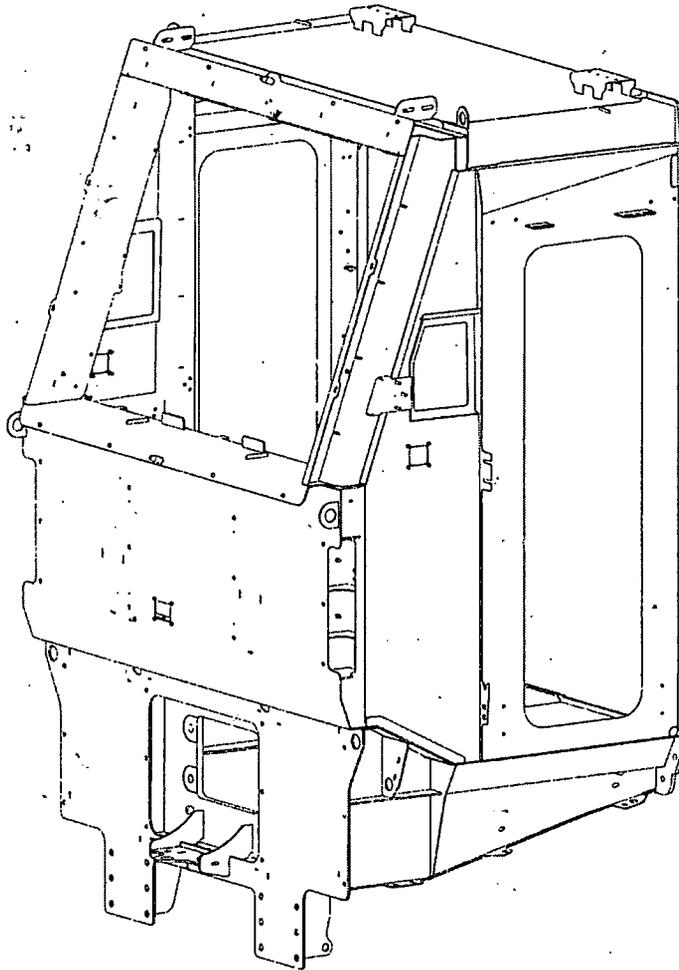


# GLOBAL

MANUFACTURING  
SOLUTIONS



## CABIN STRUCTURE QUALITY CARD

CAB No.: CAB 4 6 1   

WEIGHT: 1 4 8 9 Kg

## RAW MATERIAL TRACEABILITY

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER	PO NUMBER	TRAINSET NUMBER(S)
RCS 355	2 mm	Reganus	26/05/24	F305031 VHE 79055	LP49402	
RCS 355	2 mm					
RCS 355	2 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	3 mm	Reganus	26/05/24	F204957 VHE 73052	183653	107087 01
RCS 355	3 mm					
RCS 355	3 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	20 mm	Reganus	26/05/24	P31060 VPE03542	1896	F205272
RCS 355	20 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 355	30 mm	Reganus	26/05/24		182592	107087 01
RCS 355	30 mm					

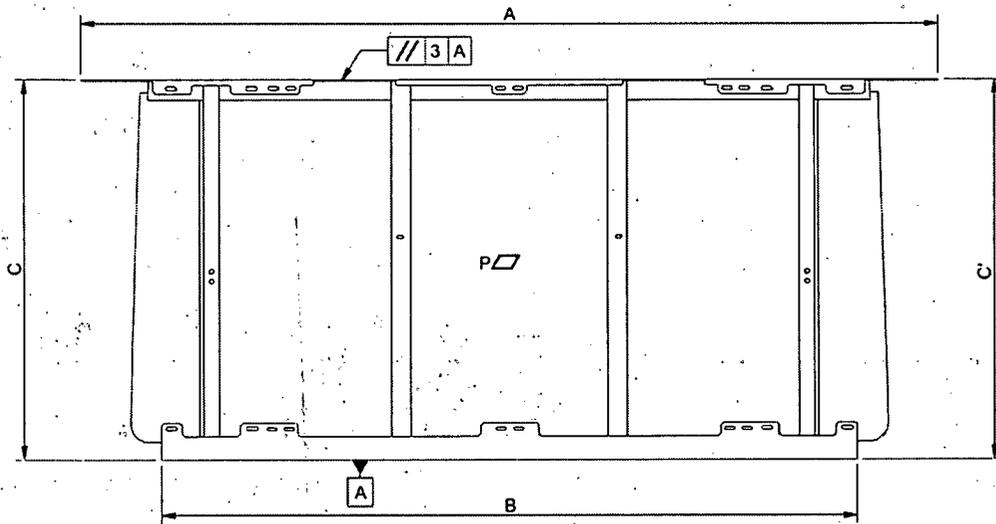
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	4 mm	Reganus	26/05/24	F207906 VHL47403	182739	107087 01
RCS 450	4 mm					
RCS 450	4 mm					
RCS 450	4 mm					

GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	6 mm	Reganus	26/05/24	F207907 VHS 62363	183446	107087 01
RCS 450	6 mm					
RCS 450	6 mm					

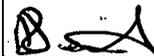
GRADE	MATERIAL THICKNESS	SUPPLIER	DATE RECEIVED	BATCH NUMBER		TRAINSET NUMBER(S)
RCS 450	8 mm	Reganus	22/05/24	F207908 VHS 62375	183451	107087 01
RCS 450	8 mm					
RCS 450	8 mm					
RCS 450	8 mm					

## Cabin Roof Assembly: GN002839

Assembly Completed as per WI/SOS MD_0046		Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	JYLAN DAVIDS	Assembly Date:	20.24/03/28		
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:	2024/03/28

### Dimensional Control

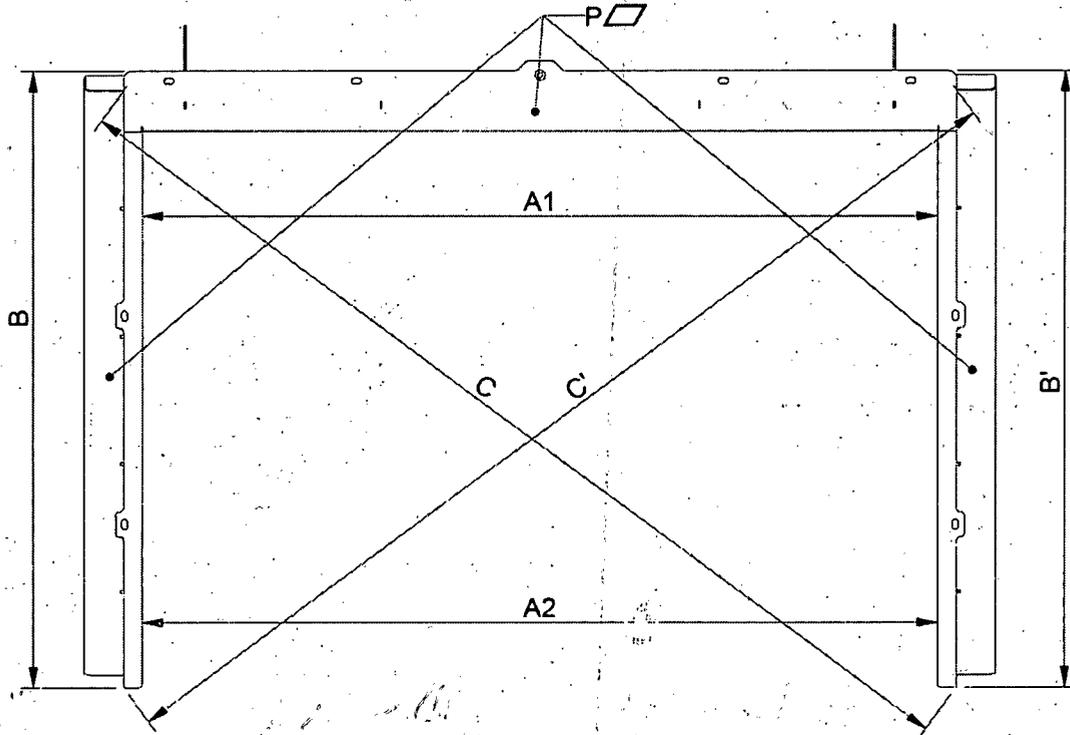
Rep	Toler.	Dimension measured		Measuring Equipment	Observations
A	2216	+5/-0	2216	Tape Measure	acceptable
B	1800	± 4	1801		acceptable
C	976	+2/-3	976      976		acceptable
QC Inspector:	Riccardo		Sign:		Date: 2024/03/28

### Geometrical Control

Nature of Checks		Dimension Measured	Measuring Equipment	Observations	
Planarity P	6 mm	Passed	Ruler	acceptable	
//	3 A	Passed	Set Square	acceptable	
QC Inspector:	Riccardo		Sign:		Date: 2024/03/28

## Cabin Front Frame Assembly: GN002840

Assembly Completed as per WI/SOS MD_0047	Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator: <i>Bowbello Gcinan</i>	Assembly Date:	2024/04/02		
Sign: <i>[Signature]</i>	Wire Batch No.:	SS2033		



### 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:	20__/__/__		

### Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations		
A1	1910	± 2	1911		Tape Measure	acceptable		
A2	1910		1911			acceptable		
B	1475	± 1	1474	1474		acceptable		
C	Diagonals  C - C'  ≤ 3		2476	2475		acceptable		
QC Inspector:	<i>Riccardo</i>		Sign:	<i>[Signature]</i>		Date:	2024/04/02	

### Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations				
P: Planeity	4 mm	<i>Passed</i>	Ruler	acceptable				
QC Inspector:	<i>Riccardo</i>		Sign:	<i>[Signature]</i>		Date:	2024/04/02	

**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	
Operator:	<i>Kande</i>	Assembly Date:	2024/03/25			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

**Cabin LHS/RHS Cantrail Assembly: GN002924/GN002907**

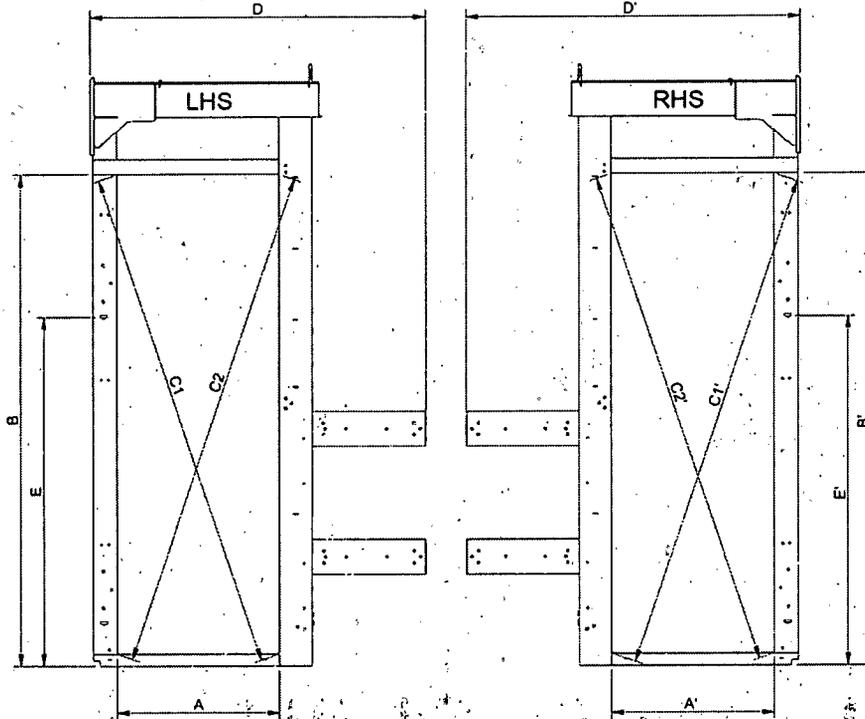
Assembly Completed as per WI/SOS MD_0065_0066		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>Glenn</i>	Assembly Date:	2024/03/20			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			

**Cabin LHS/RHS Door Post Assembly: GN002919/GN002897**

Assembly Completed as per WI/SOS MD_0067_0078		Confirmed	Yes	<input checked="" type="checkbox"/>	No	
Operator:	<i>Glenn</i>	Assembly Date:	2024/03/20			
Sign:	<i>[Signature]</i>	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:	2024/03/22	
Sign:	<i>Glenn</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>RA</i>	Date: 2024/03/25

### Dimensional Control

Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	695	± 2	696	697	Tape Measure	acceptable
B	2086	+1/-3	2085	2084		acceptable
C1 / C2	Difference of diagonals		2151	2150		acceptable
C1 - C2	C1 - C2  ≤ 3		2150	2153		acceptable
D )	1438	+2/-3	1438	1436		acceptable
E			1482	1482		

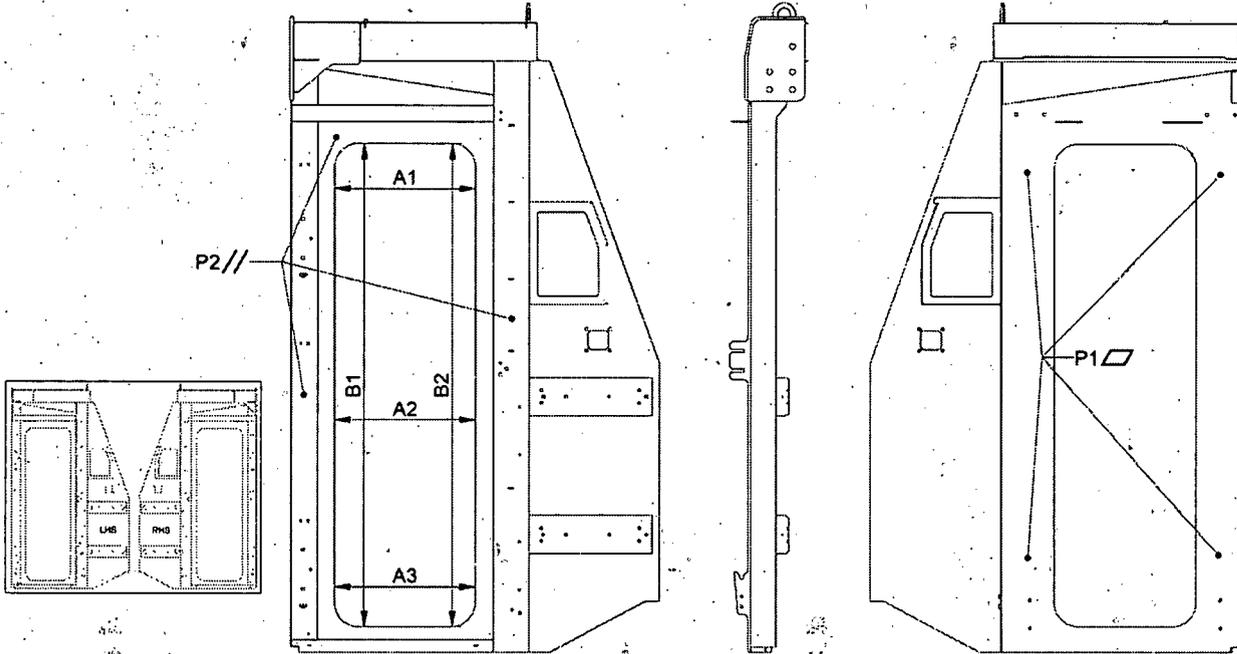
QC Inspector:	Riccardo	Sign:	<i>RA</i>	Date:	2024/03/25
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### Geometrical Control

Nature of checks		Dimension Measured	Measuring Equipment	Observations
P1 : planeity of 2 edges	4 mm	PassGo	Ruler	acceptable
QC Inspector:	Riccardo	Sign:	<i>RA</i>	Date: 2024/03/25

## Cabin LHS/RHS Side Assembly: GN002838/GN002837

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Kander</i>	Assembly Date:	2024/03/26			
Sign:	<i>[Signature]</i>	Wire Batch No.:	552033			



### Welding Control

Assembly Completed as per WI/SOS MD_0044_0045		Confirmed	Yes	<input type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/03/28	

### Dimensional Control

Rep.	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A1			558	558	Tape Measure.	<i>acceptable</i>
A2	560	± 2	560	560		<i>acceptable</i>
A3			560	560		<i>acceptable</i>
B1	1900	± 2	1898	1898		<i>acceptable</i>
B2			1898	1898		<i>acceptable</i>

QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/03/28
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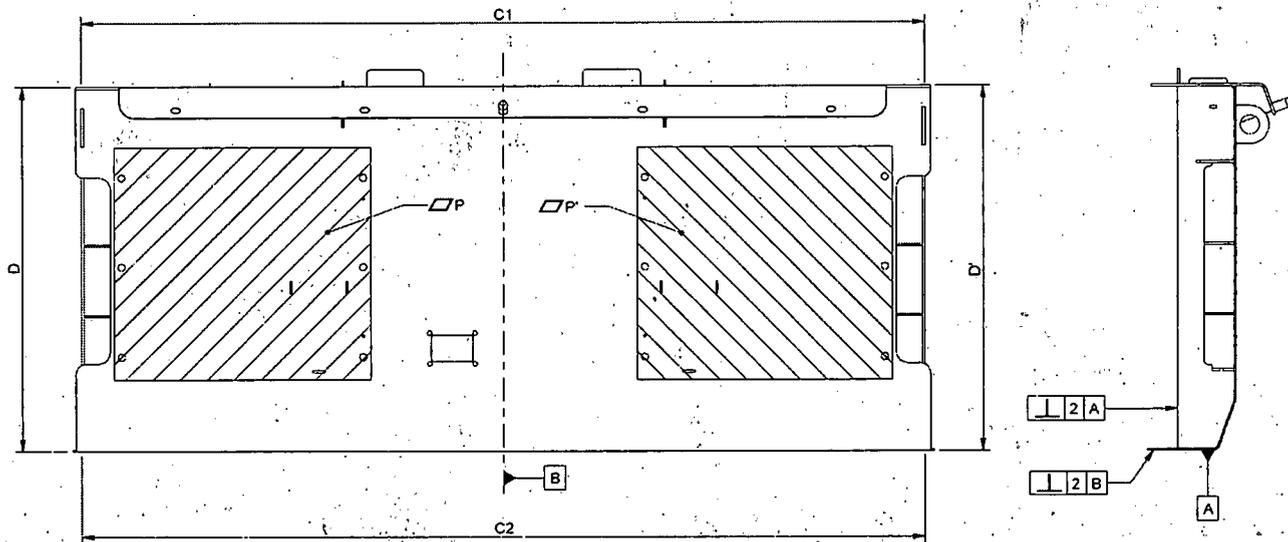
### Geometrical Control

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

QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/03/28
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## Cabin Shield Assembly: GN002836

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	Bambelo Grimaldi	Assembly Date:	20 24/04/02			
Sign:		Wire Batch No.:	582033			



### Welding Control

Assembly Completed as per WI/SOS MD_0043		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
QC Inspector:	Riccardo	Sign:		Date:	2024/04/02	

### Dimensional Control

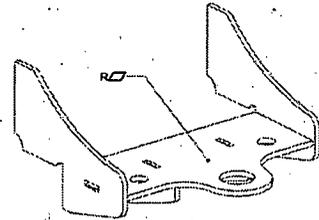
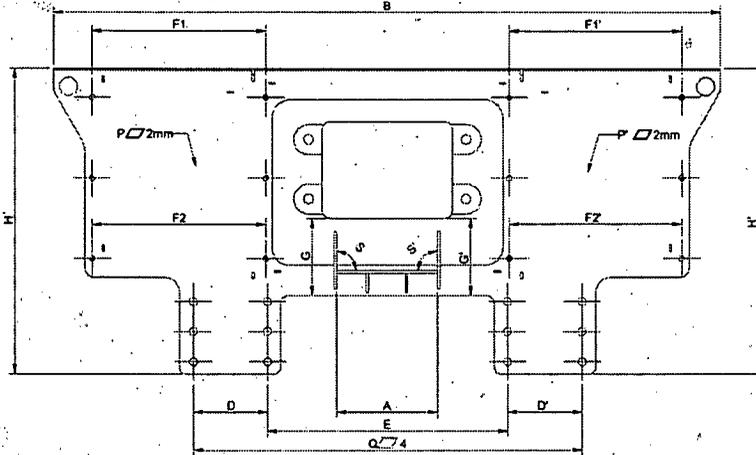
Rep	Theoretical Dim	Toler.	Dimension measured		Measuring Equipment	Observations
C1 / C2	2210	± 4	2213	2214	Tape Measure	acceptable
D / D'	956	± 2	956	955		acceptable
QC Inspector:	Riccardo		Sign:			Date: 2024/04/02

### Geometrical Control

Nature of Checks			Dimension Measured		Measuring Equipment	Observations
Planarity P / P'	2	2 mm	Passed		Ruler	acceptable
Perpendicularity	2	A	Passed		Set Square	acceptable
	2	B	Passed		Set Square	acceptable
QC Inspector:	Riccardo		Sign:			Date: 2024/04/02

## Cabin Front Headstock Assembly: GN002841

Assembly Completed as per WI/SOS MD_0019		Confirmed	Yes	No
Operator:	<i>TK BOOTH</i>	Assembly Date:	2024/03/25	
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	No
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date: 2024/03/25

### Dimensional Control

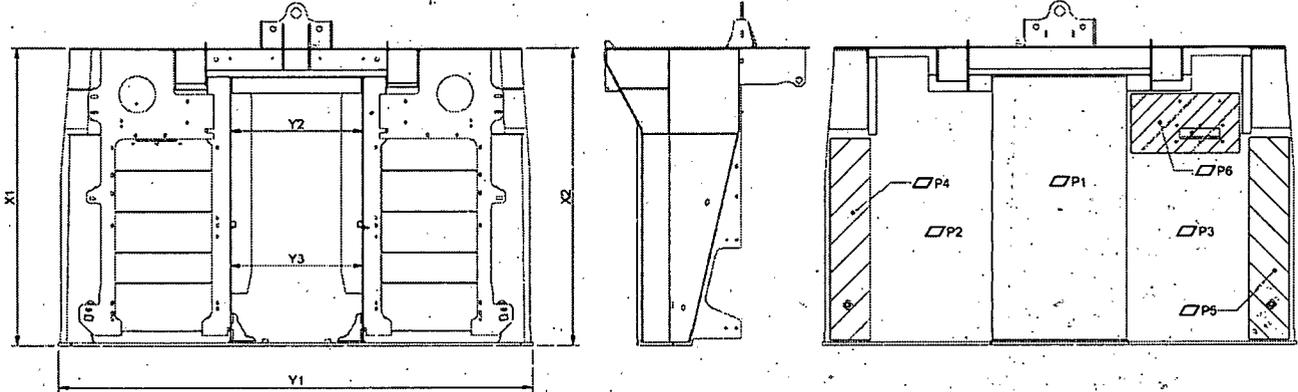
Rep	Theoretical Dim	Toler.	Dimension Measured		Measuring Equipment	Observations
A	340	± 1	340		Tape Measure	acceptable
B	2240	± 4	2244			acceptable
D / D'	250	± 1	250	251		acceptable
E	808	± 2	808			acceptable
F1 / F1'	580	± 1	581	581		acceptable
F2 / F2'			58	581		acceptable
G / G'	258	± 1	258	259		acceptable
H / H'	1019	± 2	1020	1020		acceptable
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>	Date:	2024/03/25	

### Geometrical Control

Nature of checks	Dimension Measured	Measuring Equipment	Observations
O: Planity of global assembly	4 mm	Ruler	acceptable
P / P': Planity	2 mm	Ruler	acceptable
Q: Planity Surface of Supports	4 mm	Ruler	acceptable
R: Planity Coupler Support	2 mm	Ruler	acceptable
S: Perpendicularity coupler	1 mm	Square	acceptable
QC Inspector:	<i>Riccardo</i>	Sign:	<i>[Signature]</i>
Date:	2024/03/25		

## Cabin Underframe Assembly: GN002835

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
Operator:	<i>Michael Wood</i>	Assembly Date:	2024/03/28	
Sign:	<i>[Signature]</i>	Wire Batch No.:	2202/52	



### Welding Control

Assembly Completed as per WI/SOS MD_0042		Confirmed	Yes	No
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date: 2024/03/28

### Dimensional Control

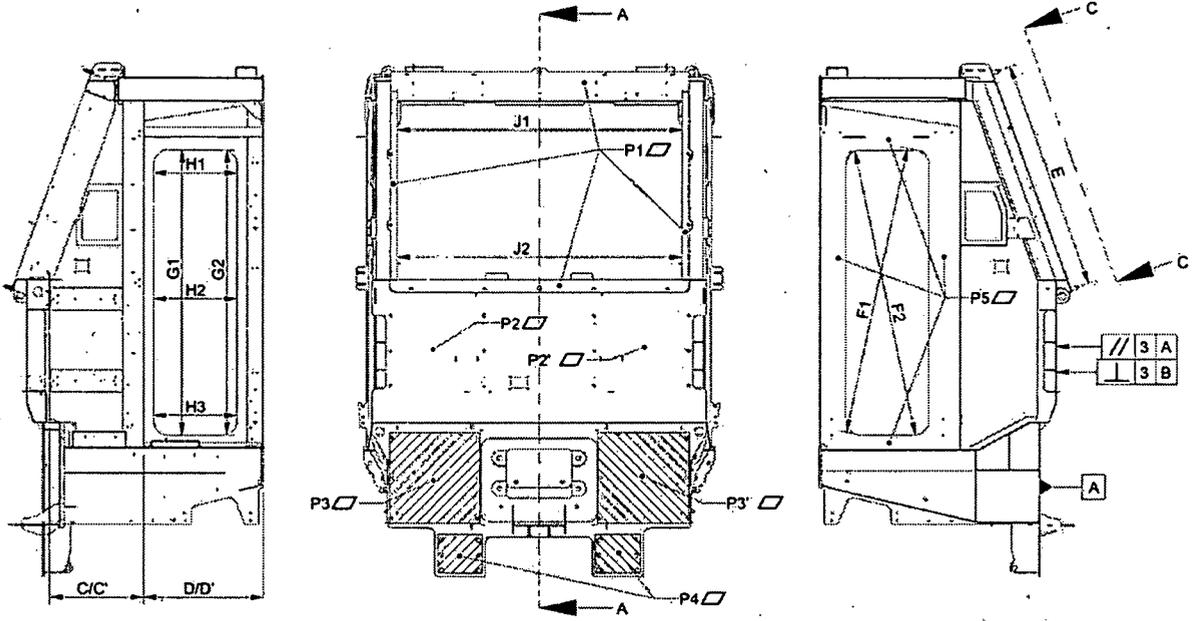
Rep	Theoretical Dim	Tolér.	Dimension Measured		Measuring Equipment	Observations
X1 / X2	1485	+5 / -2	1486	1486	Tape Measure	<i>[Signatures]</i>
Y1	2354	± 3	2352			
Y2 / Y3	666	± 1	666	668		
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>	Date:	2024/03/28	

### Geometrical Control

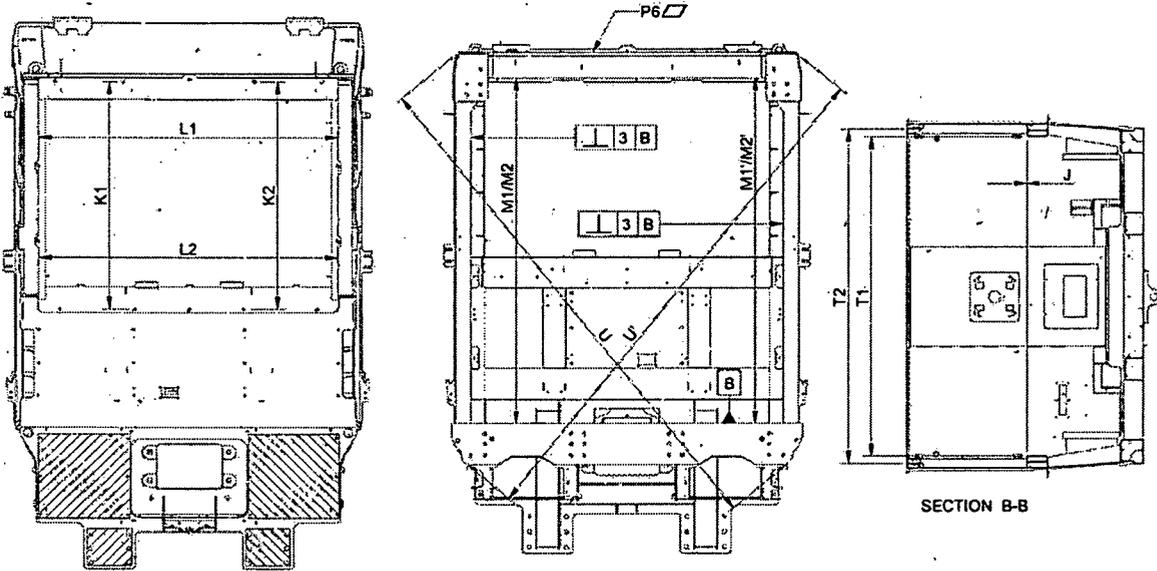
Nature of checks	Dimension Measured	Measuring Equipment	Observations
P1 : Planeity	4 mm	Ruler	<i>Pass</i>
P2 / P3 : Planeity	4 mm	Ruler	<i>Pass</i>
P4 / P5 : Planeity	2 mm	Ruler	<i>Pass</i>
P6 : Planeity	2 mm	Ruler	<i>Pass</i>
QC Inspector:	<i>LEON</i>	Sign:	<i>[Signature]</i>
			Date: 2024/03/28

# Cabin Structure Assembly: GN002834

Assembly Completed as per WI/SOS MD_0039		Confirmed	Yes	No
Operator:	<i>CHARL EISEN</i>	Assembly Date:	20 24 / 09 / 03	
Sign:		Wire Batch No.:	552635	



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	<input type="checkbox"/>
QC Inspector: <b>Riccardo</b>	Sign: <b>[Signature]</b>	Date: <b>2024/04/05</b>			

**Dimensional Control**

Rep	Theoretical Dim	Toler.	LHS / Dimension Measured / RHS		Observations
C / C'	625	±2	625	625	acceptable
D / D'	813	±2,5	813	813	acceptable
E	1531.5	±3	1531		acceptable
G1 / G'1	Height 1900	+1	1898	1897	acceptable
G2 / G'2		-3	1898	1897	acceptable
H1 / H'1	Width 560	+1	558	558	acceptable
H2 / H'2		-3	559	558	acceptable
H3 / H'3			560	559	acceptable
F1 / F'1	Diagonals 1939		1937	1938	acceptable
F2 / F'2			1937	1937	acceptable
Difference	F1-F2 / F'1-F'2	≤ 4	0	1	acceptable
J	Gap of Doors	± 1,5	1	1	acceptable
K1 / K2	1515	±3	1514	1513	acceptable
L1 / L2	1996	±3	1998	1997	acceptable
M1 / M'1	2306	±3	2477	2477	acceptable
M2 / M'2			2467	2468	acceptable
T1 / T'1	2130 Top/Bottom	±3	2130	2128	acceptable
T2 / T'2	2230 Top/Bottom		2231	2231	acceptable
Difference	U - U' (3522)	≤ 4mm	3521	3520	acceptable

QC Inspector: <b>Riccardo</b>	Sign: <b>[Signature]</b>	Date: <b>2024/04/05</b>			
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**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

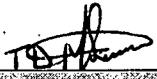
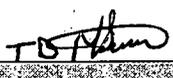
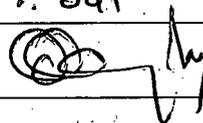
QC Inspector: <b>Riccardo</b>	Sign: <b>[Signature]</b>	Date: <b>2024/04/05</b>			
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### Cabin Bracket Assembly: GN002833

Assembly Completed as per WI/SOS MD_0091		Confirmed	Yes	<input checked="" type="checkbox"/>	No	<input type="checkbox"/>
Operator:	<i>Dumila</i>	Assembly Date:	2024/02/05			
Sign:	<i>[Signature]</i>	Wire Batch No.:	SS2-58			

### 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 __/__/__			
Sign:	<i>[Signature]</i>	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:	DAVID	Sign:		
Date:	2024/05/14			
Record of Shot Blasting				
Operator:		Date:	2024/05/14	
Start Time:	08 H 13	End Time:	13 H 07	
Temperature ( $\geq 15^\circ$ ):	20-08°C	Humidity ( $\leq 75\%$ ):	66-03	
Shot Blasting Self-Inspection				
Interior of Cabin: Sa 1 - Light Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No
When examined with the naked eye, the surface free of any trace of oil, grease and dirt, and from poorly adhering materials such as scale, rust, paint and foreign particles.	Confirmed	Yes	<input checked="" type="checkbox"/>	No
Exterior of Cabin: Sa 2 1/2 - Very Thorough Stripping	Confirmed	Yes	<input checked="" type="checkbox"/>	No
	Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DAVID	Sign:		
Date:	2024/05/14			
Shot Blasting Cleaning				
Cabin free of all sand	Confirmed	Yes	<input checked="" type="checkbox"/>	No
Operator:	DAVID	Sign:		
Date:	2024/05/14			
Shot Blasting Control				
Temperature $\geq 15^\circ$ :	20-02°C	Humidity $\leq 75\%$ :	63-06	
Internal Roughness 3.2 $\leq$ Ra $\leq$ 12.5	7.782	External Roughness 3.2 $\leq$ Ra $\leq$ 12.5	7.041	
QC Inspector:	2473	Sign:		
Date:	14/5/24			

2a 5,099  
 5,551  
 5,062  
 5,643  
 5,353  
 6,359  
 6,519  
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 34,828  
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 34,775  
 36,748  
 39,604  
 42,383  
 32,442

Record of Priming			
Start Time:	15:00	End Time:	17:00
Temperature ≥ 15°:	26°C	Humidity ≤ 75%:	43%
Paint Batch No.:	8016059	Paint Expiry Date:	08/25
Hardener Batch No.:	7331119	Hardener Expiry Date:	01/11/24
Desolvation Start Time:	17:00	Desolvation End Time:	17:15
Stoving Start Time:	17:15	Stoving End Time:	18:15
Stoving Temp:	60°C		
Operator:	MUSA	Sign:	
Date:	20/10/24		MUSA

Priming Control									
DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front			
1: 80.3	5: 56	1: 83	5: 78.6	1: 63.6	5: 66.2	1: 39	5: 40.6		
2: 74.2	6: 44	2: 33.6	6: 100	2: 113.6	6: 60.4	2: 70.6	6: 102.3		
3: 70.8	7: 41.3	3: 60	7: 86.3	3: 90.6	7: 61.2	3: 89.2	7: 70.6		
4: 96.1	8: 39.6	4: 70	8: 74.2	4: 102.8	8: 71.8	4: 78.9	8: 77.8		
Min:	39.6	Min:	33.6	Min:	60.4	Min:	39		
Max:	86.3	Max:	100	Max:	113.6	Max:	102.3		
Average:	58.5	Average:	73.2	Average:	78.5	Average:	68.6		
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside			
1: 56.7	5: 60.9	1: 100.6	5: 60.8	1: 50.3	5: 60	1: 69.8	5: 77.8		
2: 113.8	6: 102.6	2: 66.7	6: 70.6	2: 54	6: 90	2: 60.8	6: 70.4		
3: 45.6	7: 98.2	3: 78.9	7: 71.8	3: 43	7: 74	3: 74	7: 80.6		
4: 39.4	8: 110.6	4: 39.8	8: 30.6	4: 61.2	8: 50.7	4: 69.8	8: 90.6		
Min:	39.4	Min:	30.6	Min:	50.3	Min:	60.8		
Max:	113.8	Max:	100.6	Max:	90	Max:	90.6		
Average:	78.4	Average:	64.3	Average:	61	Average:	73		
DFT Exterior Front		DFT Exterior Roof		DFT Machined Base		DFT Machined Top RHS/LHS			
1: 54.6	5: 113.6	1: 54	5: 28.3	1: 77.3	5: 70.6	1: 86.1	5: 77.6		
2: 57.8	6: 104	2: 80.6	6: 76.8	2: 89.2	6: 43.6	2: 100.6	6: 43.6		
3: 83.2	7: 60.8	3: 77.8	7: 93.2	3: 93.2	7: 78.6	3: 74.6	7: 59.8		
4: 77.6	8: 74.6	4: 68.2	8: 77.6	4: 78.6	8: 39.8	4: 68.8	8: 70.6		
Min:	54.3	Min:	28.3	Min:	39.8	Min:	43.6		
Max:	113.6	Max:	93.2	Max:	93.2	Max:	100.6		
Average:	77.8	Average:	69	Average:	70	Average:	71		
Primer has been inspected and is free of defects				Confirmed		Yes		No	
QC Inspector:		Reece		Sign:		Reece			
Date:		22/10/24							

Record of Painting NCSS3010 R90B			
Start Time:	21:00	End Time:	21:30
Temperature $\geq 15^{\circ}$ :	27 $^{\circ}$ C	Humidity $\leq 75\%$ :	61%
Paint Batch No.:	8216294	Paint Expiry Date:	04/04/2025
Hardener Batch No.:	8138195113	Hardener Expiry Date:	11/26
Desolvation Start Time:	21:30	Desolvation End Time:	21:45
Stoving Start Time:	21:45	Stoving End Time:	22:45
Stoving Temp:	60 $^{\circ}$ C		
Operator:	Ntuthuko	Sign:	M. Shange
Date:	2024/05/22		

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: 180	5: 158	1: 912	5: 685	
2: 113	6: 152	2: 735	6: 823	
3: 129	7: 190	3: 817	7: 103	
4: 157	8: 163	4: 101	8: 955	
Min:	133	Min:	685	
Max:	190	Max:	103	
Average:	155	Average:	818	
Painting NCSS3010 R90B has been inspected and is free of defects			Confirmed	
GMS-SOS-GIBELA-PS-002 Gloss Test			Value	
QC Inspector:	Zothile		Sign:	[Signature]
Date:	24 May 2024			

**Record of Painting Blue NCSS1565 B**

Start Time:	03:00	End Time:	03:30
Temperature ≥ 15°:	031°C	Humidity ≤ 75%:	64%
Paint Batch No.:	8216288	Paint Expiry Date:	27.03.2025
Hardener Batch No.:	8138195113	Hardener Expiry Date:	11/26
Desolvation Start Time:	03:30	Desolvation End Time:	03:45
Stoving Start Time:	03:45	Stoving End Time:	04:45
Stoving Temp:	60°C		
Operator:	ntutuko	Sign:	
Date:	2024/05/23		

**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: 97.6	5: 133	1: 106	5: 99.5			
2: 97.1	6: 100	2: 99.7	6: 76.4			
3: 98.1	7: 178	3: 101	7: 99.1			
4: 99.8	8: 122	4: 89.4	8: 106			
Min: 97.1		Min: 89.4				
Max: 178		Max: 106				
Average: 115		Average:				
Painting NCSS3010 R90B has been inspected and is free of defects						Confirmed
GMS-SOS-GIBELA-PS-002 Gloss Test				Value		
QC Inspector:	Zothile			Sign:		
Date:	24 May					

**Record of RAL 7012**

Start Time:	14:00	End Time:	16:00
Temperature ≥ 15°:	30°C	Humidity ≤ 75%:	58
Paint Batch No.:	8196593	Paint Expiry Date:	16-02-25
Hardener Batch No.:	8138195113	Hardener Expiry Date:	11/26
Solvation Start Time:	16:00	Desolvation End Time:	16:15
Stoving Start Time:	16:15	Stoving End Time:	17:15
Stoving Temp:	60°C	Sign:	MUSA
Operator:	MUSA		
Date:	2024/05/22		

**RAL 7012 Control**

DFT Interior RHS		DFT Interior LHS		DFT Floor		DFT Interior Front	
1: 104	5: 118	1: 143	5: 104	1: 146	5: 9914	1: 818	5: 8018
2: 111	6: 9611	2: 9916	6: 120	2: 106	6: 9111	2: 7513	6: 102
3: 908	7: 9611	3: 9510	7: 808	3: 944	7: 141	3: 156	7: 9811
4: 127	8: 9611	4: 8012	8: 118	4: 8610	8: 9010	4: 118	8: 140
Min:	9018	Min:	8012	Min:	8610	Min:	7513
Max:	127	Max:	143	Max:	146	Max:	156
Average:	104	Average:		Average:	106	Average:	106
DFT Interior Roof		DFT Exterior LHS		DFT Exterior RHS		DFT Underside	
1: 108	5: 103	1: 152	5: 9913	1: 152	5: 143	1: 8718	5: 143
2: 102	6: 9919	2: 102	6: 9815	2: 119	6: 144	2: 9212	6: 9011
3: 8318	7: 104	3: 124	7: 161	3: 133	7: 154	3: 9115	7: 122
4: 120	8: 144	4: 9913	8: 9815	4: 115	8: 160	4: 174	8: 148
Min:	8318	Min:	9815	Min:	115	Min:	8718
Max:	144	Max:	152	Max:	160	Max:	174
Average:	107	Average:	109	Average:	140	Average:	118
DFT Exterior Front		DFT Exterior Roof		GMS-SOS-GIBELA-PS-001 Adhesion Test			
1: 111	5: 170	1: 9218	5: 198				
2: 101	6: 128	2: 108	6: 158				
3: 942	7: 124	3: 946	7: 174				
4: 127	8: 180	4: 122	8: 167				
Min:	942	Min:	9218	Confirmed <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No <input type="checkbox"/>			
Max:	180	Max:	198				
Average:		Average:	129				

Painting NCSS3010 R90B has been inspected and is free of defects

GMS-SOS-GIBELA-PS-002 Gloss Test  
 QC Inspector: Zahile  
 Date: 24 May 2024

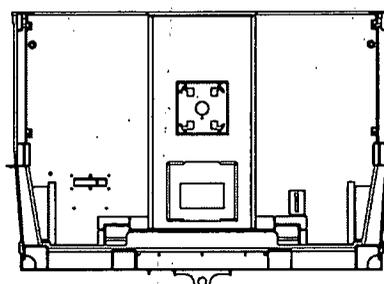
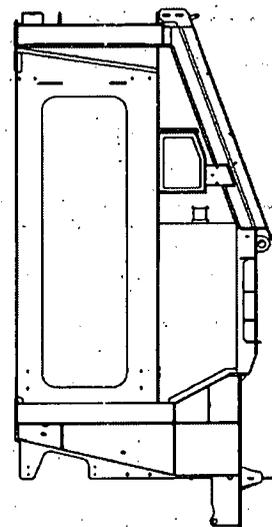
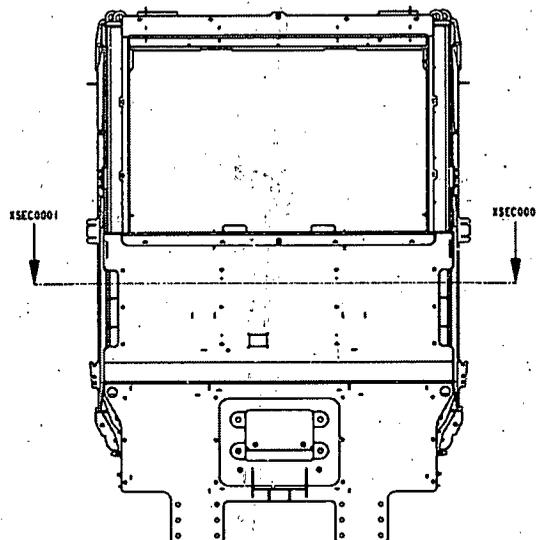
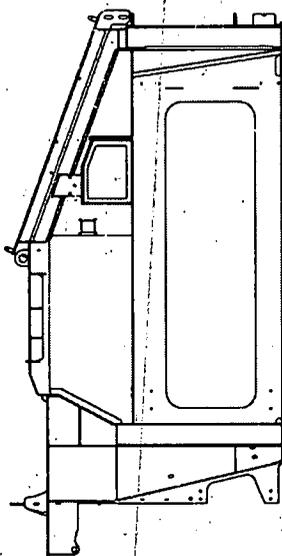
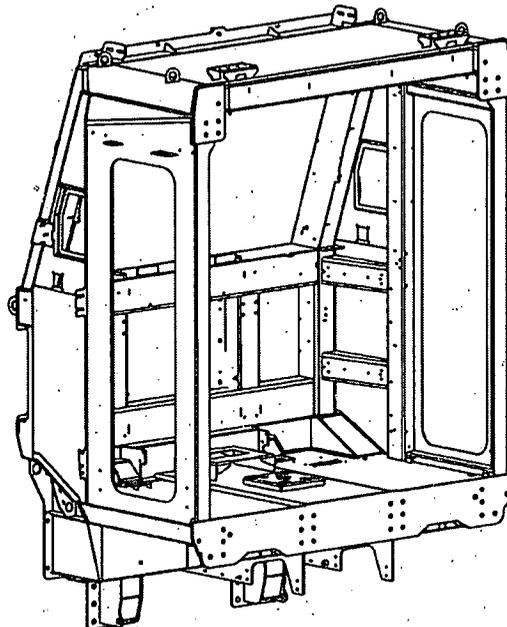
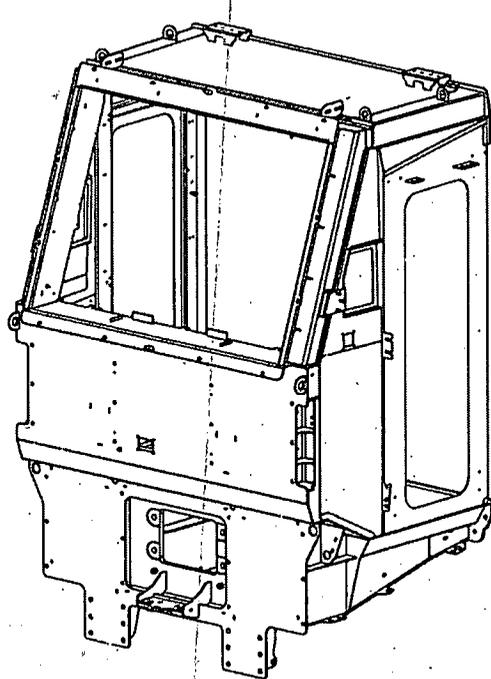
SEALING OF CABIN  
 All areas where there is no welding has been sealed with SIKA  
 All sealants have been neatly applied along joints

CLOCK No: 2458 OPERATOR SIGN: M. Kellaw DATE: 24 May 2024

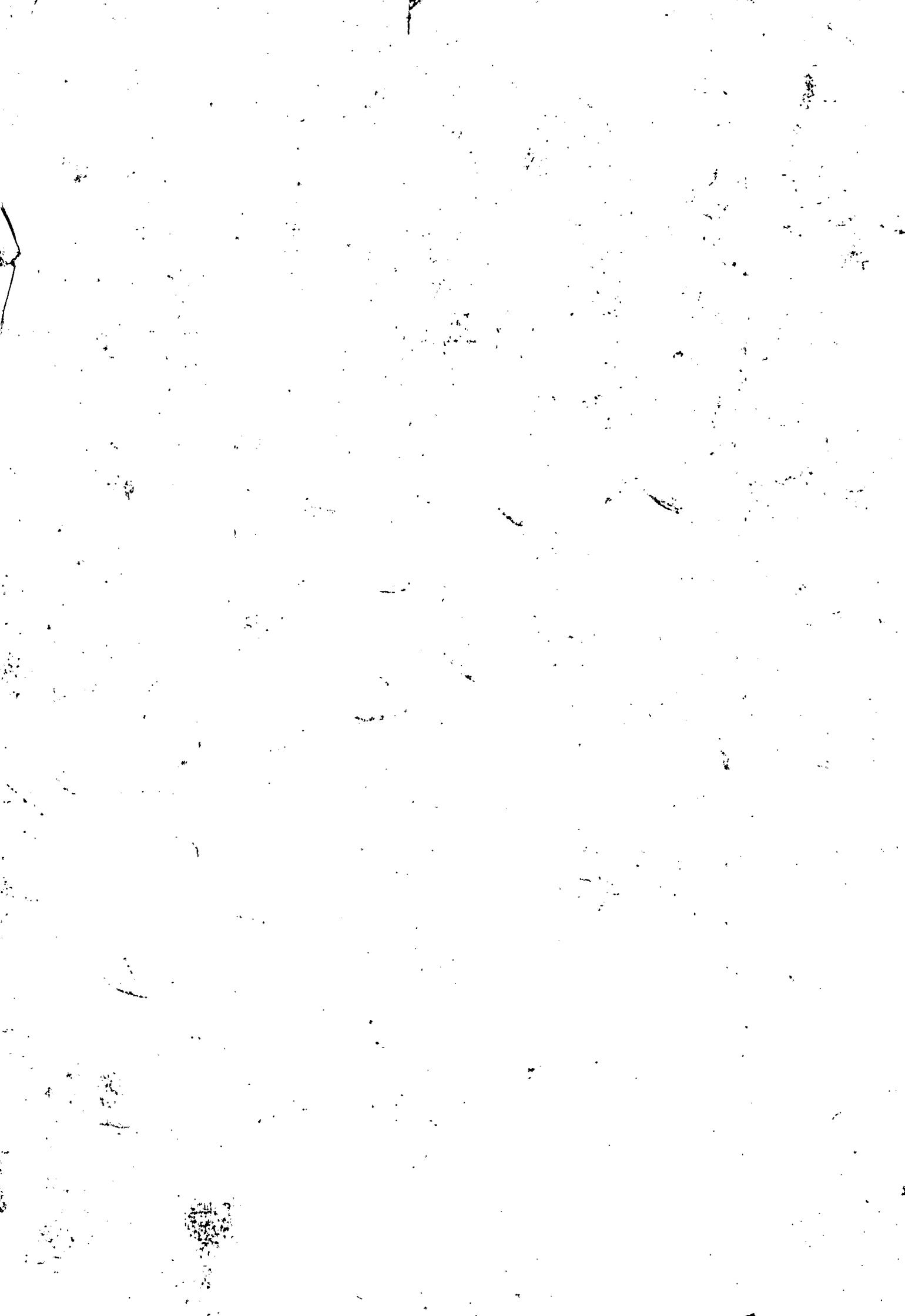


# REWORK IDENTIFICATION

(MARK SECTIONS EFFECTED NUMERICALLY)









# CABIN STRUCTURE QUALITY HOT CHECKLIST

<b>Running No.:</b>		<b>Updated By:</b>	Jonathan Chetty
<b>Frame No.:</b>	461	<b>Checks Updated:</b>	2022/08/26

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

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

<b>Quality approval for release Signature</b>	<b>CO. NO:</b>	<b>DATE</b>
ASB	2291	27/08/24