GIBELA

PRASA PROJECT

APPLICABLE FROM TRAINSET 190+ AS PER BASELINE 10.4

SELF INSPECTION SHEET

APPLICATION REFERENCE

	MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE TC1	M4	M1	M2	M3	TC2	WORK INSTRUCTION	SAFETY?
☐	DTR3000152644	AAD0001278566	CARBODYSHELL M3,M4 ASSEMBLY	CB1210		X			(X)		PRA.CB1210.DTR30225 487/3.V30	YES
☐												

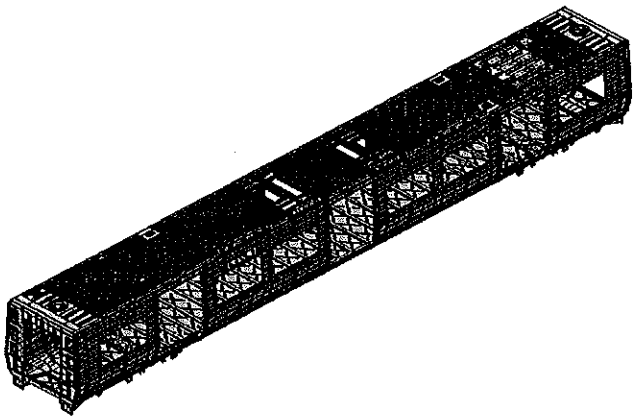
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018
			CHECKER	Nosizo Pindela	10/01/2018
			COMPILER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality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

TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
230	M3	LUNGA 471497	28/05/24	SI.CB1210.254.V30	17

GIBELA	CARBODYSHELL M3,M4 ASSEMBLY DTR302254B7/3	Rev. 31 Date 07/11/2023	Project: PRASA SI.CB1210.254.V30

Car: M3 & M4	NCR:	Work station: CB1210

Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car TC1	MT	M2	M3	M4	TC2	Revision	Observation	OK			Signature/Date (Manufacturing)	Signature/Date (Quality)
DTR302254B7/3				X					✓				28/05/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULAR	39823-2	15/05/24	✓		28/05/24	
30 M TAPE	GIBTP0084	14/03/24	✓		28/05/24	28/05/24
LASER TAPE	12542592 4	08/01/24	✓		28/05/24	

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
AWS (CAT) 308 LSI	F221880	MIG	✓		28/05/24	
ER 309 LSI	318394	MIG	✓		28/05/24	28/05/24

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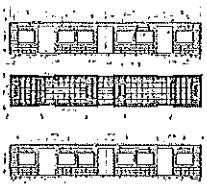
II.- Self Inspection - Items to Check

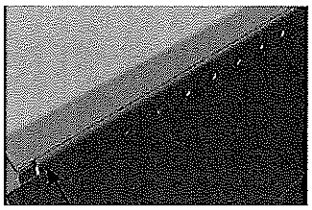
II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	[illegible]	[illegible]	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓			28/05/24	28/05/24
02	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	**IND-SAL-WMS-016 e DTD0000210675**	✓			28/05/24	28/05/24
03	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	**IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000**	✓			28/05/24	28/05/24
04		Cleaning of all Stainless Steel Surface	**According TO GIB-WEL - PROC-0002**	✓			28/05/24	28/05/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓			28/05/24	28/05/24
06	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.	✓			28/05/24	28/05/24

GIBELA	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31 Date 07/11/2023	Project: PRASA SI.CB1210.254.V30

Welding Traceability

Roof ring welds



LHS

Boiler maker (Name & Sign): GIBELA

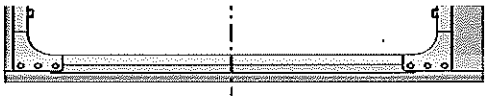
Welder (Name & Sign): SIPHOKAZI

RHS

Boiler maker (Name & Sign): TIM

Welder (Name & Sign): SIPHOKAZI

Door ring welds



LHS

Boiler maker (Name & Sign): WINGA

Welder (Name & Sign): GIFT

RHS

Boiler maker (Name & Sign): TINUS

Welder (Name & Sign): GIFT

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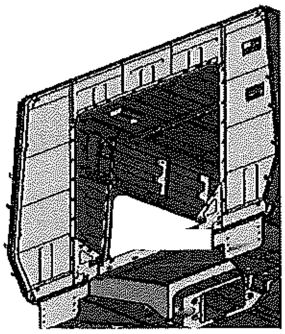
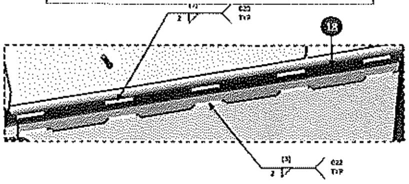
EUF Reinforcement Plates

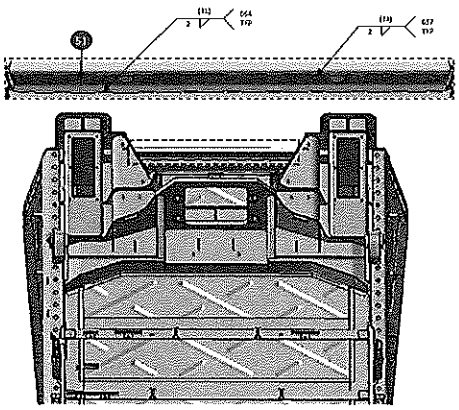




END 1

Boiler maker (Name & Sign): SEAN

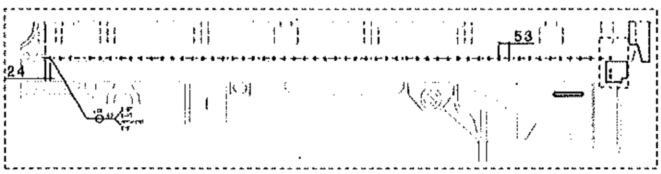
Welder (Name & Sign): SIPHOMAZI



END 2

Boiler maker (Name & Sign): JUSTICE

Welder (Name & Sign): Thabang

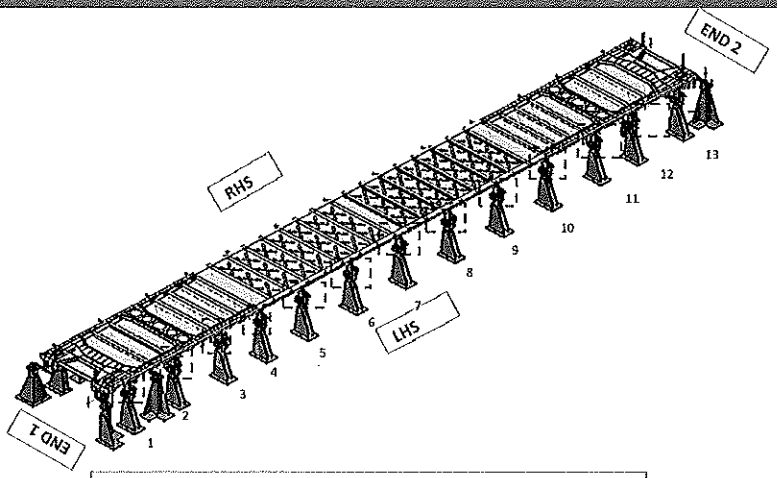


FEDOLI

Operator: LUNGA

GIBELA	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31	Project: PRASA SI.CB1210.254.V30
		Date 07/11/2023	

Specifications of Details for CBS measurement



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

After loading and clamping

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

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side						N/A							
Right Hand Side													

Signature Operations: Date: 9.8/05/24

After Welding.

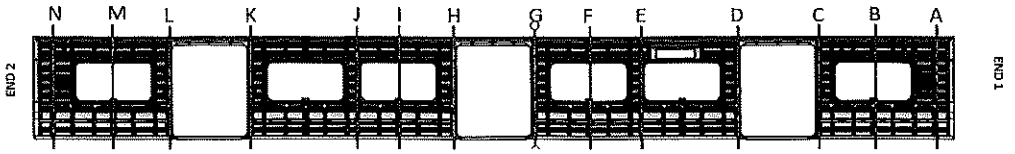
Fill in the gap found each jig pillars / chair and underframe should be 0mm.

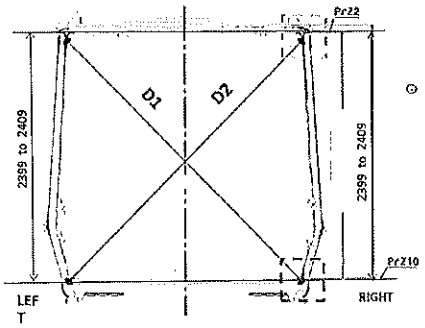
	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side						9/9							
Right Hand Side													

Signature Industrial Quality: Date: 28/05/24

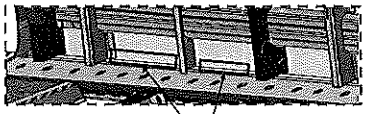
GIBELA	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31	Project: PRASA
		Date 07/11/2023	SI.CB1210.254.V30

Specifications of Details for CBS measurement

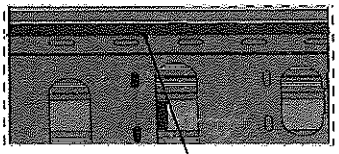




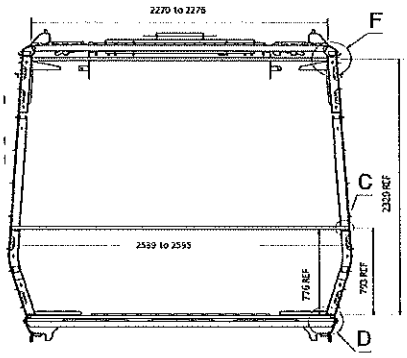
Measurement positions on roof rail and sidewall omega corner.

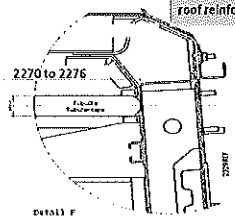


Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.





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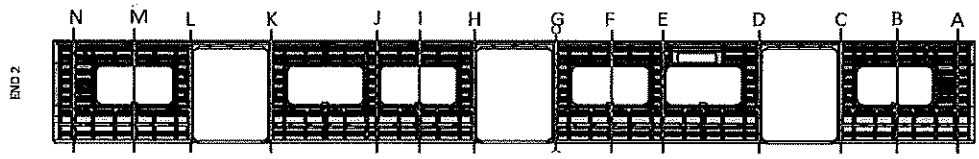
Specifications of Details for CBS measurement



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

BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	32.68	32.68	0	2408	2407	1
B	32.66	32.69	3	2406	2406	0
C	32.67	32.68	1	2407	2405	2
D	32.68	32.68	0	2406	2407	1
E	32.65	32.65	0	2405	2405	0
F	32.64	32.66	2	2405	2406	1
G	32.68	32.68	0	2404	2406	2
H	32.67	32.68	1	2405	2407	2
I	32.66	32.64	2	2406	2406	0
J	32.66	32.66	0	2405	2405	0
K	32.68	32.67	1	2406	2404	2
L	32.69	32.69	0	2405	2406	1
M	32.64	32.68	4	2406	2406	0
N	32.68	32.69	1	2407	2407	0

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GIBELA	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31	Project: PRASA
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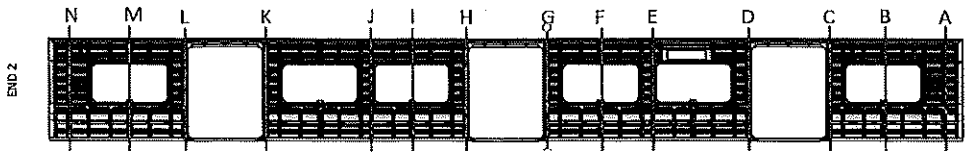
Specifications of Details for CBS measurement



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

AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	32.95	32.94	1	2407	2406	1
B	32.66	32.68	2	2405	2405	0
C	32.95	32.95	0	2407	2406	1
D	32.95	32.96	1	2406	2405	1
E	32.66	32.66	0	2404	2405	1
F	32.66	32.65	1	2406	2404	2
G	32.94	32.95	1	2405	2405	0
H	32.95	32.95	0	2405	2406	1
I	32.64	32.65	1	2405	2405	0
J	32.66	32.66	0	2406	2407	1
K	32.96	32.94	2	2405	2406	1
L	32.95	32.95	0	2404	2405	1
M	32.68	32.65	3	2405	2405	0
N	32.94	32.95	1	2407	2407	0

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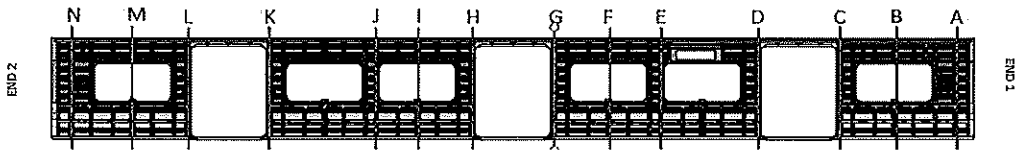
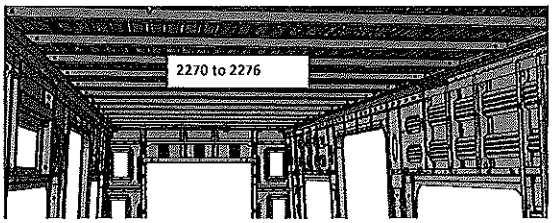
CBS measurement

BEFORE WELDING

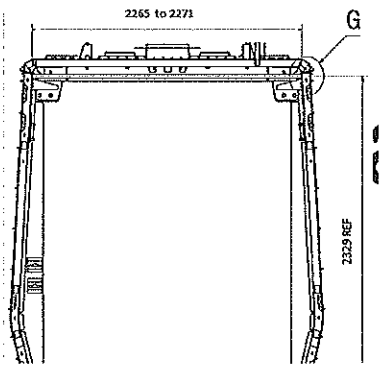


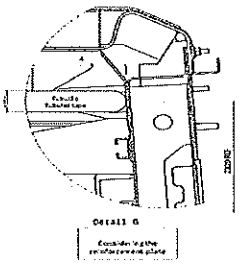


Do not consider reinforcement (Take measurements top area of zee profile

2270 to 2276

A	2.271
B	2.275
C	2.272
D	2.272
E	2.277
F	2.275
G	2.272
H	2.270
I	2.276
J	2.277
K	2.272
L	2.271
M	2.275
N	2.270





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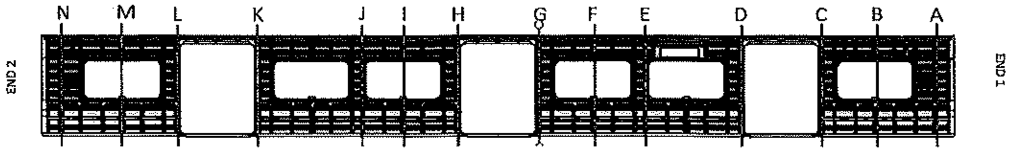
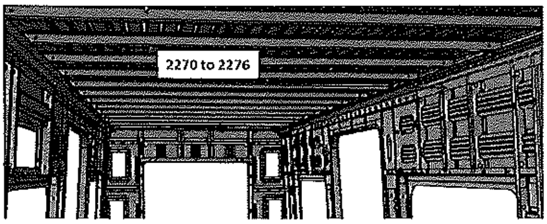
CBS measurement

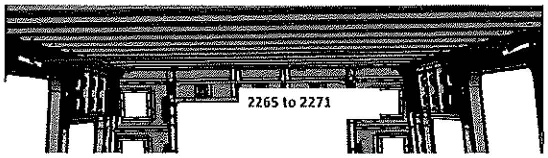
AFTER WELDING



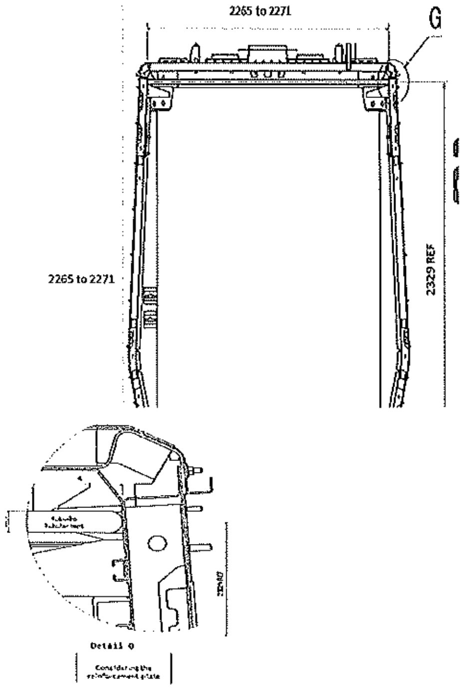
	2265 to 2271	2270 to 2276
A	2265	/
B	/	2274
C	2270	/
D	2266	/
E	/	2276
F	/	2274
G	2268	/
H	2269	/
I	/	2275
J	/	2275
K	2269	/
L	2266	/
M	/	2273
N	2268	/



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



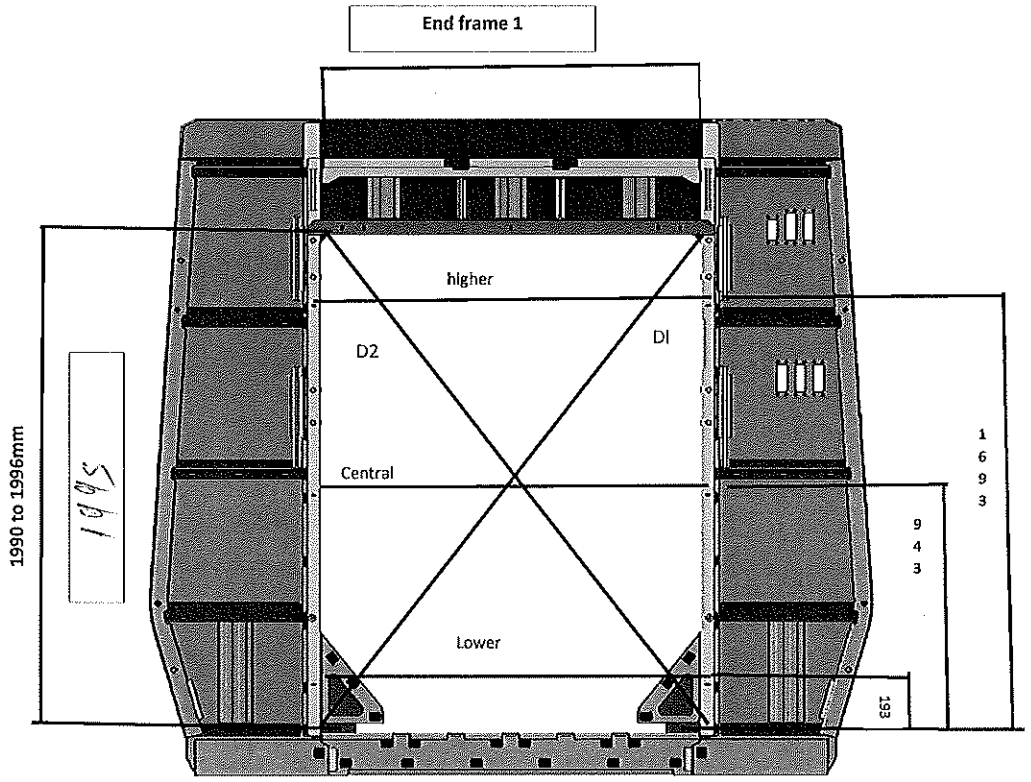
Take measurement close to radius (considering reinforcement)



28/05/24

GIBELA	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31 Date 07/11/2023	Project: PRASA SI.CB1210.254.V30

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE **D1-D2** ≤ 3mm

Higher Dimension	1381	D1	2413
Central Dimension	1380	D2	2414
Lower Dimension	1380	D1-D2	1

28/05/24

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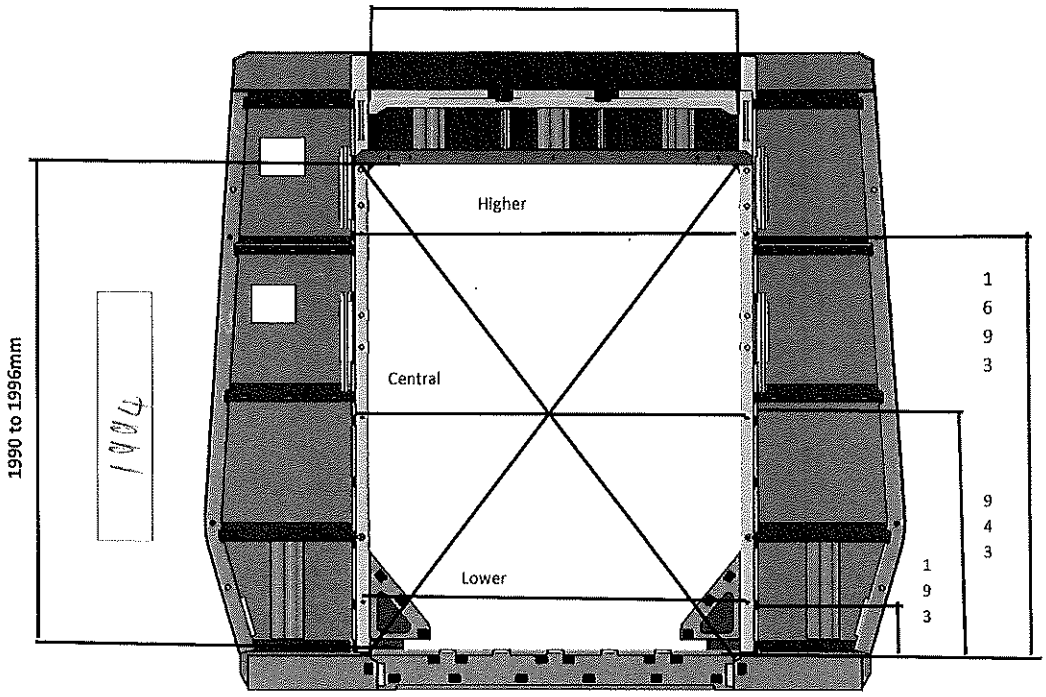
Specifications of Details for CBS measurement

Endframe 2

1380 to 1382 mm



1380 to 1382 mm

DIAGONAL DIFFERENCE **D1-D2** ≤ 3mm

Higher Dimension	1381	**D1**	2414
Central Dimension	1381	**D2**	2414
Lower Dimension	1380	**D1-D2**	0

25/05/24

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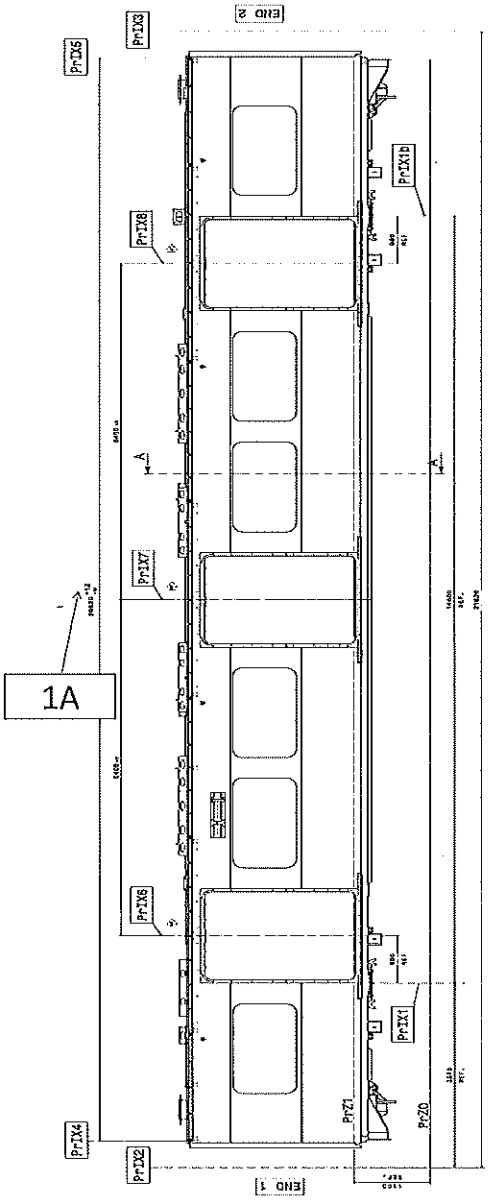
Specifications of Details for CBS measurement



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

	RIGHT SIDE	
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20616

Dye penetrant test

Dye-penetration test to be performed by quality personnel

GIBELO	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31 Date 07/11/2023	Project: PRASA SI.CB1210.254.V30

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	NOK	Comments	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX					

GIBELA	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 31 Date 07/11/2023	Project: PRASA SI.CB1210.254.V30

Self Inspection - Final Result

				DATE	NAME	SIGNATURE
HOLD POINT		GO	(If activities are not complete, the missing activities must not impact the next stage)	28/05/24	Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	28/05/24	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

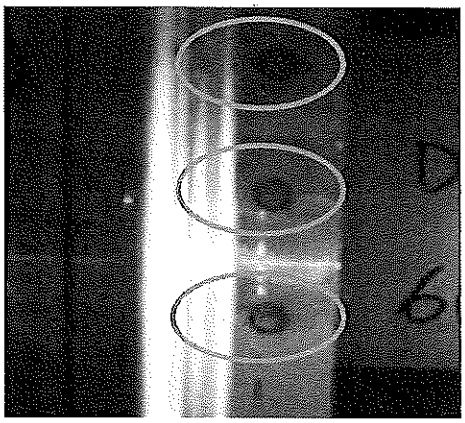
In case of "NO GO", the operations manager must define below action plan to ensure "GO":

Item	Description		Responsible	Due date	Status

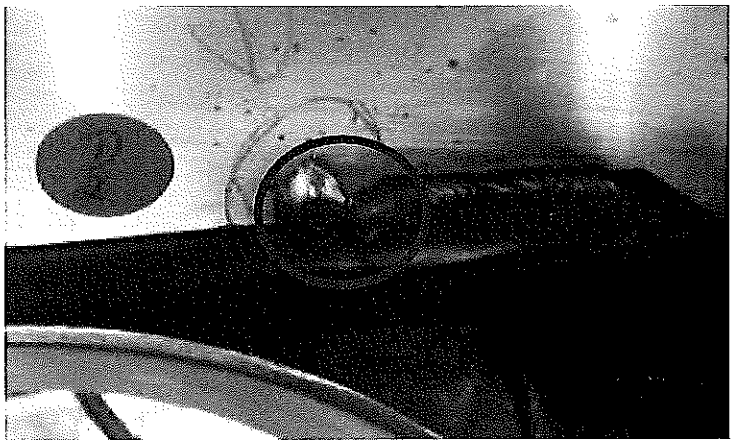
Operations

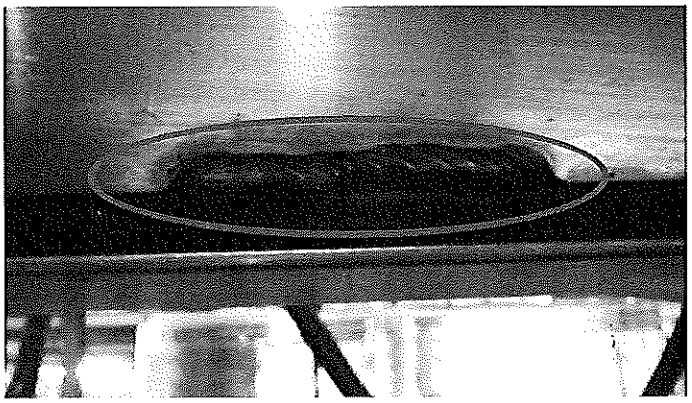
Quality

ANNEXURE A: Spot Welding Quality Acceptance Standard



ANNEXURE B: Arc Welding Quality Acceptance Standard





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	M6	M1	M2	M3	TC2	WORK INSTRUCTION	SAFETY?
☐ DTR3000152648	AAD0001278566	CARBODYSHELL M1,M3,M6 ASSEMBLY	CB2220			X				PRA.CB2220.DTR3022548 7/2.V21	YES
☐ DTR3000152649	AAD0001278566	CARBODYSHELL M1,M3,M6 ASSEMBLY	CB2220		X	X		X		PRA.CB2220.DTR3022548 7/2.V21	YES
☐											
☐											
☐											
☐											
☐											

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 Remove length measurements	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	22/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	22/08/2019
			CHECKER	Nosizo Pindela	22/08/2019
			REVISED BY	Nosizo Pindela	22/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021
			CHECKER	Mpho Mulaudzi	
			REVISED BY	Mpho Mulaudzi	
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	19/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbhombhi	14/06/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
27	19/10/2022	Addition of traceability for sealant application & welding	APPROVER	Collins Mbhombhi	19/10/2022
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
28	14/04/2023	Added sealant batch number & welding consumable's traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	
29	28/10/2023	Addition of bracket quantity	APPROVER	Ngobeni Tyson	28/10/2023
			CHECKER	Ntokozo Zwane	
			REVISED BY	Amogelang Mohlampe	

TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
230	M3	Levi 483003	30/01/24	SI.CB2220.250.V29	13

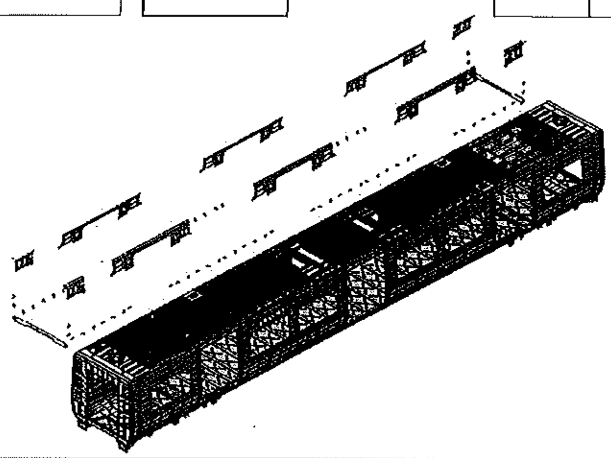
GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

Car: M1,M3&M4

NCR:

Work station: CB2220

Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	TC1	M1	M2	M3	M4	TC2	Revision	Observation	OK	NOK		Signature/Date (Manufacturing)	Signature/Date (Quality)
DTR30225487/2							29	28/10/2023	X		N/A	30/05/24	30/05/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Tubular	3283263	15/03/2023 - 15/03/24	X		30/05/24	
Measuring Tape	YC8M0432	17/04/2024 - 17/04/2025	X		30/05/24	30/05/24

1.3 Consumables

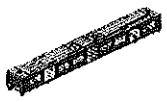
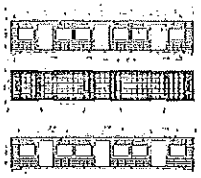
Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Welding 308LSI	B221850	Mig	X		30/05/24	30/05/24

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

II - Self Inspection - Items to Check

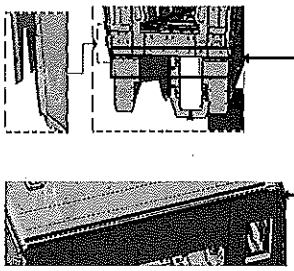
II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK			Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB2220.DTR30225487/2 Verification of fitment for all reinforcement brackets.	PRA.CB2220.DTR30225487/2	✓				30/05/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓				30/05/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	**IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000**	✓				30/05/24
04		Cleaning of all Stainless Steel Surface	**According TO GIB-WEL - PROC-0002**	✓				30/05/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓				30/05/24
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.	✓				30/05/24
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% - 60%	Sealant Batch No: B3497/05/24 Exp Date: 04/05/24 Actuals Temperature: 20°C Humidity: 40%	✓			30/05/24	30/05/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278565	✓			30/05/24	30/05/24
09		Verfication of safety welds	Approved according to DTD000210658 reference and Self inspection	✓				30/05/24

GIBELO	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 26/10/2023	Project: PRASA SI.CB2220.250.V29

II - Self Inspection - Items to Check

SEALANT APPLICATION



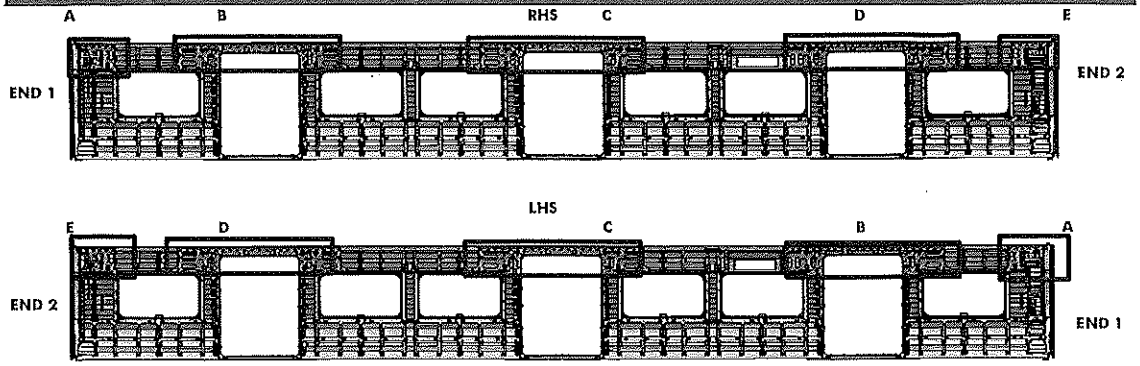
AREA 1 & 2 END 1

Operator (Name & sign): Priscilla

Operator (Name & sign): Priscilla

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

II - Self Inspection - Items to Check

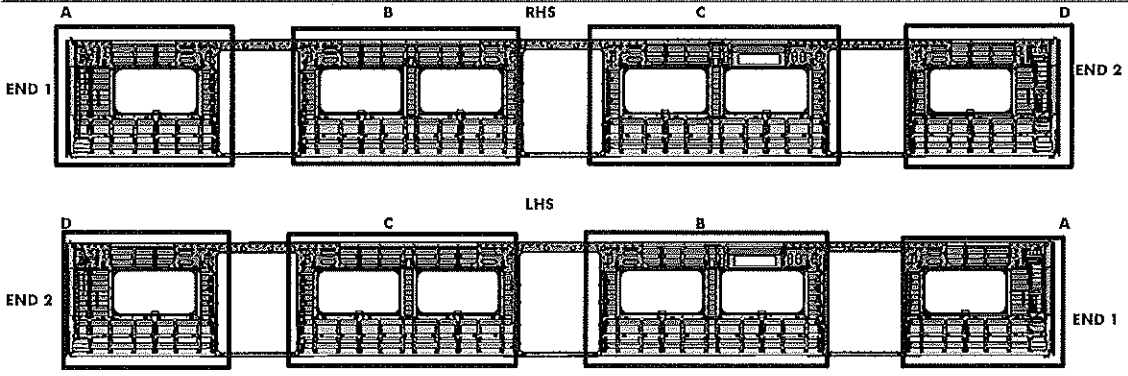


REINFORCEMENT WELDING

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

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

II - Self Inspection - Items to Check



BRACKETING

INSTALLATION

C-RAILS: Operator: Asanda

Operator:

DOOR MECHANISMS: Operator: Lenri

Operator:

TAPPING PADS Operator: Lindo

Operator: S. Mkhize

INSTALLATION & VERIFICATION

SEAT & LUGGAGE BRACKETS: Operator: MMhlongisi

Operator:

SEAT BRACKETS VERIFICATION: Operator: Priscilla

Operator:

WELDING

AREA		LHS	RHS
A	(Seat brackets) : Operator (Name&sign):		Lindo
	(C-rails, Luggage and earth bushes) : Operator (Name&sign):		Lindo
B	(Seat brackets) : Operator (Name&sign):		Lindo
	(C-rails, Luggage and earth bushes) : Operator (Name&sign):		Lindo & MASHUDU
C	(Seat brackets) : Operator (Name&sign):		Mmamsuelo Mooa
	(C-rails, Luggage and earth bushes) : Operator (Name&sign):		
D	(Seat brackets) Operator (Name&sign):		Mmamsuelo Mooa
	(C-rails, Luggage and earth bushes) : Operator (Name&sign):		Mmamsuelo Mooa

ENDS

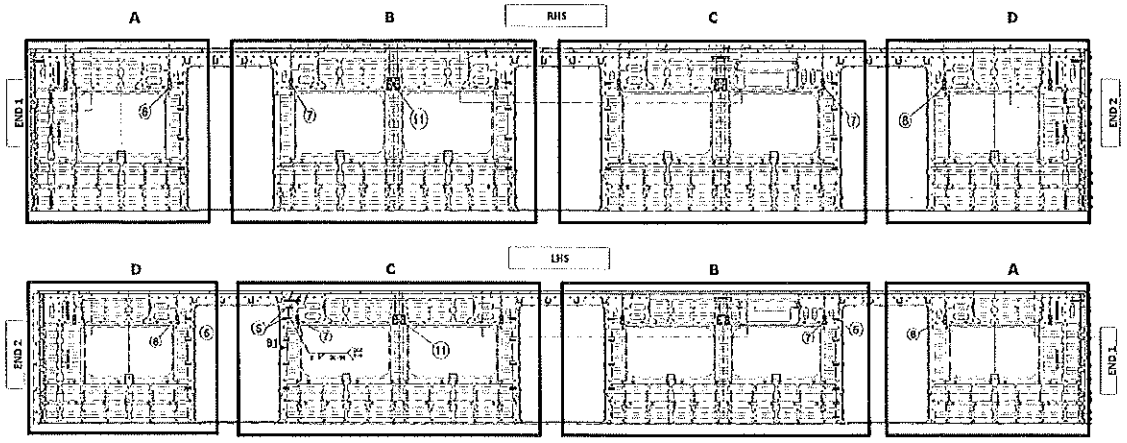
END 1 TAPPING PADS WELDING: Operator (Name&sign): Lindo

END 2 TAPPING PADS WELDING: Operator (Name&sign): S. Mkhize

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

II - Self Inspection - Items to Check

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

RHS

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

ROOF ENDS:

CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: _____

LHS

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

ROOF ENDS:

CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: _____

QUANTITIES (M1)

RHS

	SECTION	QUANTITY	OK	NOK
C-RAILS	A	7		
	B	8		
	C	8		
	D	8		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	2		
	B	4		
	C	5		
	D	3		

ROOF ENDS:

CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: _____

LHS

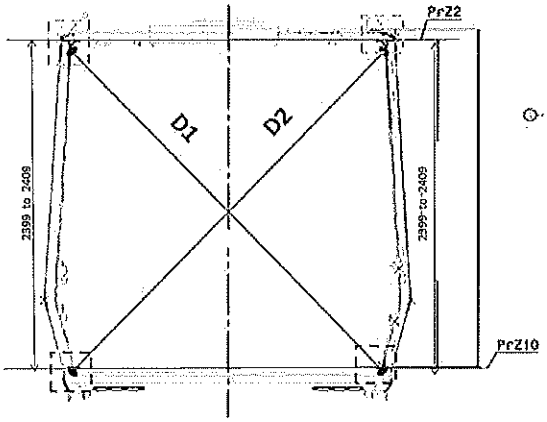
	SECTION	QUANTITY	OK	NOK
C-RAILS	A	2		
	B	10		
	C	11		
	D	6		
SEAT BRACKETS	A	13		
	B	21		
	C	21		
	D	13		
EARTH BUSH	A	3		
	B	7		
	C	6		
	D	2		

ROOF ENDS:

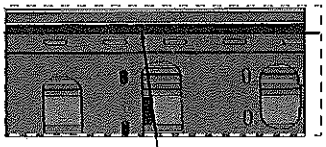
CRAILS 2 OFF EACH END
EARTH BUSH 6 OFF EACH END

VERIFICATION BY: _____

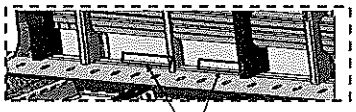
Specifications of Details for CBS measurement



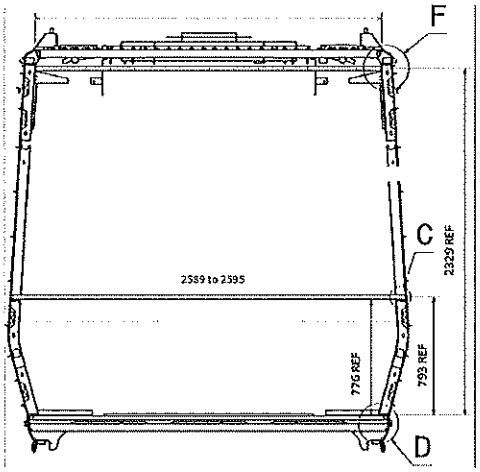
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.

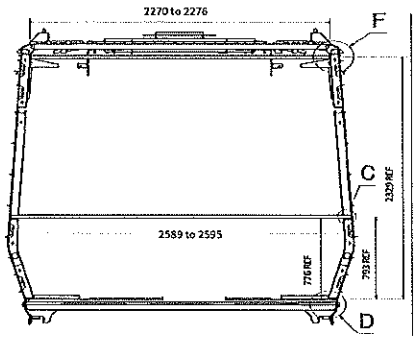


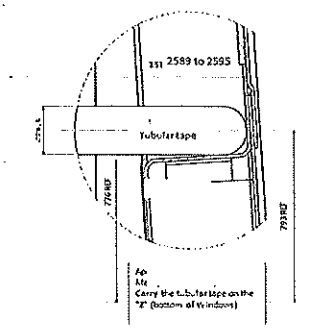
Measurement positions on sidewall and side sill corner.



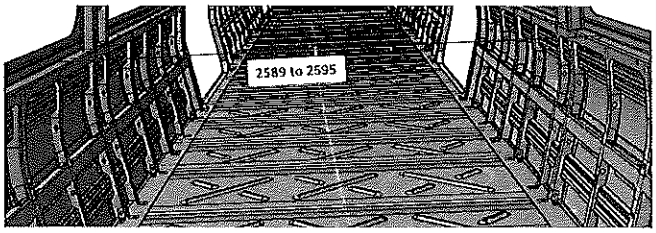
GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

CBS measurement

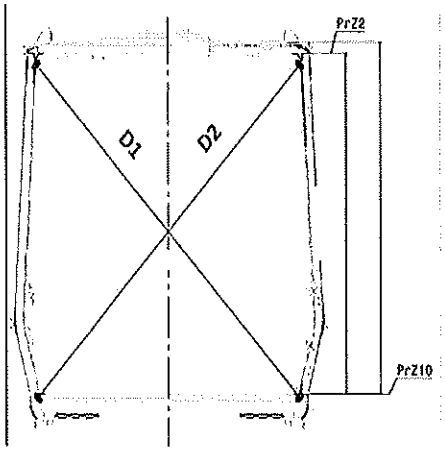


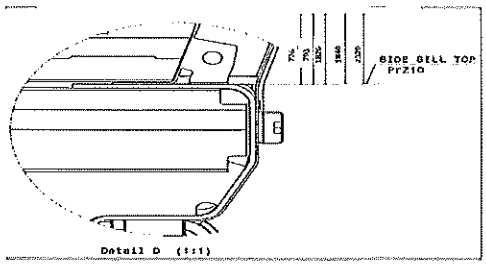


Detail C



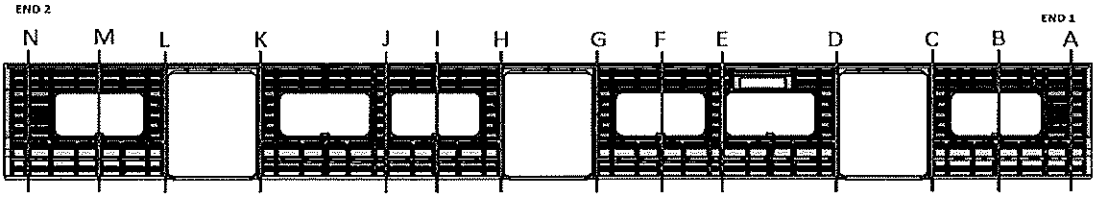
Take measurement close to radius





GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

CBS measurement

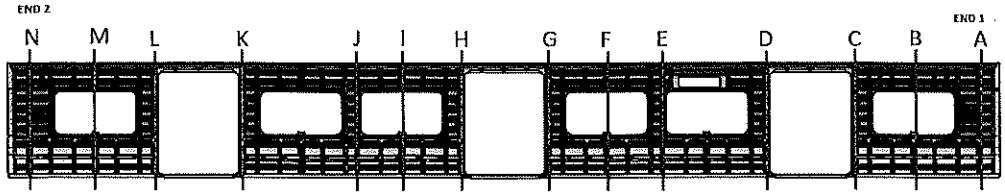


BEFORE WELDING

	.ecord D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3294	3296	2	
B	3263	3267	4	
C	3293	3295	2	
D	3298	3295	3	
E	3263	3262	1	
F	3263	3263	0	
G	3298	3298	0	
H	3299	3297	2	
I	3263	3262	1	
J	3263	3262	1	
K	3265	3265	0	
L	3295	3293	2	
M	3267	3267	1	
N	3294	3298	4	

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

CBS measurement

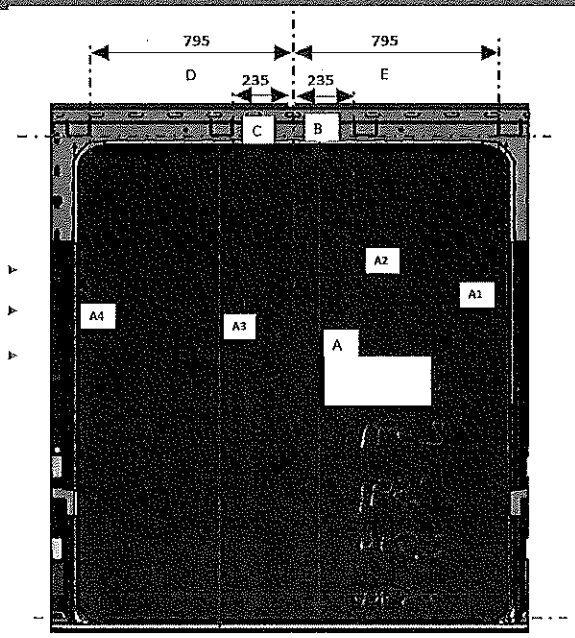


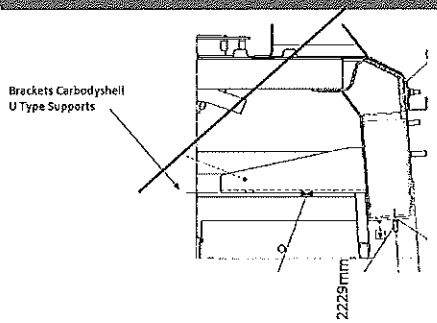
AFTER WELDING

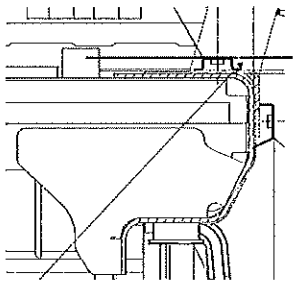
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3294	3295	1	2594
B	3267	3266	1	2591
C	3293	3294	1	2591
D	3297	3295	2	2594
E	3264	3263	1	2594
F	3263	3265	2	2593
G	3295	3295	0	2595
H	3296	3295	1	2595
I	3296	3297	1	2595
J	3265	3268	3	2595
K	3296	3294	2	2592
L	3294	3291	3	2590
M	3262	3264	2	2595
N	3295	3295	0	2595

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30226487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

Specifications of Details for CBS measurement CB1220







DOOR 1 - LHS

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

DOOR 2 - LHS

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

DOOR 2 - LHS

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

DOOR 1 - RHS

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

DOOR 2 - RHS

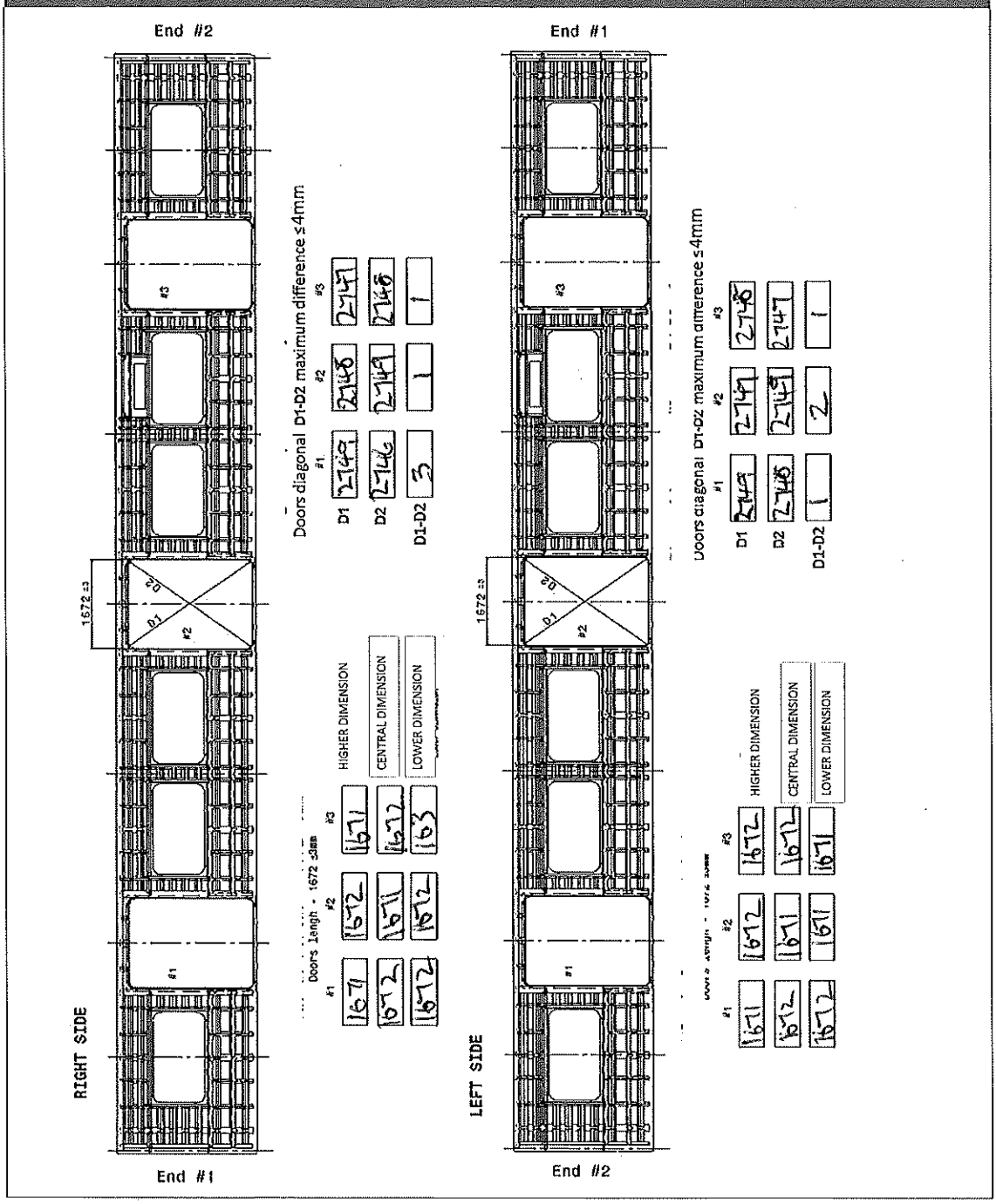
	VALUE	ACTUAL
A1	2230 to 2232	2231
A2	2230 to 2232	2231
A3	2230 to 2232	2230
A4	2230 to 2232	2230
B	234 to 236	235
C	234 to 236	235
D	794 to 796	795
E	794 to 796	795

DOOR 3 - RHS

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

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR302256487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

Specifications of Details for CBS measurement CB1220

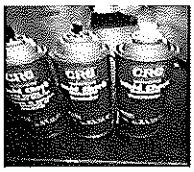


GIBELO	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225467/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

CBS measurement (Manufacturing)

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	CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2	Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29

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!	30/05/2024	Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party)	30/05/24	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

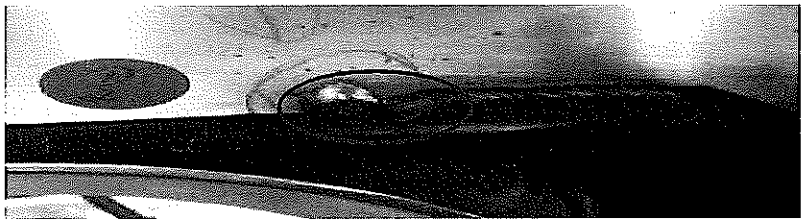
In case of "NO GO", the operations manager must define below action plan to ensure "GO":

Item	Description		Responsible	Due date	Status

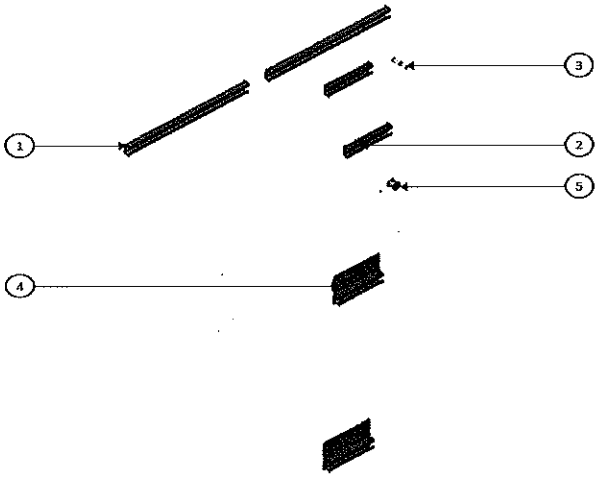
Operations

Quality

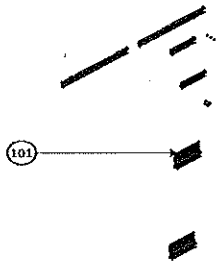
ANNEXURE A: Arc Welding Quality Acceptance Standard



Station: CB1220-004- U108 & U107



PART NO.	ITEM NO.	QTY	DESCRIPTION	MASS (KG)
DTR0200740SB	5	6	EARTH STUD 6	0.036
AA00001201843	4	6	ASSEMBLY SUPPORT	0.371
DTR0000343805	3	12	WELDING STUD ISO13918 PT – M6X20 - SST	0.007
AA00001150424	2	12	ASSEMBLY SUPPORT	0.193
AA00001184418	1	14	ASSEMBLY SUPPORT	0.522
AA00001161080	101	6	CARBODYSHELL BRACKETS CARBODYSHELL M1/M3/M4 CAR[SIDE FRAME MODULE LHD – OPP)	12.132



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	M4	M1	M3	M2	TC2	WORK INSTRUCTION	SAFETY?
☐	DTR3000152668	AAD0001278566	CARBODYSHELL M1,M3,M4 ASSEMBLY	CB2230			X				PRA.CB2230.DT000002 25487.V20	YES
☐	DTR3000152673	AAD0001278566	CARBODYSHELL M1,M3,M4 ASSEMBLY	CB2230		X			(X)		PRA.CB2230.DT000002 25487.V20	YES
☐												

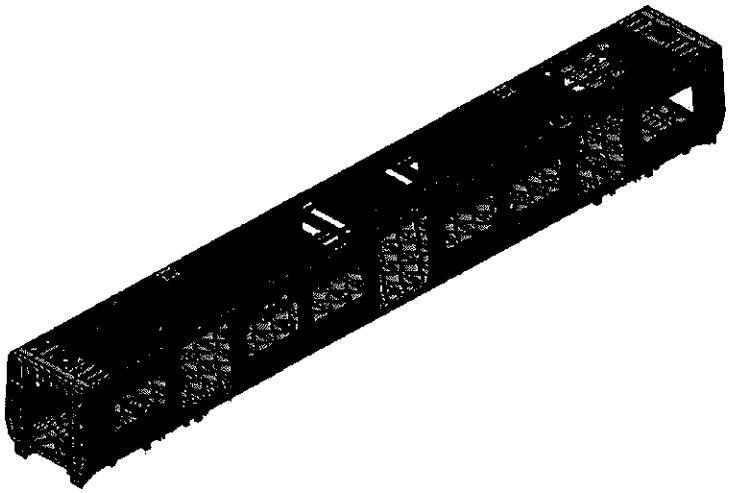
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	2018/08/02	GIBELA NEW CREATION	APPROVER	Philipe Marques	2018/08/02
			CHECKER	Nosizo Pindela	2018/08/02
			COMPILER	Nosizo Pindela	2018/08/02
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	30/5/2018
			CHECKER	Nosizo Pindela	30/5/2018
			REVISED BY	Nosizo Pindela	30/5/2018
2	2018/05/07	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	2018/05/07
			CHECKER	Nosizo Pindela	2018/05/07
			REVISED BY	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
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	23/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	23/08/2019
			CHECKER	Nosizo Pindela	23/08/2019
			REVISED BY	Nosizo Pindela	23/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	20/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbhombhi	14/06/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
27	26/07/2022	Threashold measurements addition	APPROVER	Collins Mbhombhi	26/07/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
28	17/10/2022	Added traceability of sealant application	APPROVER	Collins Mbhombhi	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 threashold traceability 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
230	M3	Emmanuel 4104478	31.05.24	SI.CB2230.256.V29	12

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000226487	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29

Car:	NCR:	Work station: CB2230

Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car M1	M2	M3	M4	TCR	Revision	Observation	OK		Signature/Date (Operations)	Signature/Date (Quality)
PRA.CB2230.DT00000226487			X			30	OK	✓	N/A	31.05.24	31/05/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK		Signature/Date (Operations)	Signature/Date (Quality)
Multimeter	3283-7	15.03.25	✓		31/05/24	
Measuring tape	C180774	25.04.24	✓			
Combustion Sensor	CABC0072	07.07.24	✓		31.05.24	31/05/24

1.3 Consumables

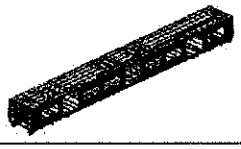
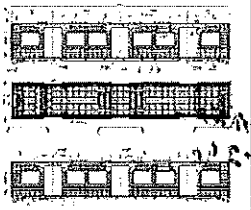
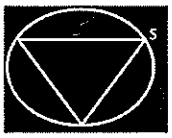
Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
308 LSi	373779	Mig	X		31.05.24	31/05/24

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29

II - Self Inspection - Items to Check

II.1 - Items to check

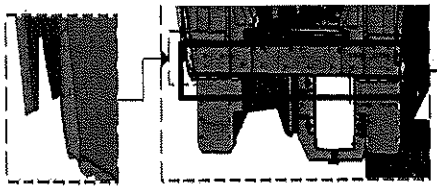
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK			Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering nº PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	X			31.05.24	31/05/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	X			31.05.24	31/05/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	**IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000**	X			31.05.24	31/05/24
04		Cleaning of all Stainless Steel Surface	**According TO GIB-WEL - PROC-0002**	X			31.05.24	31/05/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	X			31.05.24	31/05/24
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.	X			31.05.24	31/05/24
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: R09349 Exp Date: ___ / 06 / 24 Actuals Temparature: 14°C Humidity: 59%	X			31.05.24	31/05/24
08	N/A	Verification of sealant application on the roof and sidewall finishers.	Sealant must be: -Applied straight and even -Free of gaps,cracks,damage and debris (flashes, dirt, dust) **Refer to Annexure B**	X			31.05.24	31/05/24
09	N/A	Verification of sealant application in certain regions in the drawing.	AAD0001278566	X			31.05.24	31/05/24

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225467	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29

II - Self Inspection - Items to Check

END 2 SEALANT

AREA 1

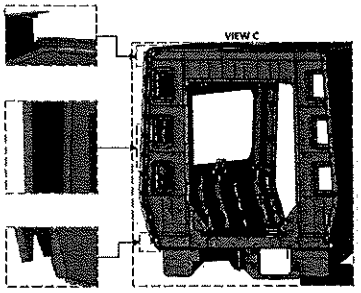


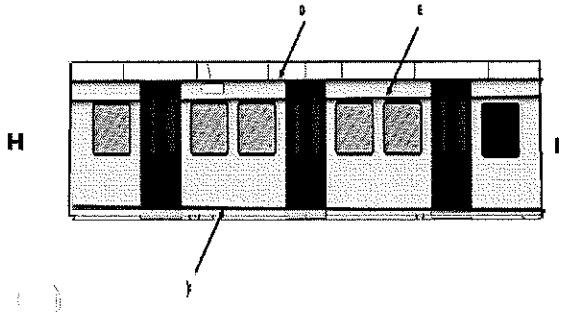
OPERATOR (Name & sign): Leroy

OPERATOR (Name & sign): Leroy

OPERATOR (Name & sign): Leroy

AREA 2 (VIEW C)



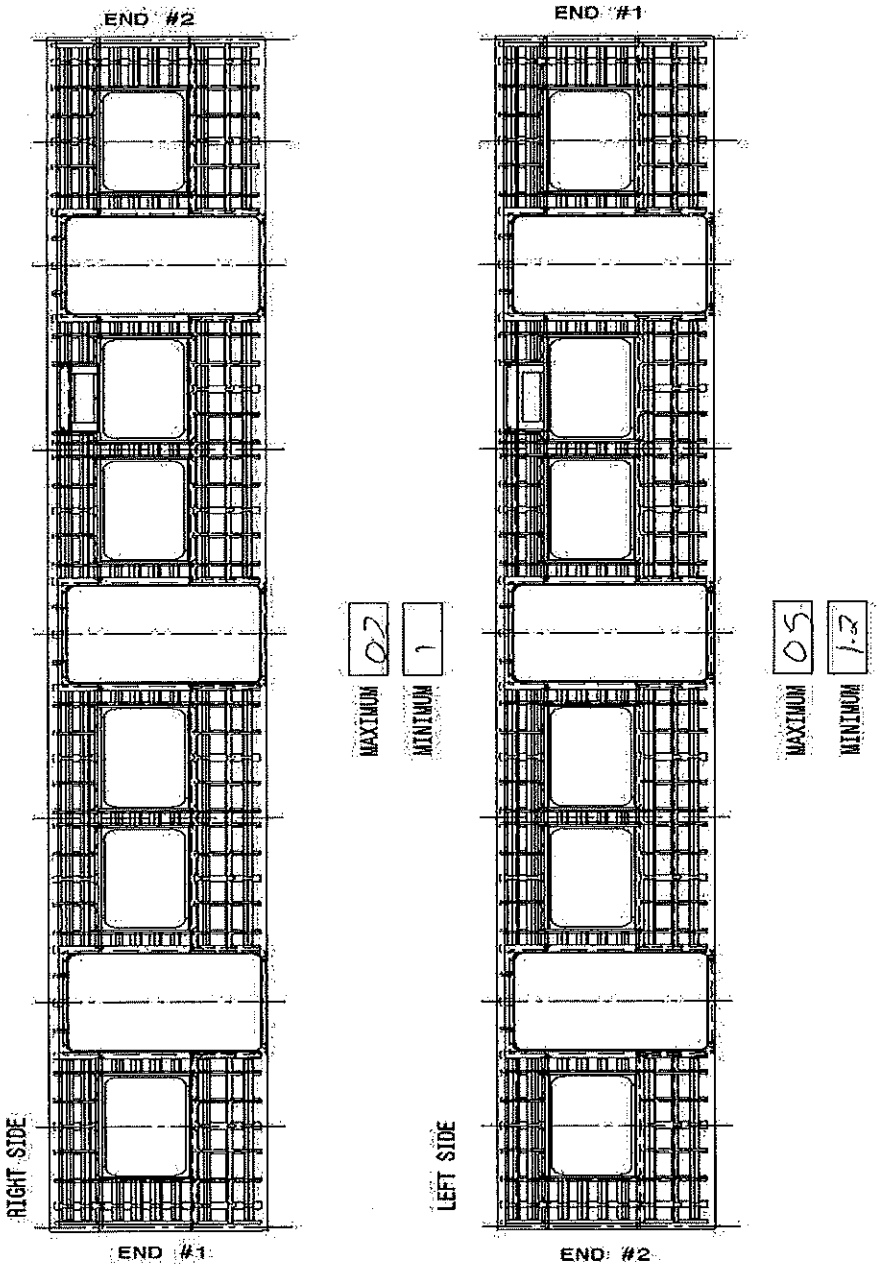


Area D,E,F,G,H,I	LHS	RHS
Operator (Name & sign) :	D,E,F,G,H,I top	D,E,F,G,H,I
Operator (Name & sign) :	Sihle	Leroy
Operator (Name & sign) :		Bunie
Operator (Name & sign) :	Tshembo	Bonky
Operator (Name & sign) :		
Operator (Name & sign) :	F Leroy H,I BOTTOM Bonky Bunie	

GIBELO	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000226487	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230

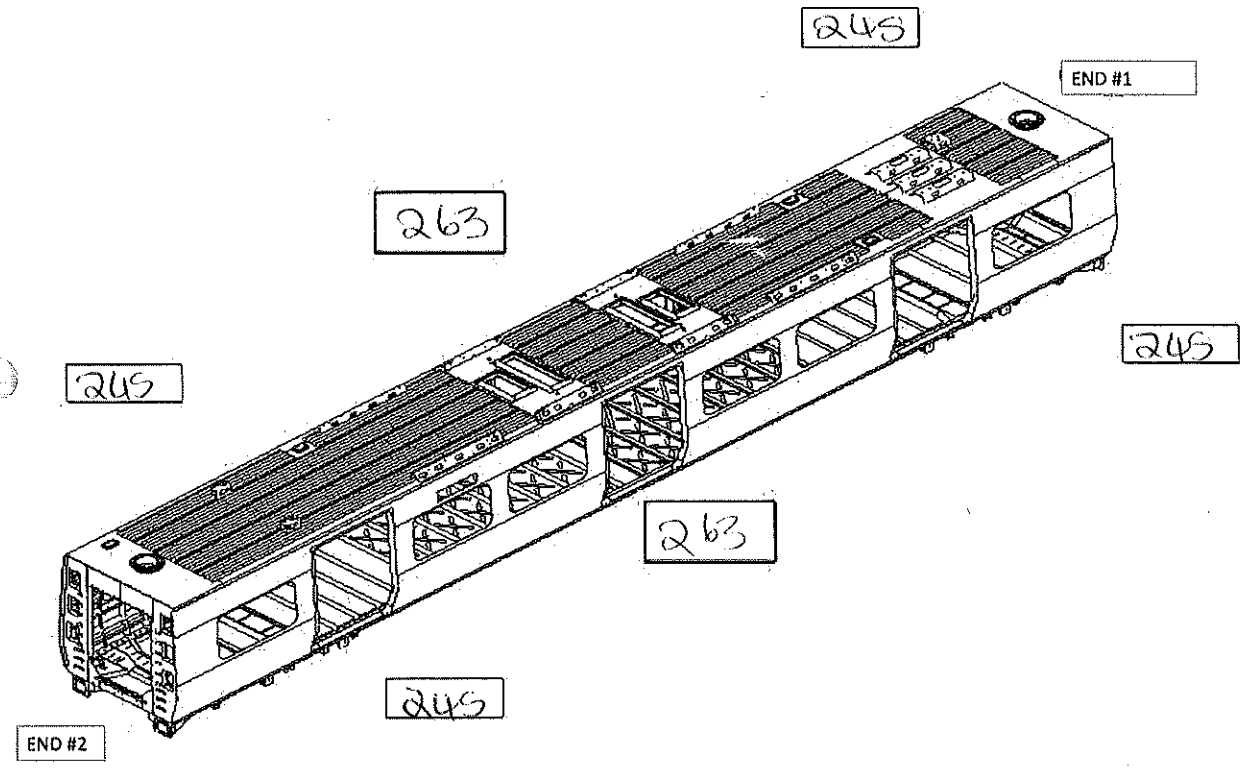
Flatness side left and right maximum of 2mm in the valley to peak measured in 900mm. Recod the maximum and minimum value foundand indicate the corresponding region.



GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000226487	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230

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

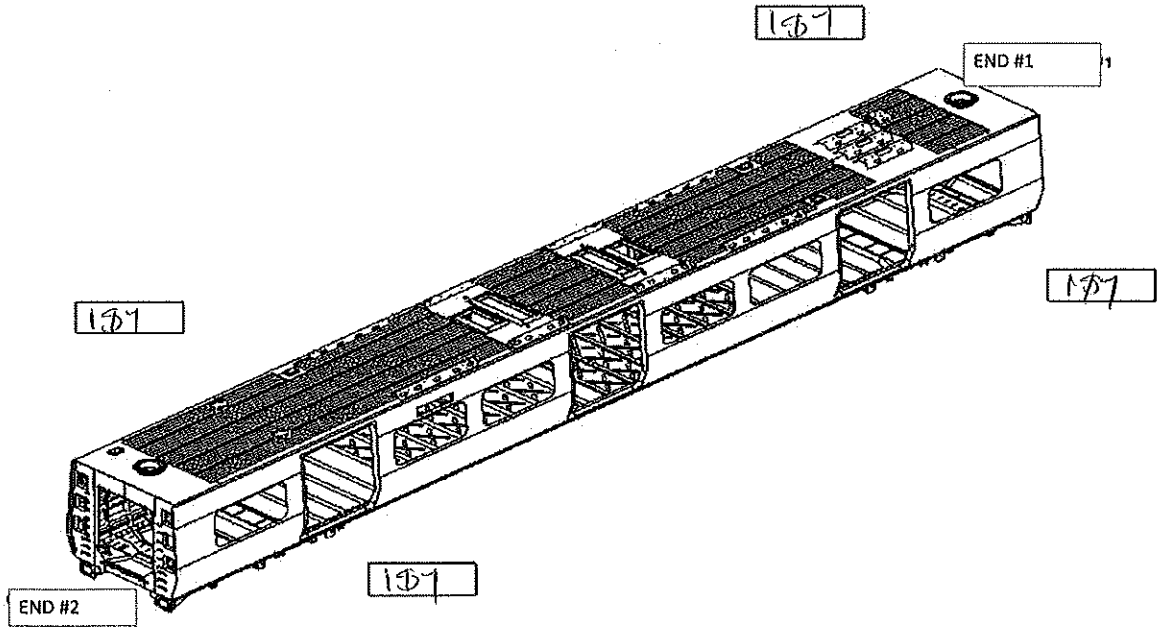


MEASURED CAMBER VALUES	
RIGHT	19
LEFT	19

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29

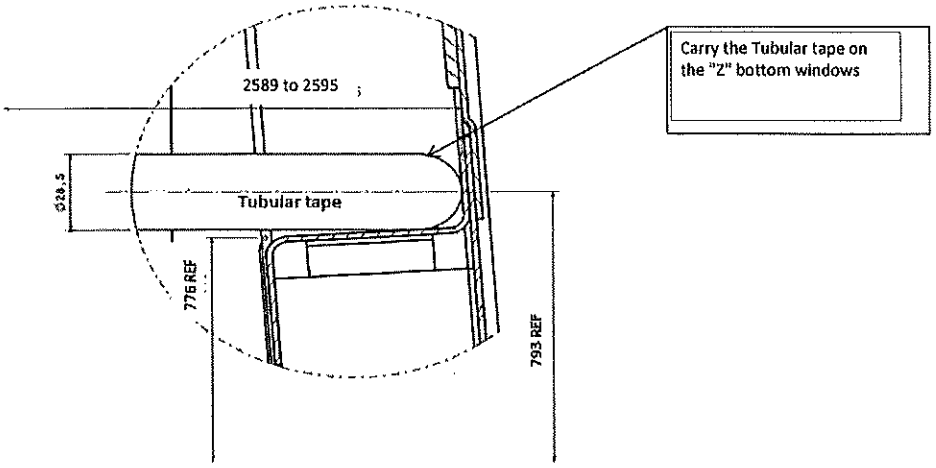
Specifications of Details for CBS measurement CB1230

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

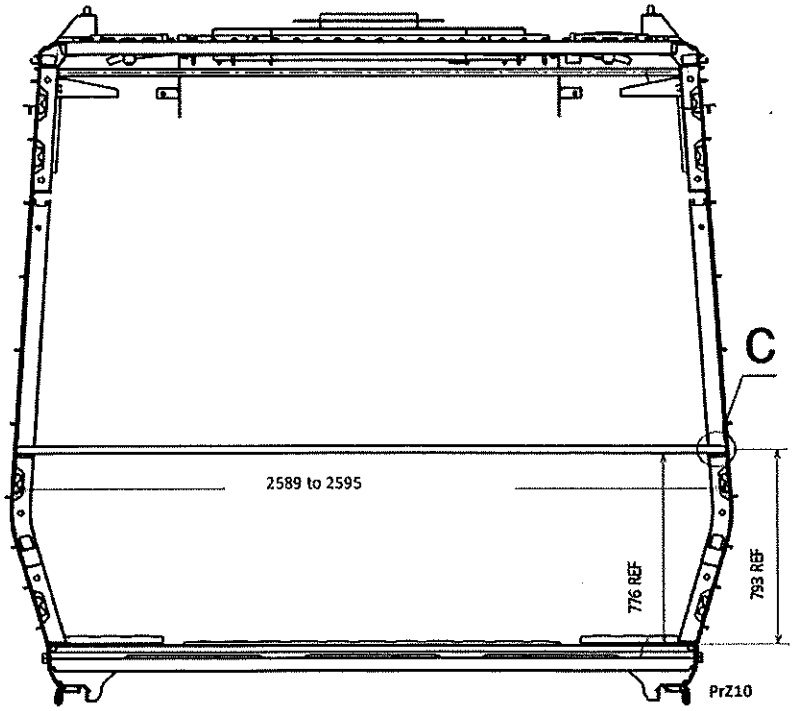


TWIST FOUND ON END 1	
TRANVERSE	0
LONGITUDINAL	0

TWIST FOUND ON END 2	
TRANVERSE	0
LONGITUDINAL	0

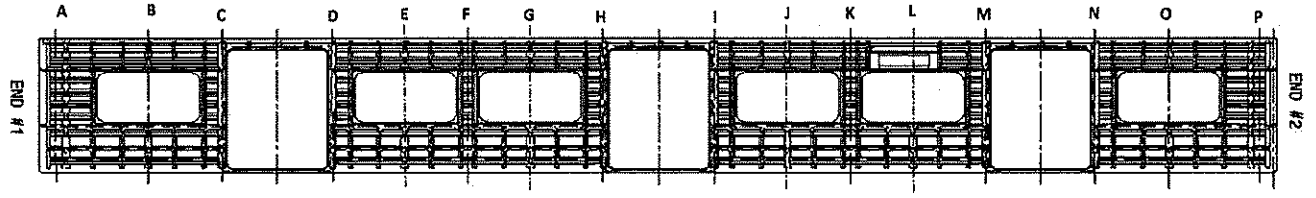

2589 to 2595
Carry the Tubular tape on the "Z" bottom windows
Ø28.5
Tubular tape
776 REF
793 REF

Detail C


C
2589 to 2595
776 REF
793 REF
PrZ10

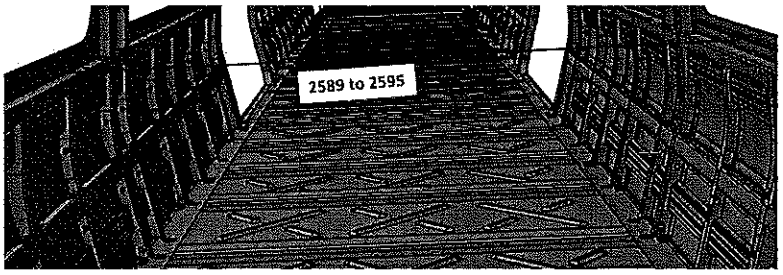
GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230



2589 to 2595mm

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



Threashold verification

Nominal value :38

Door 1		Door 2		Door 3	
L	R	L	R	L	R
39	37	39	38	39	38
Door 4		**Door 5**		**Door 6**	
L	R	L	R	L	R
38	38	38	38	39	39

BOILER MAKER: ASANDA

WELDER: Lindo

Dye penetrant test

Dye-penetration test to be performed by quality personnel

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.V29

Specifications of Details for CBS measurement

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			Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX					

GIBELA	CARBODYSHELL M1,M3,M4 ASSEMBLY DT00000225487	Rev. 30 Date 06/11/2023	Project: PRASA SI.CB2230.256.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 f activities are not complete, the missing activities must not impact the next stage!	31-05-24	Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	31/05/24	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

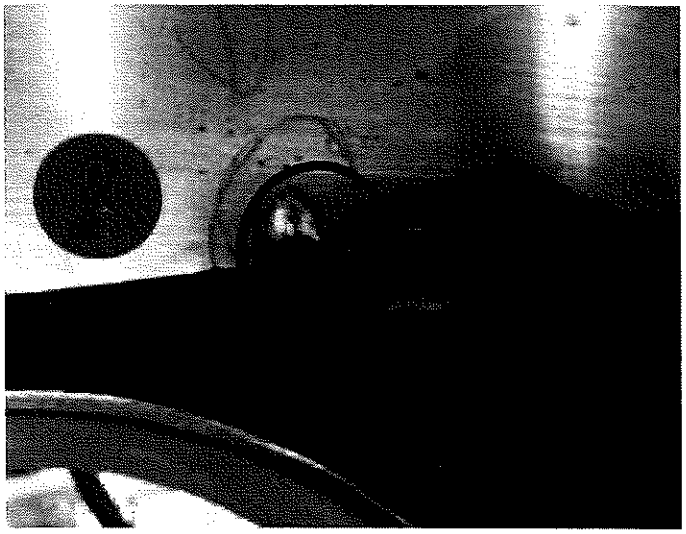
In case of "NO GO", the operations manager must define below action plan to ensure "GO":

Item	Description		Responsible	Due date	Status

Operations

Quality

ANNEXURE A: Arc Welding Quality Acceptance Standard



ANNEXURE B: Sealant