SELF INSPECTION SHEET

APPLICATION REFERENCE

MOUNTING		DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?
				TC1	M4	M1	M2	M3	TC2		
☐	DTR3-PROCE-14	LEVELLING, WEIGHTING AND BALANCING M CAR	FT1140		1	1	1	1		PRA.FT1140.04	YES
☐	DTR3-PROCE-14	LEVELLING, WEIGHTING AND BALANCING TC CAR	FT1140	1	i				1	PRA.FT1140.05	YES
☐	DTR3-PROCE-17	LEVELLING, WEIGHTING AND BALANCING TC CAR	FT1140	1	1	1	1	1	1	PRA.FT1140.05	YES
☐	DTR3-PROCE-17	LEVELLING, WEIGHTING AND BALANCING TC CAR	FT1140	1	1	1	1	1	1	PRA.FT1140.05	YES
☐											
☐											
☐											

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
7	2/11/2020	UPDATE OF AIR TIGHTNESS TEST TIME FROM 4 MIN TO 5 MIN. ADD PANTOGRAPH AIR TIGHTNESS.	APPROVER	GIVEN SILOWA	2/11/2020
			CHECKER	SIMON MOKOENA	2/11/2020
			COMPILER	COMFORT MALATJI	2/11/2020
8	9/13/2021	ADDING GAUGE MEASUREMENT CHECK ON THE SI.	APPROVER	MAKOFANE LUCY	9/13/2021
			CHECKER	RATAU EDISON	9/13/2021
			COMPILER	TSAKANI KHOSA	9/13/2021
9	5/31/2022	pressure valve (APV) Isolation	APPROVER	MAKHURUPETJI THABANG	5/31/2022
			CHECKER	HAZEL MGIBA	5/31/2022
			COMPILER	RATAU EDISON	5/31/2021

TUE	CAR	OPERATOR NAME	DATE	SELF INSPECTION NUMBER	PAGES
TS 234	M4	Sandie	04.07.29	**SI.FT1140.52**	01/08

GIBELO	SELF INSPECTION INDUSTRIAL QUALITY	Rev:09 Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

Car:	NCR:	Work Station	FT1140

Safety Related

I - Document and Instrument Control

I.1 - Documents control

Document	TG1	M1	M2	M3	M4	TG1	Revision	Remark	OK	NOK	Signature/Date
PRA.FT1140.04											
PRA.FT1140.05					✓				✓		04.07.24
PRA.FT1140.05											

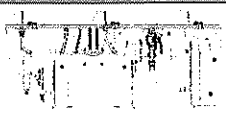
I.2 - Instruments Control - Monitoring and Measuring Instrument Control (Used for all instrument with calibration needed)

Instruments description	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date
Measuring tape	GIBTA 0276	26.10.23 - 26.10.24	✓		
Venier Caliper	GIBVR 0060	06.09.23 - 06.09.24	✓		
Torque Wrench 320 N.m	A96900177	19.12.23 - 19.12.24	✓		
Torque Wrench 150 N.m	TS8121766	21.12.23 - 21.12.24	✓		
Torque Wrench 35 N.m	D25110283	21.12.23 - 21.12.24	✓		

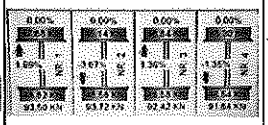
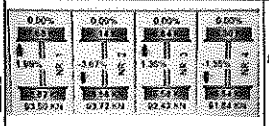
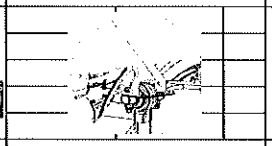
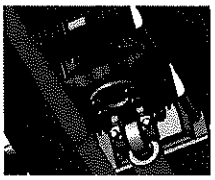
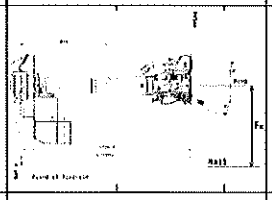
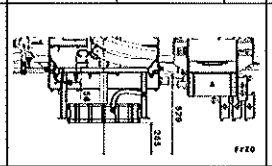
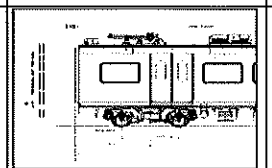
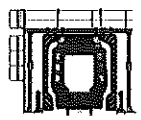
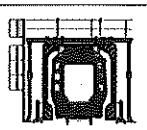
GIBELA	SELF INSPECTION INDUSTRIAL QUALITY	Rev:09 Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

II - Self Inspection - Items to Check

II.1 - Items to Check

Item	Picture/Sketch	Description	Criteria/Record	OK	Note	Pending	Signature/Date
01		Ensure that the average pressure valve (APV) is isolated by capping the two input pipes at the fittings installing the blanking fitting on the pipes highlighted		✓			04-07-24
02		Check underframe pipe system Air tightness Test performance according to WI PRA.FT1130.15.	The test was performed and no leak was observed. Initial pressure (IP): 10.05 bar Final pressure (FP): 10.02 bar FP - IP = 10.03 bar APPROVAL CRITERIA: After 5 minutes the pressure cannot drops more than 0,2 bar	✓			04-07-24
03		Movement performed at least 50m to shudder the car. And position on the leveled load cell, with wheels on the center.		✓			04-07-24
04		Measurement Inspection was done with car on condition AW0 and the rail levelled. (The load cells system must be levelled and calibrated)	Calibration Validation Date __/__/__	✓			04-07-24
05		In case of the equipments not installed, equivalent weight of the item should be added in the same place to simulate the equipment. (Any simulated weight, add on pending list)	EQUIPMENT DESCRIPTION / WEIGHT (kg) Gangway / 340	✓			04-07-24
06		The pressure difference between air spring on each bogie when raise the pressure was maintened < 0.3 bar.		✓			04-07-24
07		Measuremet recorded with empty suspention and loaded are on conformity with tolerances of the project.		✓			04/07/24
08		All levelling measurements are according to the reference. (Values out of reference must be recorded on "Description of defects")		✓			04-07-24

GIBELO	SELF INSPECTION INDUSTRIAL QUALITY	Rev:09 Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

Item	Picture/Sketch	Description	Criteria/Record	OK			Signature/Date
09		Check that the leveling rods are torqued and have torque marker.		✓			04-07-24
10		The difference of weight between the left and right wheels of each axis, must be ≤ 4%. (Verify on the T&C equipment if all arrows are in green).		✓			04-07-24
11		Remove the car, move back onto the load cells and repeat the step 09. Confirm if both are in the tolerance of ≤ 4%.		✓			04-07-24
12		1 - Record shims thicknes used on rod. 2 - All screws were torqued and have torque marker.	THICKNESS (mm) I II III IV	✓			04-07-24
13		Pivot fixation	1- M20 x 90 screws with application of torque according to PRA.FT1140.04 / 05	✓			04-07-24
14		FOR TC CARS F= Height of the center of Automatic coupler F = 895mm (+5 / -10mm) (Using levelled rail)	TC CAB #1= _____ mm				N/A
15		FOR TC CARS Height of Eurobalise Antenna = 205mm(+/-10mm) (Using levelled rail)	TC CAB #1= _____ mm				N/A
16		Check pantograph piping air tightness. Test performance according to WI PRA.FT1140.17.	The test was performed and no leak was observed. -Roof piping connection fittings. -Room piping connection fittings(Roof arch and door trimming)				N/A
17		Pantograph does not come in contact with the higher height gauge when passing through.	No Contact with Pantograph and Gauge -GO Contact with Pantograph and Gauge - NO GO				N/A
18		Car does not come into contact with the gauge.	No Contact with Car and Gauge -GO Contact with Car and Gauge - NO GO	✓			04-07-24

GIBELO	SELF INSPECTION INDUSTRIAL QUALITY	Rev:09 Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

DRAFT TO MEASUREMENTS DURING LEVELLING (ALL UNITS MUST BE IN mm/bar/kg)

END#1

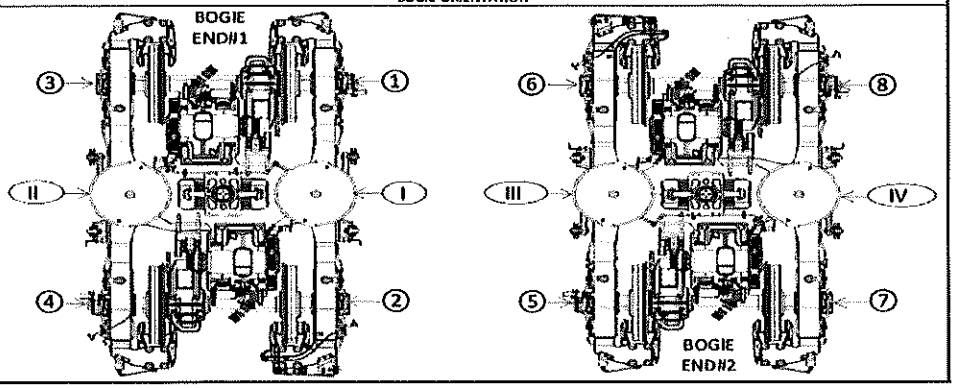
DESCRIPTION	TOLERANCE		LEFT SIDE 6	5	4	3	2	1	RIGHT SIDE 1	2	3	4	5	6	
AIR SPRING HEIGHT (EMPTY)	N/A	A`II													A`I
AIR SPRING HEIGHT (FULL)	min 254 max 261	AII					260	261	256	256					AI
FLOOR COVERING HEIGHT	min 1096 max 1116	EII													EI
AIR SPRING PRESSURE	≤ 0.3 (CI - CI)	CII					2,73	3,04	2,41	2,75					CI
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D3													D1
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D4													D2
PIVOT VERTICAL GAP	min 25 max 32	KII													KI
PIVOT LATERAL STOP GAPS DIFFERENCE	≤ 4 (JI - JI)	JII													JI
QTY OF TURNS OF LEVELLING ROD	N/A	XII					↓1								XI
SHIMS OF ANTI-ROLL BAR	N/A	YII													YI
DESCRIPTION	**TOLERANCE**		6	5	4	3	2	1	1	2	3	4	5	6	
AIR SPRING HEIGHT (EMPTY)	N/A	A`III													A`IV
AIR SPRING HEIGHT (FULL)	min 254 max 261	AIII					259	253	256	256					AIV
FLOOR COVERING HEIGHT	min 1096 max 1116	EIII													EIV
AIR SPRING PRESSURE	≤ 0.3 (CIV - CII)	CIII					2,75	2,40	3,08	2,79					CIV
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D5													D7
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D6													D8
PIVOT VERTICAL GAP	min 25 max 32	KIII													KIV
PIVOT LATERAL STOP GAPS DIFFERENCE	≤ 4 (JIV - JII)	JIII													JIV
QTY OF TURNS OF LEVELLING ROD	N/A	XIII					↑1/3			↑1					XIV
SHIMS OF ANTI-ROLL BAR	N/A	YIII													YIV

LEFT SIDE — END#2 — RIGHT SIDE

COMPARE EACH TENTATIVE WITH THE TOLERANCE AND IDENTIFY EACH MEASURE AS BELOW		
GOOD	LOWER	HIGHER
✓	↓	↑

WEIGHT COMPENSATION	
EQUIPMENT	
WEIGHT	
EQUIPMENT	
WEIGHT	
SECUNDARY MEASUREMENTS (ONLY TC CARS)	
AUTOMATIC COUPLER HEIGHT	
ANTENNA HEIGHT	

BOGIE ORIENTATION



GIBELA	SELF INSPECTION INDUSTRIAL QUALITY	Rev:09 Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

DRAFT TO MEASUREMENTS DURING LEVELLING (ALL UNITS MUST BE IN mm/bar/kg)

END#1

DESCRIPTION	TOLERANCE		LEFT SIDE 6	5	4	3	2	1	RIGHT SIDE 1	2	3	4	5	6	
AIR SPRING HEIGHT (EMPTY)	N/A	A`II													A`I
AIR SPRING HEIGHT (FULL)	min 254 max 261	AII													AI
FLOOR COVERING HEIGHT	min 1096 max 1116	EII													EI
AIR SPRING PRESSURE	≤ 0.3 (QI - QI)	CII													CI
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D3													D1
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D4													D2
PIVOT VERTICAL GAP	min 25 max 32	KII													KI
PIVOT LATERAL STOP GAPS DIFFERENCE	≤ 4 (JI - JI)	JII													JI
QTY OF TURNS OF LEVELLING ROD	N/A	XII													XI
SHIMS OF ANTI-ROLL BAR	N/A	YII													YI
DESCRIPTION	TOLERANCE		6	5	4	3	2	1	1	2	3	4	5	6	
AIR SPRING HEIGHT (EMPTY)	N/A	A`III													A`IV
AIR SPRING HEIGHT (FULL)	min 254 max 261	AIII													AIV
FLOOR COVERING HEIGHT	min 1096 max 1116	EIII													EIV
AIR SPRING PRESSURE	≤ 0.3 (QV - QII)	CIII													CIV
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D5													D7
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D6													D8
PIVOT VERTICAL GAP	min 25 max 32	KIII													KIV
PIVOT LATERAL STOP GAPS DIFFERENCE	≤ 4 (JIV - JII)	JIII													JIV
QTY OF TURNS OF LEVELLING ROD	N/A	XIII													XIV
SHIMS OF ANTI-ROLL BAR	N/A	YIII													YIV

LEFT SIDE — RIGHT SIDE

END#2

COMPARE EACH TENTATIVE WITH THE TOLERANCE AND IDENTIFY EACH MEASURE AS BELOW		
GOOD	LOWER	HIGHER
✓	↓	↑

WEIGHT COMPENSATION	
EQUIPMENT	
WEIGHT	
EQUIPMENT	
WEIGHT	
SECUNDARY MEASUREMENTS (ONLY TC CARS)	
AUTOMATIC COUPLER HEIGHT	
ANTENNA HEIGHT	

BOGIE ORIENTATION

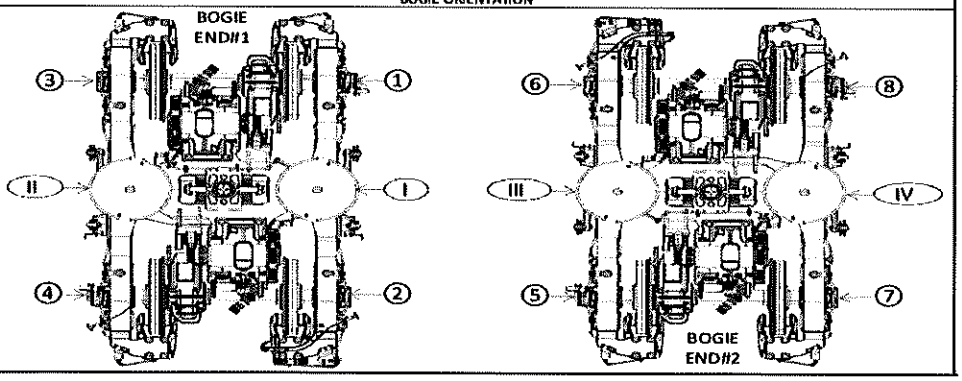


Table 1 - Reference Values and Measurement Tolerances for the Car Levelling.

ITEM			THEORETICAL VALUES											
			TC1 CAR		M4 CAR		M3 CAR		M2 CAR		M3 CAR		TC2 CAR	
			Tbct	Tbint	MB1	MB1	MB1	MB2	MB2	MB1	MB1	MB1	Tbint	Tbct
Pivot lateral stop gaps difference [mm]	$J_1=J_2=J$ (±2%)	Fig. 4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4
Air Spring height [mm]	A_e (±2%)	Fig. 5	255^{-6}_{-4}	255^{-6}_{-4}	255^{-6}_{-4}	255^{-6}_{-4}	255^{-6}_{-4}	255^{-6}_{-4}	255^{-6}_{-4}	255^{-6}_{-4}	255^{-6}_{-4}	255^{-6}_{-4}	255^{-6}_{-4}	255^{-6}_{-4}
Air spring pressure at AWD [Bar]	$C_1 = C_4$	Fig. 5	3,76 (Ref.)	2,82 (Ref.)	2,87 (Ref.)	2,83 (Ref.)	3,02 (Ref.)	2,91 (Ref.)	3,07 (Ref.)	2,85 (Ref.)	2,83 (Ref.)	2,87 (Ref.)	2,83 (Ref.)	3,76 (Ref.)
	$C_2 = C_3$		0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.	0,3 Max.
Primary Suspension gaps [mm]	$D_1; D_5$ $D_2; D_6$ $D_3; D_7$ $D_4; D_8$	Fig. 6	35^{+2}_{-3}	35^{+2}_{-3}	35^{+2}_{-3}	35^{+2}_{-3}	35^{+2}_{-3}	35^{+2}_{-3}	35^{+2}_{-3}	35^{+2}_{-3}	35^{+2}_{-3}	35^{+2}_{-3}	35^{+2}_{-3}	35^{+2}_{-3}
Carbody Floor height [mm]	E_n (±2%)	Fig. 7	1106^{-10}_{-10}	1106^{-10}_{-10}	1106^{-10}_{-10}	1106^{-10}_{-10}	1106^{-10}_{-10}	1106^{-10}_{-10}	1106^{-10}_{-10}	1106^{-10}_{-10}	1106^{-10}_{-10}	1106^{-10}_{-10}	1106^{-10}_{-10}	1106^{-10}_{-10}
Bolster height [mm]	N_n (±2%)	Fig. 7	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}	850^{-3}_{-7}
Coupling End height [mm]	F_1	Fig. 8	895 (Ref.)		760 (Ref.)		760 (Ref.)		760 (Ref.)		760 (Ref.)		895 (Ref.)	
	F_2	Fig. 9	760 (Ref.)		760 (Ref.)		760 (Ref.)		760 (Ref.)		760 (Ref.)		760 (Ref.)	
Pivot Vertical gap [mm]	K_n	Fig. 10	30^{-13}_{-3}	30^{-13}_{-3}	30^{-13}_{-3}	30^{-13}_{-3}	30^{-13}_{-3}	30^{-13}_{-3}	30^{-13}_{-3}	30^{-13}_{-3}	30^{-13}_{-3}	30^{-13}_{-3}	30^{-13}_{-3}	30^{-13}_{-3}

GIBELO	SELF INSPECTION INDUSTRIAL QUALITY	Rev:09 Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

Leveling report from Production (Final measurements after Levelling and Weighting fine)

References for secondary suspention empty
- **A'n** Air spring height empty

References for secondary suspention full
- **An** Air spring height
- **Bn** Difference between measurement A'n and An
- **En** Floor covering height
- **Cn** Air spring pressure
- **Dn** Primary suspention
- **Kn** Pivot Vertical gap
- **Jn** Pivot Lateral slop gaps difference

Item	Reference [mm]	END#1		END#2	
		Right Side	Left Side	Left Side	Right Side
A'n	N/A	A'I 244	A'II 244	A'III 246	A'IV 240
An	254 to 261	AI 260	AII 255	AIII 257	AIV 257
Bn = An - A'n	N/A	BI 16	BII 11	BIII 11	BIV 17
En	1106 ±10 mm	EI 1110	EII 1100	EIII 1105	EIV 1112

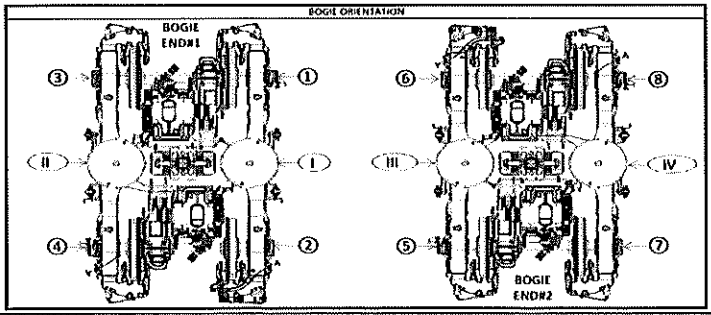
Item	Reference [bar]	END#1		END#2	
		Right Side	Left Side	Left Side	Right Side
Cn	Table 02 (*)	CI 2.72	CII 2.72	CIII 2.75	CIV 2.72
Cn - Cn+1	Diference ≤ 0,3	CI - CII 0		CIII - CIV 0,03	
Gauge serial number	N/A	GIB05873	GIB05873	GIB05873	GIB05873

Item	Reference [mm]	END#1		END#2	
		Right Side	Left Side	Left Side	Right Side
Dn	Table 01 (*)	D1 44.53	D3 44.53	D5 44.98	D8 46.02
		D2 45.51	D4 44.56	D6 45.01	D7 45.03
Kn	25 to 45	KI 36.52		KII 34.50	
Jn	Diference ≤ 4	JI 25.38	JII 25.09	JIII 24.42	JIV 25.62

(*) Reference, only include values, isn't approval criteria.

Table 01 D Theorethical Values	TC1		M4		M1		M2		M3		TC2	
	Tbex	TBin	Mb1	Mb1	Mb1	Mb2	Mb2	Mb1	Mb1	Mb1	Tbin	Tbex
D=	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}

Table 02 C Theorethical Values	TC1		M4		M1		M2		M3		TC2	
	Tbex	TBin	Mb1	Mb1	Mb1	Mb2	Mb2	Mb1	Mb1	Mb1	Tbin	Tbex
C=	3.76	2.62	2.87	2.83	3.02	2.91	3.07	2.85	2.83	2.87	2.83	3.76



Weighting report from Test and Commissioning (Final measurements after Levelling and Weighting fine)

GIBELO	SELF INSPECTION INDUSTRIAL QUALITY	Rev:09 Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

Item	Description of defects	NOK	OK	Signature/Date

II.2 - Check List REX

Check List Items

Item	Picture/Drawing	Description Description	Criteria Record	OK	NOK	N/A	Signature/Date
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX	✓			04.07.24

Self Inspection - Final Result

			Is the car good to advance to the next workstation/process? (Approval of Operations Manager/Team Leader and Industrial Quality)	DATE	NAME	SIGNATURE
HOLD POINT		GO	If activities are not complete, the missing activities must not impact the next stage!	04/07/2024	Operations Manager	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.	04/07/2024	Industrial Quality	
		NO GO	There are activites pendings that impact/stop the activities of the next process Obs: (To describe problems below)		Operations Manager	
			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		Status

Operations Manager / Team Leader

Quality Manager / Team Leader

Gibela Rail Transport Consortium RF (Pty)
Ltd
2 Shosholoza Avenue
Dunnottar X7
Ekurhuleni, 1590, South Africa
Reception: +27 (0)10 600 0651

TRAIN SET 234	
	PC09 WEIGHING REPORT

M4	Balance across front and rear bogies	Front Bogie [Tons]	Rear Bogie [Tons]	Longitudinal Imbalance [%]	Criteria Longitudinal Imbalance ≤ 3%	
		17.91	17.80	0.31%	PASS	
	Weight Mesured vs Predicted	Weight Mesured [Tons]	Weight Predicted [Tons]	Weight Difference [%]	Tolerance [%]	Criteria Min≤Diff≤Max
		35.71	35.95	0.67%	1.36%	PASS

Test Participants				
Name	Company	Department	Signature	Date
Elias	Gibela	EOC		04/07/2024