CARBODYSHELL M2 ASSEMBLY DTR31374497/3

Rev. 20  
Date 07/11/2023

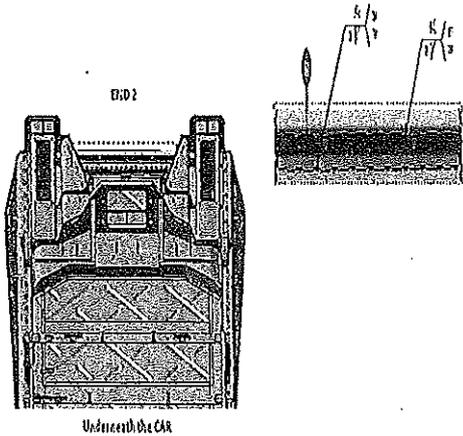
Project PRASA  
SI.CB1210.247.V28

EUF Reinforcement Plates



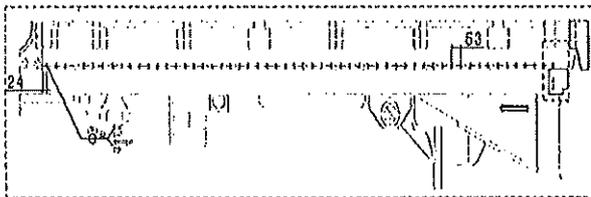
END 1  
 Boiler maker (Name & Sign): TONTOO

Welder (Name & Sign): SIPHOKAZA



END 2  
 Boiler maker (Name & Sign): Justice

Welder (Name & Sign): Katu K. MABU



FEDOLI  
 OPERATOR: LAWRENCE

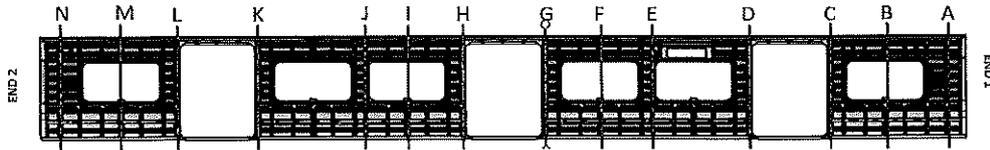


CARBODYSHELL M2 ASSEMBLY DTR31374497/3

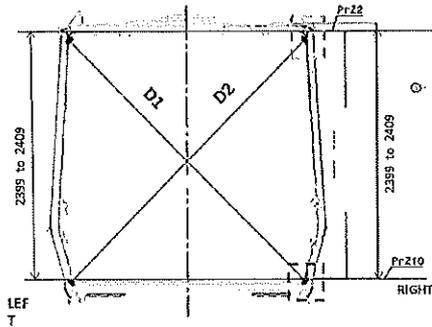
Rev. 28  
Date 07/11/2023

Project: PRASA  
SI.CB1210.247.V28

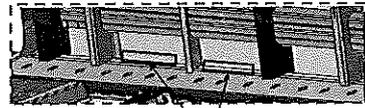
### Specifications of Details for CBS measurement



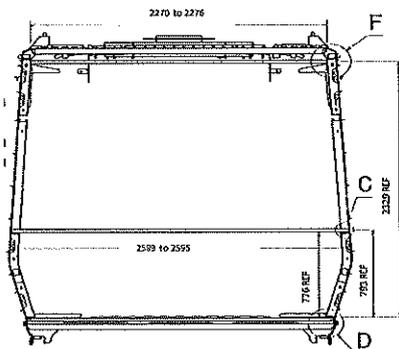
9



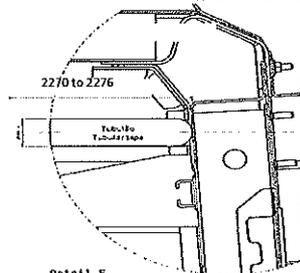
Measurement positions on roof rail and sidewall omega corner.



Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.



Detail F

Don't considering the reinforcement



CARBODYSHELL M2 ASSEMBLY DTR31374497/3

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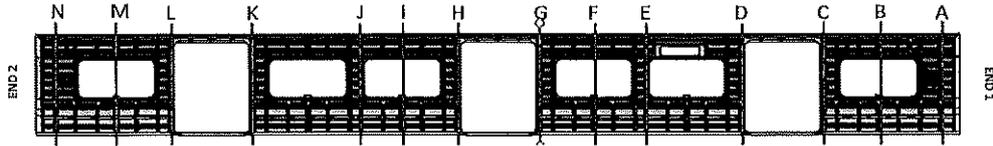
07/11/2023

Project: PRASA

SI.CB1210.247.V28

Specifications of Details for CBS measurement

AFTER WELDING



Note: The difference in Height values measured on the LHS and RHS should be  $\leq 2\text{MM}$  on each point.

	Record D1 values	Record D2 values	D1-D2 $\leq 5\text{mm}$	2399 to 2409 (LHS)	2399 to 2409 (RHS)	LHS-RHS $\leq 2$
A	3296	3296	0	2406	2406	0
B	3267	3265	2	2405	2405	0
C	3298	3298	0	2406	2406	0
D	3297	3297	0	2406	2405	1
E	3271	3270	1	2408	2407	1
F	3269	3270	1	2406	2406	0
G	3296	3296	0	2407	2406	1
H	3298	3298	0	2406	2405	1
I	3269	3270	1	2407	2405	2
J	3271	3270	1	2406	2406	0
K	3295	3295	0	2407	2407	0
L	3296	3296	0	2406	2406	0
M	3267	3265	2	2405	2406	1
N	3297	3297	0	2406	2405	1

*BBB*

08.05.24



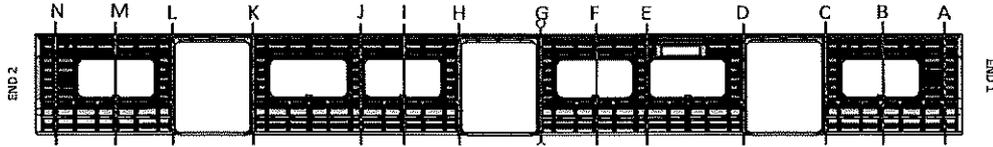
CARBODYSHELL M2 ASSEMBLY DTR31374497/3

Rev. 26  
Date 07/11/2023

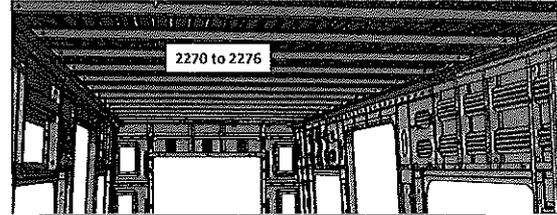
Project: PRASA  
SI.CB1210.247.V28

CBS measurement

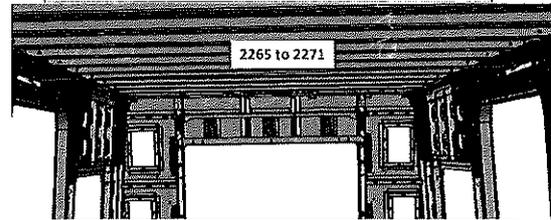
AFTER WELDING



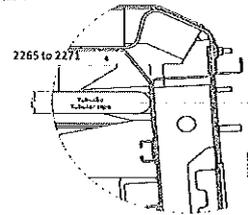
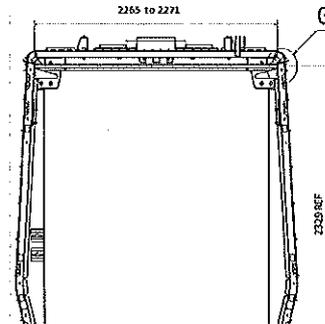
	2265 to 2271	2270 to 2276
A	2266	N/A
B	N/A	2272
C	2270	N/A
D	2269	N/A
E	N/A	2275
F	N/A	2273
G	2268	N/A
H	2267	N/A
I	N/A	2274
J	N/A	2276
K	2267	N/A
L	2268	N/A
M	N/A	2272
N	2266	N/A



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

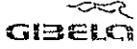


Take measurement close to radius ( considering reinforcement)



Detail D  
Cons. during the reinforcement plate

*Handwritten signature*  
08.05.24

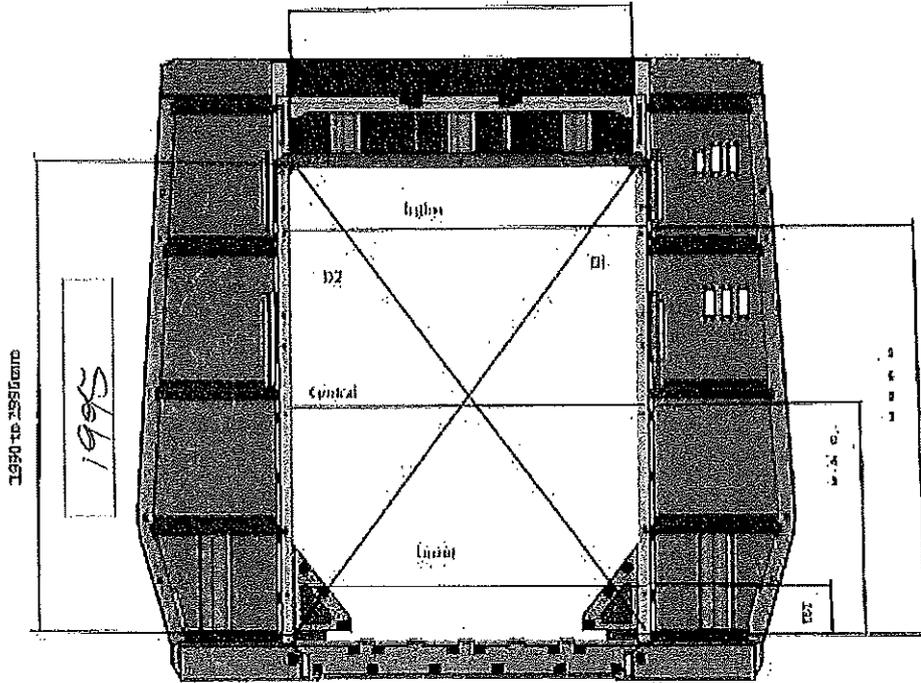


CARRODYSHELL M2 ASSEMBLY DTR31374497/3

Rev.  
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End frame 2



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

High Dimension

1380

D1

2416

Central Dimension

1381

D2

2415

Low Dimension

1381

D1-D2

1

*[Handwritten signature]*

08.05.24



CARBODYSHELL M2 ASSEMBLY DTR31374497/3

Rev.  
28  
Date  
07/11/2023

Project: PRASA  
SI.CB1210.247.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!)	08.05.24	TUMELLO Operations	
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	08/05/24	Molano Industrial Quality	
		There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)			

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



APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

# SELF INSPECTION SHEET

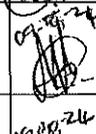
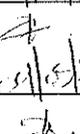
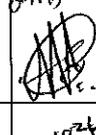
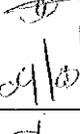
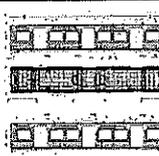
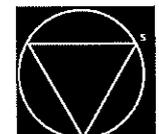
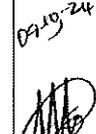
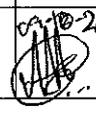
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**APPLICATION REFERENCE**

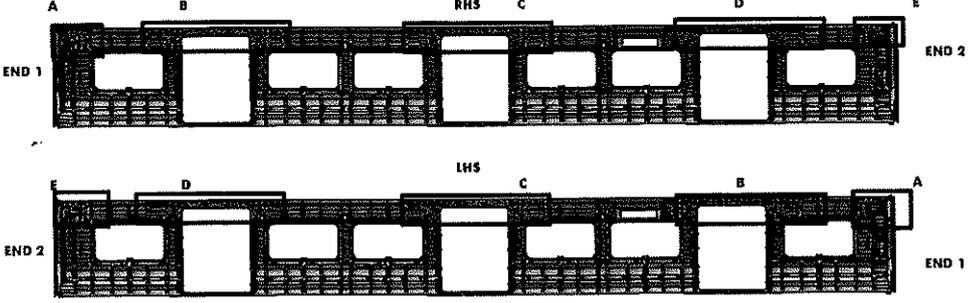
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE							WORK INSTRUCTION	SAFETY?
				YES	NA	NO	NA	NO	NA	NO		
<input type="checkbox"/>	DTR000152665	AAD0001413929	CARBODYSHELL M2 ASSEMBLY	CB1226				X			PRA.CB1220.DTR51374497 /z.V21	YES
<input type="checkbox"/>												
<input type="checkbox"/>												
<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 DT0000336600	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 Remove	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
7	27/05/2019	Removed measurement positions on the display windows	APPROVER	Itumeleng Modiba	27/05/2019
			CHECKER	Nosizo Pindela	27/05/2019
			REVISED BY	Nosizo Pindela	27/05/2019
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	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	
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	20/02/2022
			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	19/10/2022	Addition of traceability for sealant application and welding.	APPROVER	Mbhombi Collins	19/10/2022
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mhlangeni	
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mhlangeni	
29	28/10/2023	Addition of bracket quantity	APPROVER	Tyson Ngobeni	28/10/2023
			CHECKER	Kelebene Mathapo	
			REVISED BY	Amogelang Mhlangeni	

TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
TS226	MD2	ASANIWA - 90994	09-05-24	SI.CB1220.276.V29	15

GIBELQ		CARBODYSHELL M2 ASSEMBLY DTR31374497/2		Rev. 29	Project: PRASA	
				Date 28/10/2023	SI.CB1220.276.V29	
II - Self Inspection - Items to Check						
II.1 - Items to check						
Item	Picture/Drawing	Description	Reference criteria / Record		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1220.DTR31374497/2 Verification of filament for all reinforcement brackets.	PRA.CB1220.DTR31374497/2	✓	 09/05/24	 09/05/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DT00000210675	✓	 09/05/24	 09/05/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO 016 - TYPDEF - ARC - 0000	✓	 09/05/24	 09/05/24
04		Cleaning of all Stainless Steel Surface	According to GIB-WEL - PROC-0002	✓	 09/05/24	 09/05/24
05		Functionals dimensions approved according drawing or complementary document approved by Abtom engineering and registered in this document.	Approved according specified on pages below.	✓	 09/05/24	 09/05/24
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-016. Run by penetrant testing welds (weld ring) and fillet sampling as described in DT00000210658.	As the welding procedure IND-SAL-WMS-016 and DT00000210658.	✓	 09/05/24	 09/05/24
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 (%) Min/Max: 25% - 80%	Sealant Batch No: <u>2090059</u> Exp Date: <u>10/06/24</u> Actuals Temperature: <u>17</u> Humidity: <u>41</u>	✓	 09/05/24	 09/05/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001413319	✓	 09/05/24	 09/05/24

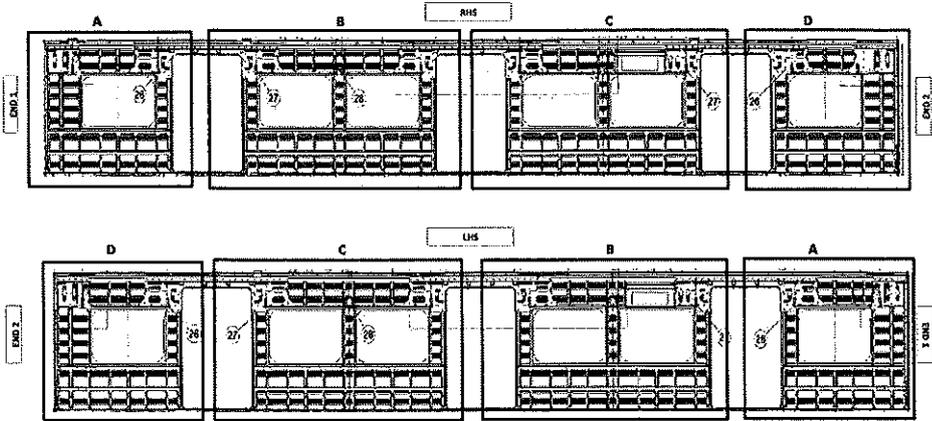
**II - Self Inspection - Items to Check**



**REINFORCEMENT WELDING**

AREA	LHS	RHS
A	Operator (Name&sign): <u>LINDO [Signature]</u>	<u>Tolly [Signature]</u>
B	Operator (Name&sign): <u>LINDO [Signature]</u>	<u>Tolly [Signature]</u>
C	Operator (Name&sign): <u>LINDO [Signature]</u>	<u>Tolly [Signature]</u>
D	Operator (Name&sign): <u>[Signature]</u>	<u>Munir Suwato Mon</u>
E	Operator (Name&sign): <u>[Signature]</u>	<u>Munir Suwato Mon</u>

**M2 BRACKET INSTALLATION**



**QUANTITIES (M2)**

RHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	8	/	
	B	8	/	
	C	3	/	
	D	2	/	
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: *ASA-DA* 

LHS				
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	8	/	
	B	11	/	
	C	11	/	
	D	12	/	
SEAT BRACKETS	A	12	/	
	B	21	/	
	C	21	/	
	D	13	/	
EARTH BUSH	A	3	/	
	B	6	/	
	C	6	/	
	D	2	/	

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

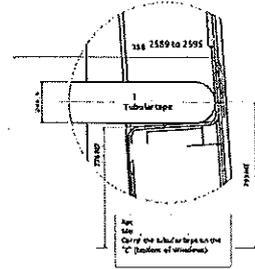
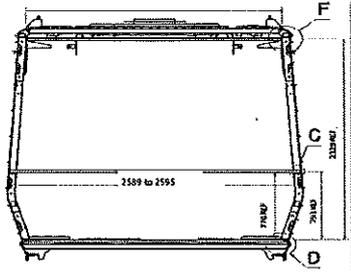
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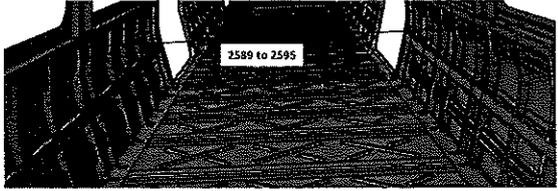
CARBODYSHELL M2 ASSEMBLY DTR31374497/2

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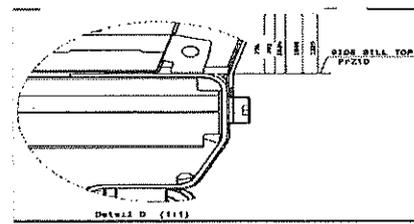
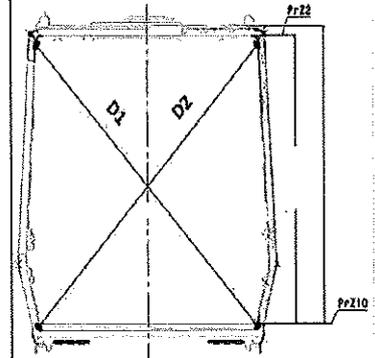
Project: PRASA  
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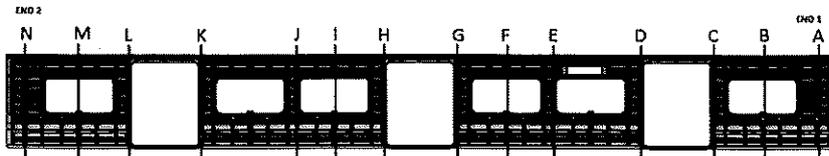
Detail C



Take measurement close to radius



**CBS measurement**

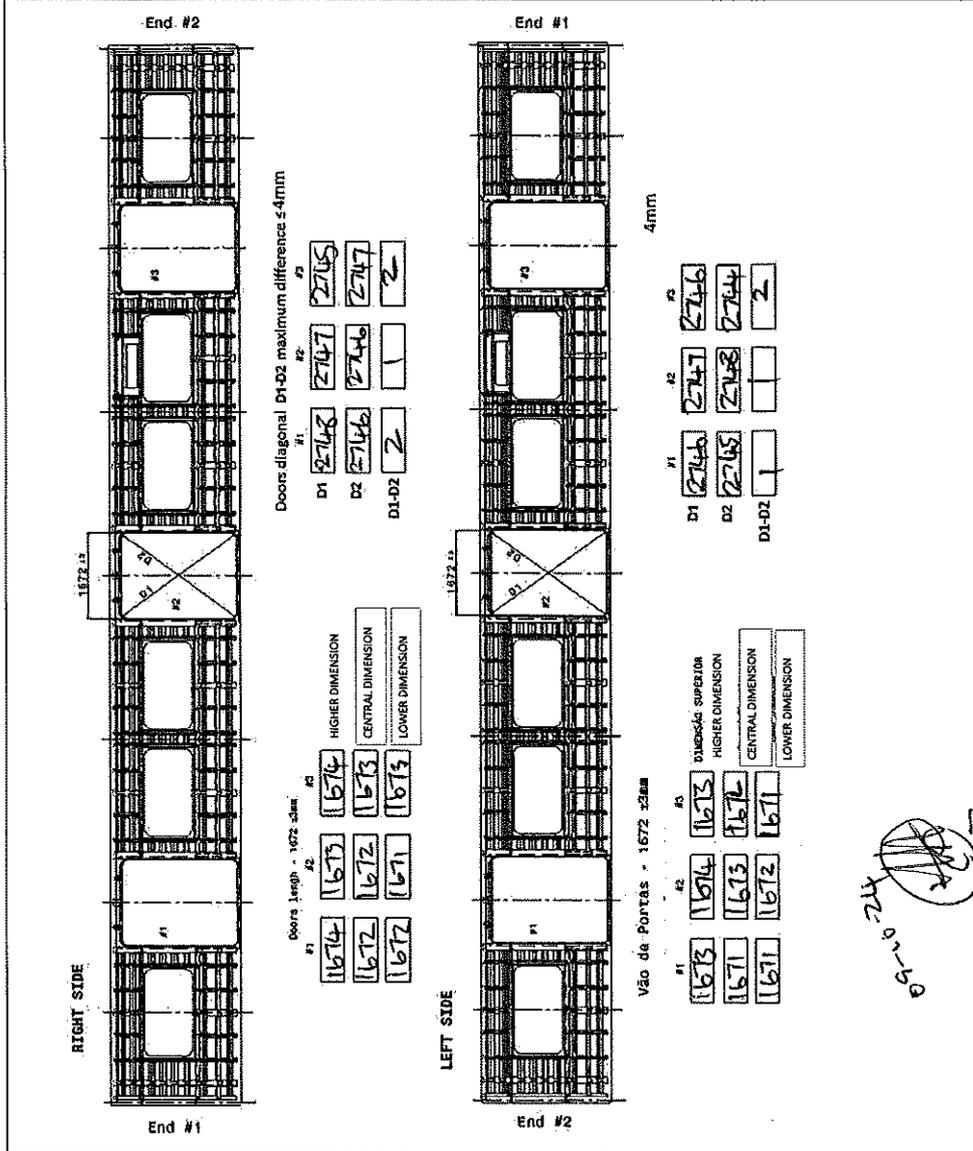


**AFTER WELDING**

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3301	3298	3	2595
B	3265	3264	1	2589
C	3301	3294	5	2589
D	3299	3297	2	2591
E	3265	3264	1	2594
F	3261	3266	5	2591
G	3304	3297	7	2594
H	3300	3297	3	2592
I	3260	3267	7	2592
J	3268	3263	5	2593
K	3298	3295	3	2590
L	3295	3294	1	2589
M	3261	3266	5	2589
N	3298	3291	7	2591

*[Handwritten signature]*  
09-05-2024

Specifications of Details for CBS measurement CB1220







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 ?	
				TCL	M4	M1	M2	M3	TCL				
<input type="checkbox"/>	DTRJ000152710	AMD0001413329	CARBODYSHELL M2 ASSEMBLY	CB1230				<input checked="" type="checkbox"/>				PRA CB1230.AA000013 74497.V20	YES
<input type="checkbox"/>													
<input type="checkbox"/>													
<input type="checkbox"/>													

RL	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
			COMPILED	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	Ramokone 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
5	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	Vanessa Ntuli	13/03/2019
10	23/03/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	23/03/2019
			CHECKER	Nosizo Pindela	23/03/2019
			REVISED BY	Nosizo Pindela	23/03/2019
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 Mhombhi	20/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mhombhi	14/06/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
27	26/07/2022	Threshold measurement addition	APPROVER	Collins Mhombhi	27/07/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
28	17/10/2022	Addition of traceability for sealant application	APPROVER	Collins Mhombhi	17/10/2022
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
29	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
30	06/11/2023	Added traceability on thresholds for boiler makers and welders	APPROVER	Ngobeni Tyson	06/11/2023
			CHECKER	Andani Muthelo	
			REVISED BY	Ntokozo Zwane	

TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
22b	M02	Mmuthapelo 483004	13/08/2024	SI.CB1230.277.V29	11



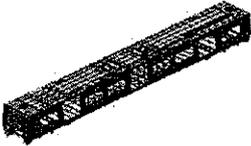
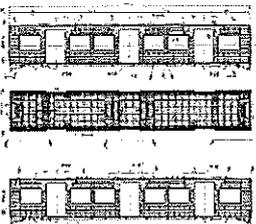
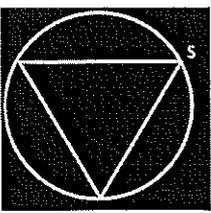
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**II - Self Inspection - Items to Check**

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.AA00001374497 Verification of fitment for all brackets.	PRA.CB1230.AA00001374497	✓	Wubela 13/05/24	<del>Wubela</del> 13/05/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	Wubela 13/05/24	<del>Wubela</del> 13/05/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	Wubela 13/05/24	<del>Wubela</del> 13/05/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	Wubela 13/05/24	<del>Wubela</del> 13/05/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓	Wubela 13/05/24	<del>Wubela</del> 13/05/24
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.	✓	Wubela 13/05/24	<del>Wubela</del> 13/05/24
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% - 80%	Sealant Batch No: 11 2240 Exp Date: 24 / 05 / 24  Actuals Temperature: 16.6 Humidity: 65%	✓	Wubela 13/05/24	<del>Wubela</del> 13/05/24
08	N/A	Verification of sealant application in regions of roof and sideframe.	Sealant applied in regions of roof and sideframe.	✓	Wubela 13/05/24	<del>Wubela</del> 13/05/24



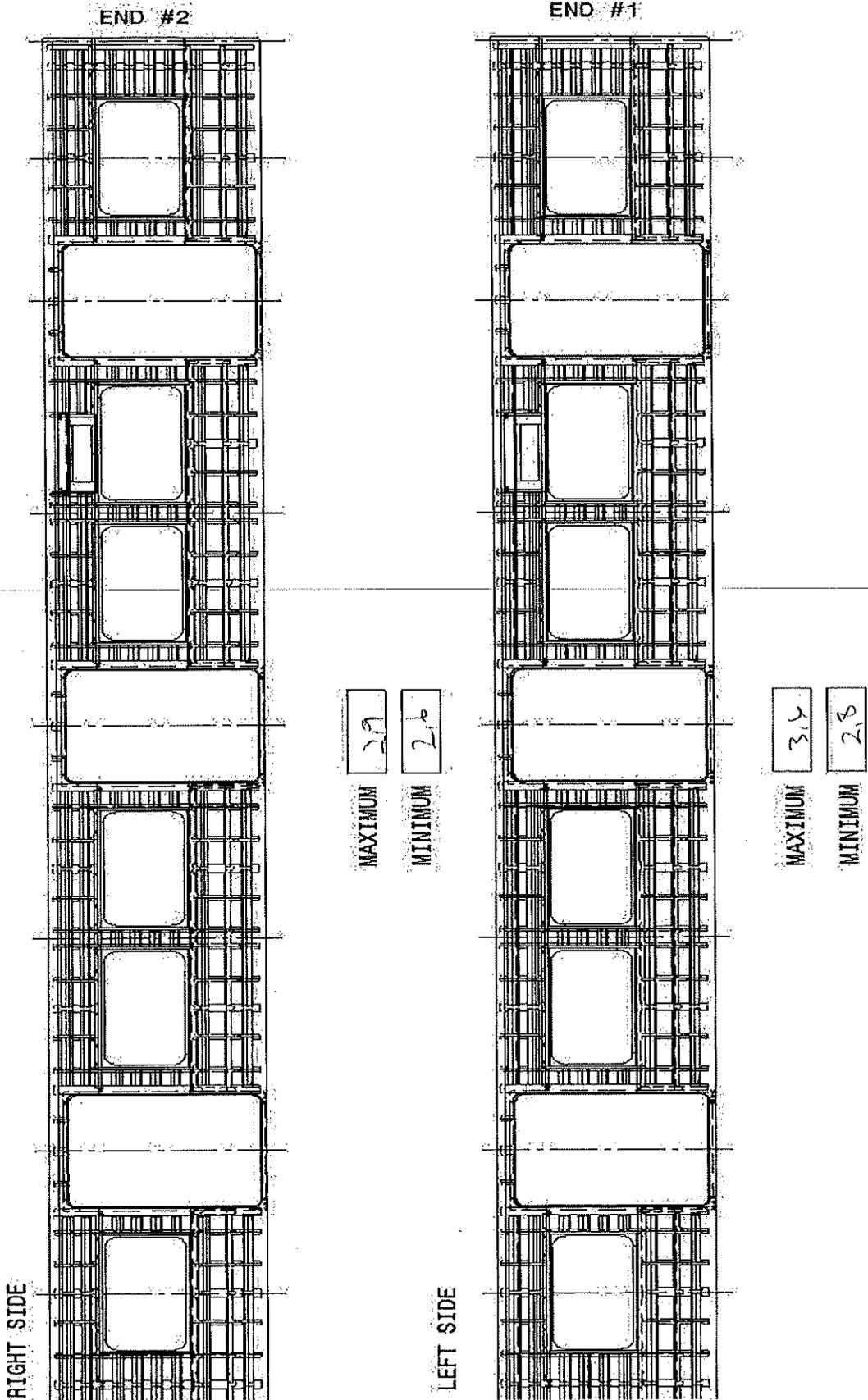
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latness side left and right maximum of 2mm in the valley to peak measured in 900mm. Record the maximum and minimum value found and indicate the corresponding region.





CARBODYSHELL M2 ASSEMBLY AA00001374497

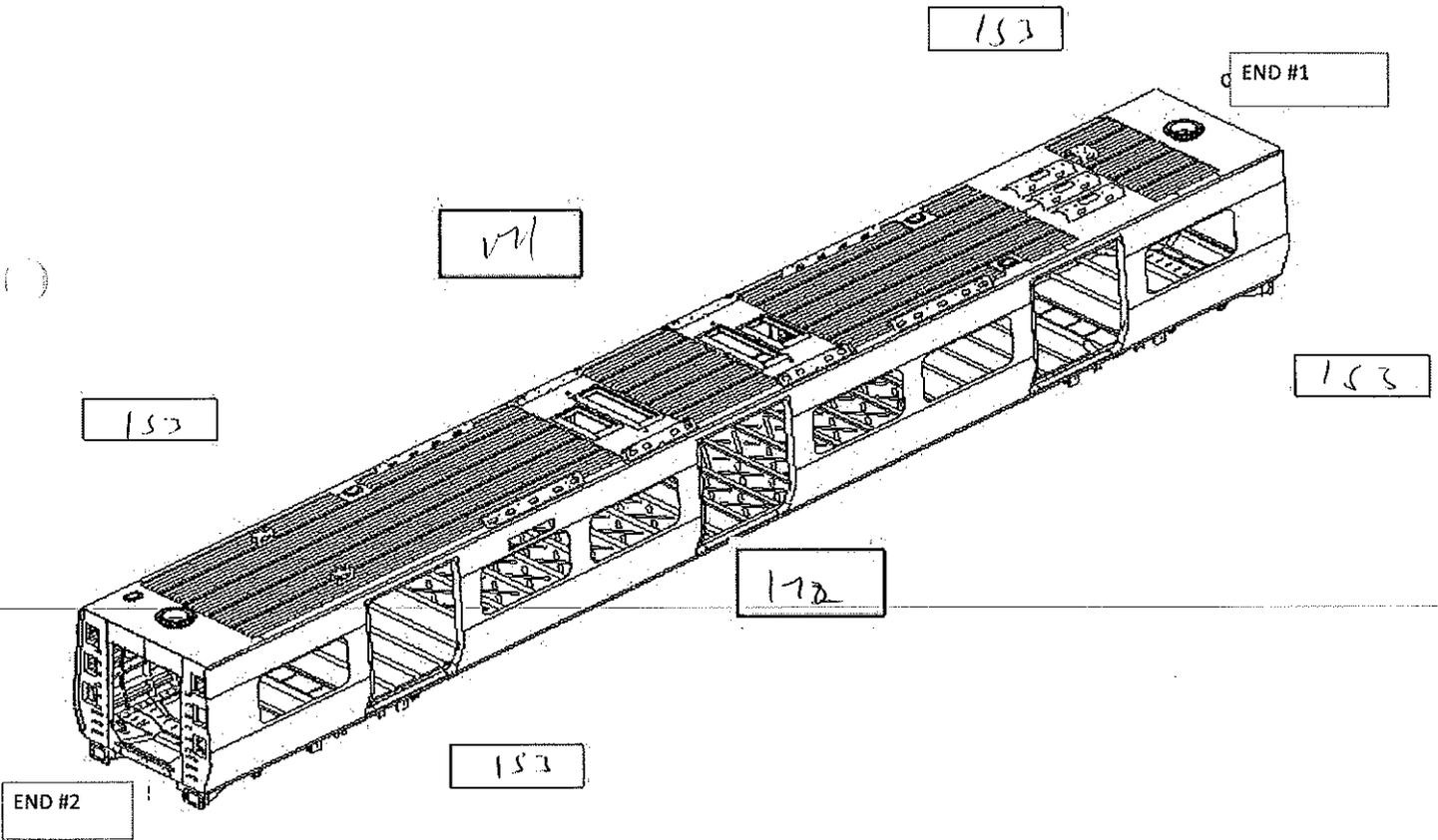
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Specifications of Details for CBS measurement CB1230

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



CAMBER	
RIGHT	19
LEFT	18

E



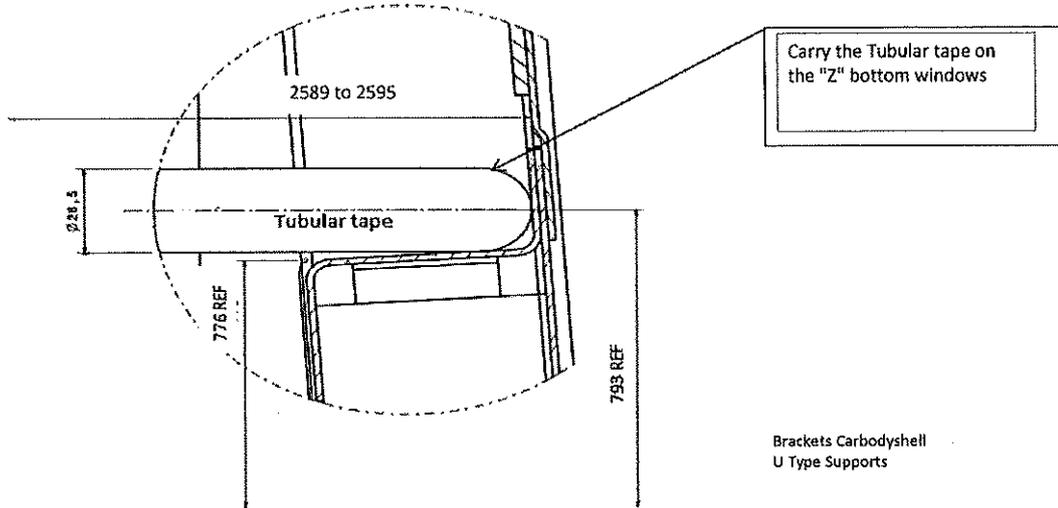
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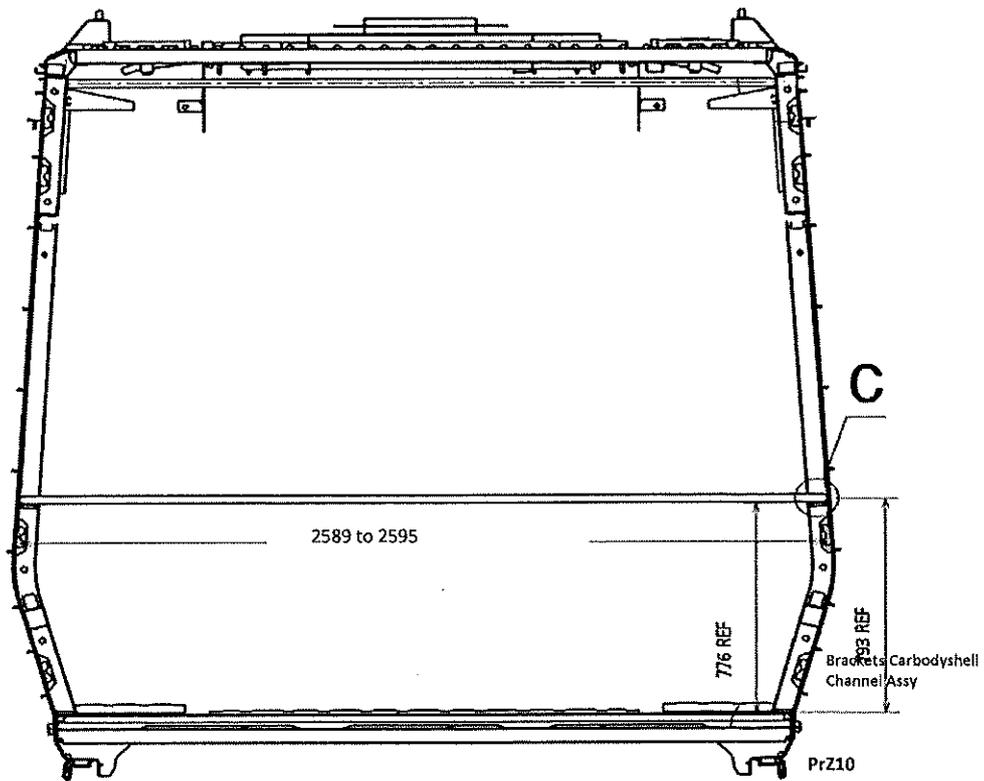
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Specifications of Details for CBS measurement CB1230



Detail C





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