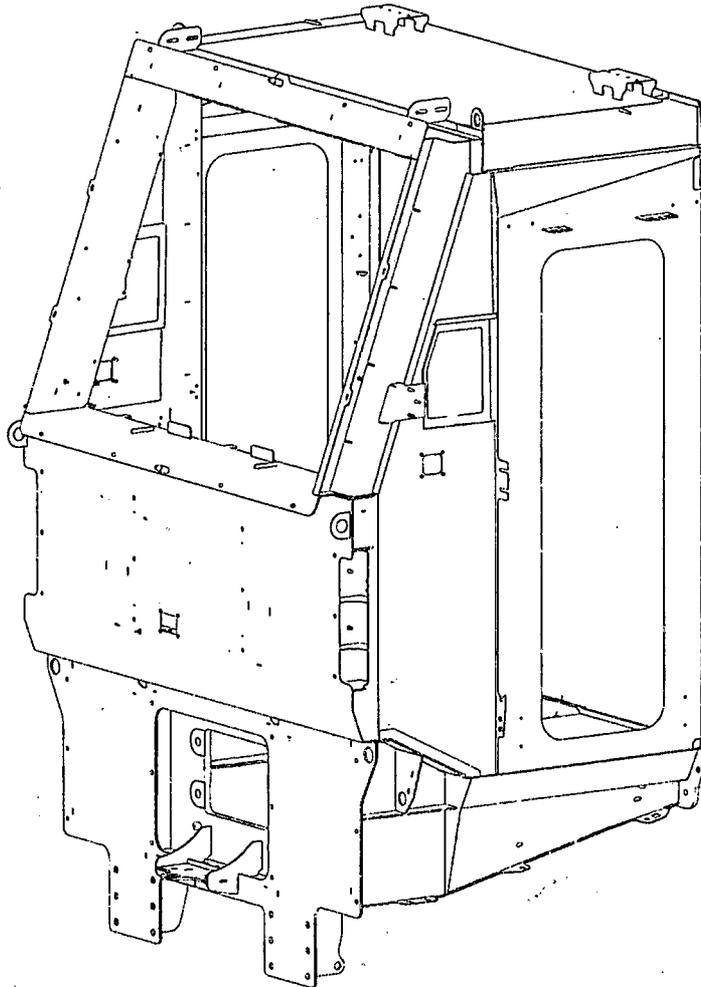


GLOBAL

MANUFACTURING
SOLUTIONS



CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 4 7 0 _

WEIGHT: 1 4 8 8 Kg

RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Pegasus	24/05/24	178247 104895 01	F305031	
RCS 355	2 mm				YI-E99055	
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Pegasus	24/05/24	183653 107087 01	F207906	
RCS 355	3 mm				VHE 73062	
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Pegasus	24/05/24	178488 104640 01	P310156	
RCS 355	20 mm				VPL03512	

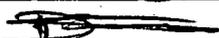
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Pegasus	26/05/24			
RCS 355	30 mm					

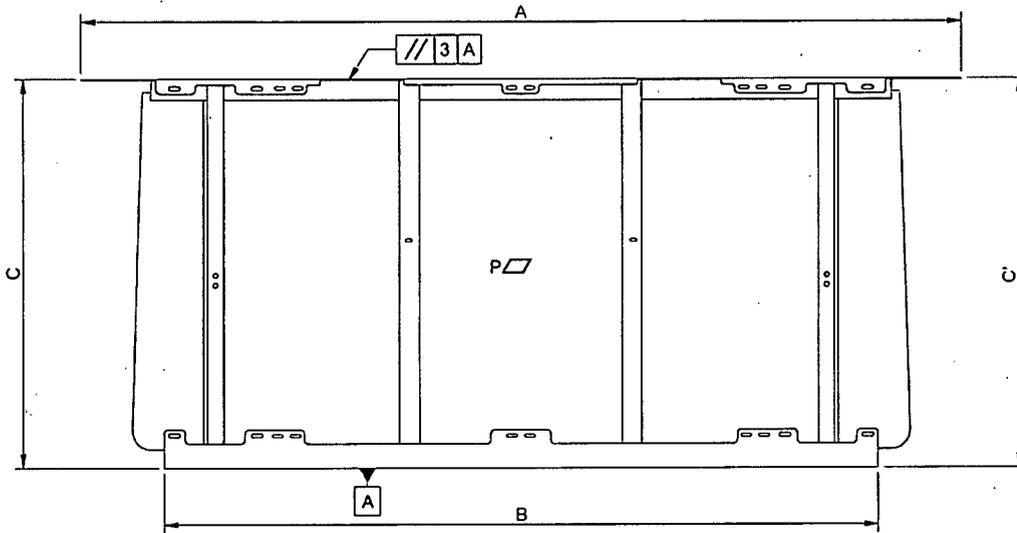
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Pegasus	24/05/24	182739 107087 01	F207906	
RCS 450	4 mm				VH447403	
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Pegasus	24/05/24	183446 107087 01	F207907	
RCS 450	6 mm				VHS6235	
RCS 450	6 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Pegasus	24/05/24	188451 107087 01	F305031	
RCS 450	8 mm				VHS62365	
RCS 450	8 mm					
RCS 450	8 mm					

Cabin Roof Assembly: GN002839

Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DYLAN DAVIDS	Assembly Date:	20 24/04/22		
Sign:		Wire Batch No.:	107238201		



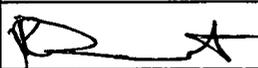
Welding Control

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

Dimensional Control

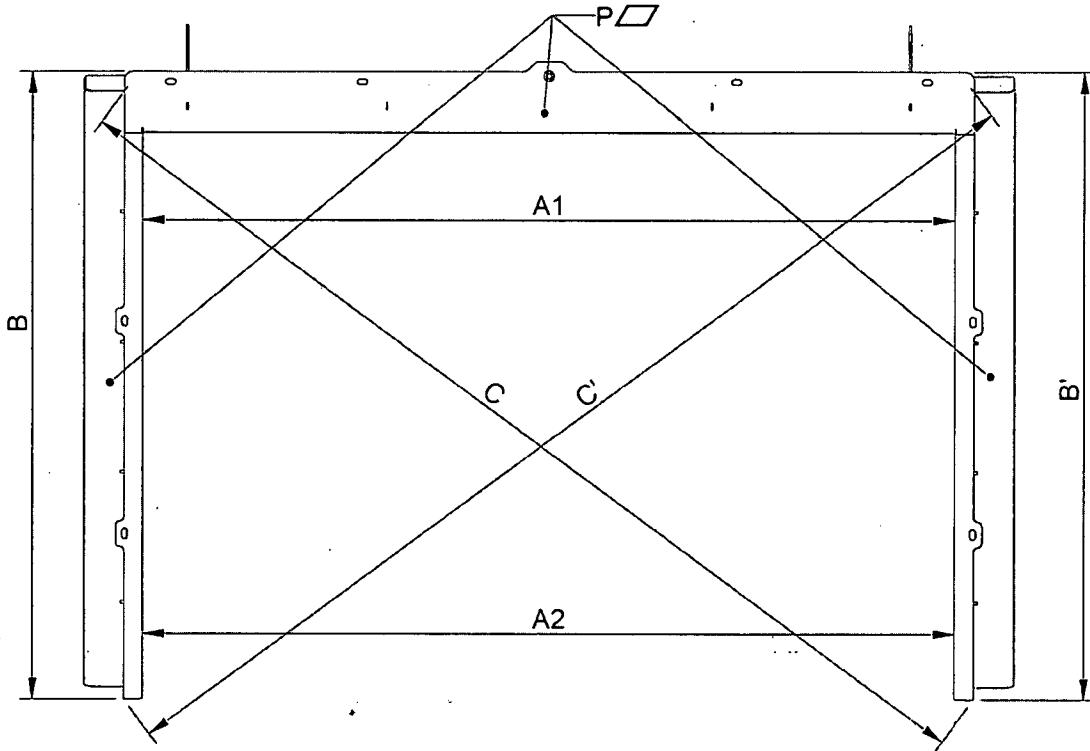
Rep	Toler.	Dimension measured		Measuring Equipment	Observations	
A	2216	+5/-0	2216	Tape Measure	acceptable	
B	1800	± 4	1800		acceptable	
C	976	+2/-3	976 976		acceptable	
QC Inspector:	Riccardo		Sign:		Date:	2024/04/22

Geometrical Control

Nature of Checks		Dimension Measured	Measuring Equipment	Observations		
Planéité P	6 mm	Passed	Ruler	acceptable		
//	3 A	Passed	Set Square	acceptable		
QC Inspector:	Riccardo		Sign:		Date:	2024/04/22

Cabin Front Frame Assembly: GN002840

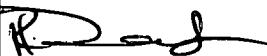
Assembly Completed as per WI/SOS MD_0047		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Bambelo Geroni	Assembly Date:	2024/04/22			
Sign:		Wire Batch No.:	SS2037			



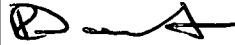
Welding Control

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:		Sign:		Date:	20__/__/__	

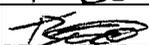
Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	1910	± 2	1912		Tape Measure	acceptable
A2	1910		1911			acceptable
B	1475	± 1	1474	1474		acceptable
C	Diagonals C - C' ≤ 3		2475	2475		acceptable
QC Inspector:	Riccardo	Sign:			Date:	2024/04/22

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations			
P : Planeity	4 mm	Passed	Ruler	acceptable		
QC Inspector:	Riccardo	Sign:			Date:	2024/04/22

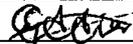
Cabin LHS/RHS Wing Mirror Plate Assembly: GN002846/GN002844

Assembly Completed as per WI/SOS MD_0068_0073		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	TB0064	Assembly Date:	20 24/04/12			
Sign:		Wire Batch No.:	552033			

Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907

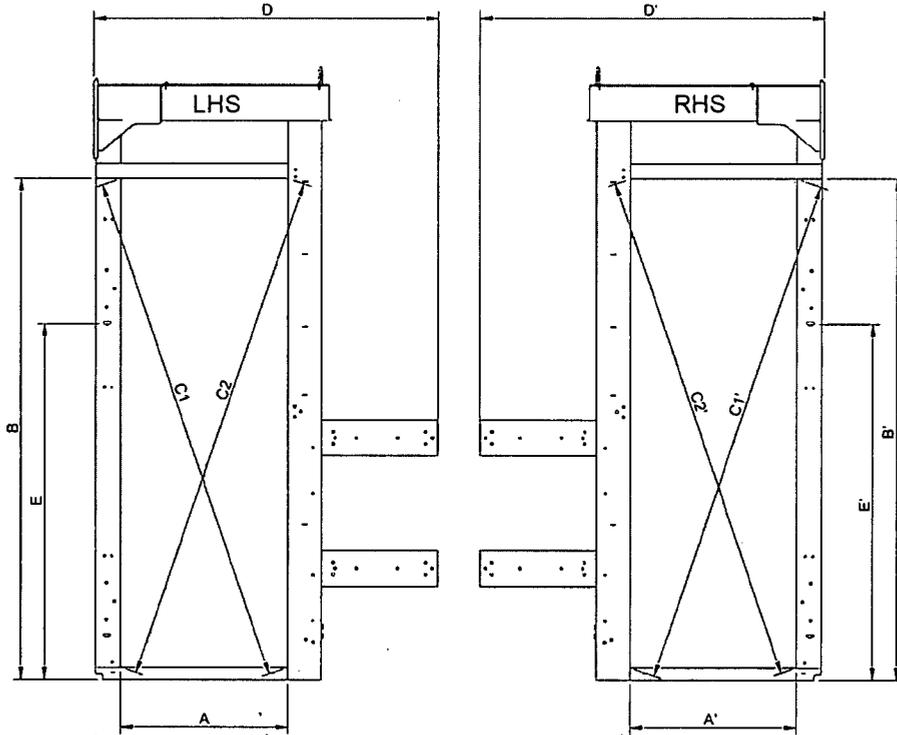
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Glenn	Assembly Date:	20 24/04/12			
Sign:		Wire Batch No.:	552033			

Cabin LHS/RHS Door Post Assembly: GN002919/GN002897

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Glenn	Assembly Date:	20 24/04/12			
Sign:		Wire Batch No.:	552033			

Cabin LHS/RHS Door Frame Assembly: GN002839

Assembly Completed as per WI/SOS MD_0067_0078	Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator: Glenn	Assembly Date:	2024/04/13		
Sign: <i>[Signature]</i>	Wire Batch No.:	552033		



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042	Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector: Riccardo	Sign: <i>[Signature]</i>	Date:	2024/04/18	

Dimensional Control

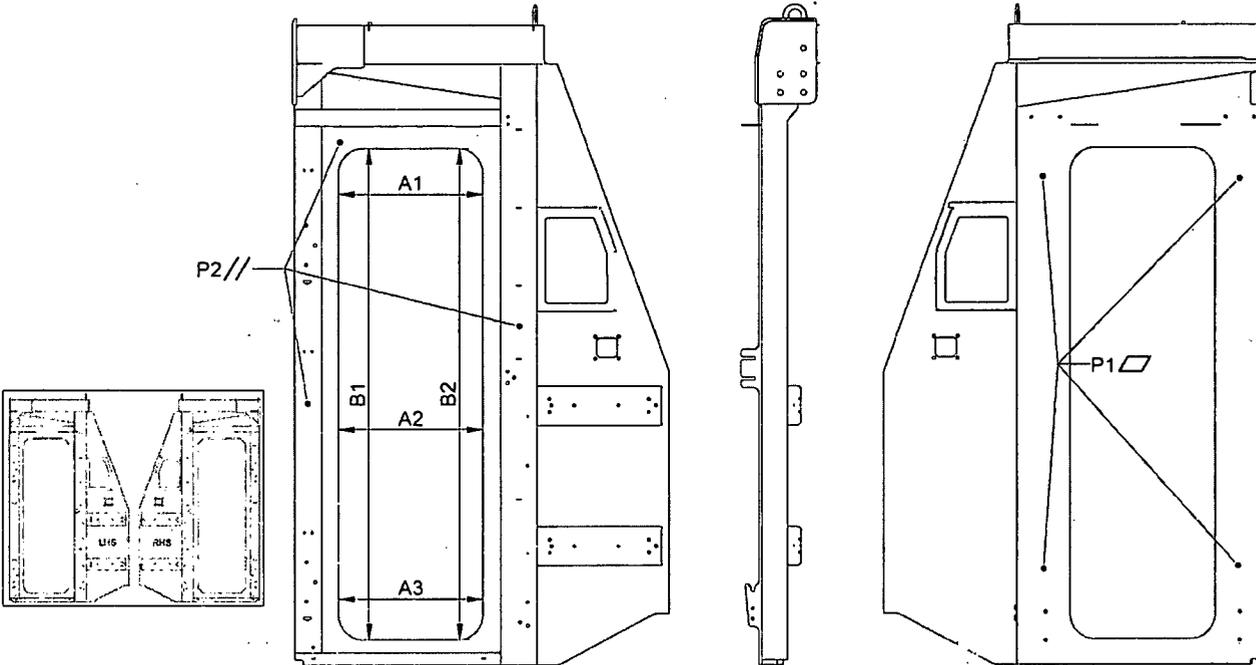
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	696	Tape Measure	acceptable
B	2086	+1/-3	2085	2085		acceptable
C1 / C2	Difference of diagonals $ C1 - C2 \leq 3$		2153	2154		acceptable
$ C1 - C2 $			2153	2151		acceptable
D	1438	+2/-3	1438	1438		acceptable
E			1484			
QC Inspector: Riccardo		Sign: <i>[Signature]</i>		Date:	2024/04/16	

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	Ruler	Passed acceptable
QC Inspector: Riccardo		Sign: <i>[Signature]</i>	
Date:		2024/04/22	

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>Brian</i>	Assembly Date:	20 <u>24</u> / <u>04</u> / <u>22</u>			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			



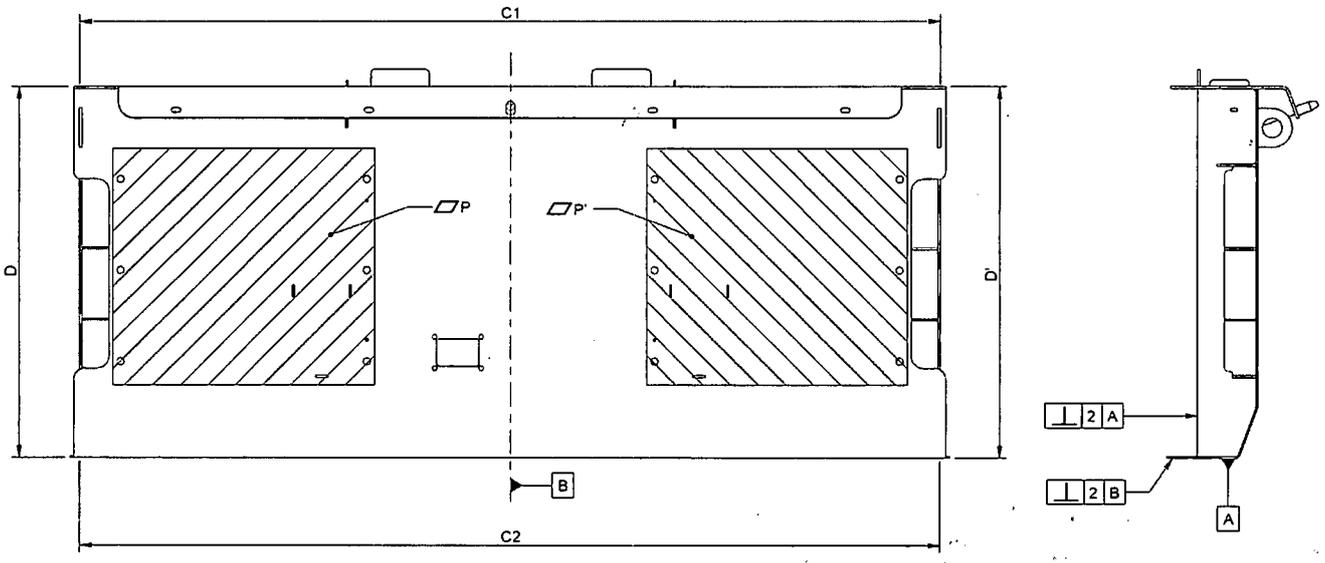
Welding Control						
Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	20 <u>24</u> / <u>04</u> / <u>22</u>	

Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1	560	± 2	<i>558</i>	<i>559</i>	Tape Measure	<i>acceptable</i>
A2			<i>560</i>	<i>559</i>		<i>acceptable</i>
A3			<i>560</i>	<i>559</i>		<i>acceptable</i>
B1	1900	± 2	<i>1898</i>	<i>1898</i>		<i>acceptable</i>
B2			<i>1898</i>	<i>1898</i>		<i>acceptable</i>
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>		Date:	20 <u>24</u> / <u>04</u> / <u>22</u>

Geometrical Control						
Nature of checks		Dimension Measured	Measuring Equipment	Observations		
P1 : Planenity	4 mm	<i>Passed</i>	Ruler	<i>acceptable</i>		
P2 : Planenity	2 mm	<i>Passed</i>	Ruler	<i>acceptable</i>		
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>		Date:	20 <u>24</u> / <u>04</u> / <u>22</u>

Cabin Shield Assembly: GN002836

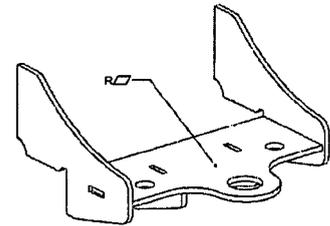
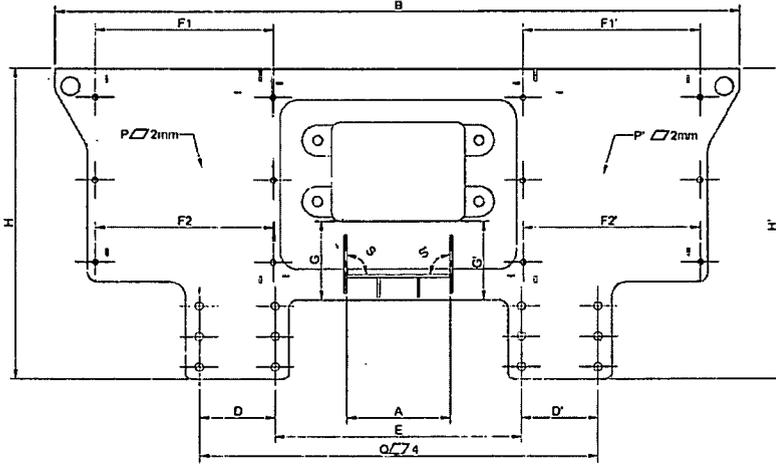
Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Bambelo Guinan	Assembly Date:	2024/04/22			
Sign:	<i>[Signature]</i>	Wire Batch No.:	SS 2033			



Welding Control						
Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Riccardo	Sign:	<i>[Signature]</i>	Date:	2024/04/22	
Dimensional Control						
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2213	2213	Tape Measure	acceptable
D / D'	956	± 2	955	955		acceptable
QC Inspector:	Riccardo	Sign:	<i>[Signature]</i>	Date:	2024/04/22	
Geometrical Control						
Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planeity P / P'		2 mm	<i>Passed</i>		Ruler	
Perpendicularity	2	A	<i>Passed</i>		Set Square	<i>Acceptable</i>
	2	B	<i>Passed</i>		Set Square	<i>Acceptable</i>
QC Inspector:		Sign:		Date:	2024/04/22	

Cabin Front Headstock Assembly: GN002841

Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>TK Boon</i>	Assembly Date:	2024/04/16	
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033	



Welding Control

Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042		Confirmed	Yes	<input checked="" type="checkbox"/> No
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date: 2024/04/17

Dimensional Control

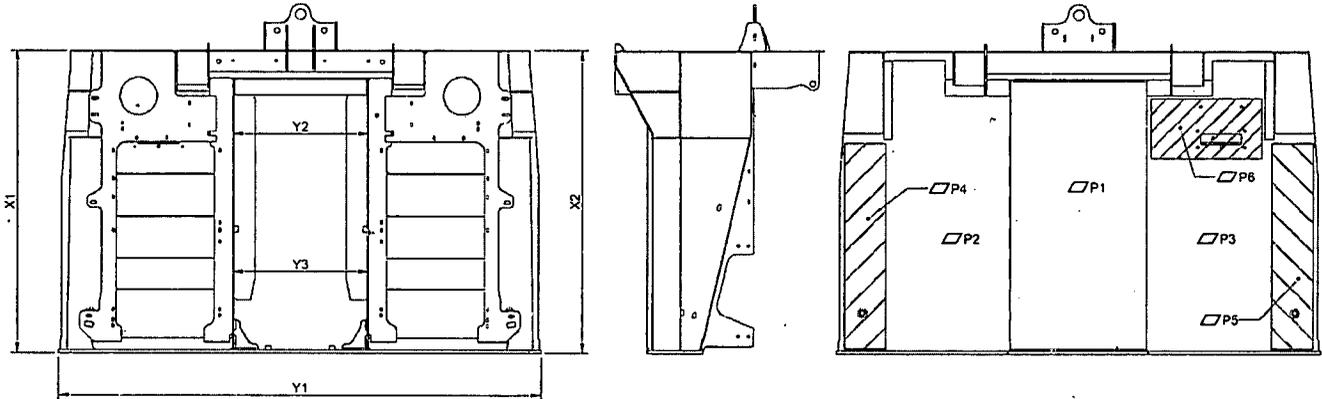
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	±1	539		Tape Measure	acceptable
B	2240	±4	2244			acceptable
D / D'	250	±1	250	250		acceptable
E	808	±2	808			acceptable
F1 / F1'	580	±1	581	581		acceptable
F2 / F2'			581	581		acceptable
G / G'	258	±1	259	259		acceptable
H / H'	1019	±2	1020	1020		acceptable
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/04/17	

Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations		
O: Planeity of global assembly	4 mm	<i>Passed</i>	Ruler	acceptable	
P / P': Planeity	2 mm	<i>Passed</i>	Ruler	acceptable	
Q: Planeity Surface of Supports	4 mm	<i>Passed</i>	Ruler	acceptable	
R: Planeity Coupler Support	2 mm	<i>Passed</i>	Ruler	acceptable	
S: Perpendicularity coupler	1mm	<i>Passed</i>	Square	acceptable	
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/04/17

Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	20 24 04 20	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202162	



Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date: 2024/04/20

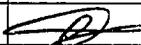
Dimensional Control

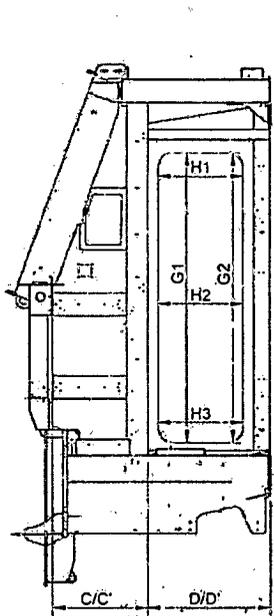
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1486	1468	Tape Measure	acceptable
Y1	2354	±3	2351			acceptable
Y2 / Y3	666	±1	666	666		acceptable
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>		Date:	2024/04/20

Geometrical Control

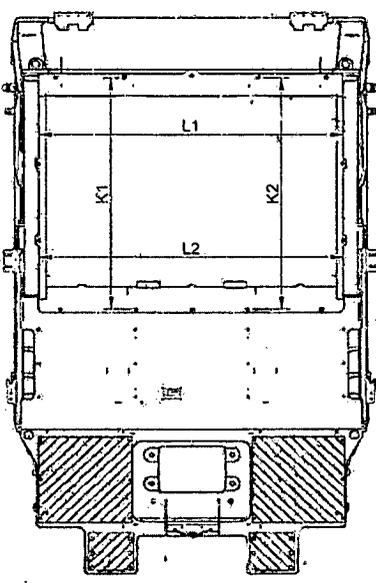
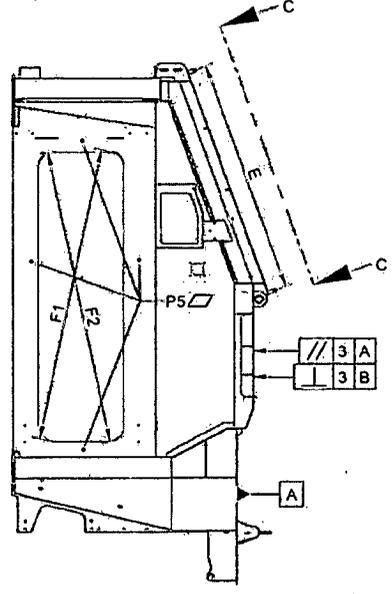
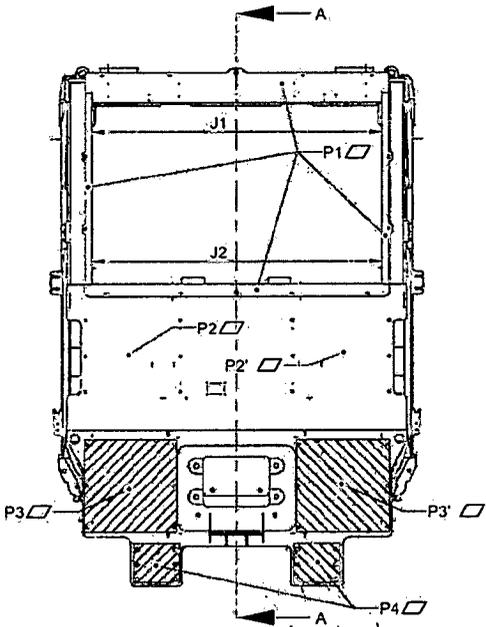
Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm Passed	Ruler	acceptable
P2 / P3 : Planeity	4 mm Passed	Ruler	acceptable
P4 / P5 : Planeity	2 mm Passed	Ruler	acceptable
P6 : Planeity	2 mm Passed	Ruler	acceptable
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>
Date:	2024/04/20		

Cabin Structure Assembly: GN002834

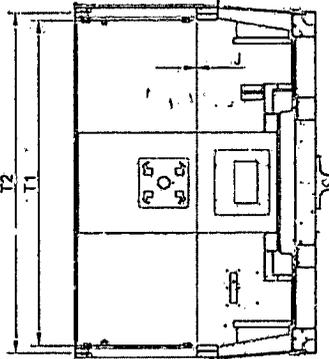
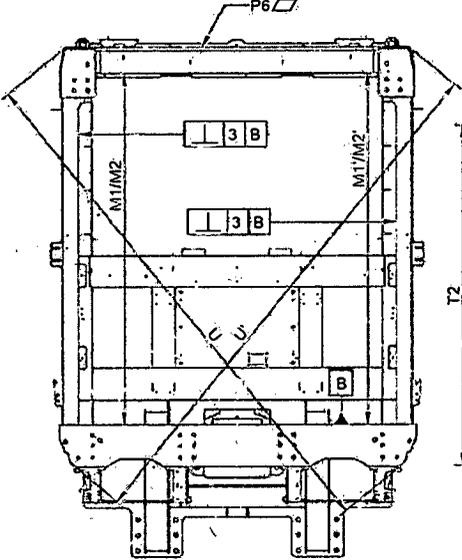
Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	<input checked="" type="checkbox"/> No
Operator:	<i>CHARL BLOEM</i>	Assembly Date:	20 24 / 04 / 20	
Sign:		Wire Batch No.:	55 2053	



SECTION A-A



AUX VIEW: C



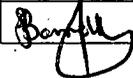
SECTION B-B

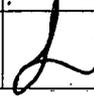
Welding Control									
Visual inspection of all Welds as per Drawing and EN ISO 5817 / EN ISO 10042					Confirmed	Yes	<input checked="" type="checkbox"/>	No	
QC Inspector: LEON		Sign: A			Date: 2024/04/27				
Dimensional Control									
Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations				
C / C'	625	± 2	627	625	Acceptable				
D / D'	813	± 2,5	812	812	Acceptable				
E	1531.5	± 3	1530		Acceptable				
G1 / G'1	Height 1900	+1	1897	1897	Acceptable				
G2 / G'2		-3	1898	1899	Acceptable				
H1 / H'1	Width 560	+1	557	557	Acceptable				
H2 / H'2		-3	558	558	Acceptable				
H3 / H'3				560	558	Acceptable			
F1 / F'1	Diagonals 1939		1987	1938	Acceptable				
F2 / F'2			1987	1936	Acceptable				
Difference	F1-F2 / F'1-F'2	≤ 4	0	2	Acceptable				
J	Gap of Doors	± 1,5	0		Acceptable				
K1 / K2	1515	± 3	1515	1513	Acceptable				
L1 / L2	1996	± 3	1997.5	1995	Acceptable				
M1 / M'1	2306	± 3	2461	2461	Acceptable				
M2 / M'2			2471	2471	Acceptable				
T1 / T'1	2130 Top/Bottom	± 3	2128	2128	Acceptable				
T2 / T'2	2230 Top/Bottom		2230	2231	Acceptable				
Difference	U - U' (3522)	≤ 4mm	3518	3518	Acceptable				
QC Inspector: LEON		Sign: A			Date: 2024/04/27				
Geometrical Control									
Nature of checks		Toler.	LHS / Dimension Measured / RHS		Observations				
P1 / P'1	Planeity	2 mm	PASSED		Acceptable				
P2 / P'2	Planeity	2 mm	PASSED		Acceptable				
P3 / P'3	Planeity	4 mm	PASSED		Acceptable				
P4 / P'4	Planeity	4 mm	PASSED		Acceptable				
P5 / P'5	Planeity	4 mm	PASSED		Acceptable				
P6 Roof	Planeity	6 With 2m Ruler	PASSED		Acceptable				
Shield	//	3 A	3		PASSED Acceptable				
Shield	⊥	3 A	3		PASSED Acceptable				
Door Post	⊥	3 A	Front		PASSED Acceptable				
			Back		PASSED Acceptable				
QC Inspector: LEON		Sign: A			Date: 2024/04/27				

Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>CHARL ELLER</i>	Assembly Date:	20 __ / __ / __			
Sign:		Wire Batch No.:	<i>552033</i>			

Cabin Rivnut Assembly: GN002832

Assembly Completed as per WI/SOS MD_0092		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>SELWYN</i>	Assembly Date:	20 <i>24</i> / <i>04</i> / <i>27</i>			
Sign:		Wire Batch No.:				

Shot Blasting					
Shot Blasting Pre-Inspection					
All external threads masked	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Fasteners positioned in all Rivnuts and Bosses	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Masked as per GMS-SOS-GIBELA-CABIN-001	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Johnson		Sign: 		
Date:	2024/05/17				
Record of Shot Blasting					
Operator:	Johnson		Date:	2024/05/17	
Start Time:	11:00 AM		End Time:	12:00 PM	
Temperature ($\geq 15^\circ$):	29.9 $^\circ$ C		Humidity ($\leq 75\%$):	60-9%	
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:	Johnson		Sign: 		
Date:	2024/05/17				
Shot Blasting Cleaning					
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	Johnson		Sign: 		
Date:	2024/05/17				
Shot Blasting Control					
Temperature $\geq 15^\circ$:		Humidity $\leq 75\%$:			
Internal Roughness 3.2 \leq Ra \leq 12.5	Ra 7,086 Rz 43,680	External Roughness 3.2 \leq Ra \leq 12.5	Ra 5,822 Rz 51,410		
QC Inspector:	2473		Sign: 		
Date:	17/5/24				

Ra 5,817
 7,086
 7,121
 6,993
 6,105
 5,690
 5,227
 5,057
 6,386
 4,484

Rz 37,986
 43,680
 40,359
 43,353
 38,457
 33,035
 35,060
 30,822
 35,725
 31,654

Ra 6,215
 6,287
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 5,384
 4,989
 8,822
 8,071
 6,830
 6,673
 6,595

Rz 42,067
 39,876
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 47,671
 39,971
 40,305
 40,102

Record of Priming

Start Time:	19:00	End Time:	21:00
Temperature ≥ 15°:		Humidity ≤ 75%:	
Paint Batch No.:	8016059	Paint Expiry Date:	08/25
Hardener Batch No.:	7331119	Hardener Expiry Date:	01/11/2024
Desolvation Start Time:	21:00	Desolvation End Time:	21:15
Stoving Start Time:	21:15	Stoving End Time:	22:15
Stoving Temp:	60°C		
Operator:	Ntuthuko	Sign:	Ntuthuko
Date:	20 24 05/17		

Priming Control

DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 616	5: 464	1: 525	5: 77.1	1: 462	5: 462	1: 49.6	5: 87.7
2: 688	6: 81.0	2: 525	6: 57.4	2: 83.4	6: 47.0	2: 49.1	6: 68.2
3: 442	7: 80.4	3: 65.6	7: 52.9	3: 57.0	7: 83.4	3: 48.2	7: 68.2
4: 501.6	8: 68.6	4: 12.1	8: 82.4	4: 47.5	8: 47.5	4: 71.9	8: 68.2
Min:	442	Min:	52.5	Min:	46.2	Min:	48.2
Max:	80.4	Max:	82.4	Max:	83.4	Max:	87.7
Average:	58.9	Average:	64.0	Average:	57.2	Average:	68.8
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 53.9	5: 66.1	1: 73.6	5: 71.4	1: 52.3	5: 83.3	1: 47.2	5: 45.4
2: 76.4	6: 70.6	2: 47.0	6: 52.2	2: 72.1	6: 69.9	2: 57.0	6: 51.5
3: 77.1	7: 79.3	3: 47.6	7: 47.6	3: 89.5	7: 82.8	3: 56.3	7: 60.7
4: 89.7	8: 71.5	4: 66.6	8: 73.6	4: 77.0	8: 57.2	4: 82.6	8: 50.5
Min:	53.9	Min:	47.0	Min:	52.3	Min:	45.4
Max:	89.7	Max:	73.6	Max:	89.5	Max:	82.6
Average:	72.9	Average:	57.3	Average:	73.0	Average:	55.3
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top: RHS/LHS	
1: 78.1	5: 68.7	1: 62.7	5: 60.6	1: 63.2	5: 81.4	1: 62.5	5: 49.0
2: 35.7	6: 100	2: 73.9	6: 60.2	2: 68.3	6: 72.5	2: 82.6	6: 66.4
3: 92.9	7: 72.7	3: 51.4	7: 75.9	3: 71.8	7: 100	3: 66.0	7: 70.2
4: 92.8	8: 68.0	4: 61.6	8: 70.1	4: 62.5	8: 64.9	4: 80.2	8: 47.2
Min:	35.7	Min:	51.4	Min:	62.5	Min:	47.2
Max:	100	Max:	75.9	Max:	109	Max:	82.6
Average:	76.1	Average:	64.1	Average:	74.2	Average:	66.2
Primer has been inspected and is free of defects				Confirmed	Yes	<input checked="" type="checkbox"/>	No
QC Inspector:	Zozile			Sign:	Hou		
Date:	21 May 2024						

Record of Painting NCSS3010 R90B					
Start Time:	09:00	End Time:	10:00		
Temperature ≥ 15°:		Humidity ≤ 75%:			
Paint Batch No.:	8216294	Paint Expiry Date:	04-04-23		
Hardener Batch No.:	8187506 024	Hardener Expiry Date:	02-27		
Desolvation Start Time:	10:00	Desolvation End Time:	10:15		
Stoving Start Time:	10:15	Stoving End Time:	11:15		
Stoving Temp:	60°C				
Operator:	Musa	Sign:	Musa		
Date:	2024/03/25				
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: 117	5: 121	1: 982	5: 124		
2: 142	6: 124	2: 104	6: 137		
3: 138	7: 119	3: 859	7: 100		
4: 120	8: 106	4: 118	8: 128		
Min:	106	Min:	859		
Max:	142	Max:	137		
Average:	124	Average:	111		
Painting NCSS3010 R90B has been inspected and is free of defects					
GMS-SOS-GIBELA-PS-002 Gloss Test				Value	33.8
QC Inspector:	Zotule			Sign:	[Signature]
Date:	26 June 2024				

Record of Painting Blue NCSS1565 B				
Start Time:	09:00		End Time:	10:00
Temperature ≥ 15°:			Humidity ≤ 75%:	
Paint Batch No.:	8216288		Paint Expiry Date:	27-03-25
Hardener Batch No.:	8187506 024		Hardener Expiry Date:	02-27
Desolvation Start Time:	10:00		Desolvation End Time:	10:15
Stoving Start Time:	10:15		Stoving End Time:	11:15
Stoving Temp:	60 °C			
Operator:	musa		Sign:	musa
Date:	2024/05/27			
Painting Blue NCSS1565 B Control				
DFT Exterior Door Aperture RHS		DFT Exterior Door Aperture LHS		GMS-SOS-GIBELA-PS-001 Adhesion Test (attach test tape)
1: 125	5: 125	1: 127	5: 123	
2: 116	6: 952	2: 130	6: 139	
3: 98.9	7: 108	3: 101	7: 121	
4: 122	8: 119	4: 99.0	8: 110	
Min:	95.2	Min:	99.0	
Max:	135	Max:	139	
Average:	115	Average:	119	
Painting NCSS3010 R90B has been inspected and is free of defects			Confirmed	
GMS-SOS-GIBELA-PS-002 Gloss Test			Value	90.3
QC Inspector:	Zohle		Sign:	Zohle
Date:	28 May 2024			

Record of RAL 7012

Start Time:	13:00	End Time:	15:00
Temperature ≥ 15°:	28°C	Humidity ≤ 75%:	46%
Paint Batch No.:	8216273	Paint Expiry Date:	13-23-25
Hardener Batch No.:	8787506024	Hardener Expiry Date:	02/7
Desolvation Start Time:	15:00	Desolvation End Time:	15:15
Stoving Start Time:	15:15	Stoving End Time:	16:15
Stoving Temp:	60°C		
Operator:	musa	Sign:	
Date:	2024/05/24		musa

RAL 7012 Control

DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 89.9	5: 103	1: 122	5: 157	1: 122	5: 151	1: 101	5: 128
2: 107	6: 122	2: 131	6: 151	2: 167	6: 144	2: 85.7	6: 162
3: 116	7: 113	3: 92.2	7: 132	3: 148	7: 85.6	3: 99.6	7: 78.9
4: 108	8: 165	4: 156	8: 142	4: 125	8: 94.2	4: 114	8: 142
Min:	89.5	Min:	92.2	Min:	85.6	Min:	78.9
Max:	165	Max:	154	Max:	167	Max:	162
Average:	127	Average:	123	Average:	126	Average:	120
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 99.8	5: 152	1: 127	5: 131	1: 83.6	5: 109	1: 103	5: 124
2: 135	6: 147	2: 131	6: 83.6	2: 109	6: 102	2: 99.5	6: 102
3: 82.7	7: 138	3: 120	7: 95.2	3: 101	7: 105	3: 80.9	7: 161
4: 111	8: 141	4: 118	8: 134	4: 124	8: 93.4	4: 86.8	8: 128
Min:	82.7	Min:	83.6	Min:	83.6	Min:	80.9
Max:	157	Max:	134	Max:	124	Max:	161
Average:	119	Average:	108	Average:	103	Average:	120
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 123	5: 98.3	1: 104	5: 122				
2: 108	6: 116	2: 129	6: 138				
3: 119	7: 108	3: 89.3	7: 157				
4: 142	8: 125	4: 117	8: 114				
Min:	98.3	Min:	89.3				
Max:	142	Max:	157				
Average:	120	Average:	123				

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	42.6	25	100	
QC Inspector:	Zorhile		Sign:		
Date:	25 May 24				

SEALING OF CABIN

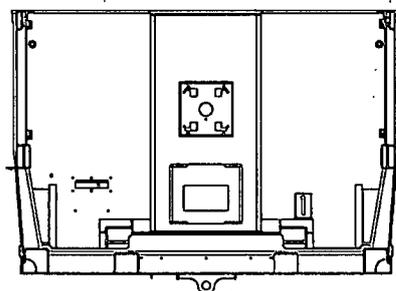
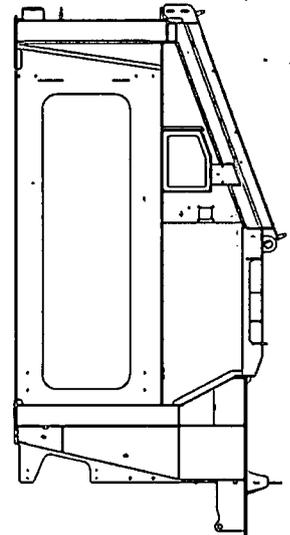
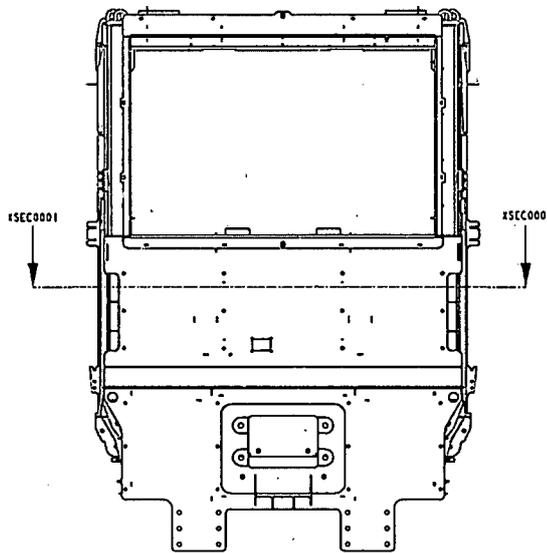
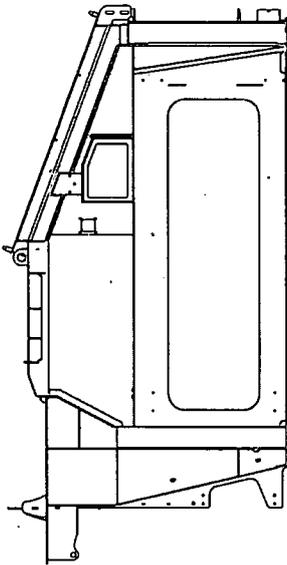
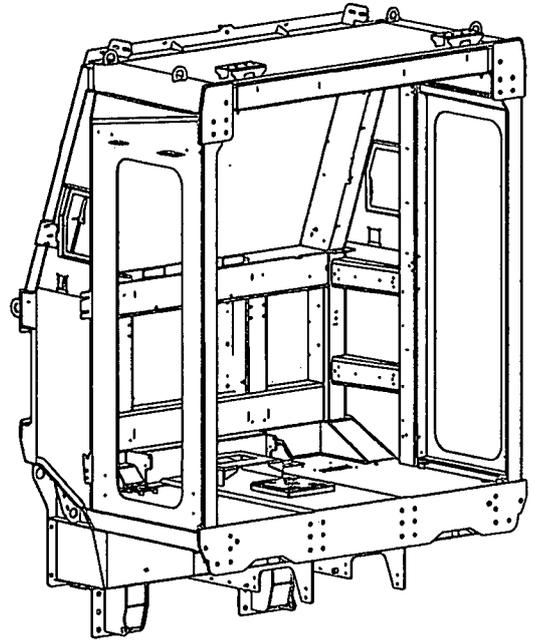
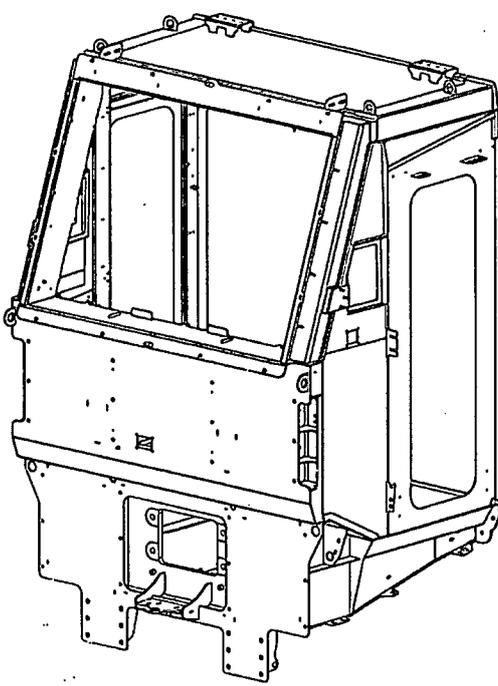
All areas where there is no welding has been sealed with SIKA	Confirmed	YES	<input checked="" type="checkbox"/>	NO	<input type="checkbox"/>
All sealants have been neatly applied along joints	Confirmed	YES	<input checked="" type="checkbox"/>	NO	<input type="checkbox"/>

SIGN OFF

CLOCK No:	2400	OPERATOR SIGN:		DATE:	
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REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)







CABIN STRUCTURE QUALITY HOT CHECKLIST

Running No.:		Updated By:	Jonathan Chetty
Frame No.:	470	Checks Updated:	2022/08/26

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

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

Quality approval for release Signature	CO. NO:	DATE
	2285	30 May 2024