

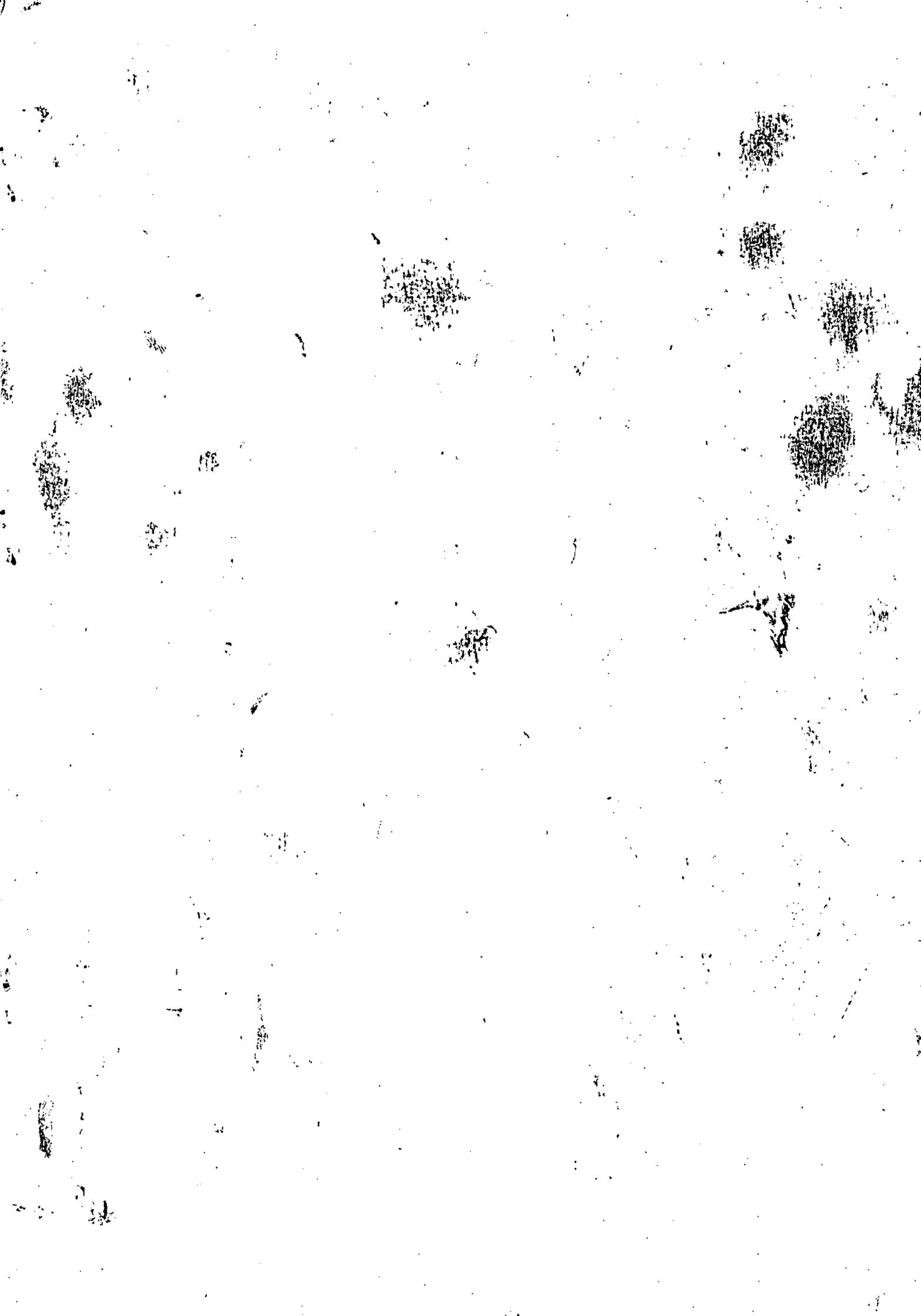
CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	CAB 438	Checks Updated:	2021/07/07

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

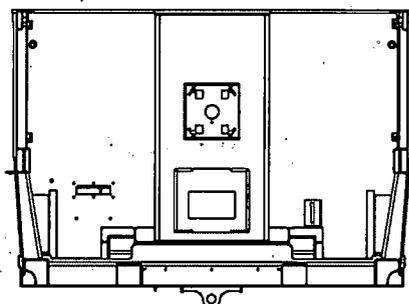
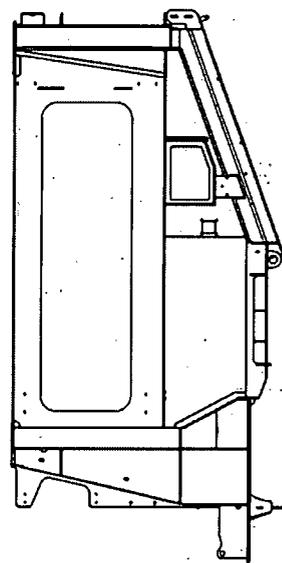
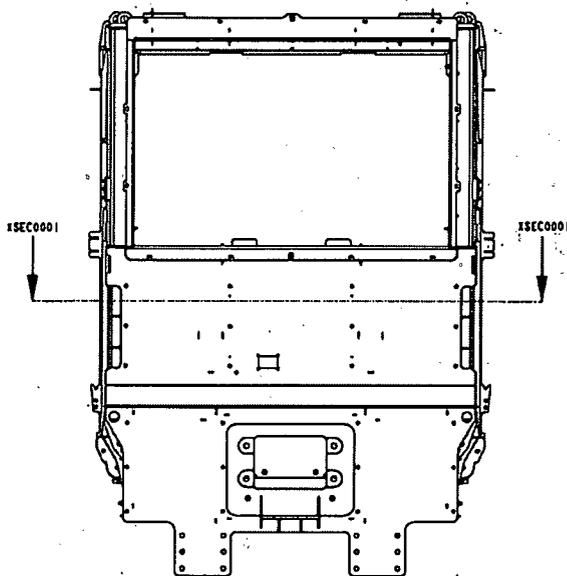
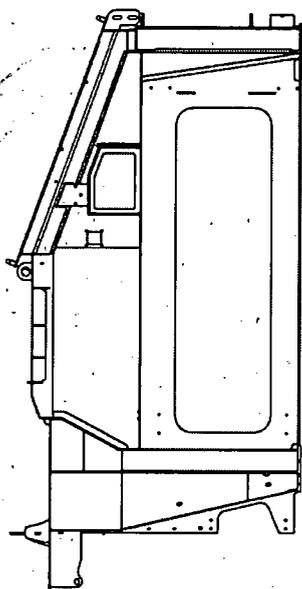
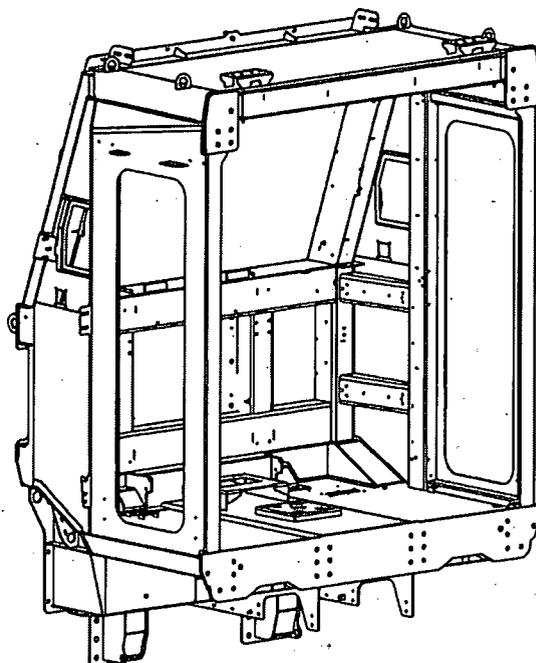
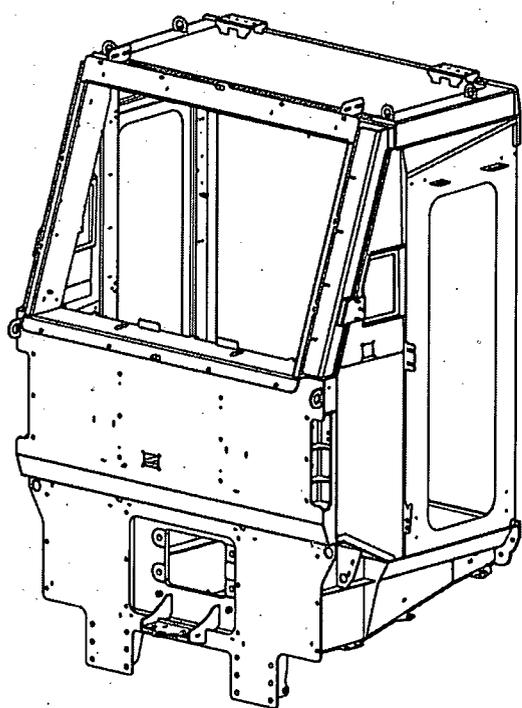
No.	Description of inspection	Disposition	Validation after rework		Sign
			Repairer	Disposition	
1	WELDS ARE CLOSED	0			
2	NO PIN HOLES ON CAB STRUCTURE	0			
3	SEALANT IS APPLIED CORRECTLY <ul style="list-style-type: none"> • JOINTS ARE CLOSED • NO BREAKS IN THE SEALANT • CORRECT BEAD 	0			
4	RIVET NUTS 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					
8					
9					
10					
11					
12					
13					
14					

Quality approval for release Signature	CO. NO:	DATE
	2385	23/02/24



REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)



Record of RAL 7012

Start Time:	03:00	End Time:	05:00
Temperature ≥ 15°:	21°C	Humidity ≤ 75%:	63%
Paint Batch No.:	8156853	Paint Expiry Date:	06/02/2025
Hardener Batch No.:	750215/21	Hardener Expiry Date:	12/24
Desolvation Start Time:	05:00	Desolvation End Time:	05:15
Stoving Start Time:	05:15	Stoving End Time:	06:15
Stoving Temp:	60°C		
Operator:	Nituthuko	Sign:	[Signature]
Date:	20/03/02		

RAL 7012 Control

DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 163	5: 157	1: 118	5: 144	1: 121	5: 138	1: 128	5: 87.6
2: 144	6: 122	2: 163	6: 156	2: 98.6	6: 139	2: 121	6: 81.5
3: 155	7: 140	3: 124	7: 137	3: 114	7: 140	3: 135	7: 92.6
4: 165	8: 138	4: 141	8: 128	4: 106	8: 160	4: 109	8: 131
Min:	122	Min:	118	Min:	98.6	Min:	81.5
Max:	165	Max:	163	Max:	160	Max:	135
Average:		Average:		Average:		Average:	

DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 117	5: 98.4	1: 139	5: 119	1: 138	5: 135	1: 121	5: 155
2: 82.3	6: 156	2: 148	6: 138	2: 124	6: 160	2: 165	6: 144
3: 112	7: 97.8	3: 113	7: 154	3: 143	7: 125	3: 94.3	7: 121
4: 92.7	8: 128	4: 144	8: 163	4: 155	8: 149	4: 111	8: 128
Min:	82.3	Min:	113	Min:		Min:	
Max:	156	Max:	163	Max:		Max:	
Average:		Average:		Average:		Average:	

DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 137	5: 146	1: 135	5: 114				
2: 110	6: 125	2: 115	6: 130				
3: 122	7: 97.3	3: 103	7: 154				
4: 75.7	8: 144	4: 94.3	8: 167				
Min:	75.7	Min:	94.3				
Max:	146	Max:	154				
Average:		Average:					

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		
QC Inspector:	Zathile	Sign:	[Signature]
Date:	02 Mar 2024		

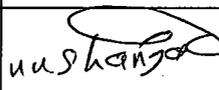
SEALING OF CABIN

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

SIGN OFF

CLOCK No:	2400	OPERATOR SIGN:	[Signature]	DATE:	02.03.2024
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Record of Painting Blue NCSS1565 B

Start Time:	20:00	End Time:	21:00
Temperature ≥ 15°:	29°C	Humidity ≤ 75%:	37%
Paint Batch No.:	8176318	Paint Expiry Date:	02.02.2025
Hardener Batch No.:	7502115121	Hardener Expiry Date:	12/24
Desolvation Start Time:	21:00	Desolvation End Time:	21:45
Stoving Start Time:	21:45	Stoving End Time:	22:45
Stoving Temp:	60°C		
Operator:	Ntuthuko	Sign:	
Date:	20 24 03/21		

Painting Blue NCSS1565 B Control

DFT Exterior Door Aperture RHS <i>R/W</i>		DFT Exterior Door Aperture LHS <i>R/W</i>		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)		
1: 122	5: 87.7	1: 137	5: 82.1			
2: 97.3	6: 64.8	2: 103	6: 81.9			
3: 88.2	7: 123	3: 82.9	7: 78.2			
4: 80.6	8: 101	4: 109.2	8: 82.6			
Min: 64.3		Min: 78.2				
Max: 123		Max: 137				
Average: 95.5		Average: 94.5				
Painting NCSS3010 R90B has been inspected and is free of defects						
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	91.7	
QC Inspector:		Zothile		Sign:		
Date:		08 Mar 2024				

Record of Painting NCSS3010 R90B							
Start Time:	22:30		End Time:	23:30			
Temperature $\geq 15^\circ$:	26°C		Humidity $\leq 75\%$:	52%			
Paint Batch No.:	8136210		Paint Expiry Date:	17.11.2024			
Hardener Batch No.:	7502115 121		Hardener Expiry Date:	12/24			
Desolvation Start Time:	23:30		Desolvation End Time:	23:45			
Stoving Start Time:	23:45		Stoving End Time:	00:45			
Stoving Temp:	60°C						
Operator:	Mfuthuko		Sign:	Mashangane			
Date:	2024 03/01						
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: 79.6	5: 94.4	1: 96.0	5: 101				
2: 127	6: 104	2: 118	6: 114				
3: 100	7: 92.1	3: 128	7: 85.9				
4: 123	8: 85.7	4: 109	8: 129				
Min: 79.6		Min: 85.9					
Max: 127		Max: 129					
Average: 100		Average: 110					
Painting NCSS3010 R90B has been inspected and is free of defects						Confirmed	Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>
GMS-SOS-GIBELA-PS-002 Gloss Test						Value	43.8
QC Inspector:	Zolile		Sign:			Hany	
Date:	08 Mar 2024						

Record of Priming

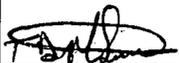
Start Time:	00:00	End Time:	02:00
Temperature ≥ 15°:	27°C	Humidity ≤ 75%:	39%
Paint Batch No.:	7978267	Paint Expiry Date:	06/25
Hardener Batch No.:	7331119	Hardener Expiry Date:	01/1/24
Desolvation Start Time:	02:00	Desolvation End Time:	02:15
Stoving Start Time:	02:15	Stoving End Time:	03:15
Stoving Temp:	60°C		
Operator:	Muthuko	Sign:	115
Date:	2024/03/01		

Priming Control

DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 88.7	5: 77.2	1: 73.3	5: 77.7	1: 74.2	5: 71.7	1: 88.2	5: 71.40.3
2: 70.1	6: 70.7	2: 72.8	6: 70.5	2: 64.8	6: 11.5	2: 76.7	6: 48.51.8
3: 52.2	7: 75.7	3: 70.3	7: 83.1	3: 61.4	7: 67.3	3: 76.9	7: 49.6
4: 10.6	8: 61.2	4: 76.7	8: 95.3	4: 11.9	8: 58.5	4: 68.4	8: 7.46
Min:	52.2	Min:	72.8	Min:	58.5	Min:	40.3
Max:	88.7	Max:	167	Max:	11.9	Max:	88.2
Average:	70.7	Average:	77.4	Average:	52.3	Average:	67.0
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 94.8	5: 72.0	1: 92.2	5: 72.3	1: 69.2	5: 72.7	1: 75.4	5: 72.7
2: 79.7	6: 67.8	2: 76.2	6: 71.2	2: 54.2	6: 72.5	2: 83.1	6: 70.1
3: 70.6	7: 83.7	3: 72.5	7: 75.8	3: 71.1	7: 72.1	3: 48.4	7: 70.5
4: 71.3	8: 40.3	4: 70.8	8: 74.5	4: 96.8	8: 71.0	4: 76.4	8: 82.6
Min:	40.3	Min:	92.2	Min:	54.2	Min:	76.4
Max:	120	Max:	96.2	Max:	96.8	Max:	96.4
Average:	68.7	Average:	75.6	Average:	72.4	Average:	78.6
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS	
1: 95.8	5: 72.2	1: 71.2	5: 70.0	1: 93.8	5: 78.7	1: 84.6	5: 64.4
2: 77.3	6: 90.2	2: 82.6	6: 63.4	2: 71.4	6: 69.5	2: 72.9	6: 73.8
3: 73.0	7: 84.7	3: 70.8	7: 85.7	3: 80.9	7: 78.2	3: 68.4	7: 79.2
4: 73.5	8: 98.9	4: 91.2	8: 96.3	4: 74.6	8: 81.1	4: 75.0	8: 81.1
Min:	72.2	Min:	63.4	Min:	69.5	Min:	64.4
Max:	98.9	Max:	96.3	Max:	93.8	Max:	84.6
Average:	83.2	Average:	78.9	Average:	77.3	Average:	74.9
Primer has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	Zotiale			Sign:			
Date:	02 Mar 2024						

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/ 02/ 29				

Record of Shot Blasting

Operator:	1	Date:	20 24/ 02/ 29
Start Time:	09 H 01	End Time:	13 H 13
Temperature ($\geq 15^\circ$):	21 - 02 °C	Humidity ($\leq 75\%$):	41 - 0.8 %

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/ 02/ 29				

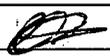
Shot Blasting Cleaning

Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	DAVID		Sign:		
Date:	20 24/ 02/ 29				

Shot Blasting Control

Temperature $\geq 15^\circ$:	22 - 05 °C	Humidity $\leq 75\%$:	47 - 03 %
Internal Roughness 3.2 \leq Ra \leq 12.5	9.682	External Roughness 3.2 \leq Ra \leq 12.5	10.375
QC Inspector:	LEA		Sign:
Date:	29/02/24		

Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	CHARL BLEN	Assembly Date:	20 __ / __ / __			
Sign:		Wire Batch No.:	2202152			

Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	RICARDO	Assembly Date:	20 20 / 02 / 20			
Sign:	974	Wire Batch No.:				

Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042

Confirmed	Yes	✓	No	
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QC Inspector:	LEON	Sign:		Date:	2024/02/10
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Dimensional Control

Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations
C / C'	625	± 2	625	625	Acceptable
D / D'	813	± 2,5	812	812	Acceptable
E	1531.5	± 3	1531		Acceptable
G1 / G'1	Height 1900	+1	1898	1887	Acceptable
G2 / G'2		-3	1898	1898	Acceptable
H1 / H'1	Width 560	+1	557	557	Acceptable
H2 / H'2		-3	558	559	Acceptable
H3 / H'3			559	559	Acceptable
F1 / F'1	Diagonals 1939		1936	1935	Acceptable
F2 / F'2			1935	1935	Acceptable
Difference	F1-F2 / F'1-F'2	≤ 4	0		Acceptable
J	Gap of Doors	± 1,5	0		Acceptable
K1 / K2	1515	± 3	1514	1514	Acceptable
L1 / L2	1996	± 3	1999	1998	Acceptable
M1 / M'1	2306	± 3	2465	2465	Acceptable
M2 / M'2			2478	2477	Acceptable
T1 / T'1	2130 Top/Bottom	± 3	2127	2128	Acceptable
T2 / T'2	2230 Top/Bottom		2230	2229	Acceptable
Difference	U - U' (3522)	≤ 4mm	3518	3519	Acceptable

QC Inspector:	LEON	Sign:		Date:	2024/02/10
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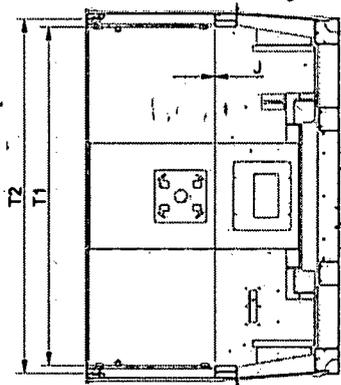
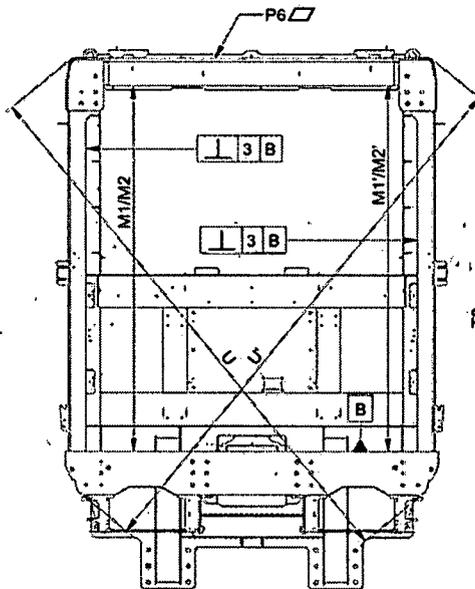
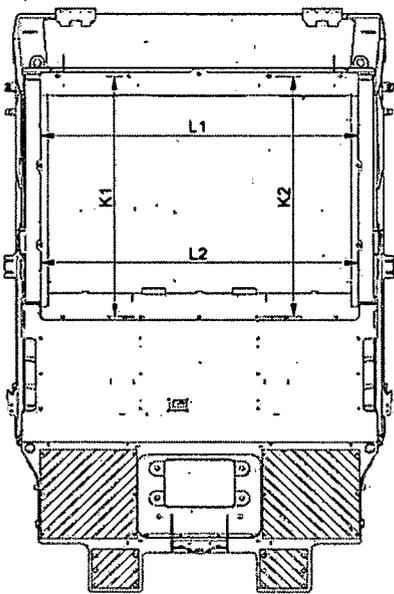
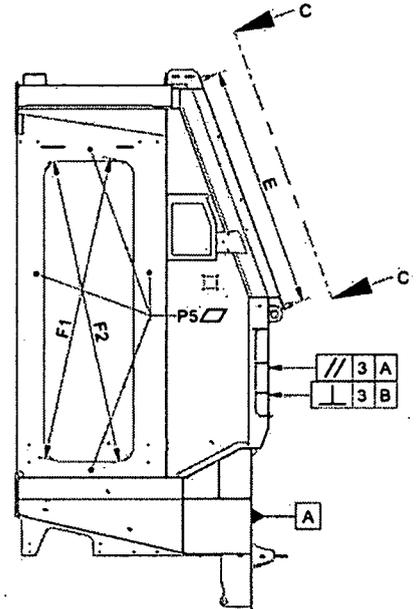
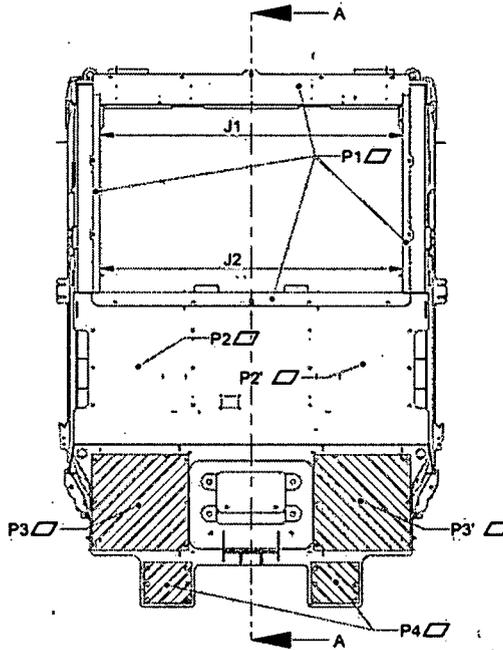
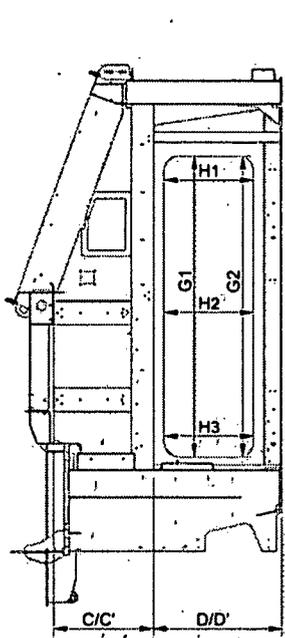
Geometrical Control

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

QC Inspector:	LEON	Sign:		Date:	2024/02/10
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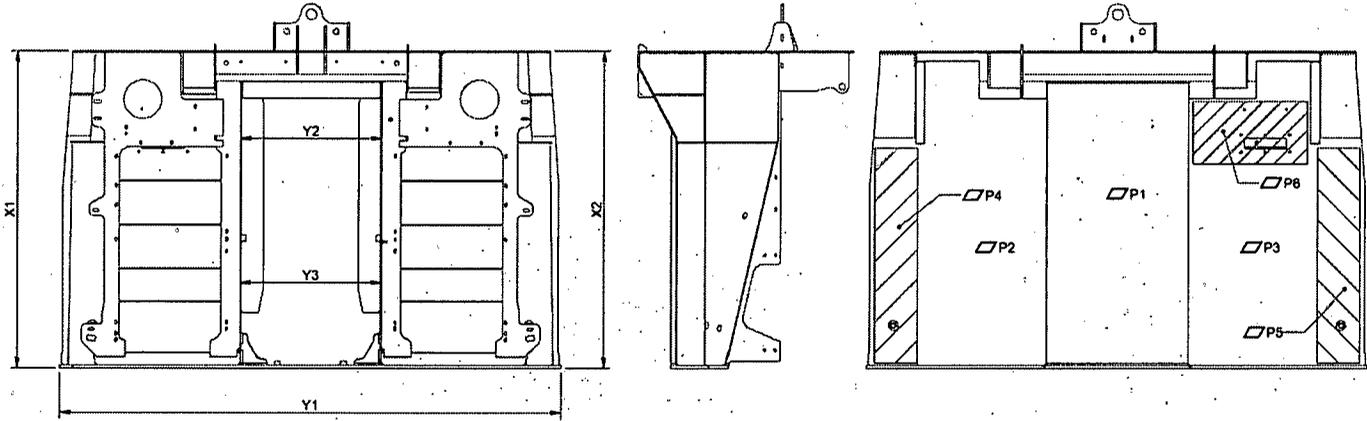
Cabin Structure Assembly: GN002834

Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	/	No
Operator:	CHARL BLOEM	Assembly Date:	20__/__/__		
Sign:		Wire Batch No.:	2202152		



Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	2024/02/17	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2201252	



Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	<i>Budley</i>	Sign:	<i>[Signature]</i>	Date: 2024/02/17

Dimensional Control

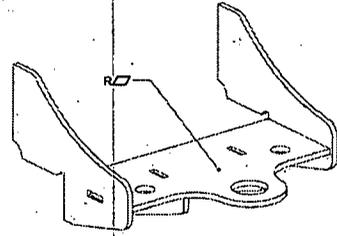
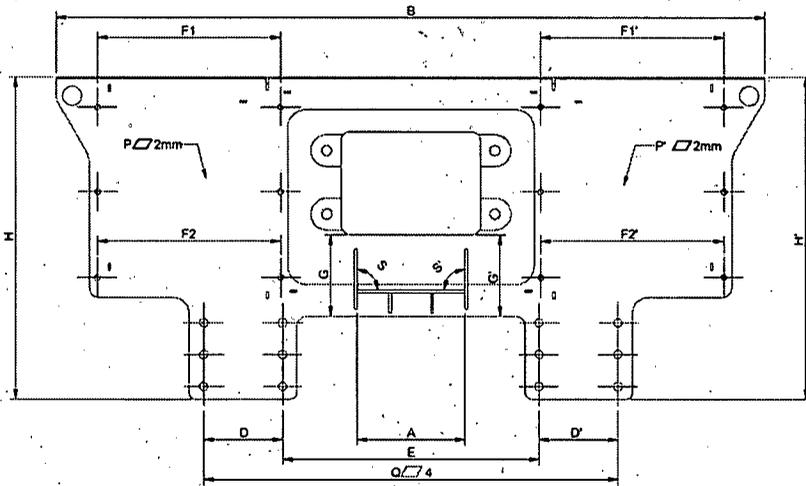
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1487	1488	Tape Measure	Acceptable
Y 1	2354	± 3	2352			Acceptable
Y2 / Y3	666	± 1	667	667		Acceptable
QC Inspector:	<i>Leon</i>		Sign:	<i>[Signature]</i>	Date:	2024/02/10

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planéité	4 mm	Ruler	Acceptable
P2 / P3 : Planéité	4 mm	Ruler	Acceptable
P4 / P5 : Planéité	2 mm	Ruler	Acceptable
P6 : Planéité	2 mm	Ruler	Acceptable
QC Inspector:	<i>Leon</i>		Sign: <i>[Signature]</i> Date: 2024/02/10

Cabin Front Headstock Assembly: GN002841

Assembly Completed as per WI/SOS MD_0019	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator: <i>TK BOEHN</i>	Assembly Date:	<i>2024/02/05</i>			
Sign: <i>[Signature]</i>	Wire Batch No.:	<i>2202152</i>			



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:	<i>2024/02/05</i>

Dimensional Control

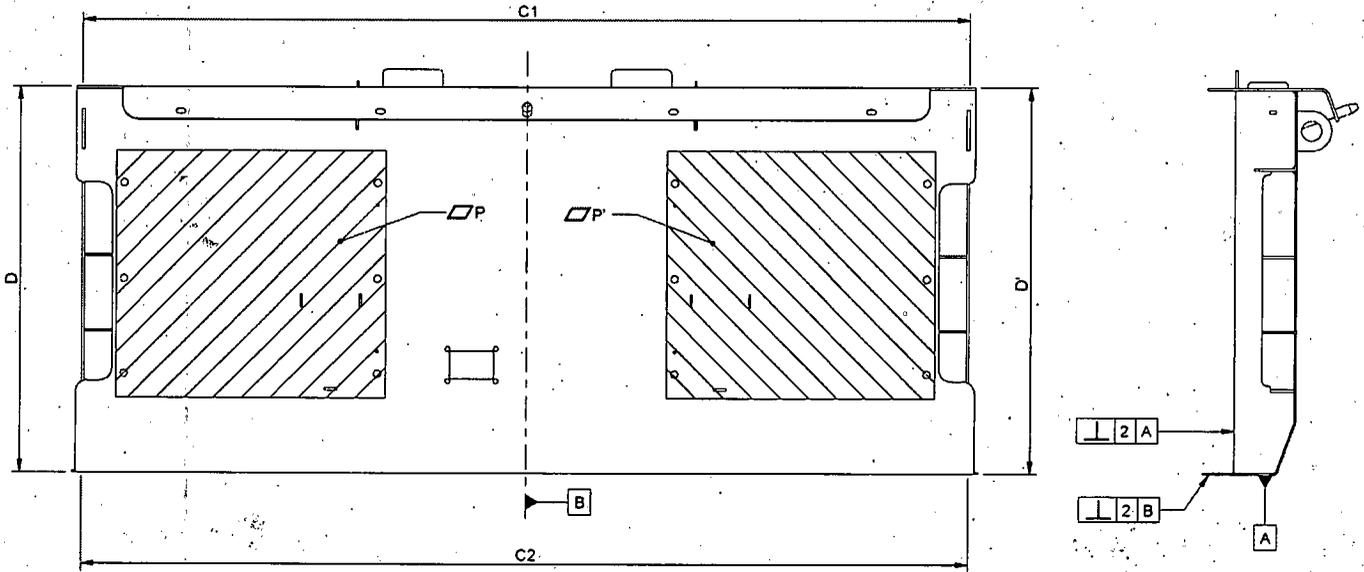
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	±1	<i>339</i>		Tape Measure	<i>Acceptable</i>
B	2240	±4	<i>2243</i>			<i>Acceptable</i>
D / D'	250	±1	<i>250.5</i>	<i>250.5</i>		<i>Acceptable</i>
E	808	±2	<i>807</i>			<i>Acceptable</i>
F1 / F1'	580	±1	<i>581</i>	<i>581</i>		<i>Acceptable</i>
F2 / F2'			<i>581</i>	<i>581</i>		<i>Acceptable</i>
G / G'	258	±1	<i>257</i>	<i>258</i>		<i>Acceptable</i>
H / H'	1019	±2	<i>1020</i>	<i>1020</i>		<i>Acceptable</i>
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>		Date:	<i>2024/02/05</i>

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations			
O: Planeity of global assembly	4 mm	<i>PASSED</i>	Ruler	<i>Acceptable</i>		
P / P': Planeity	2 mm	<i>PASSED</i>	Ruler	<i>Acceptable</i>		
Q: Planeity Surface of Supports	4 mm	<i>PASSED</i>	Ruler	<i>Acceptable</i>		
R: Planeity Coupler Support	2 mm	<i>PASSED</i>	Ruler	<i>Acceptable</i>		
S: Perpendicularity coupler	1mm	<i>PASSED</i>	Square	<i>Acceptable</i>		
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>		Date:	<i>2024/02/05</i>

Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>BEVAN JAVENHILL</i>	Assembly Date:	20__/02/07			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			



Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Bradley</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/07	

Dimensional Control

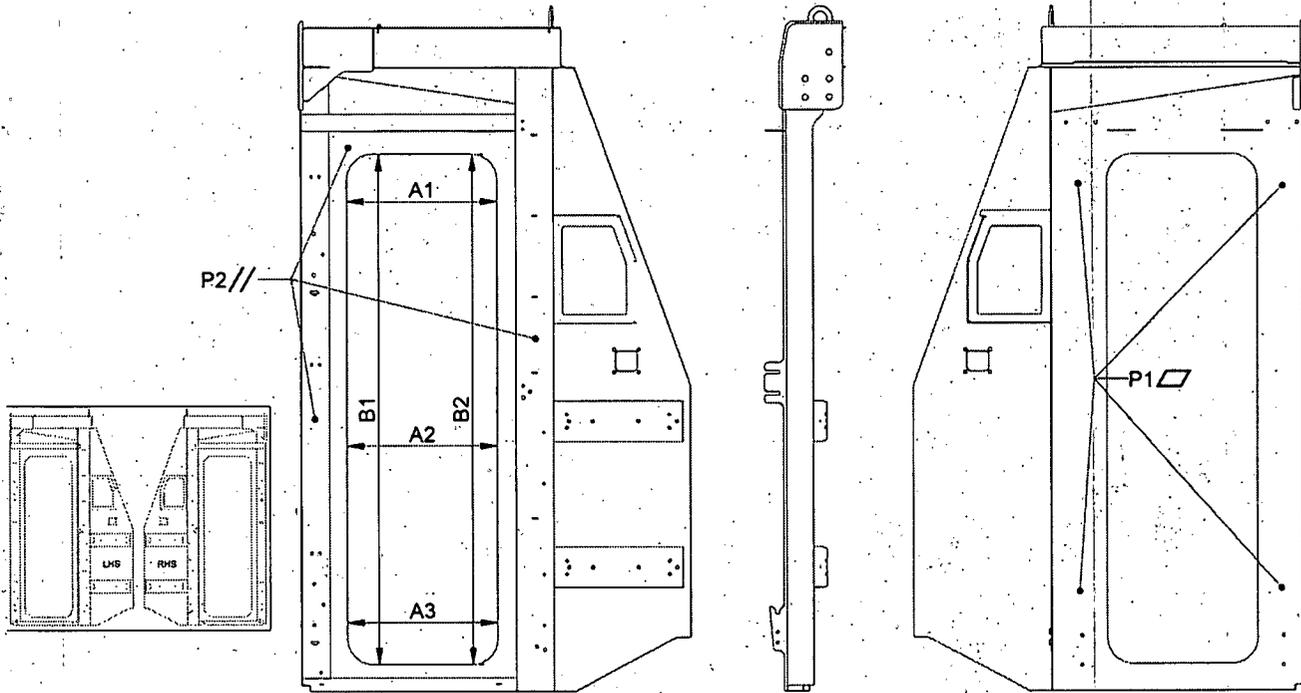
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations	
C1 / C2	2210	± 4	2213	2211	Tape Measure	Acceptable	
D / D'	956	± 2	957	956		Acceptable	
QC Inspector:			Sign:			Date:	2024/02/07

Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations	
Planeity P / P'		2 mm	<i>Passed</i>		Ruler	<i>Acceptable</i>	
Perpendicularity	2	A	<i>Passed</i>		Set Square	<i>Acceptable</i>	
	2	B	<i>Passed</i>		Set Square	<i>Acceptable</i>	
QC Inspector:	<i>Bradley</i>		Sign:	<i>[Signature]</i>		Date:	2024/02/07

Cabin LHS/RHS Side Assembly: GN002838/GN002837

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Kander</i>	Assembly Date:	2024/01/31			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202165			



Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Predley</i>	Sign:	<i>[Signature]</i>	Date:	2024/01/07	

Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	560	558	Tape Measure	Acceptable
A2			560	560		Acceptable
A3			558	560		Acceptable
B1	1900	± 2	1898	1898		Acceptable
B2			1898	1898		Acceptable

QC Inspector:	<i>Predley</i>	Sign:	<i>[Signature]</i>	Date:	2024/02/04
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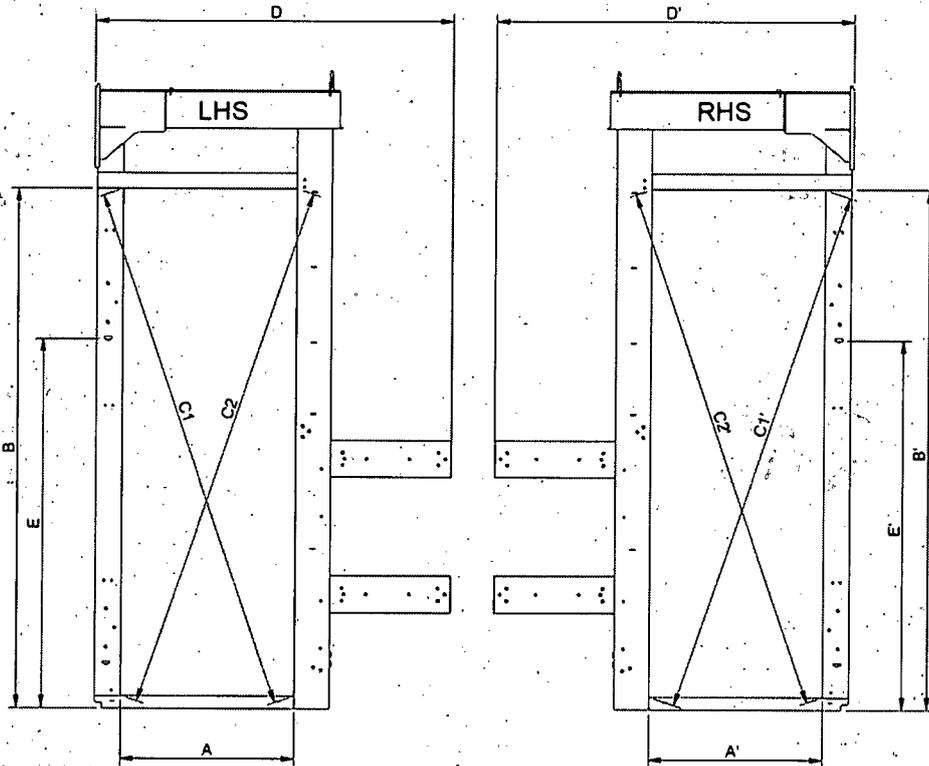
Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1: Planeity	4 mm	<i>Passed</i>	Ruler	Acceptable
P2: Planeity	2 mm	<i>Passed</i>	Ruler	Acceptable

QC Inspector:	<i>Predley</i>	Sign:	<i>[Signature]</i>	Date:	20__/__/__
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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:	20 <u>24</u> / <u>01</u> / <u>29</u>			
Sign:	<i>Glenn</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	<input type="checkbox"/>
QC Inspector:	Leon	Sign:	<i>Leon</i>		Date:	20 <u>24</u> / <u>01</u> / <u>30</u>

Dimensional Control

Rep.	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	696	Tape Measure	Acceptable
B	2086	+1/-3	2086	2085		
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2151	2151		
$ C1 - C2 $			2151	2151		
D	1438	+2/-3	1440	1436		
E				1483		Acceptable
QC Inspector:		Leon		Sign:	<i>Leon</i>	
				Date:	20 <u>24</u> / <u>01</u> / <u>30</u>	

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	<i>99800</i>	Ruler
QC Inspector:		Leon	
		Date:	20 <u>24</u> / <u>01</u> / <u>30</u>

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>Kenner</i>	Assembly Date:	2024/01/29			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202163			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

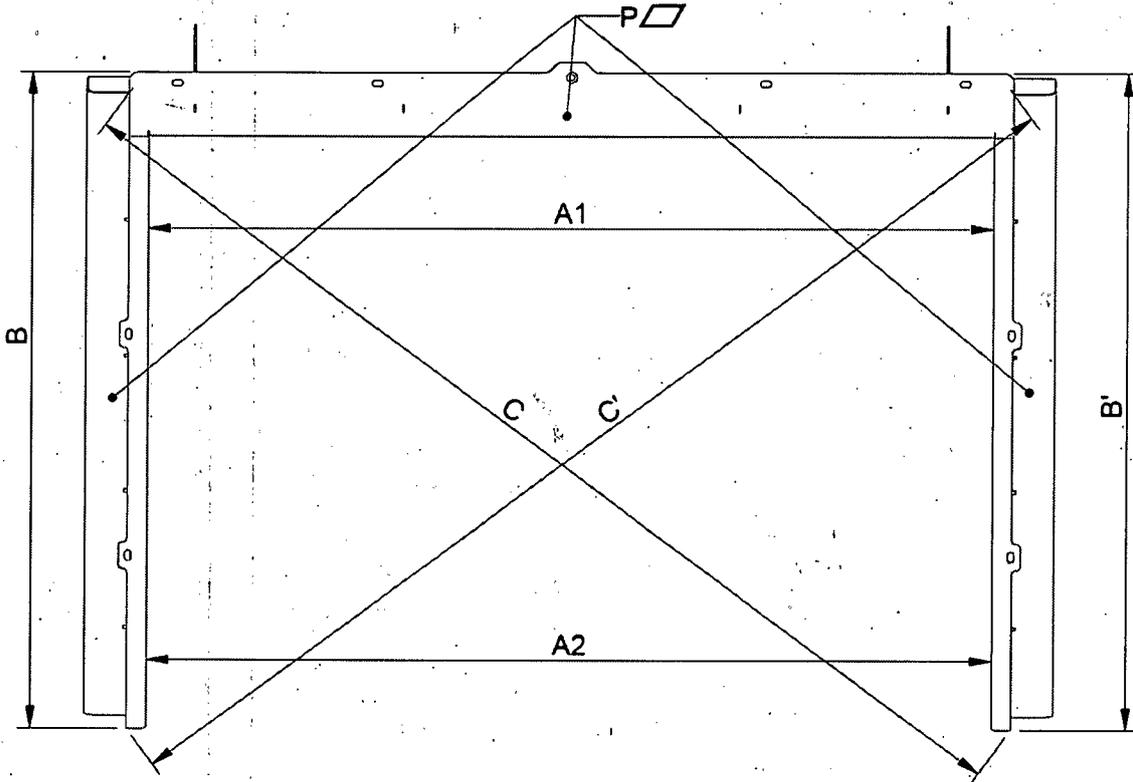
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Glenn</i>	Assembly Date:	2024/01/29			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Glenn</i>	Assembly Date:	2024/01/23			
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202152			

Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	No
Operator:		Assembly Date:	20__/__/__	
Sign:		Wire Batch No.:		



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	No
QC Inspector:	<i>Budley</i>	Sign:	<i>RB</i>	Date: 2024/02/06

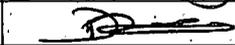
Dimensional Control

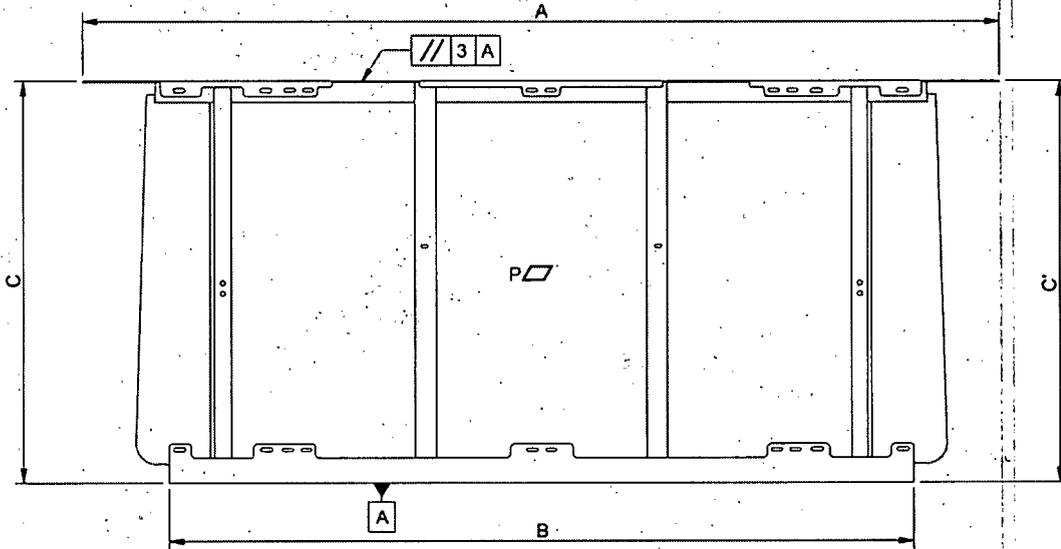
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	1910	± 2	1912		Tape Measure	<i>Acceptable</i>
A2	1910		1912			<i>Acceptable</i>
B	1475	± 1	1474	1474		<i>Acceptable</i>
C	Diagonals C - C' ≤ 3		2478	2478		<i>Acceptable</i>
QC Inspector:	<i>Budley</i>	Sign:	<i>RB</i>		Date:	2024/02/06

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations		
P : Planeity	4 mm	<i>Passed</i>	Ruler	<i>Acceptable</i>	
QC Inspector:	<i>Budley</i>	Sign:	<i>RB</i>	Date:	2024/02/06

Cabin Roof Assembly: GN002839

Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	BYLAN DAVIDS	Assembly Date:	2024/02/07			
Sign:		Wire Batch No.:	10723201			



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:		Sign:		Date:	2024/02/07	

Dimensional Control

Rep	Toler.	Dimension measured		Measuring Equipment	Observations	
A	+5/-0	2216		Tape Measure	Accepted	
B	± 4	1800			Accepted	
C	+2/-3	976	976		Accepted	
QC Inspector:	Leon	Sign:		Date:	2024/02/07	

Geometrical Control

Nature of Checks		Dimension Measured	Measuring Equipment	Observations		
Planeity P	6 mm	Passed	Ruler	Accepted		
//	3 A	Passed	Set Square	Accepted		
QC Inspector:	Leon	Sign:		Date:	2024/02/07	

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Regulus	09/02/24	178247 104825 01	CP49402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	3 mm	Regulus	14/02/24	178620 104640 01	P205272	
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	20 mm	Regulus	08/02/24	178488 104640 01	P30091	
RCS 355	20 mm					

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

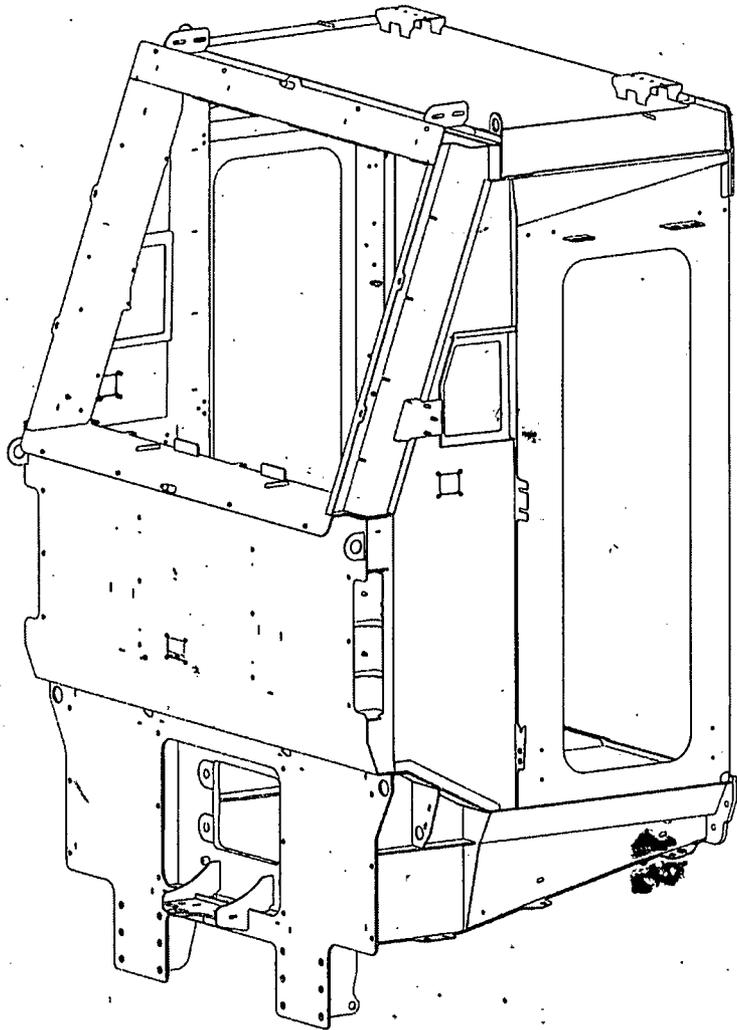
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 450	4 mm	Regulus	8/02/24	178489 104660 01	WIK 35578	
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 450	6 mm	Regulus	14/02/24	178815 104460 01	P201903 WIK 28402	
RCS 450	6 mm					
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 450	8 mm	Regulus	22/11/23	135569 102206 01	P207806 WIK 58432	
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

GLOBAL

MANUFACTURING
SOLUTIONS



CABIN STRUCTURE QUALITY CARD

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