GIBELA

PRASA PROJECT

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

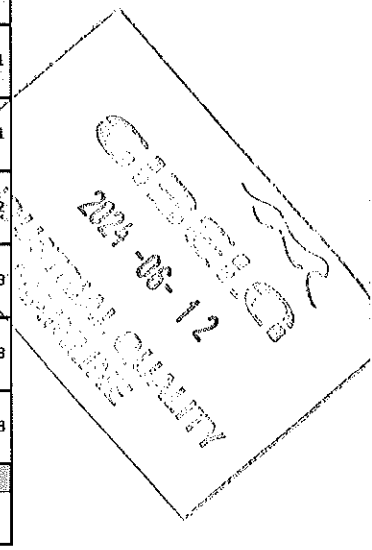
CONFIDENTIAL INFORMATION
This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE TC1	M1	M2	M3	TC2	WORK INSTRUCTION	SAFETY?
☐ DTR30223319/3	AAD0001241033	Carshell Assembly TC	CB1210	X				X	PRA.CB1210.DTR3022331 9/3.V25	YES
☐										

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	09/04/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	09/04/2018
			CHECKER	Nosizo Pindela	09/04/2018
			COMPILER	Thanyani Mathegu	06/04/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motama	2018/05/18
2	2018/06/18	MODIFICATION CONTENT	APPROVER	Itumeleng Modiba	2018/06/18
			CHECKER	Nosizo Pindela	2018/06/18
			REVISED BY	Ramokone Motama	2018/05/18
3	2018/12/12	Additional checkpoints	APPROVER	Itumeleng Modiba	2018/12/12
			CHECKER	Nosizo Pindela	2018/12/12
			REVISED BY	Ramokone Motama	2018/12/12
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	22/01/2019
			CHECKER	Nosizo Pindela	22/01/2019
			REVISED BY	Vanessa Ntuli	22/01/2019
6	2019/11/03	Record D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	2019/11/03
			CHECKER	Nosizo Pindela	2019/11/03
			REVISED BY	Nosizo Pindela	2019/11/03
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	21/08/2019
			CHECKER	Nosizo Pindela	21/08/2019
			REVISED BY	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
20	19/04/2020	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi Collins	17/08/2021
			CHECKER	Mpho Mulaudzi	
			REVISED BY	Mpho Mulaudzi	
25	21/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombhi Collins	21/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlampe Amogelang	
			REVISED BY	Mohlampe Amogelang	
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	27/07/2023
			CHECKER	Mathapo Kelebone	
			REVISED BY	Mohlampe Amogelang	
28	07/11/2023	Addition of welding traceability	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Andani Muthelo	
			REVISED BY	Ntokozo Zwane	

TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
232	TC1	Tshepo Sithole	10/06/24	SI.CB1210.322.V28	16



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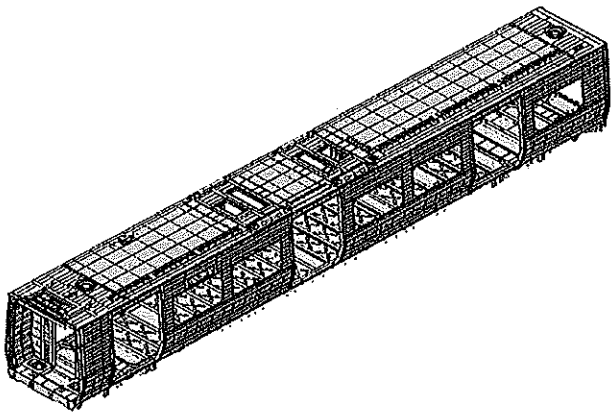
Car: TC1 & TC2	NCR:	Work station: CB1210

Safety Related



I - Documentation and Instruments

I.1 - Documentation Control

Document	Type of car TC	MC1	MC2	TC2	M1	TC1	Revision	Obsevation	OK	NOK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)
DTR30223319/3	X										N/A		

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Validation	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Tubular	32923-2	18/03/28	✓			
Boom tape	CIBTP0102	18/11/24	✓			
Laser tape	1284-289-24	08/01/25	✓			

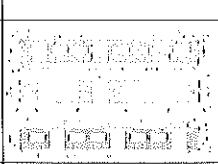
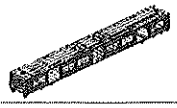
1.3 Consumables

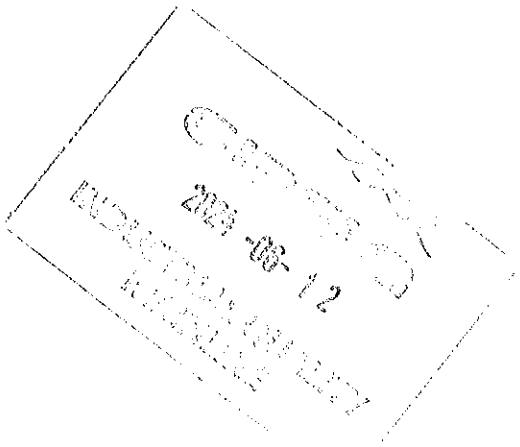
Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER308 LSI	314018-740917	Mig	✓			
ER 308L	794687-703122	TIG	✓			

GIBELA
2024 -06- 12
INDUSTRIAL QUALITY
MAKUNG

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

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	N/A	Remarks	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls,Endframes,Roof and Underframe)	DT00000284980	✓			10/06/24	
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓				
03		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			10/06/24	
04	REFER TO ANNEXURE A	Spot Welding inspected and approved according procedure	**IND-SAL-WMS-016 e DTD0000210675**	✓				
05	REFER TO ANNEXURE B	Arc Welding inspected and approved according procedure.	**IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000**	✓			10/06/24	
06		Cleaning of all Stainless Steel Surface	**According TO GIB-WEL - PROC-0002**	✓			10/06/24	
07	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658	✓			10/06/24	



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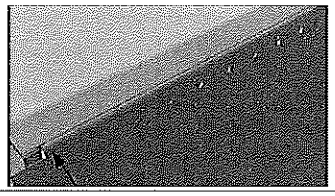
Welder traceability

Roof ring welds



END 1

LHS

Boiler maker (Name & Sign): LUNGA Welder (Name & Sign): Thabang

RHS

Boiler maker (Name & Sign): Welder (Name & Sign): Thabang

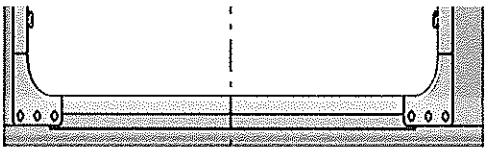
END 2

LHS

Boiler maker (Name & Sign): LUNGA Welder (Name & Sign): Thabang

RHS

Boiler maker (Name & Sign): Welder (Name & Sign):



LHS

Boiler maker (Name & Sign): LUNGA

Welder (Name & Sign): Mthokozisi

RHS

Boiler maker (Name & Sign): LUNGA

Welder (Name & Sign): Mthokozisi

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INDUSTRIAL QUALITY
DEPARTMENT

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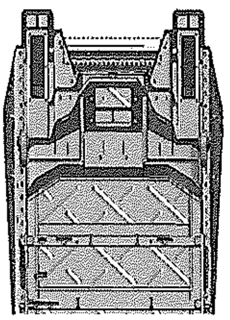
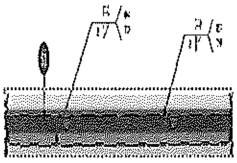
EUF Reinforcement Plates

END 2



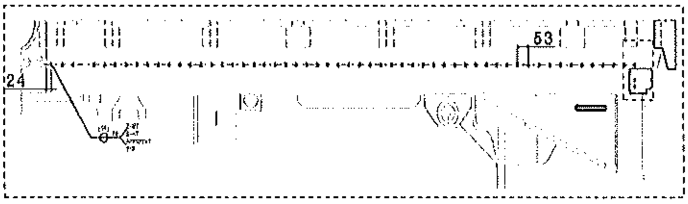
Underneath the CAR



END 2

Boiler maker (Name & Sign): Lawrence [signature]

Welder (Name & Sign): Siphokazi [signature]



FEDOLI

Operator: Lwanga [signature]

GIBELA
2024-06-12
INDUSTRIAL QUALITY

GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
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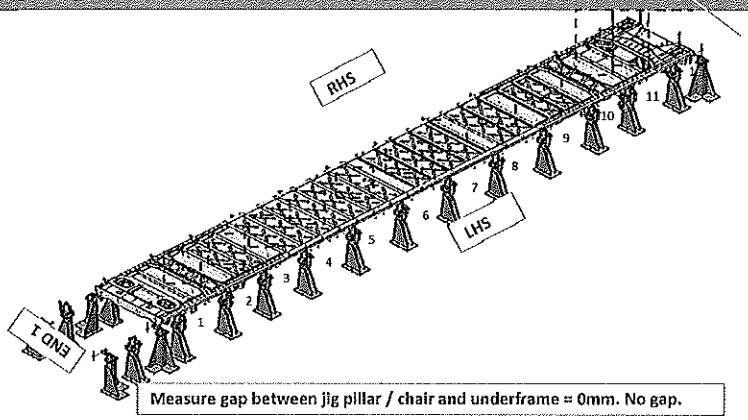
Specifications of Details for CBS measurement



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

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

After Loading Underframe and Clamping.

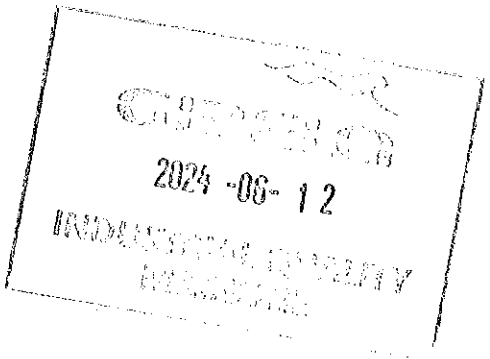
	1	2	3	4	5	6	7	8	9	10	11	12
Left Hand Side					N/A							
Right Hand Side												

Signature Operations: Date: 10/06/24

After Welding.

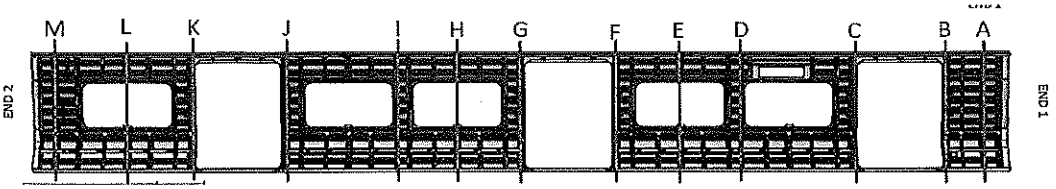
	1	2	3	4	5	6	7	8	9	10	11	12
Left Hand Side					N/A							
Right Hand Side												

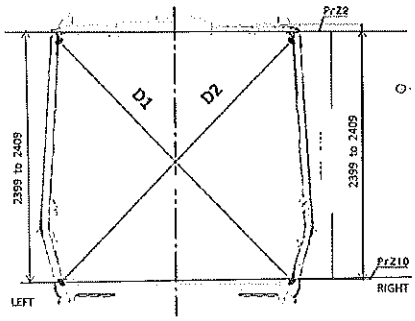
Signature Industrial Quality: Date: 10/06/24

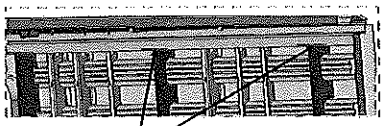


GIBELA	DTR30223319/3 Carshell Assembly TC	Rev, V28 Date- 07/11/2023	Project: PRASA SI.CB1210.322.V28

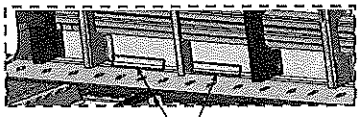
Specifications of Details for CBS measurement



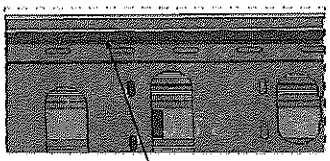




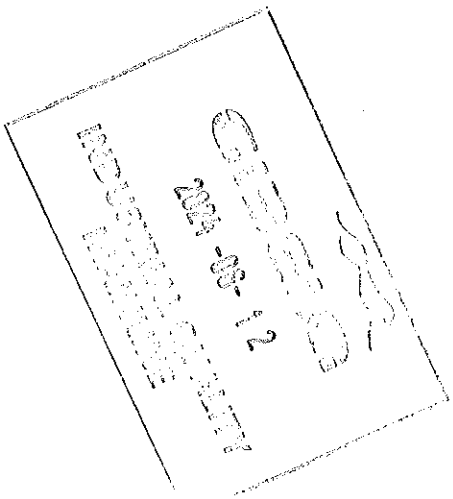
Measurement positions on roof rail and sidewall omega corner.



Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.



GIBELA	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
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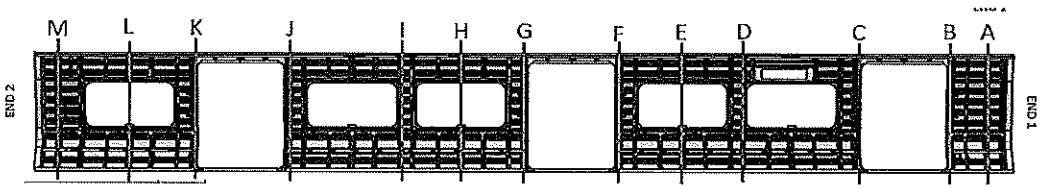
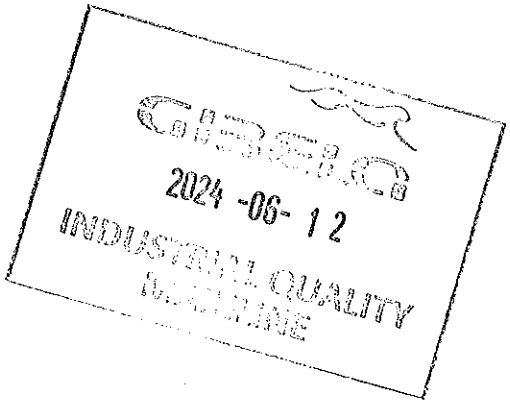
Specifications of Details for CBS measurement

BEFORE WELDING



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

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3266	3265	1	2405	2405	0
B	3264	3266	2	2406	2405	1
C	3266	3265	1	2406	2405	1
D	3264	3265	1	2406	2404	2
E	3267	3266	1	2403	2405	2
F	3266	3266	0	2406	2405	1
G	3268	3266	2	2406	2406	0
H	3268	3266	1	2407	2406	1
I	3266	3267	1	2405	2406	2
J	3265	3267	2	2403	2404	1
K	3264	3267	3	2404	2404	0
L	3264	3265	1	2404	2406	2
M	3268	3268		2406	2408	2



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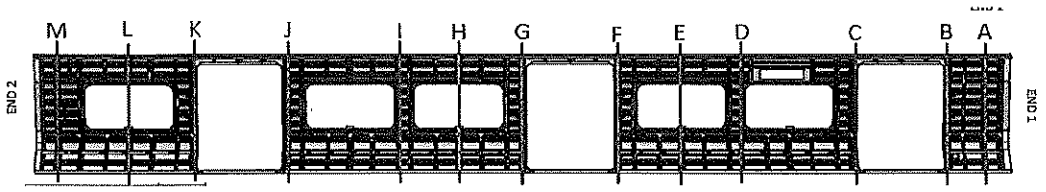
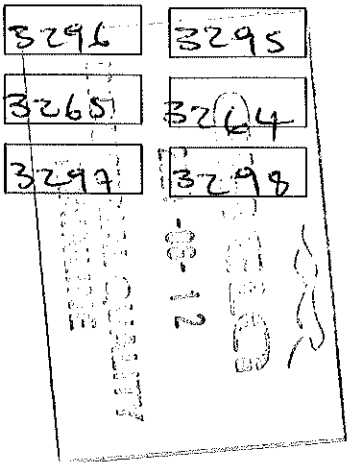
Specifications of Details for CBS measurement

AFTER WELDING



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

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3266	3267	1	2404	2405	1
B	3295	3296	1	2406	2405	1
C	3294	3294	0	2405	2405	0
D	3265	3265	0	2403	2404	1
E	3264	3265	1	2404	2404	0
F	3293	3295	2	2405	2404	1
G	3295	3294	1	2403	2405	2
H	3265	3267	2	2405	2404	1
I	3266	3266	0	2406	2404	2
J	3294	3296	2	2405	2404	1
K	3296	3295	1	2404	2403	1
L	3265	3264	1	2406	2405	1
M	3297	3298	1	2407	2406	1



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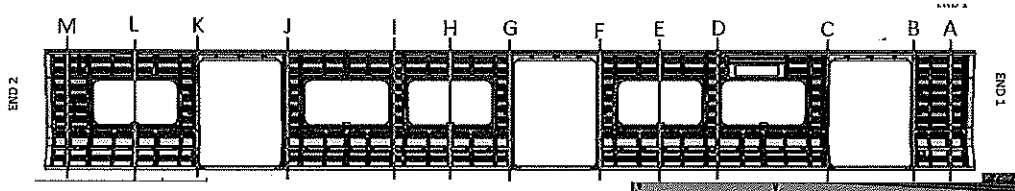
GBS measurement

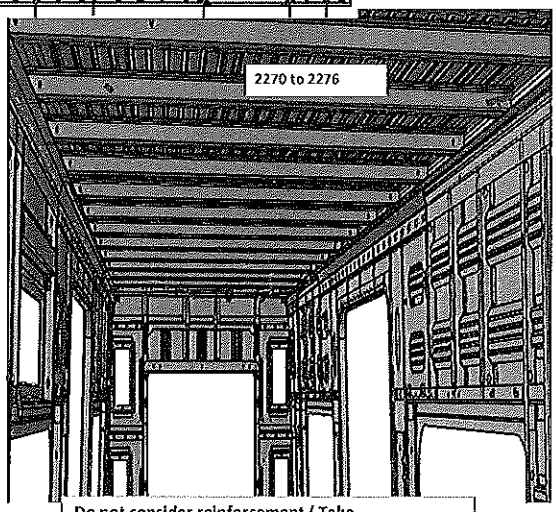
BEFORE WELDING



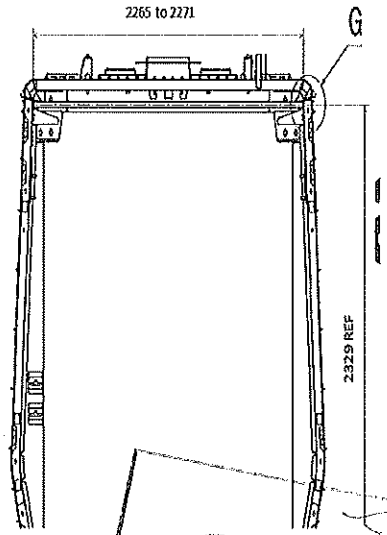
2270 to 2276

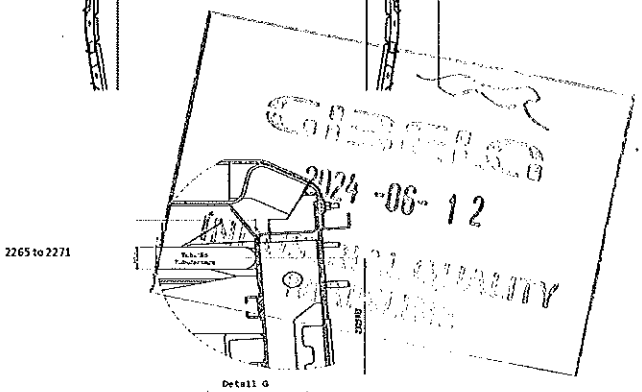
2268 a 2274

A	2270
B	2274
C	2273
D	2276
E	2275
F	2271
G	2269
H	2274
I	2276
J	2271
K	2268
L	2275
M	2272



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





2265 to 2271

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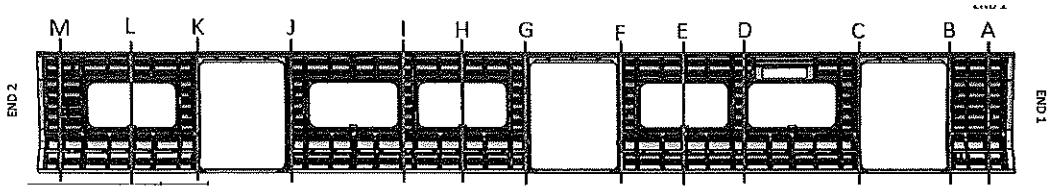
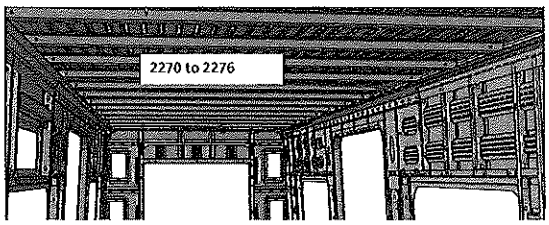
Specifications of Details for CBS measurement

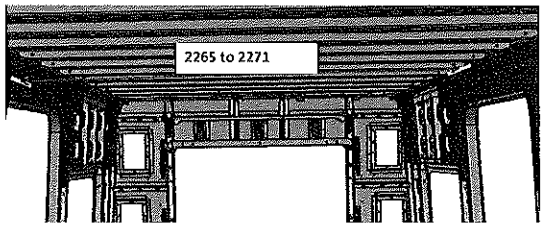
AFTER WELDING



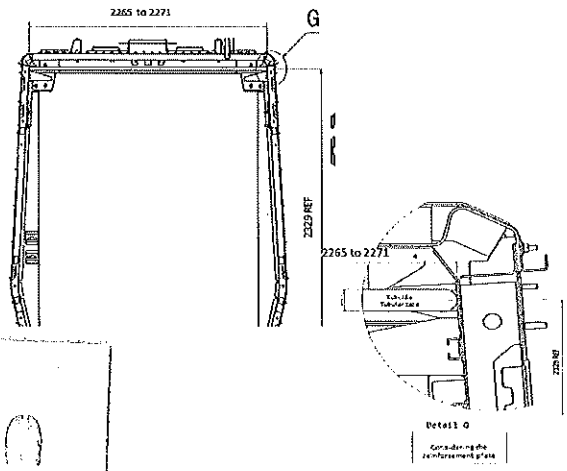
	2265 to 2271	2270 to 2276
A	N/A	2276
B	2266	N/A
C	2269	N/A
D	N/A	2274
E	N/A	2276
F	2268	N/A
G	2270	N/A
H	N/A	2273
I	N/A	2275
J	2271	N/A
K	2269	~~N/A~~ 2275
L	N/A	2273
M	2267	N/A

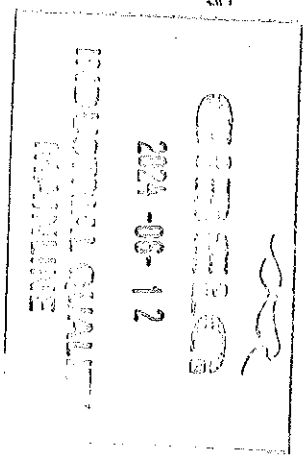


Do not consider reinforcement (Take measurements top area of zee profile



Take measurement close to radius (considering reinforcement)





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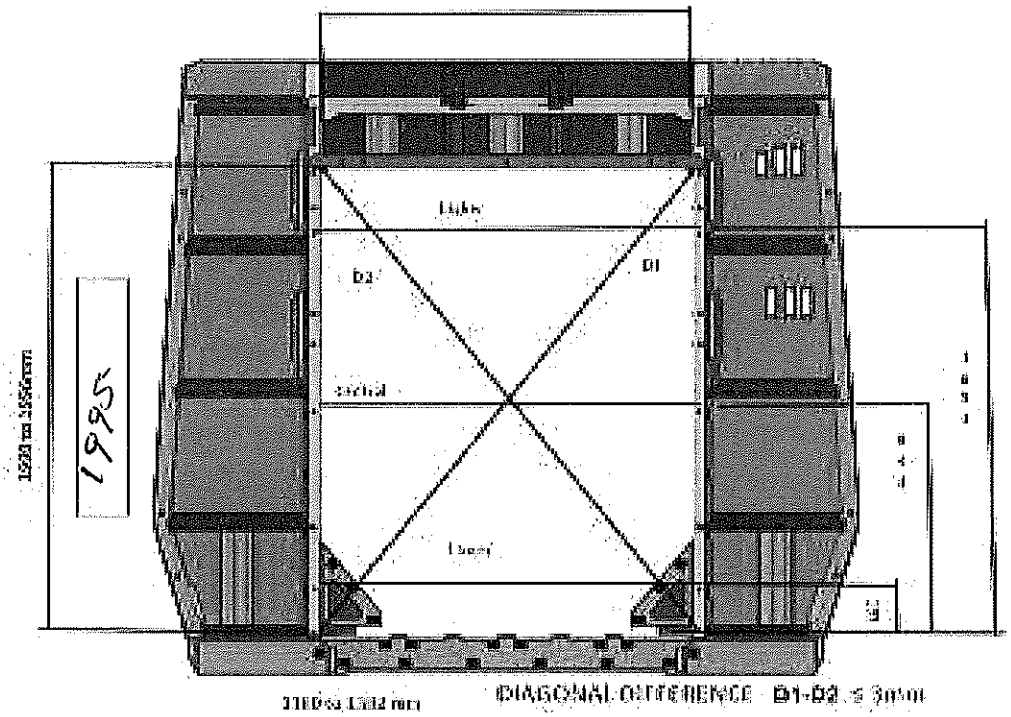
Specifications of Details for CBS measurement

Endframe 2



DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Diameter	1381
Central Diameter	1381
Lower Diameter	1381

D1	2414
D2	2414
D1-D2	0

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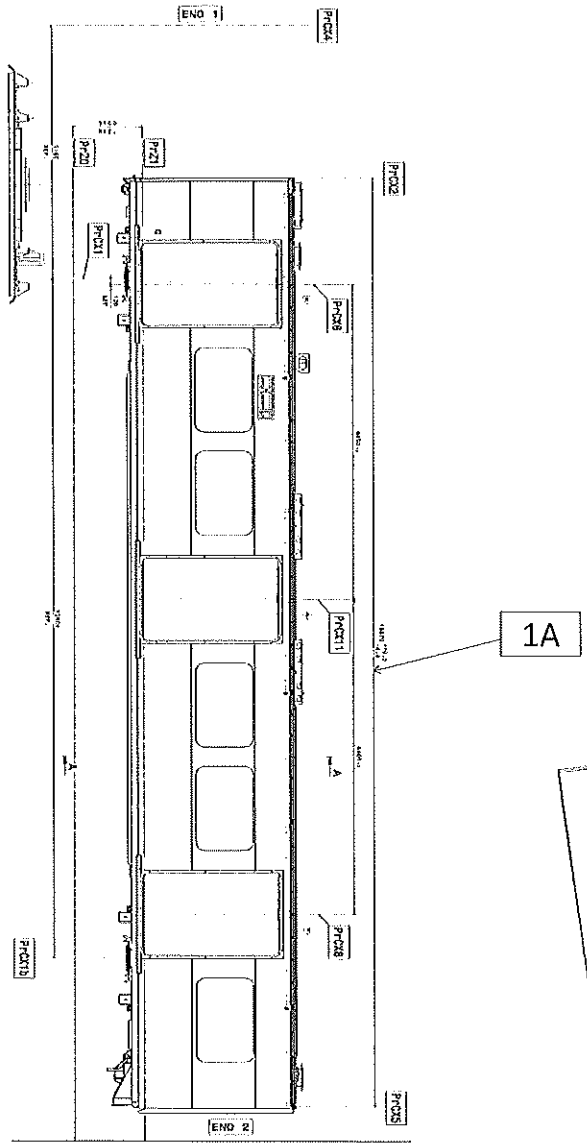
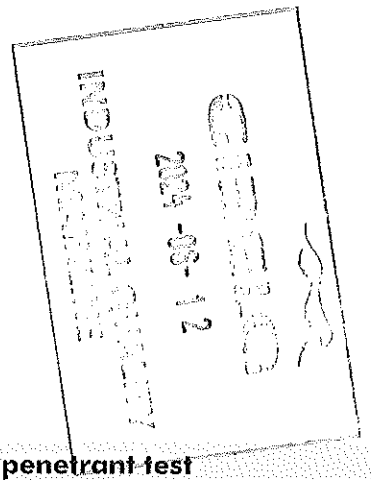
		Date- 07/11/2023	SI.CB1210.322.V28

Specifications of Details for CBS measurement



	LEFT SIDE	
	SPECIFICATION SIZE	ACTUAL SIZE
1A	18870 +10.5 -4.5	18868

	RIGHT SIDE	
	SPECIFICATION SIZE	ACTUAL SIZE
1A	18870 +10.5 -4.5	18867



Dye penetrant test

Dye-penetration test to be performed by quality personnel

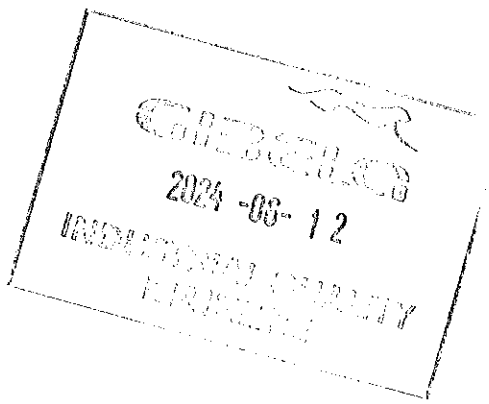
GIBELO	DTR30223319/3 Carshell Assembly TC	Rev. V28	Project: PRASA
		Date- 07/11/2023	SI.CB1210.322.V28

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



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

Self Inspection - Final Result

			Is 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!	10/06/24	Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	10/06/24	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)		Quality	

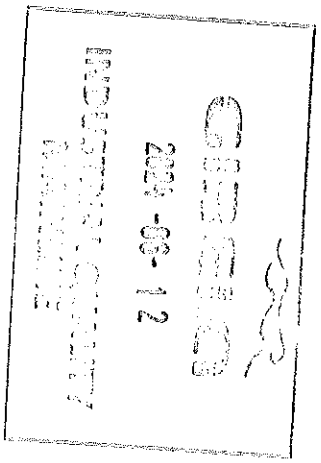
In case of "NO GO", describe blocking problems

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

Item	Description	Action	Responsible	Due date	Status

Operations

Quality



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	M1	M2	M1	TC2		
DT00000223319	AAD0001238963	DT00000223319 Carshell Assembly TC	CB2230	X					X	PRA.CB2230.DT0000012 23319.V20	YES

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	06/04/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	09/04/2018
			CHECKER	Nosizo Pindela	09/04/2018
			COMPILER	Thanyani Mathegu	06/04/2018
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	05/07/2018	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	05/07/2018
			CHECKER	Nosizo Pindela	05/07/2018
			COMPILER	Ramokone Motama	05/07/2018
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			REVISED BY	Vanessa 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
			COMPILER	Nosizo Pindela	13/03/2019
7	17/09/2019	Added Cab Fire Barrier Flatness Measurements	APPROVER	Itumeleng Modiba	17/09/2019
			CHECKER	Nosizo Pindela	17/09/2019
			COMPILER	Nosizo Pindela	17/09/2019
10	20/09/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	20/09/2019
			CHECKER	Nosizo Pindela	20/09/2019
			COMPILER	Nosizo Pindela	20/09/2019
15	28/01/2021	New Baseline 10.2.6	APPROVER	Timothy Maimela	28/01/2021
			CHECKER	Bongane Masina	28/01/2021
			COMPILER	Bongane Masina	28/01/2021
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			COMPILER	Bongane Masina	19/04/2021
25	20/04/2022	New Baseline change 10.3.1	APPROVER	Collins Mbhombhi	20/02/2022
			CHECKER	Andani Muthelo	20/02/2022
			COMPILER	Andani Muthelo	20/02/2022
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbhombhi	14/06/2022
			CHECKER	Andani Muthelo	
			COMPILER	Andani Muthelo	
27	27/07/2022	Threashold measurements addition	APPROVER	Collins Mbhombhi	26/07/2022
			CHECKER	Andani Muthelo	
			COMPILER	Andani Muthelo	
28	19/10/2022	Addition of traceability for sealant application	APPROVER	Collins Mbhombhi	19/10/2022
			CHECKER	Ntokozo Zwane	
			COMPILER	Amogelang Mohlampe	
29	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozo Zwane	
			COMPILER	Amogelang Mohlampe	
30	06/11/2023	Added threashold traceability for boiler makers and welders	APPROVER	Tyson Ngobeni	06/11/2023
			CHECKER	Andani Muthelo	
			COMPILER	Ntokozo Zwane	

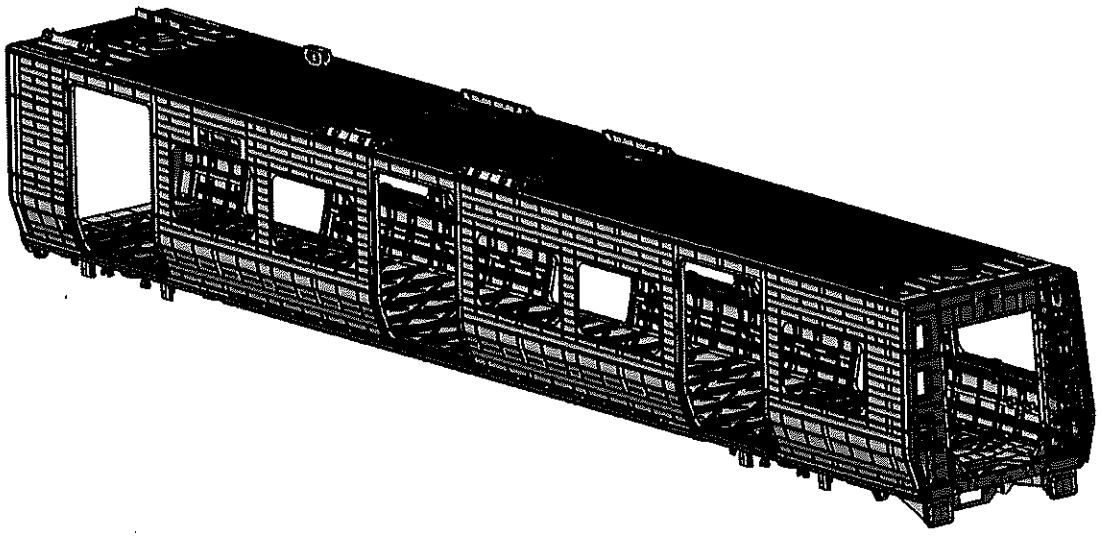
TRAINSET	CAR	OPERATOR NAME & ALPS NUMBER	DATE	SELF INSPECTION NUMBER	PAGES
232	TC1	Mthokozisi / 426964	12/06/24	SI.CB2230.324.V29	12

CB2230
2024 -06- 12
INDUSTRIAL QUALITY
MANAGEMENT

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

Carro Car: TC1	NCR:	Work station: CB2230

Safety Related



I - Documentation and Instruments

I.1 - Documentation Control

Document	Type of car TC1	M1	M2	M3	M4	TC2	Revision	Obsevation	OK	NOK	Rework	Signature/Date (Operations)	Signature/Date (Quality)
DT00000223319						X	30	12/06/2024	✓		N/A	~~[illegible]~~ 12/06/24	[illegible]

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Validation	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Operations)	Signature/Date (Quality)
Tubular	32823-3	15/03/2025	✓		~~[illegible]~~	[illegible]
Tape measure	GJBTH04-21	2025/04/17	✓		~~[illegible]~~	
Combination Square	GJBC0084	19/10/2024	✓		~~[illegible]~~ 12/06/24	

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
308	3737729	308 MIG	✓		~~[illegible]~~ 12/06/24	[illegible]

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

II - Control Activities of Prodution

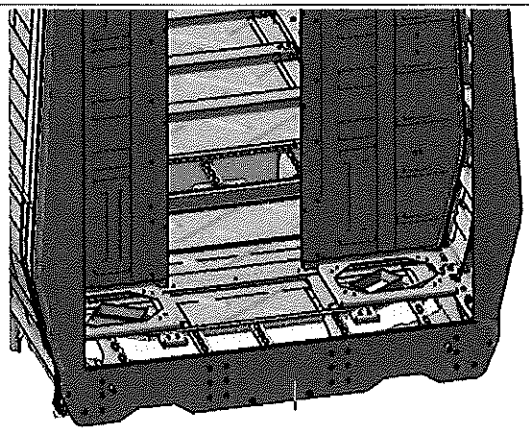
II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOK	Rework	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering nº DT00000223319	DT00000223319	✓			12/06/24	12/06/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓			12/06/24	12/06/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 DTD0000210675	✓			12/06/24	12/06/24
04	N/A	Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓			12/06/24	12/06/24
05	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658	✓			12/06/24	12/06/24
06	N/A	Before appplication of sealant record the expiry date and make sure that the room temperature and humidity are withion specified values as per Works Instructions Specified: Temperature Min - Max (1) Min-Max 10°C - 35°C Relative humidity Min – Max (1) Min-Max 25% - 80%	Sealant Batch No: 16R-10-03 Exp Date: 09 / 09 / 24 Actuals Temparature: 15,5°C Humidity: 58%	OK			12/06/24	12/06/24
07	N/A	Verification of sealant application in regions of roof and sideframe finishers.	Sealant must be: -Applied straight and even (1.5mm) -Free of gaps,cracks,damage and debris (flashes, dirt, dust) Refer to Annexure B	OK			12/06/24	12/06/24

GIBELA 2024 -06- 12 INDUSTRIAL QUALITY ASSURANCE

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

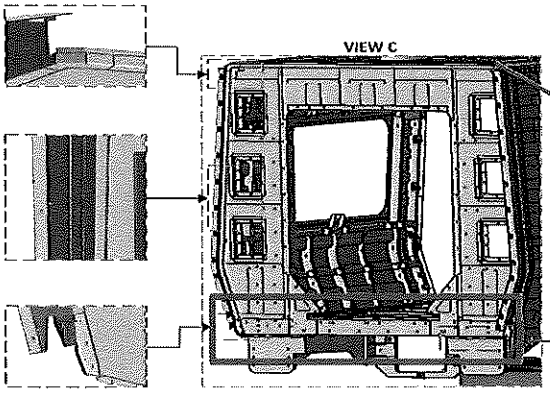
VIEW A



END 1 SEALANT

OPERATOR (Name & sign): Sihle

OPERATOR (Name & sign): Tshenolo

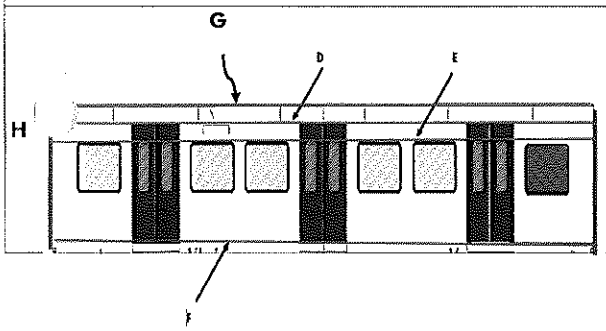


END 2 SEALANT (VIEW C)

OPERATOR (Name & sign): Zanele

OPERATOR (Name & sign): Zanele

OPERATOR (Name & sign):



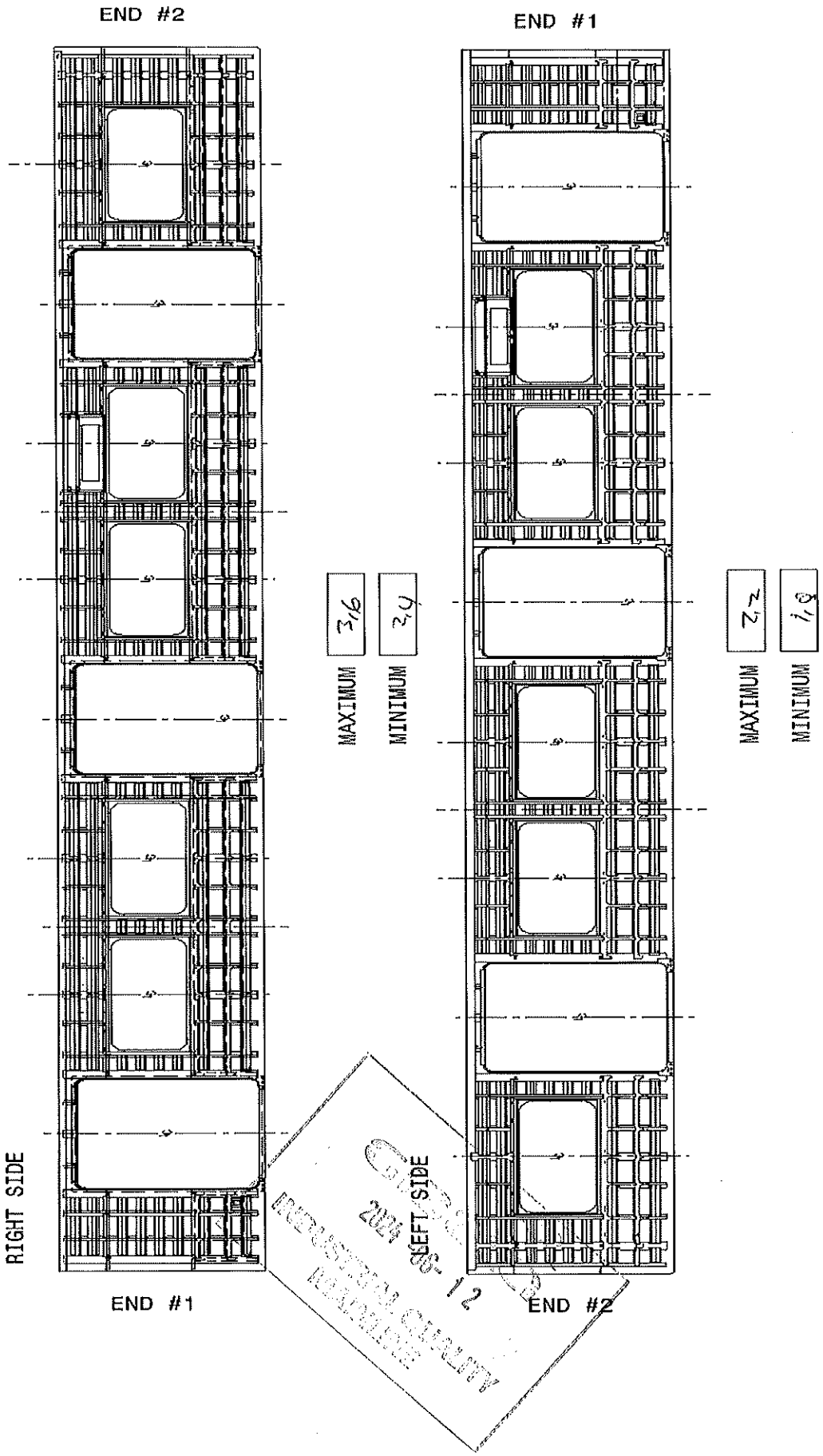
Area D,E,F,G,H,I	LHS	RHS
Operator(Name & sign) :	D,E,G,H,I	D E, G H I
Operator (Name & sign) :	Sihle	Sihle
Operator (Name & sign) :		
Operator (Name & sign) :	Tshenolo	Tshenolo
Operator (Name & sign) :		
Operator (Name & sign) :		

2024 -06- 12

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

Specifications of Details for CBS measurement CB2230

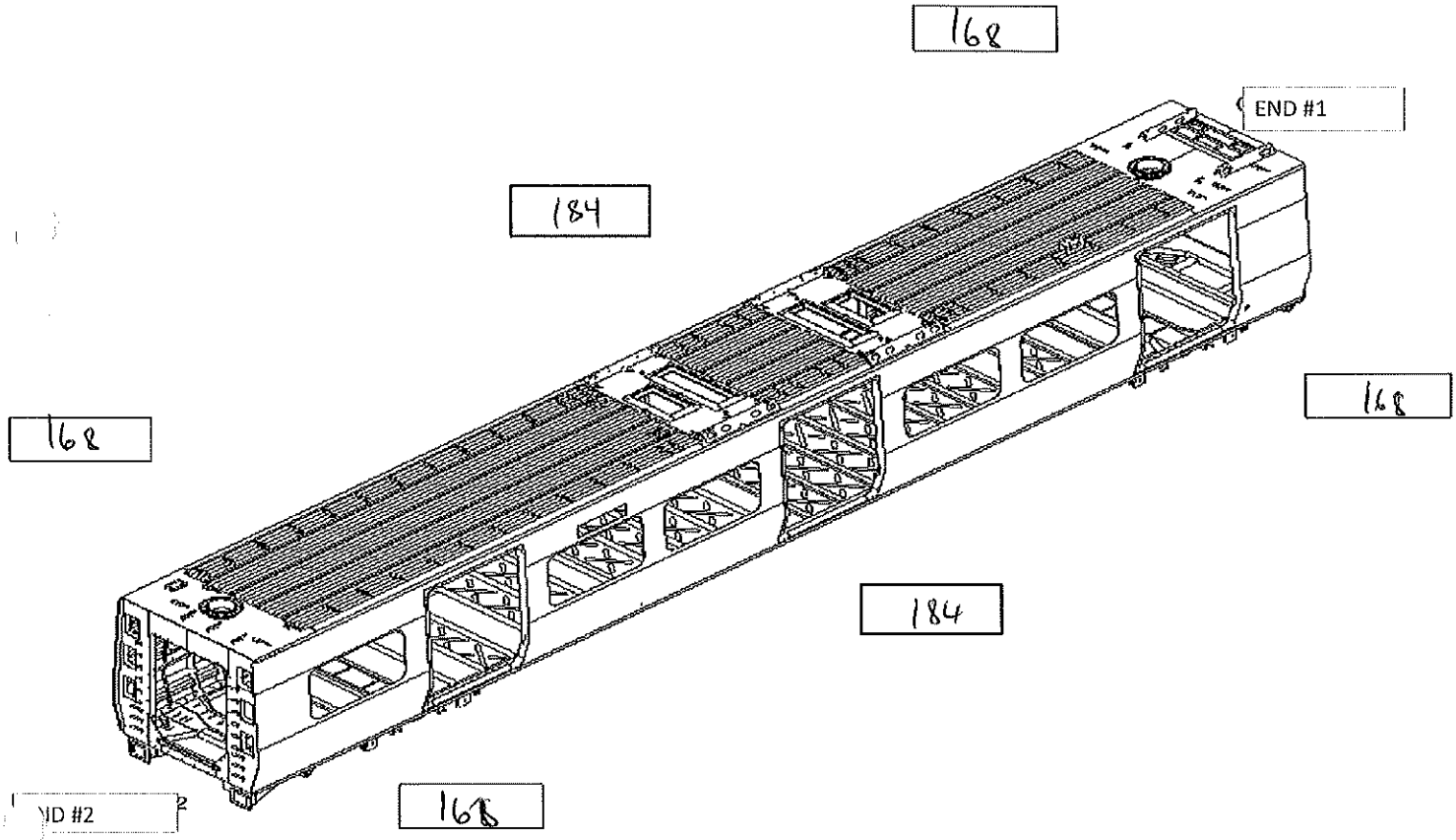
Flatness side left and right maximum of 2mm in the valley to peak measured in 900mm.
Recod the maximum and minimum value foundand indicate the corresponding region.



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

Specifications of Details for CBS measurement CB2230

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



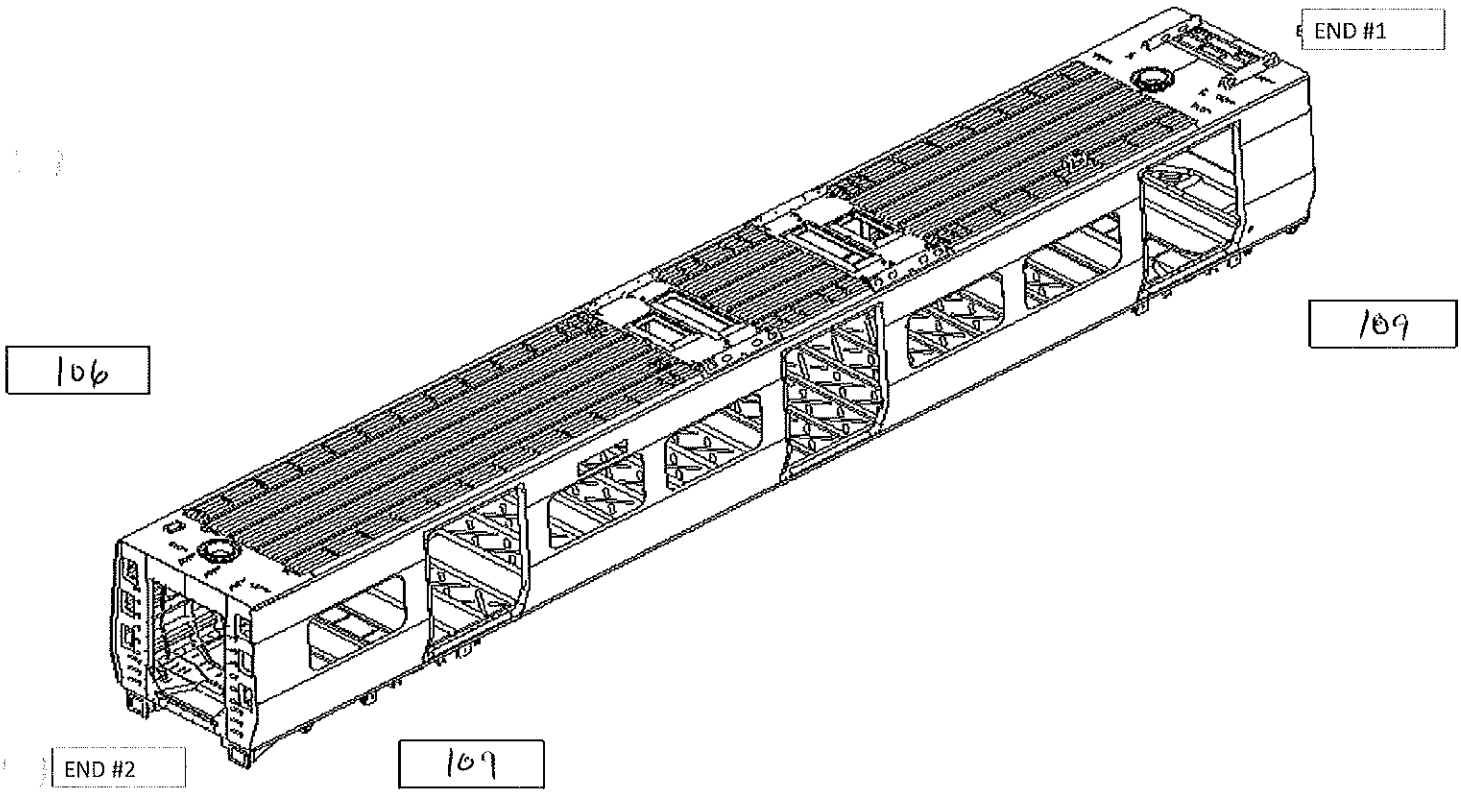
MEASURED CAMBER VALUES	
RIGHT	16
LEFT	16

GIBELA
2024 -06- 12
INDUSTRIAL QUALITY ASSURANCE

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

Specifications of Details for CBS measurement CB2230

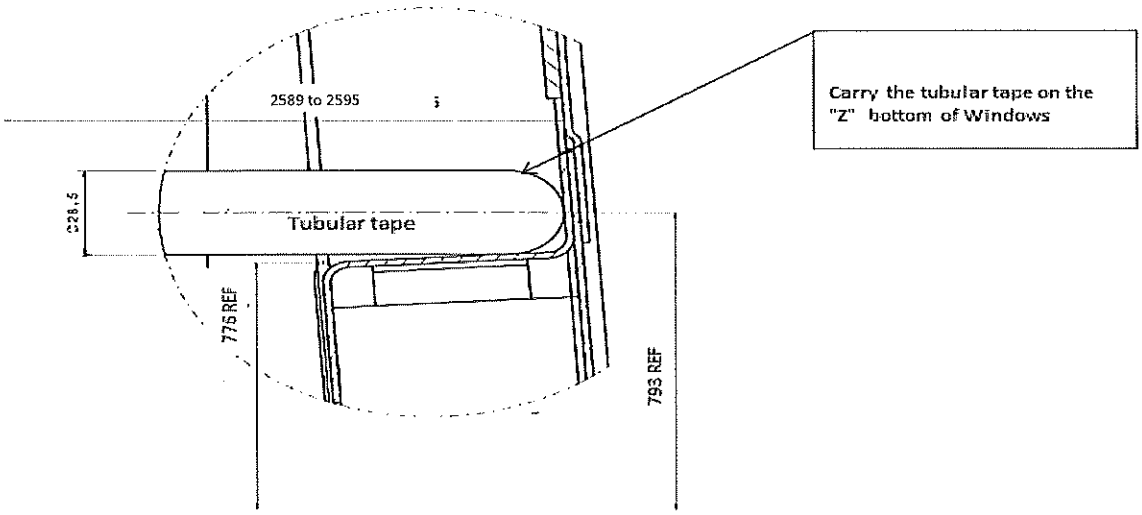
Twist measured in transversal and longitudinal = Maximum 3mm. Measure twist on air spring plates (LHS and RHS), both End 1 and End 2 folllowing twist measurement document.



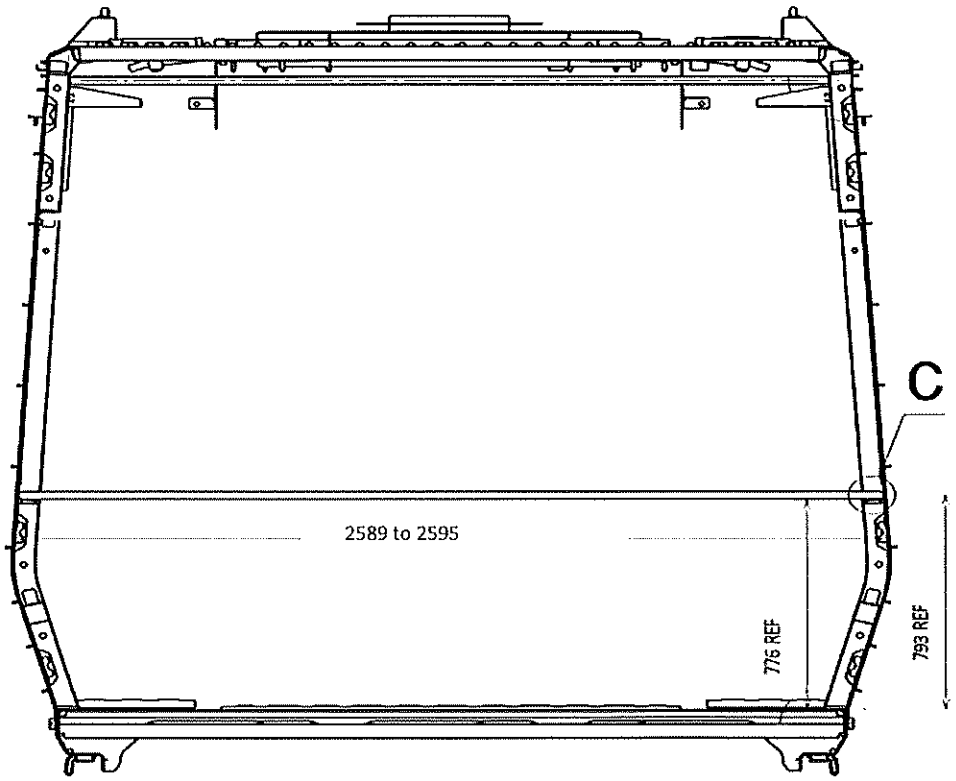
MEASURED TWIST VALUES END 1		MEASURED TWIST VALUES END 2	
LATERAL	3	LATERAL	3
LONGITUDINAL	0	LONGITUDINAL	0

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

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

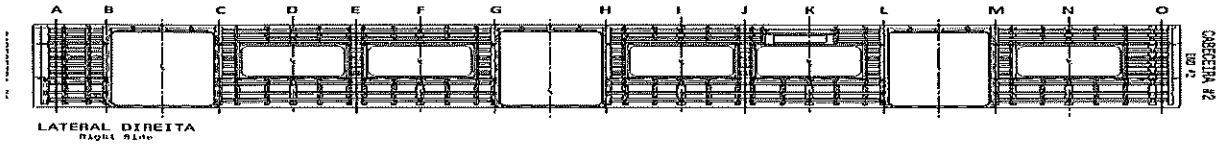


Detail C



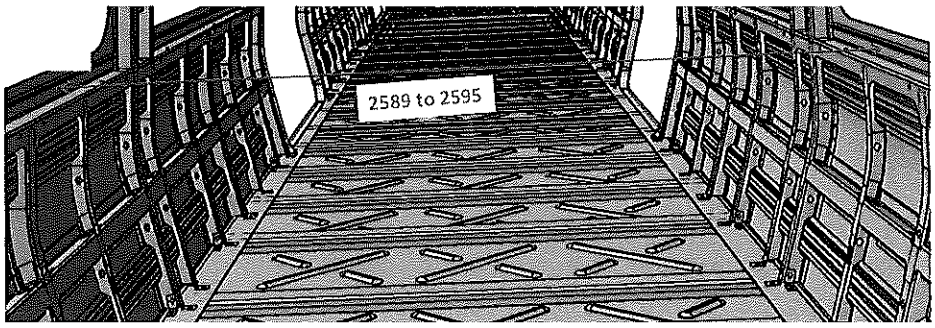
GIBELA	DT00000223319 Carshell Assembly TC	Rev. 30	Project: PRASA
		Date- 06/11/2023	SI.CB2230.324.V29

Specifications of Details for CBS measurement



2589 to 2595mm

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



Threashold verification

Nominal value :38

Door 1		Door 2		Door 3	
L	R	L	R	L	R
38	38	39	39	37	37

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

BOILER MAKER: Nohlanhla

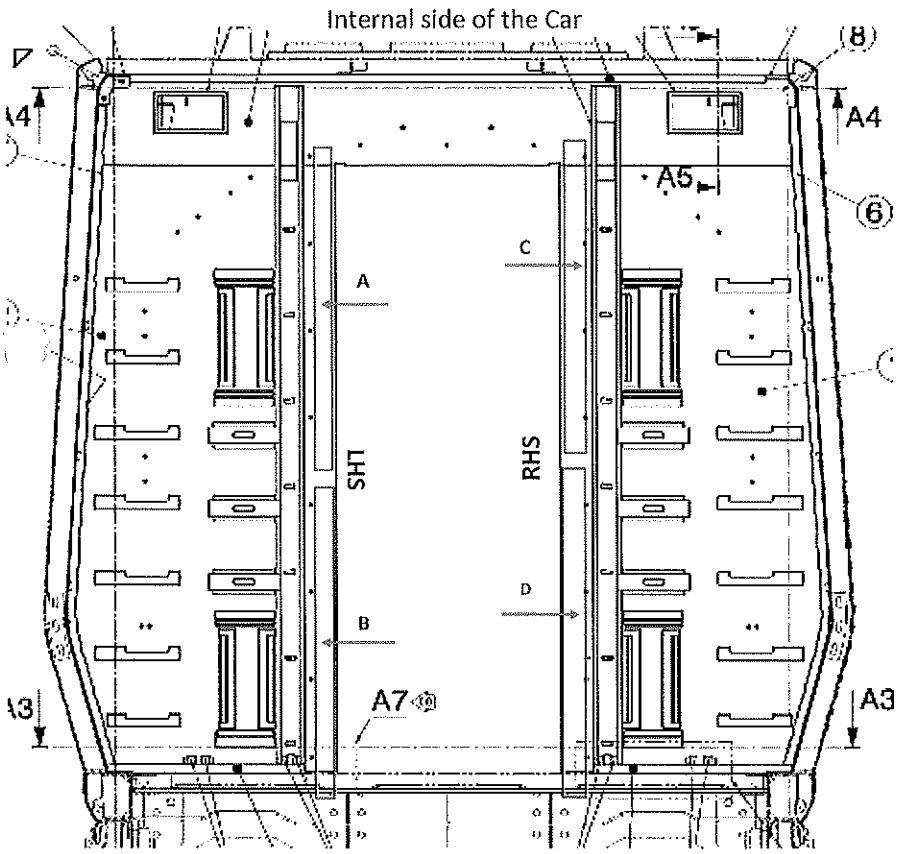
WELDER: Mtholozisi

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

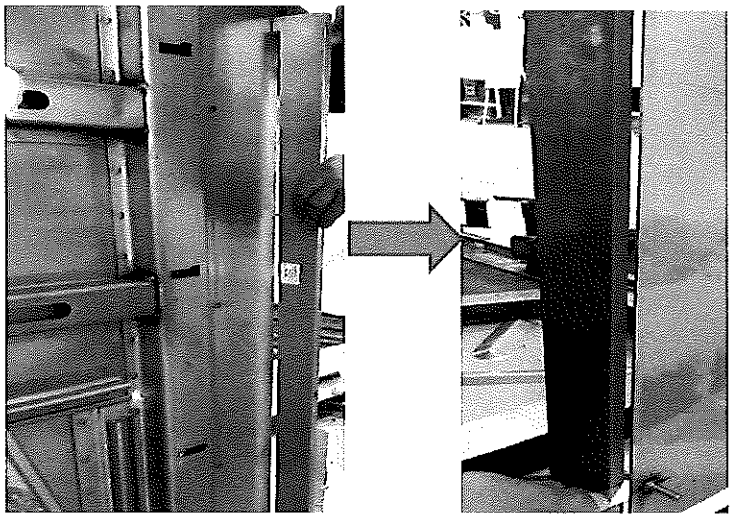
Specifications of Details for CBS measurement

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

Specified Maximum Flatness deviation on Cab Fire Barrier = 2mm



	Measured Values		
	Minimum	Maximum	Deviation
A	9	10,1	1,1
B	10	11,2	1,2
C	8,6	10	1,4
D	10	12	1



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

Dye penetrant test

Dye-penetration test to be performed by quality personnel

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

II.2 - Check List REX

Check List Items

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

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

Self Inspection - Final Result

HOLD POINT	Is the car good to advance to the next workstation/process? (Approval of Operations Manager and Industrial Quality)		DATE	NAME	SIGNATURE
	GO	If activities are not complete, the missing activities must not impact the next stage!	12/06/24	Mthokozisi Operations	
		Every auto inspection performed conforms to specification or In case of discrepancy the same is approved by the competent party.)	12/06/24	Richmond Industrial Quality	
	NO GO	There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)		Operations	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)		Industrial Quality	

In case of "NO GO", describe blocking problems

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

Item	Description	Action	Responsible	Due date	Status

Operations

Quality