



PRASA PROJECT



# 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	MA	M1	M2	M3	TC2			
DTR3000152644	AAD0001278566	CARBODYSHELL M3, M4 ASSEMBLY	CB1210		X				X		PRA.CB1210.DTR30225 487/3.V30	YES

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018
			CHECKER	Nosizo Pindela	10/01/2018
			COMPILER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	2018/05/18
			CHECKER	Nosizo Pindela	2018/05/18
			REVISED BY	Ramokone Motama	2018/05/18
2	2018/07/04	Certain dimensional checks moved to CB1220 and CB1230	APPROVER	Itumeleng Modiba	2018/07/04
			CHECKER	Nosizo Pindela	2018/07/04
			REVISED BY	Ramokone Motama	2018/07/04
3	2018/12/12	Added dimensional check points to CB1210	APPROVER	Itumeleng Modiba	2018/12/12
			CHECKER	Nosizo Pindela	2018/12/12
			REVISED BY	Ramokone Motama	2018/12/12
5	22/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	22/01/2019
			CHECKER	Nosizo Pindela	22/01/2019
			REVISED BY	Vanessa Ntuli	22/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	21/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	21/08/2019
			CHECKER	Nosizo Pindela	21/08/2019
			REVISED BY	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	06/08/2020
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	19/04/2021
			REVISED BY	Bongane Masina	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	17/08/2021
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISED BY	Mpho Mulaudzi	17/08/2021
25	19/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	19/02/2022
			CHECKER	Andani Muthelo	19/02/2022
			REVISED BY	Andani Muthelo	19/02/2022
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
			CHECKER	Mohlampe Amogelang	14/04/2023
			REVISED BY	Mohlampe Amogelang	14/04/2023
28	07/11/2023	Added traceability for welding sections	APPROVER	Ngobeni Tyson	07/11/2023
			CHECKER	Mohlampe Amogelang	07/11/2023
			REVISED BY	Ntokozo Zwane	07/11/2023

TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
234	M4	Wesley 482833	18/06/24	SI.CB1210.254.V30	17



CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev. 28  
Date 07/11/2023

Project: PRASA  
SI.CB1210.254.V30

Car: M3 & M4

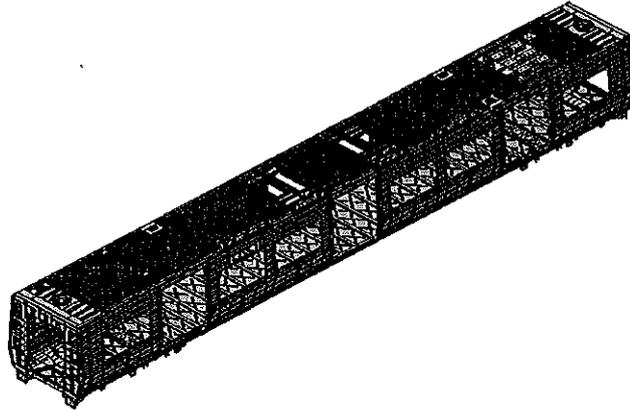
NCR:

Work station:

CB1210



Safety Related



### I - Documentation and Instruments Control

#### I.1 - Documentation Control

Document	Type of car						Revision	Observation	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
	P	M	W	R	S	B					
DTR30225487/3				X			26		✓	<i>[Signature]</i>	<i>[Signature]</i>

#### I.2 - Instruments Control

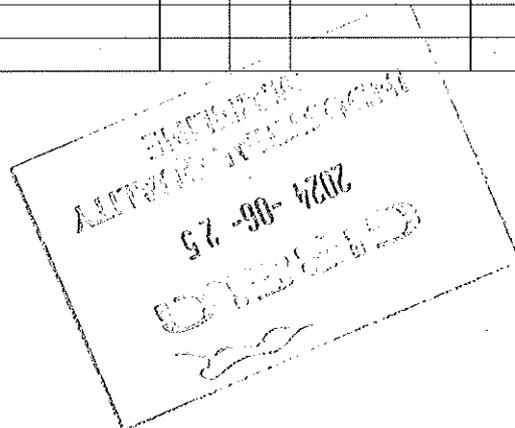
##### Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
TUBULAR	52823-2	15/03/24	✓	<i>[Signature]</i> 18/06/24	<i>[Signature]</i>
30 M TAPE	GIRTP0084	14/08/24	✓	<i>[Signature]</i> 18/06/24	<i>[Signature]</i>
LASER TAPE	125425924	08/01/24	✓	<i>[Signature]</i> 18/06/24	<i>[Signature]</i>

#### 1.3 Consumables

##### Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
AUTROD 308 LSI	122180	MIG	✓	<i>[Signature]</i> 18/06/24	<i>[Signature]</i>
ER 309 LSI	318394	MIG	✓	<i>[Signature]</i> 18/06/24	<i>[Signature]</i>





CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

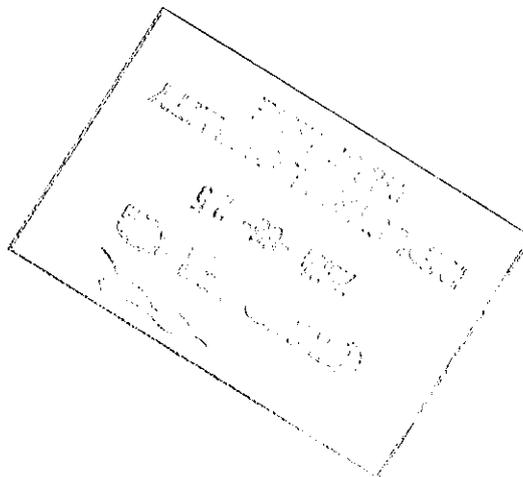
Rev. 28  
Date 07/11/2023

Project: PRASA  
SI.CB1210.254.V30

II - Self Inspection - Items to Check

H.1 - Items to check

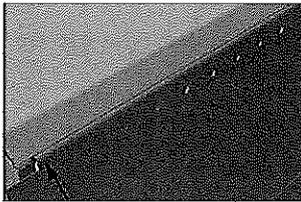
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Corshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	 15/06/24	 15/06/24
02	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	IND-SAL-WMS-016 e DTD0000210675	✓	 18/06/24	 15/06/24
03	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	 15/06/24	 15/06/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	 18/06/24	 15/06/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓	 18/06/24	 15/06/24
06	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-01B. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-01B and DTD0000210658.	✓	 18/06/24	 15/06/24



	CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V30
		Date 07/11/2023	

**Welding Traceability**

Roof ring welds



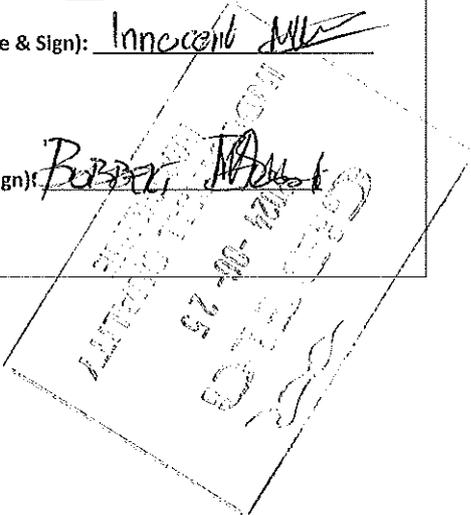
<u>LHS</u>	
Boiler maker (Name & Sign): <u>Lebogang Mphahlele</u>	Welder (Name & Sign): <u>SIPHONAZI</u>
<u>RHS</u>	
Boiler maker (Name & Sign): <u>Innocent Mli</u>	Welder (Name & Sign): <u>MITHOKOZISI</u>

Door ring welds



<u>LHS</u>
Boiler maker (Name & Sign): <u>Innocent Mli</u>
Welder (Name & Sign): <u>ROBERT MASHA</u>

<u>RHS</u>
Boiler maker (Name & Sign): <u>Innocent Mli</u>
Welder (Name & Sign): <u>ROBERT MASHA</u>

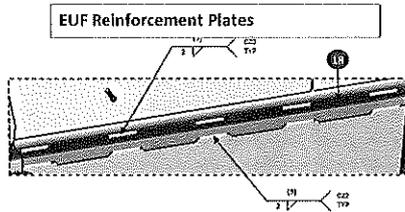
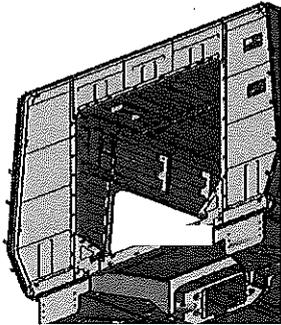




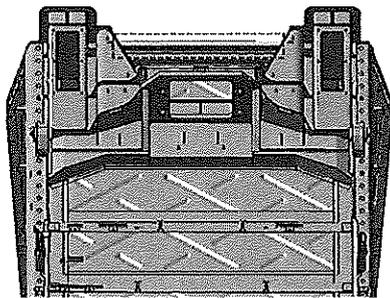
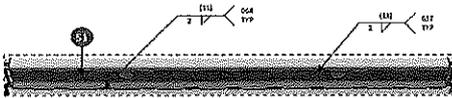
CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev.  
28  
Date  
07/11/2023

Project: PRA5A  
SI.CB1210.254.V30



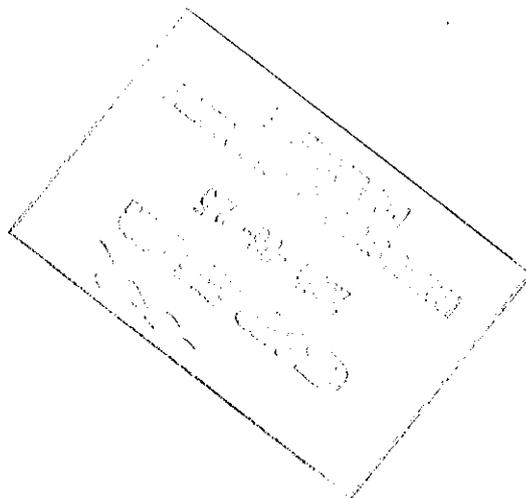
**END 1**  
Boiler maker (Name & Sign): Lawrence Wigeo  
Welder (Name & Sign): Keru Kistad

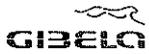


**END 2**  
Boiler maker (Name & Sign): [Signature]  
Welder (Name & Sign): Thabang Kead



**FEDOLI**  
Operator: [Signature]



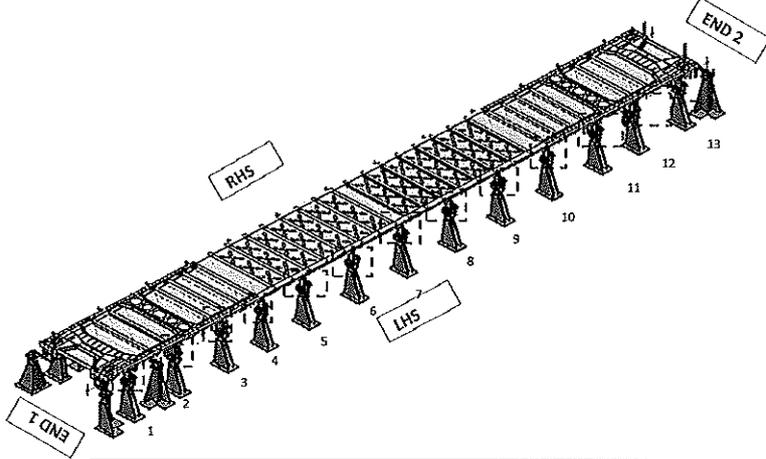


CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

Rev. 28  
Date 07/11/2023

Project: PRASA  
SI.CB1210.254.V30

Specifications of Details for CBS measurement



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

After loading and clamping

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

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0

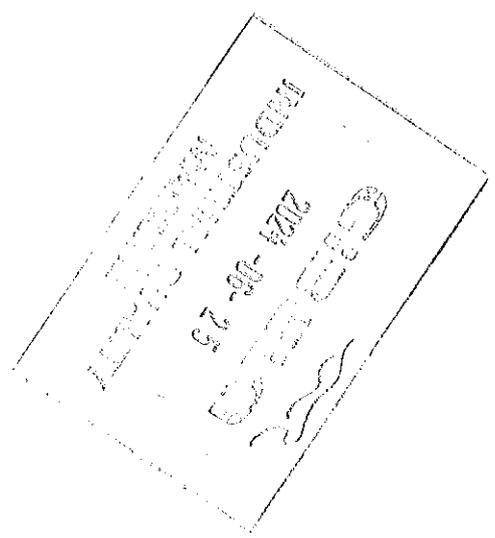
Signature Operations: Date: 18/06/24

After Weiding.

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

	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0

Signature Industrial Quality: Date: 14/06/24



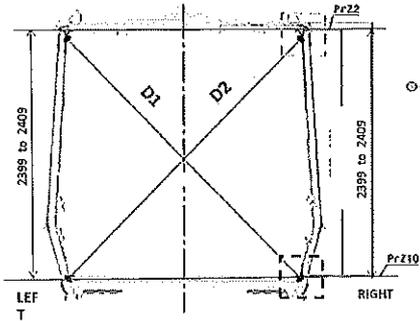
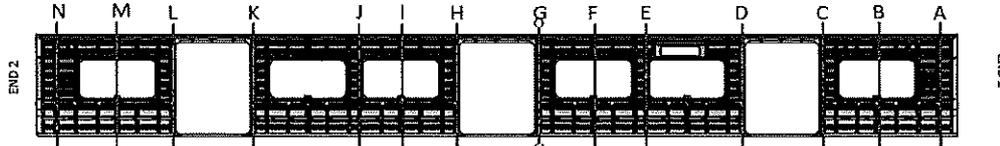


CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

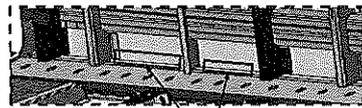
Rev. 28  
Date 07/11/2023

Project: PRASA  
SI.CB1210.254.V30

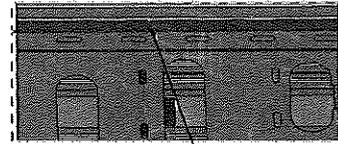
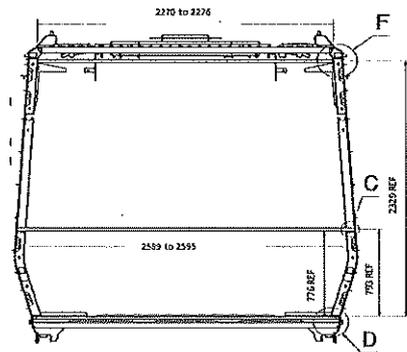
### Specifications of Details for CBS measurement



Measurement positions on roof rail and sidewall omega corner.



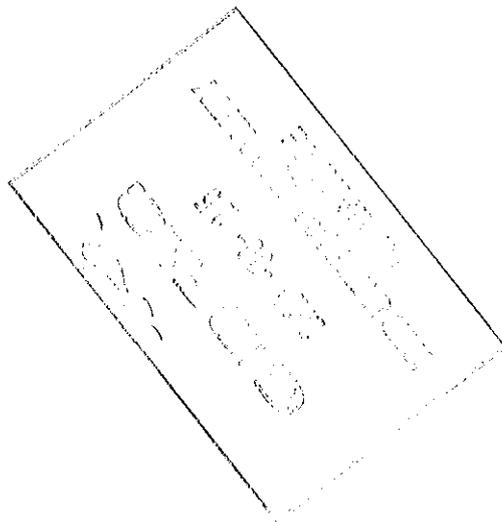
Measurement positions on sidewall and side sill corner.



Reinforcement area measurement positions on roof reinforcement area.



Detail F  
Roof reinforcement measurement



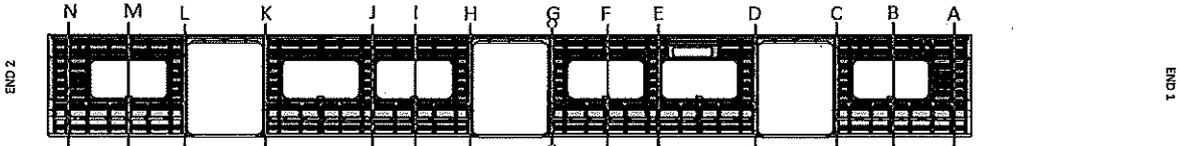


CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev. 28  
Date 07/11/2023

Project: PRASA  
SI.CB1210.254.V30

Specifications of Details for CBS measurement

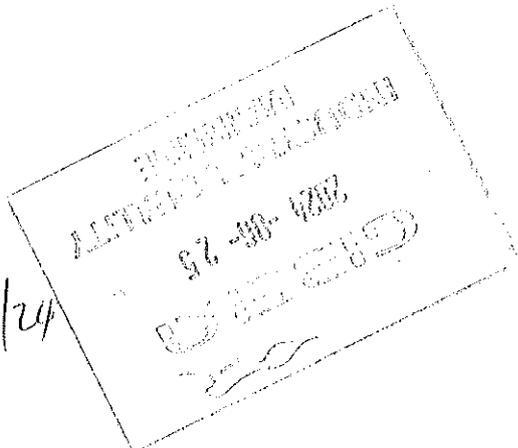


PME Column LHS - RHS should be  $\leq 2$ MM on each point.

BEFORE WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5$ mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS $\leq 2$
A	3268	3267	1	2406	2407	1
B	3265	3267	2	2405	2405	0
C	3268	3268	0	2406	2405	1
D	3269	3267	2	2404	2405	1
E	3265	3265	0	2406	2406	0
F	3264	3266	2	2405	2407	2
G	3268	3268	0	2406	2406	0
H	3268	3267	1	2404	2405	1
I	3265	3264	1	2406	2405	1
J	3266	3266	0	2406	2407	1
K	3267	3267	0	2406	2406	0
L	3268	3269	1	2405	2405	0
M	3264	3267	3	2407	2406	1
N	3268	3268	0	2406	2406	0

18/06/24



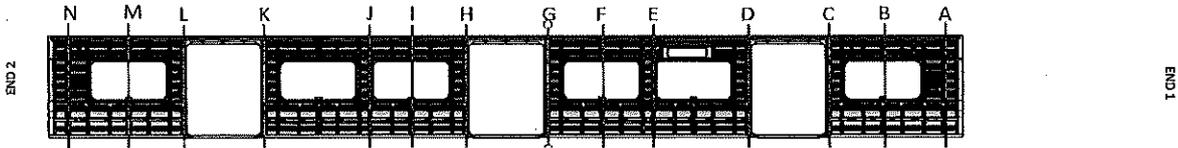


CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

Rev.  
28  
Date  
07/11/2023

Project: PRASA  
SI.CB1210.254.V30

Specifications of Details for GBS measurement



PME Column LHS - RHS should be  $\leq 2$ MM on each point.

AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 $\leq 5$ mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS $\leq 2$
A	32.95	32.94	1	2406	2406	0
B	32.66	32.08	2	2404	2405	1
C	32.95	32.94	1	2405	2407	2
D	32.94	32.94	0	2406	2405	1
E	32.65	32.65	0	2406	2404	2
F	32.66	32.65	1	2405	2405	0
G	32.96	32.94	2	2406	2405	1
H	32.95	32.95	0	2405	2405	0
I	32.64	32.65	1	2404	2406	2
J	32.66	32.66	0	2405	2406	1
K	32.94	32.94	0	2406	2404	2
L	32.95	32.94	1	2405	2405	0
M	32.68	32.65	3	2406	2405	1
N	32.94	32.94	0	2407	2406	1

18/06/24  
[Handwritten signature and stamp]



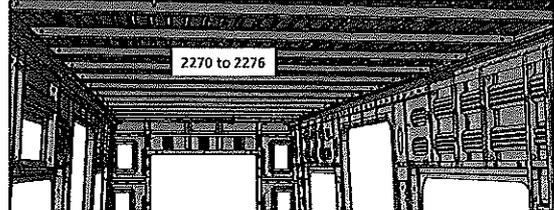
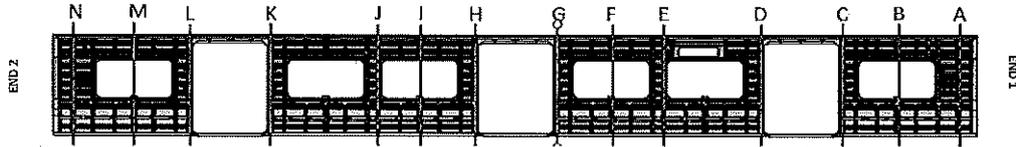
CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

Rev. 28  
Date 07/11/2023

Project: PRASA  
SI.CB1210.254.V30

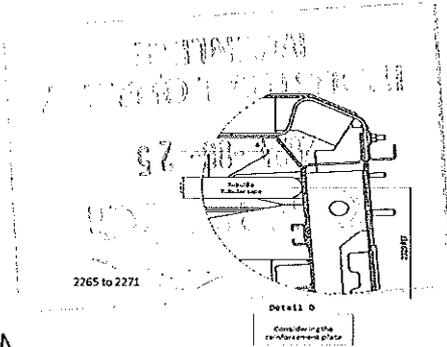
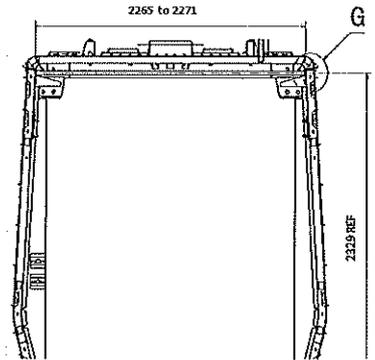
CBS measurement

BEFORE WELDING



- 2270 to 2276
- A 2271
  - B 2275
  - C 2274
  - D 2272
  - E 2278
  - F 2270
  - G 2272
  - H 2273
  - I 2276
  - J 2277
  - K 2271
  - L 2273
  - M 2274
  - N 2272

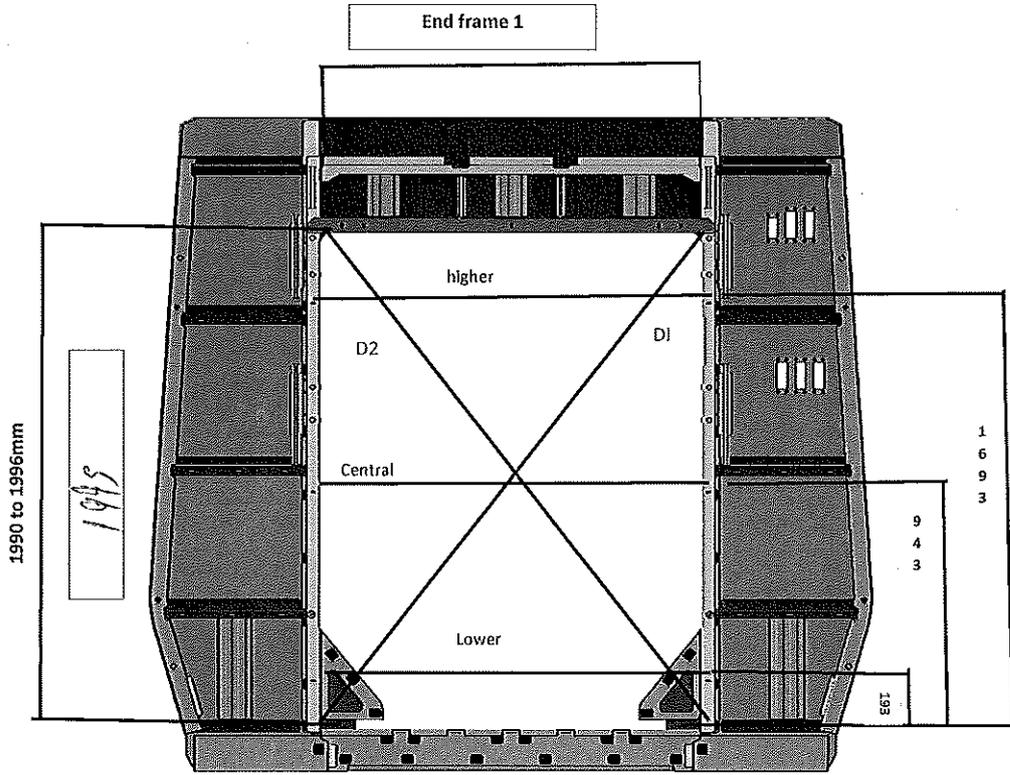
Do not consider reinforcement ( Take measurements top area of zee profile



*Handwritten signature and date: 18/06/24*



Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE D1-D2 ≤ 3mm

Higher Dimension

1381

D1

2414

Central Dimension

1381

D2

2415

Lower Dimension

1380

D1-D2

1

*[Signature]*  
18/06/24

RECEIVED  
18/06/2024  
18/06/2024

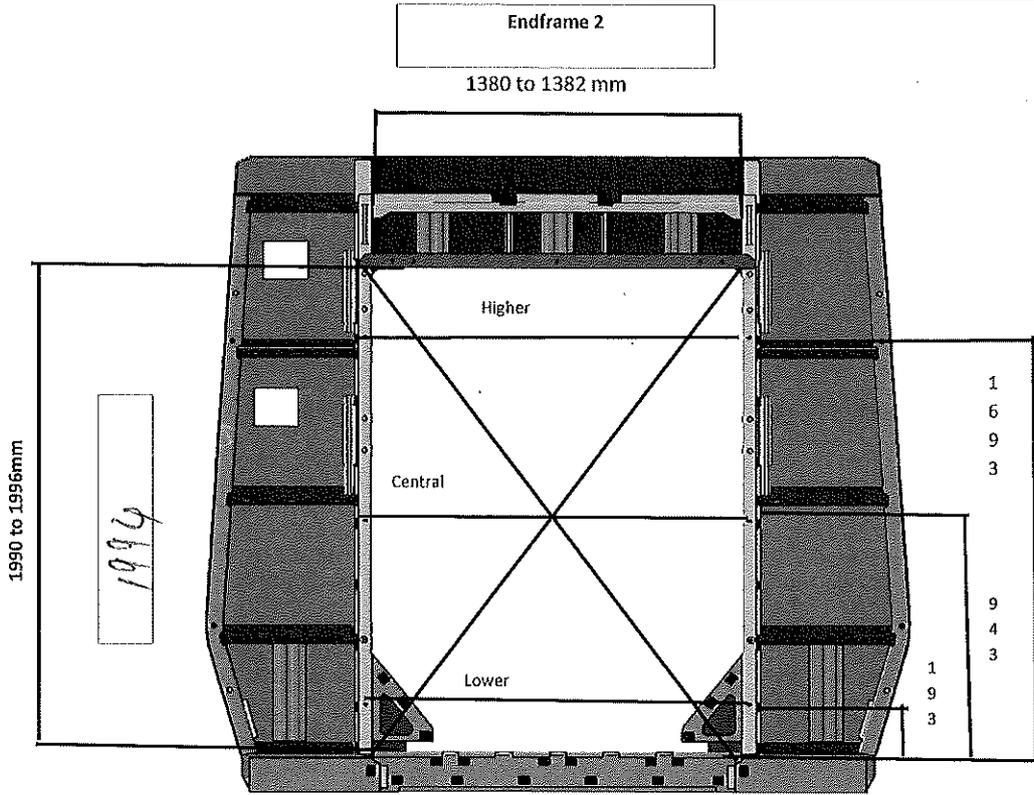


CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

Rev. 28  
Date 07/11/2023

Project: PRASA  
SI.CB1210.254.V30

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE  $D1-D2 \leq 3mm$

Higher Dimension

1382

D1

2413

Central Dimension

1381

D2

2414

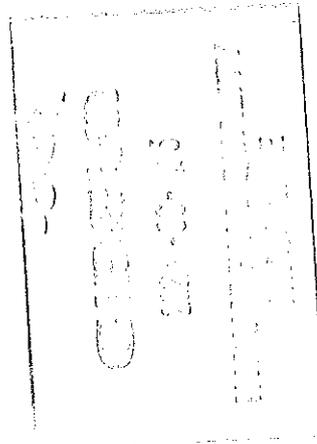
Lower Dimension

1381

D1-D2

1

18/10/24



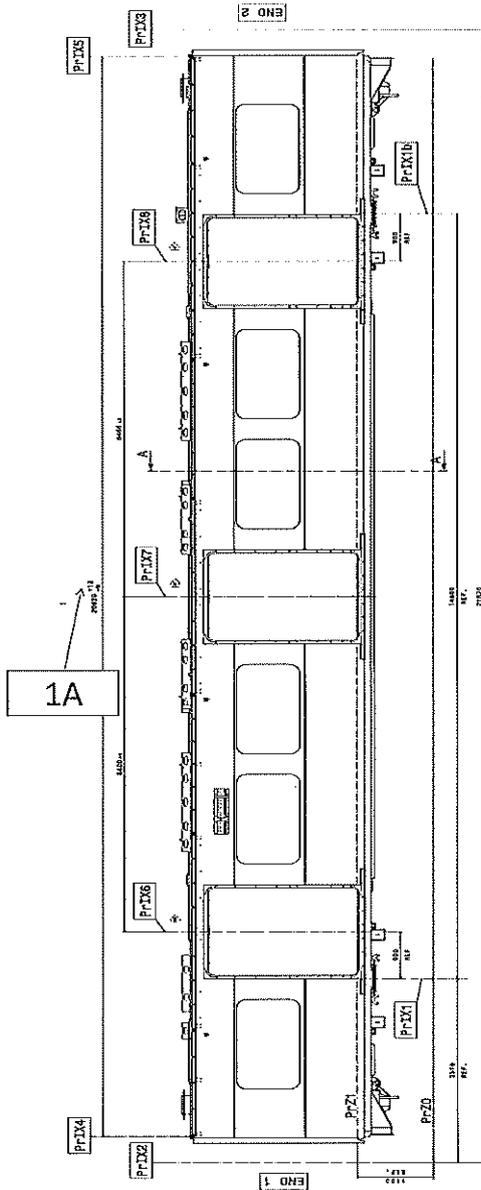


CARBODYSHELL M3,M4 ASSEMBLY DTR30226487/3

Rev. 28  
Date 07/11/2023

Project: PRASA  
SI.CB1210.254.V30

Specifications of Details for CBS measurement

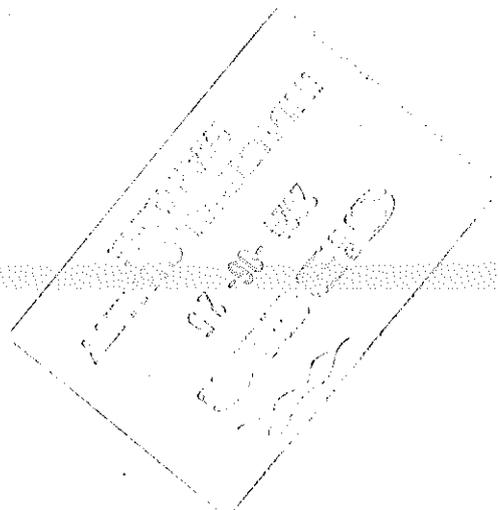


LEFT SIDE		
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20615

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

Dye penetrant test

Dye-penetration test to be performed by quality personnel







CARBODYSHELL M3,M4 ASSEMBLY DTR30225487/3

Rev. 28  
Date 07/11/2023

Project: PRASA  
SI.CB1210.254.V30

Self Inspection - Final Result

			DATE	NAME	SIGNATURE	
HOLD POINT	GO	(If activities are not complete, the missing activities must not impact the next stage)	18/06/24	Indra Operations		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	18/06/24	Ntokou Industrial Quality		
	NO GO	There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			Operations	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)				Industrial Quality

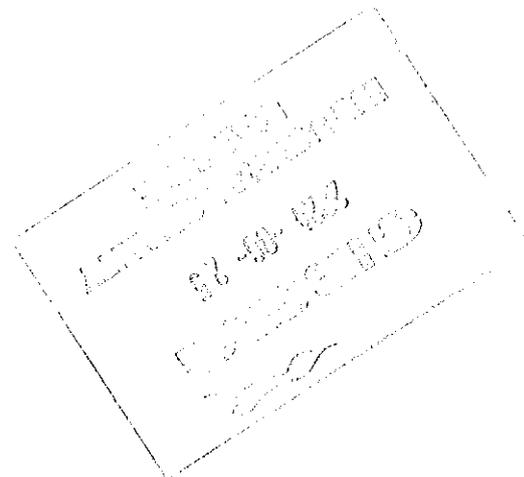
In case of "NO GO", describe blocking problems

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

Item	Description	Responsible	Due date	Status

Operations

Quality



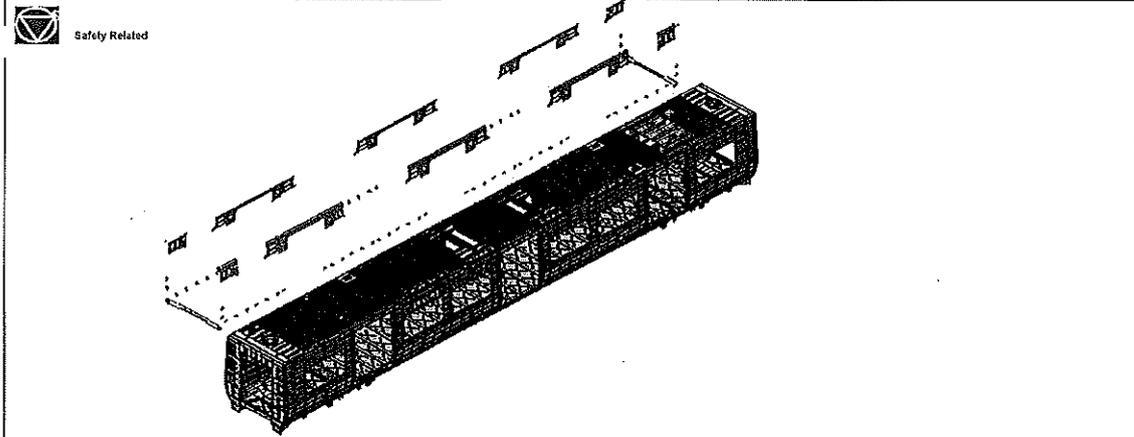


**CONFIDENTIAL INFORMATION**  
 This document and the information contemplated therein have to be considered as Confidential information pursuant to the provisions of Clause 25 of the MSA, and treated as such.

APPLICATION REFERENCE										
MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE					WORK INSTRUCTION	SAFETY ?
				TC4	MA	M1	M2	M3		
<input type="checkbox"/>	DTR3000152548	AAD0001278556	CB2220			X			PRA.CB2220.DTR3022548 7/2.V21	YES
<input type="checkbox"/>	DTR3000152549	AAD0001278556	CB2220		X	X		X	PRA.CB2220.UIN3022548 7/2.V21	YES
<input type="checkbox"/>										
<input type="checkbox"/>										
<input type="checkbox"/>										
<input type="checkbox"/>										
<input type="checkbox"/>										
REV	DATE	MODIFICATION CONTENT			RESPONSIBLE		NAME	DATE		
0	01/02/2018	GIBELA NEW CREATION			APPROVER	Itumeleng Modiba	Itumeleng Modiba	01/02/2018		
					CHECKER	Nosizo Pindela	Nosizo Pindela	01/02/2018		
					COMPILER	Thanyani Mathegu	Thanyani Mathegu	01/02/2018		
1	18/05/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager			APPROVER	Itumeleng Modiba	Itumeleng Modiba	18/05/2018		
					CHECKER	Nosizo Pindela	Nosizo Pindela	18/05/2018		
					REVISED BY	Ramokone Motama	Ramokone Motama	18/05/2018		
2	2018/07/05	Certain dimensional checks added and others moved to CB1210			APPROVER	Itumeleng Modiba	Itumeleng Modiba	2018/07/05		
					CHECKER	Nosizo Pindela	Nosizo Pindela	2018/07/05		
					REVISED BY	Ramokone Motama	Ramokone Motama	2018/07/05		
3	2018/06/12	Width tolerance as per DT0000936600			APPROVER	Itumeleng Modiba	Itumeleng Modiba	2018/06/12		
					CHECKER	Nosizo Pindela	Nosizo Pindela	2018/06/12		
					REVISED BY	Nosizo Pindela	Nosizo Pindela	2018/06/12		
5	24/01/2019	As per Baseline 10.2			APPROVER	Itumeleng Modiba	Itumeleng Modiba	24/01/2019		
					CHECKER	Nosizo Pindela	Nosizo Pindela	24/01/2019		
					REVISED BY	Vanessa Ntuli	Vanessa Ntuli	24/01/2019		
6	13/03/2019	Added D1 and D2 on Self - inspection length measurements			APPROVER	Itumeleng Modiba	Itumeleng Modiba	13/03/2019		
		Remove			CHECKER	Nosizo Pindela	Nosizo Pindela	13/03/2019		
					REVISED BY	Nosizo Pindela	Nosizo Pindela	13/03/2019		
10	22/08/2019	New Baseline 10.2.5			APPROVER	Itumeleng Modiba	Itumeleng Modiba	22/08/2019		
					CHECKER	Nosizo Pindela	Nosizo Pindela	22/08/2019		
					REVISED BY	Nosizo Pindela	Nosizo Pindela	22/08/2019		
15	06/08/2020	New Baseline 10.2.6			APPROVER	Timothy Maimela	Timothy Maimela	06/08/2020		
					CHECKER	Bongane Masina	Bongane Masina	06/08/2020		
					REVISED BY	Bongane Masina	Bongane Masina	06/08/2020		
20	19/04/2021	New Baseline change 10.3			APPROVER	Timothy Maimela	Timothy Maimela	19/04/2021		
					CHECKER	Bongane Masina	Bongane Masina	19/04/2021		
					REVISED BY	Bongane Masina	Bongane Masina	19/04/2021		
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING			APPROVER	Mbhombi collins	Mbhombi collins	17/08/2021		
					CHECKER	Mpho Mulaudi	Mpho Mulaudi	17/08/2021		
					REVISED BY	Mpho Mulaudi	Mpho Mulaudi	17/08/2021		
25	20/02/2022	New Baseline change 10.3.1			APPROVER	Collins Mbhombi	Collins Mbhombi	19/02/2022		
					CHECKER	Andani Muthelo	Andani Muthelo	19/02/2022		
					REVISED BY	Andani Muthelo	Andani Muthelo	19/02/2022		
26	14/06/2022	Update minimum temperature requirement for sealant application			APPROVER	Collins Mbhombi	Collins Mbhombi	14/06/2022		
					CHECKER	Andani Muthelo	Andani Muthelo	14/06/2022		
					REVISED BY	Andani Muthelo	Andani Muthelo	14/06/2022		
27	19/10/2022	Addition of traceability for sealant application & welding			APPROVER	Collins Mbhombi	Collins Mbhombi	19/10/2022		
					CHECKER	Ntokozo Zwane	Ntokozo Zwane	19/10/2022		
					REVISED BY	Amogelang Mohlampe	Amogelang Mohlampe	19/10/2022		
28	14/04/2023	Added sealant batch number & welding consumables traceability			APPROVER	Vanessa Ntuli	Vanessa Ntuli	14/04/2023		
					CHECKER	Ntokozo Zwane	Ntokozo Zwane	14/04/2023		
					REVISED BY	Amogelang Mohlampe	Amogelang Mohlampe	14/04/2023		
29	28/10/2023	Addition of bracket quantity			APPROVER	Ngobeni Tyson	Ngobeni Tyson	28/10/2023		
					CHECKER	Ntokozo Zwane	Ntokozo Zwane	28/10/2023		
					REVISED BY	Amogelang Mohlampe	Amogelang Mohlampe	28/10/2023		
TRAINSET	CAR	OPERATOR NAME & ALPS NO		DATE	SELF INSPECTION NUMBER		PAGES			
234	M4	Lemi 489203		19/06/2024	SI.CB2220.250.V29		13			

	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DTR30226487/2	Rev. 29	<b>Project: PRA5A</b>  <b>SI.CB2220.250.V29</b>
		Date 28/10/2023	

Car: M1,M3&M4	NCR:	Work station:	CB2220
---------------	------	---------------	--------



**I - Documentation and Instruments Control**

**I.1 - Documentation Control**

Document	Type of car					Revision	Observation	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)	
	M1	M3	M4	M3	M4							
DTR30226487/2						29	28/10/2023	X		N/A	19/06/24 LJB	19/06/24

**I.2 - Instruments Control**

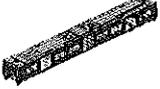
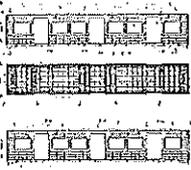
**Monitoring and Measuring Instrument Control - Used for Special Process**

Instruments	Serial number	Calibration or Verification Validation Date	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
Measuring Tape	32825-3	17/04/2024 - 17/04/2025	X	LJB 19/06/24	19/06/24
Tubular	92877042	15/03/2024 - 15/03/2025	X	LJB 19/06/24	19/06/24

**1.3 Consumables**

**Welding Consumable Control - Used for Special Process**

Filler Material	Heat Number	Welding Process	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
M Welding 308 LS1	E221880	Mig	X	19/06/24	19/06/24

GIBELQ		CARBODYSHELL M1,M3,M4 ASSEMBLY DTR30225487/2		Rev. 29 Date 28/10/2023	Project: PRASA SI.CB2220.250.V29		
<b>II - Self Inspection - Items to Check</b>							
<b>II.1 - Items to check</b>							
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK		Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA CB2220.DTR30225487/2 Verification of filament for all reinforcement brackets.	PRA.CB2220.DTR30225487/2	✓		19/06/24 LWB	19/06/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓		19/06/24 LWB	19/06/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓		19/06/24 LWB	19/06/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓		19/06/24 LWB	19/06/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓		19/06/24 LWB	19/06/24
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-038. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓		19/06/24 LWB	19/06/24
07	N/A	Before application of sealant record the expiry date and make sure that the room temperature and humidity are within specified values as per Works Instructions Specified:  Temperature Min - Max (I) Min - Max 10°C - 35°C Relative humidity Min - Max (I) Min - Max 25% - 60%	Sealant Batch No: 54324/24 Exp Date: 04/08/24  Actuals Temperature: 25°C Humidity: 40%	✓		19/06/24 LWB	19/06/24
08	NA	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓		19/06/24 LWB	19/06/24
09		Verification of safety welds	Approved according to DTD0000210658 reference and Self inspection	✓		19/06/24 LWB	19/06/24



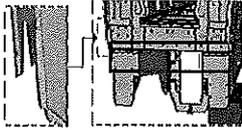
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2

Rev.  
29  
Date  
28/10/2023

Project: PRASA  
SI.CB2220.250.V29

II - Self Inspection - Items to Check

SEALANT APPLICATION



AREA 1 & 2 END 1

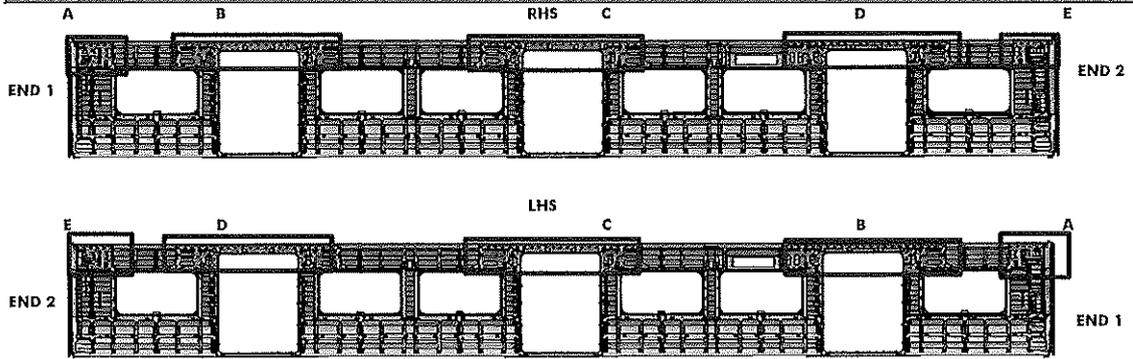
Operator (Name & sign):

*Priscilla*  
*[Signature]*

Operator (Name & sign):

*Priscilla*  
*[Signature]*

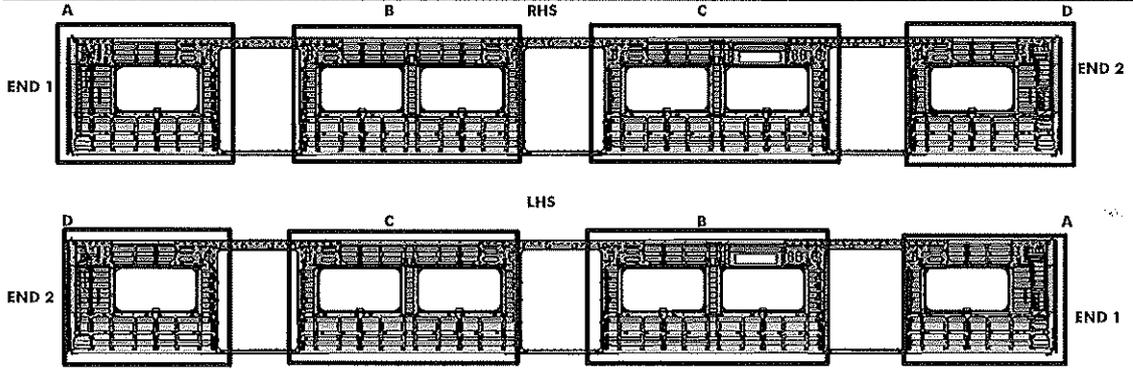
	<b>CARBODYSHELL M1,M3,M4 ASSEMBLY</b> DTR30226487/2	Rev.	Project: PRASA
		Date	SI.CB2220.250.V29
		29	28/10/2023
<b>II - Self Inspection - Items to Check</b>			



**REINFORCEMENT WELDING**

AREA	LHS	RHS
A	Operator (Name&sign): <u>LINDO [Signature]</u>	<u>LINDO [Signature]</u>
B	Operator (Name&sign): <u>LINDO [Signature]</u>	<u>LINDO [Signature]</u>
C	Operator (Name&sign): <u>MONSIEUR [Signature]</u>	<u>MONSIEUR [Signature]</u>
D	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>
E	Operator (Name&sign): <u>[Signature]</u>	<u>[Signature]</u>

**II - Self Inspection - Items to Check**



**BRACKETING**

**INSTALLATION**

C-RAILS: Operator: \_\_\_\_\_  
Operator: \_\_\_\_\_  
DOOR MECHANISMS: Operator: Tetelo  
Operator: \_\_\_\_\_  
TAPPING PADS Operator: Prusello  
Operator: \_\_\_\_\_

**INSTALLATION & VERIFICATION**

SEAT & LUGGAGE BRACKETS: Operator: M. Malozzi  
Operator: \_\_\_\_\_  
SEAT BRACKETS VERIFICATION: Operator: Levi  
Operator: \_\_\_\_\_

**WELDING**

AREA	LHS	RHS
A (Seat brackets)	Operator (Name&sign): <u>S. Madao</u>	Operator (Name&sign): <u>S. Madao</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>M. Malozzi</u>	Operator (Name&sign): <u>S. Madao</u>
B (Seat brackets)	Operator (Name&sign): <u>M. Malozzi</u>	Operator (Name&sign): <u>S. Madao</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>M. Malozzi</u>	Operator (Name&sign): <u>S. Madao</u>
C (Seat brackets)	Operator (Name&sign): <u>Gibello</u>	Operator (Name&sign): <u>S. Madao</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>S. Madao</u>	Operator (Name&sign): <u>S. Madao</u>
D (Seat brackets)	Operator (Name&sign): <u>S. Madao</u>	Operator (Name&sign): <u>S. Madao</u>
(C-rails, Luggage and earth bushes)	Operator (Name&sign): <u>S. Madao</u>	Operator (Name&sign): <u>S. Madao</u>

**ENDS**

END 1 TAPPING PADS WELDING: Operator (Name&sign): S. Madao

END 2 TAPPING PADS WELDING: Operator (Name&sign): M. Malozzi



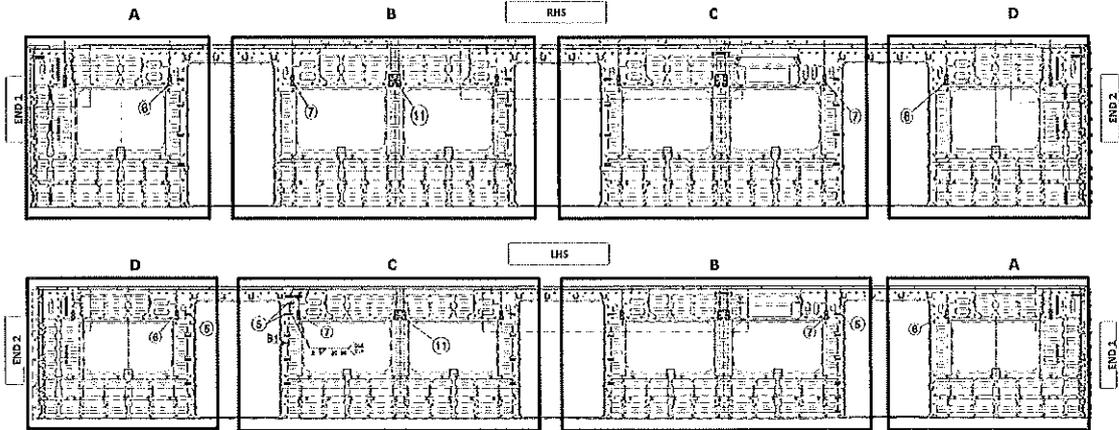
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2

Rev.  
29  
Date  
28/10/2023

Project: PRASA  
SI.CB2220.250.V29

II - Self Inspection - Items to Check

M1/M3/M4 BRACKET INSTALLATION



QUANTITIES (M3/M4)

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

ROOF ENDS:  
 CRAILS 2 OFF EACH END  
 EARTH BUSH 6 OFF EACH END  
 VERIFICATION BY: *LSB*

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

ROOF ENDS:  
 CRAILS 2 OFF EACH END  
 EARTH BUSH 6 OFF EACH END  
 VERIFICATION BY: *LSB*

QUANTITIES (M1)

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

ROOF ENDS:  
 CRAILS 2 OFF EACH END  
 EARTH BUSH 6 OFF EACH END  
 VERIFICATION BY: \_\_\_\_\_

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

ROOF ENDS:  
 CRAILS 2 OFF EACH END  
 EARTH BUSH 6 OFF EACH END  
 VERIFICATION BY: \_\_\_\_\_

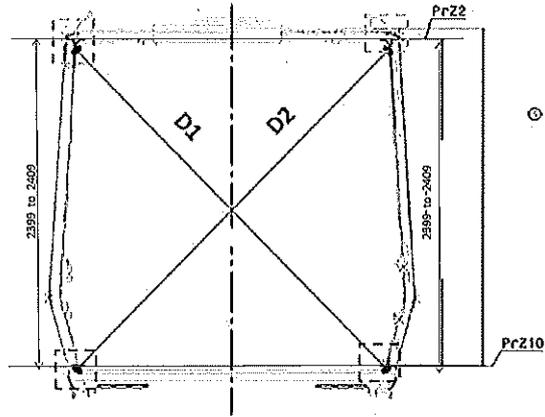


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2

Rev.  
29  
Date  
28/10/2023

Project: PRASA  
SI.CB2220.250.V29

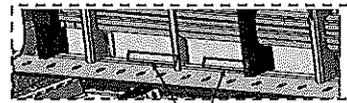
Specifications of Details for CBS measurement



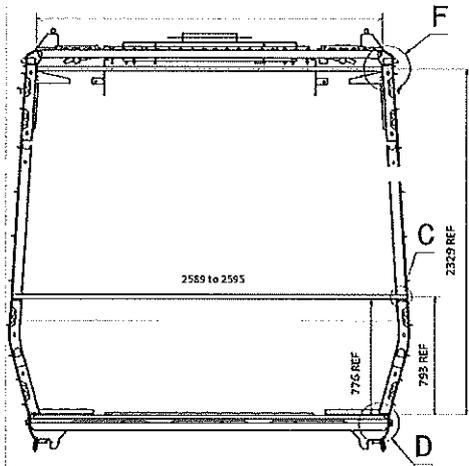
Measurement positions on roof rail and sidewall omega corner.



Reinforcement area measurement positions on roof reinforcement area.



Measurement positions on sidewall and side sill corner.



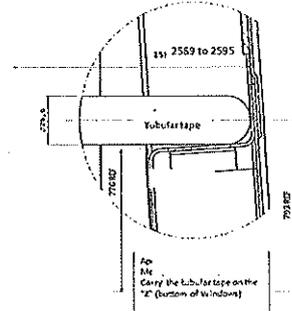
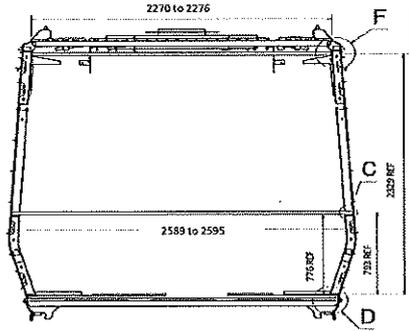


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30226487/2

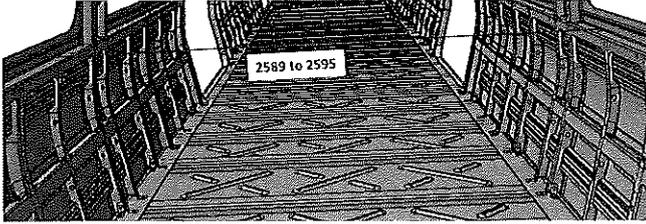
Rev.  
29  
Date  
28/10/2023

Project: PRASA  
SI.CB2220.250.V29

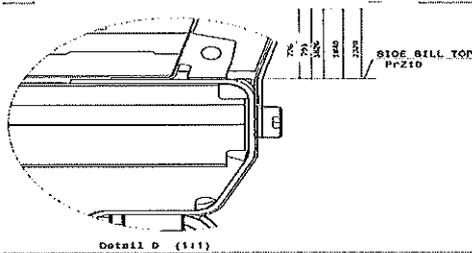
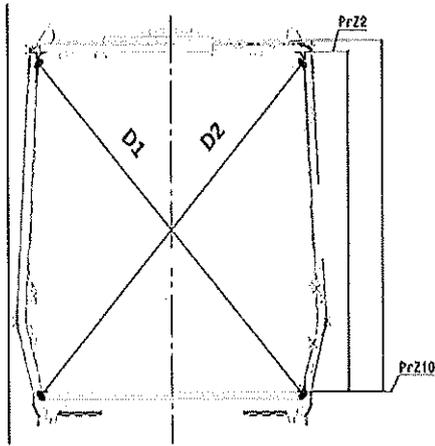
CBS measurement



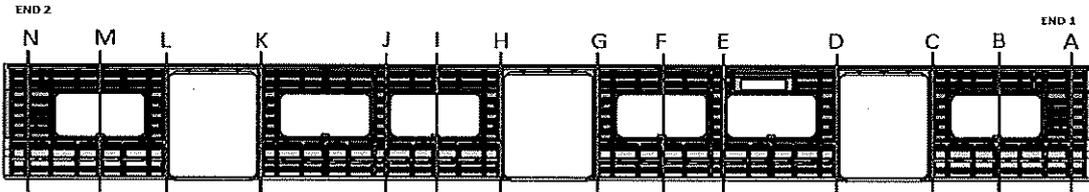
Detail C



Take measurement close to radius



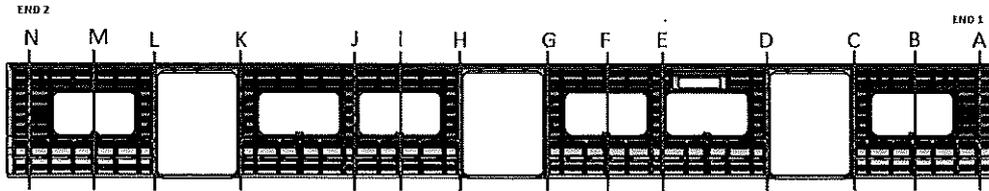
Detail D (1/1)



**BEFORE WELDING**

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3295	3295	0	-
B	3265	3264	1	-
C	3285	3286	1	-
D	3298	3298	0	-
E	3298	3294	1	-
F	3262	3266	4	-
G	3299	3299	2	-
H	3295	3300	5	-
I	3260	3267	1	-
J	3264	3267	3	-
K	3295	3297	2	-
L	3292	3298	1	-
M	3264	3267	3	-
N	3295	3297	2	-

**CBS measurement**



**AFTER WELDING**

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A	3299	3298	1	2595
B	3266	3265	1	2593
C	3294	3293	1	2592
D	3293	3292	1	2593
E	3266	3265	1	2593
F	3265	3264	1	2595
G	3297	3295	2	2591
H	3293	3295	2	2590
I	3270	3265	5	2595
J	3267	3263	4	2590
K	3295	3296	1	2590
L	3294	3294	0	2589
M	3265	3260	5	2592
N	3289	3291	2	2595

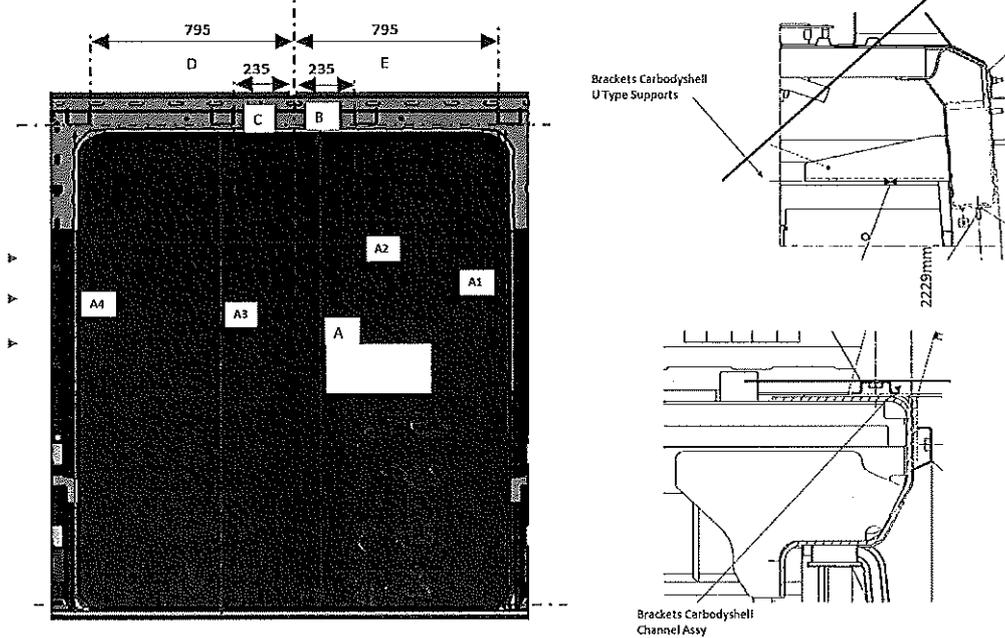


CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2

Rev.  
29  
Date  
28/10/2023

Project: PRASA  
SI.CB2220.250.V29

Specifications of Details for GBS measurement CB1220



DOOR 1 - LHS

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

DOOR 2 - LHS

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

DOOR 2 - RHS

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

DOOR 1 - RHS

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

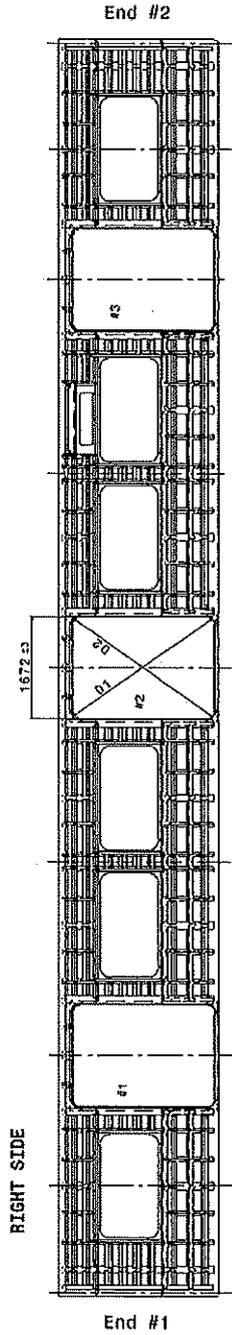
DOOR 2 - RHS

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

DOOR 3 - RHS

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

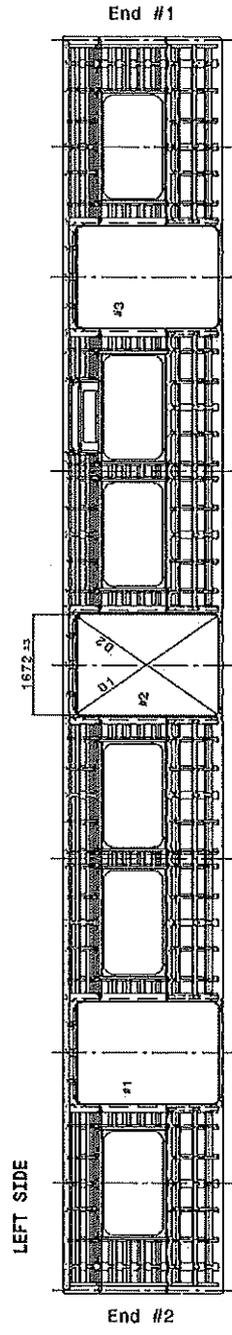
Specifications of Details for CBS measurement CB1220



Doors diagonal D1-D2 maximum difference ≤4mm

Doors Length - 1672 ±0.3mm		
#1	#2	#3
1672	1671	1673
1671	1672	1671
1672	1671	1672
HIGHER DIMENSION		
CENTRAL DIMENSION		
LOWER DIMENSION		

Doors diagonal D1-D2 maximum difference ≤4mm		
#1	#2	#3
D1	2748	2748
D2	2743	2746
D1-D2	~	2



Doors diagonal D1-D2 maximum difference ≤4mm

Doors Length - 1672 ±0.3mm		
#1	#2	#3
1671	1672	1671
1672	1671	1672
1672	1672	1671
HIGHER DIMENSION		
CENTRAL DIMENSION		
LOWER DIMENSION		

Doors diagonal D1-D2 maximum difference ≤4mm		
#1	#2	#3
D1	2546	257
D2	2548	2549
D1-D2	2	1



CARBODYSHELL M1,M3,M4 ASSEMBLY  
DTR30225487/2

Rev.	29
Date	28/10/2023

Project: PRASA  
SI.CB2220.250.V29

**CBS measurement (Manufacturing)**

**Dye penetrant test**

Dye-penetration test to be performed by quality personnel



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

II.2 - Check List REX

Check List Items

Item	Picture/Drawing	Description	Criteria/Record	OK	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX			

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

**Self Inspection - Final Result**

Is the car good to advance to the next workstation/process? (Approval of Operations Manager and Industrial Quality)			DATE	NAME	SIGNATURE	
<b>HOLD POINT</b>	<b>GO</b>	(If activities are not complete, the missing activities must not impact the next stage!)	19/06/2024	Lew <small>Operations</small>		
		Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	19/06/24	Anedani <small>Industrial Quality</small>		
		There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			<small>Operations</small>	
		There are non-conformities impact the quality of the product and there is no corrective action defined yet)			<small>Industrial Quality</small>	

In case of "NO GO", describe blocking problems

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

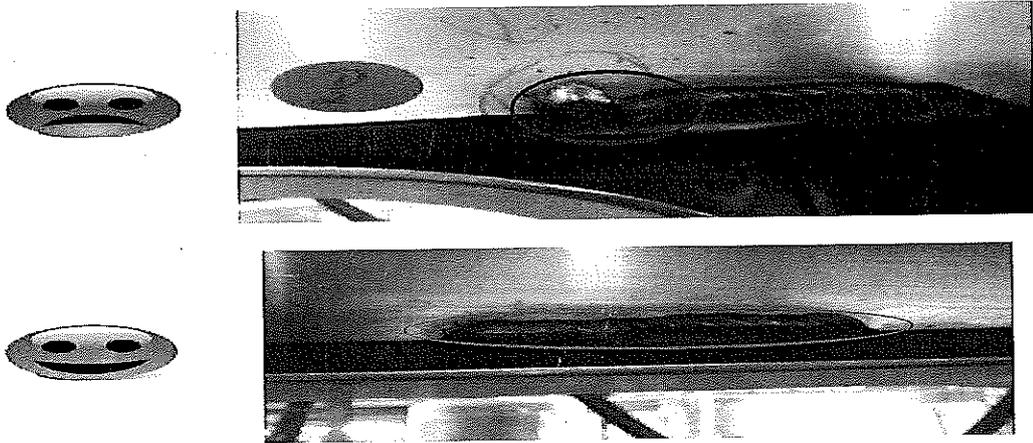
Item	Description	Responsible	Due date	Status

Operations

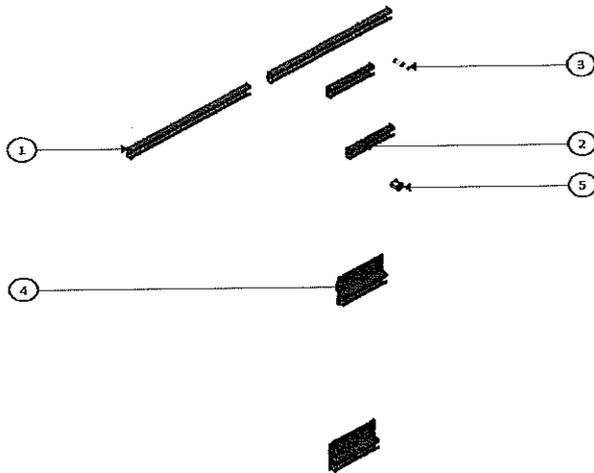
Quality

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

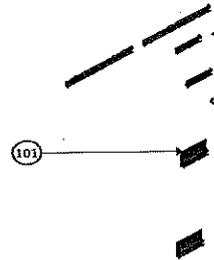
**ANNEXURE A: Arc Welding Quality Acceptance Standard**



Station: CB1220-004- U108 & U107



PART NO.	ITEM NO.	QTY	DESCRIPTION	MASS (KG)
DTF0010074033	5	6	EARTH STUD 6	0.056
AZ00001201848	4	6	ASSEMBLY SUPPORT	0.271
DTF00000348365	8	12	WELDING STUD ISO19118 PT - E80G9 - S5T	0.007
AA00001150424	2	12	ASSEMBLY SUPPORT	0.193
AZ00001151118	1	14	ASSEMBLY SUPPORT	0.522
AA00001151080	101	6	CARBODYSHELL BRACKETS CARBODYSHELL M1/M3/M4 CAR(SIDE FRAME MODULE 2710 - 077)	12.132





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 ?	
				TCA	M4	M1	M2	M3	TC2			
<input type="checkbox"/>	DTR3000152669	AAD0001278566	CARBODYSHELL M1, M3, M4 ASSEMBLY	CB2230			X				PRA.CB2230.DT000002 25487.V20	YES
<input type="checkbox"/>	DTR3000152673	AAD0001278566	CARBODYSHELL M1, M3, M4 ASSEMBLY	CB2230		X			X		PRA.CB2230.DT000002 25487.V20	YES

	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	2018/08/02	GIBELA NEW CREATION	APPROVER	Philippe Marques	2018/08/02
			CHECKER	Nosizo Pindela	2018/08/02
			COMPILER	Nosizo Pindela	2018/08/02
1	30/5/2018	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality manager	APPROVER	Itumeleng Modiba	30/5/2018
			CHECKER	Nosizo Pindela	30/5/2018
			REVISED BY	Nosizo Pindela	30/5/2018
2	2018/05/07	Certain dimensional checks moved to CB1220	APPROVER	Itumeleng Modiba	2018/05/07
			CHECKER	Nosizo Pindela	2018/05/07
			REVISED BY	Ramokone Motama	2018/05/07
5	24/01/2019	As per Baseline 10.2	APPROVER	Itumeleng Modiba	24/01/2019
			CHECKER	Nosizo Pindela	24/01/2019
			REVISED BY	Vanessa Ntuli	24/01/2019
6	13/03/2019	Added Twist and Door Bracket Measurements Remove Door Measurements	APPROVER	Itumeleng Modiba	13/03/2019
			CHECKER	Nosizo Pindela	13/03/2019
			REVISED BY	Nosizo Pindela	13/03/2019
10	23/08/2019	New Baseline 10.2.5	APPROVER	Itumeleng Modiba	23/08/2019
			CHECKER	Nosizo Pindela	23/08/2019
			REVISED BY	Nosizo Pindela	23/08/2019
15	06/08/2020	New Baseline 10.2.5	APPROVER	Timothy Maimela	06/08/2020
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	19/04/2021
			CHECKER	Bongane Masina	
			REVISED BY	Bongane Masina	
25	20/02/2022	New Baseline change 10.3.1	APPROVER	Collins Mbombhi	20/02/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Collins Mbombhi	14/06/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
27	26/07/2022	Threshold measurements addition	APPROVER	Collins Mbombhi	26/07/2022
			CHECKER	Andani Muthelo	
			REVISED BY	Andani Muthelo	
28	17/10/2022	Added traceability of sealant application	APPROVER	Collins Mbombhi	17/10/2022
			CHECKER	Ntokozi Zwane	
			REVISED BY	Amogelang Mohlampe	
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Vanessa Ntuli	14/04/2023
			CHECKER	Ntokozi Zwane	
			REVISED BY	Amogelang Mohlampe	
30	06/11/2023	Added threshold traceability for boiler makers and welders	APPROVER	Ngobeni Tyson	06/11/2023
			CHECKER	Andani Muthelo	
			REVISED BY	Ntokozi Zwane	



TRAINSET	CAR	OPERATOR NAME & ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
234	M04	Nontlanhla 421123	20/06/24	SI.CB2230.256.V29	12



CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.  
30

Project: PRASA

Date

SI.CB2230.256.V29

06/11/2023

Car:

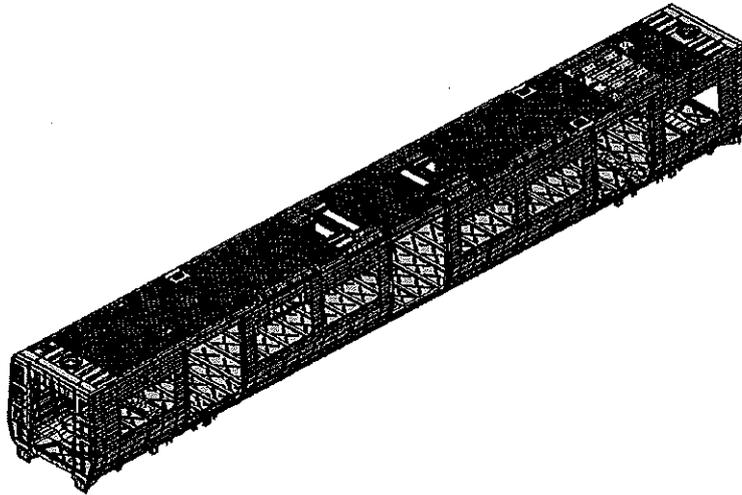
NCR:

Work station:

CB2230



Safety Related



I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car					Revision	Obsevation	OK	N/A	Signature/Date (Operations)	Signature/Date (Quality)
	M1	M2	M3	M4	TG2						
PRA.CB2230.DT00000225487						30		✓		N/A	20/06/24 20/06/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	N/A	Signature/Date (Operations)	Signature/Date (Quality)
Tubular	22615	11/10/24	✓		20/06/24	20/06/24
Combination Square	518250131	22/08/24	✓		20/06/24	20/06/24
Measuring Tape	518250049	24/07/2024	✓		20/06/24	20/06/24

1.3 Consumables

Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	N/A	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSI	E23167	MIG	✓		20/06/24	20/06/24

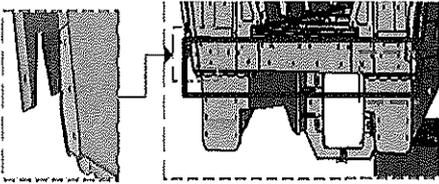
II - Self Inspection - Items to Check

II.1 - Items to check

Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	Signature/Date (Operations)	Signature/Date (Quality)
01	N/A	Assembly according to Instruction Engineering n° PRA.CB1230.DT00000225487 Verification of fitment for all brackets.	PRA.CB1230.DT00000225487	✓	20/06/24	20/06/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675	✓	20/04/24	20/06/24
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	20/06/24	20/06/24
04		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	20/06/24	20/06/24
05		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓	20/06/24	20/06/24
06		Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓	20/06/24	20/06/24
07	N/A	Before application 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 (I) M'n-Max 10°C - 35°C Relative humidity Min - Max (I) M'n-Max 25% - 80%	Sealant Batch No: 105337 Exp Date: Aug 24  Actuals Temperature: 13,5°C Humidity: 56%	✓	20/06/24	20/06/24
08	N/A	Verification of sealant application on the roof and sidewall finishers.	Sealant must be: -Applied straight and even -Free of gaps,cracks,damage and debris (flashes, dirt, dust)  Refer to Annexure B	✓	20/06/24	20/06/24
09	N/A	Verification of sealant application in certain regions in the drawing.	AAD0001278566	✓	20/06/24	20/06/24

II - Self Inspection - Items to Check

AREA 1



END 2 SEALANT

OPERATOR  
(Name & sign):

Lerato (LM)

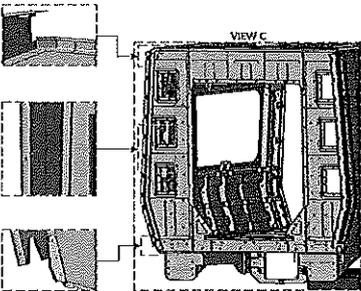
OPERATOR  
(Name & sign):

Lerato (LM)

OPERATOR  
(Name & sign):

Lerato (LM)

AREA 2 (VIEW C)



Area D,E,F,G,H,I

Operator (Name & sign):

LHS

E, H (bottom)

RHS

F, H, I (bottom)

Operator (Name & sign):

Bunie Abgala

Bunie Abgala

Operator (Name & sign):

D, E, H, I (Ep)

D, E, H, I (top)

Operator (Name & sign):

Sinie

Tshenolo

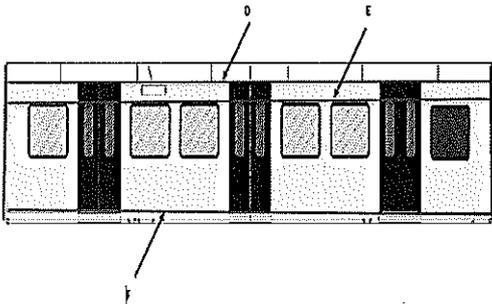
Operator (Name & sign):

Tshenolo

Sinie

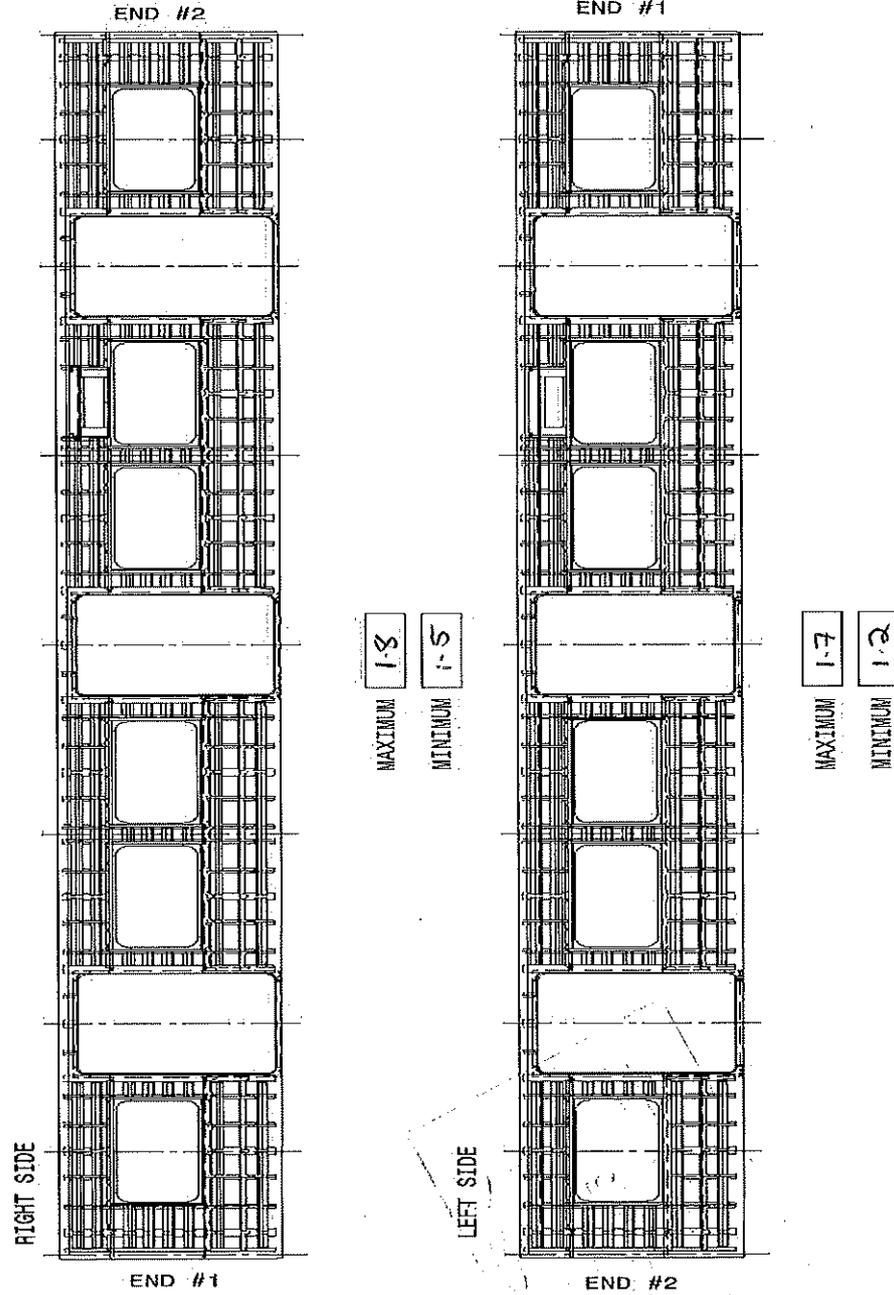
Operator (Name & sign):

H



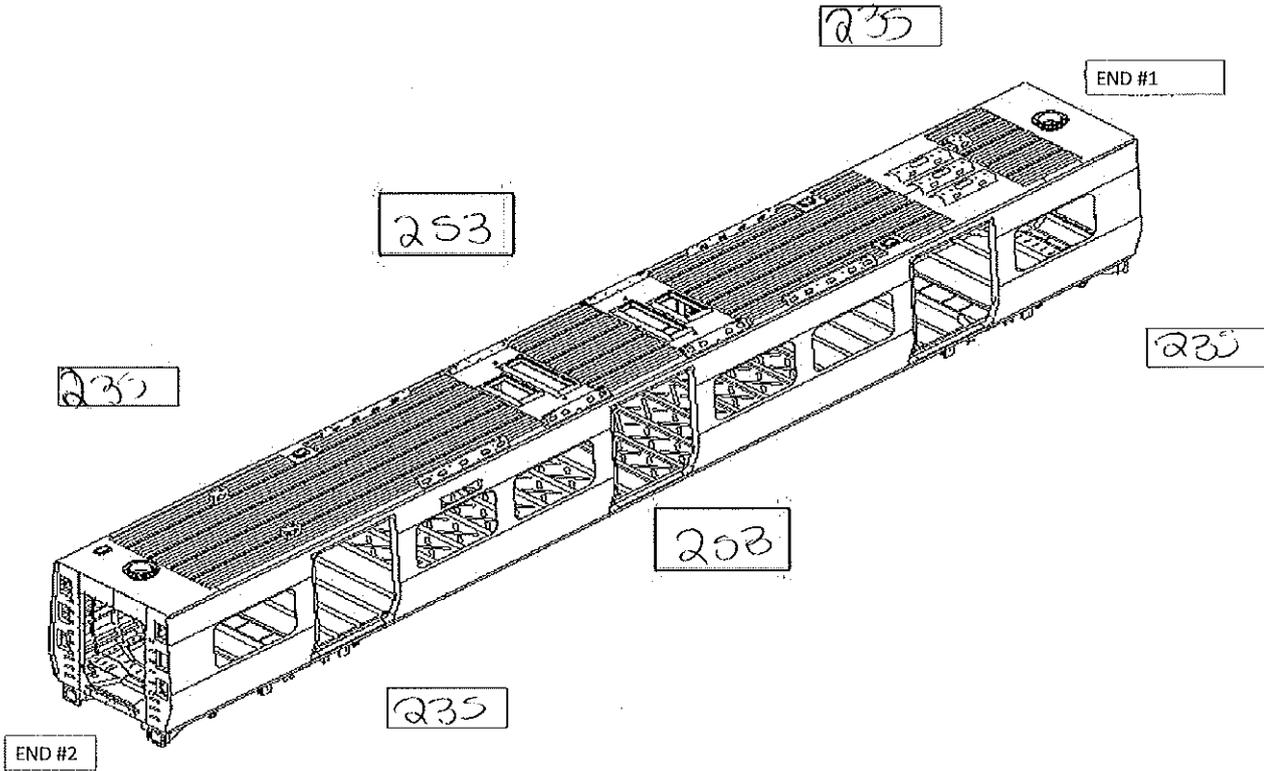
Specifications of Details for CBS measurement CB1230

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



**Specifications of Details for CBS measurement CB1230**

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



**MEASURED CAMBER VALUES**

RIGHT	u	13
LEFT	a1	13

*[Faint handwritten notes and signatures]*



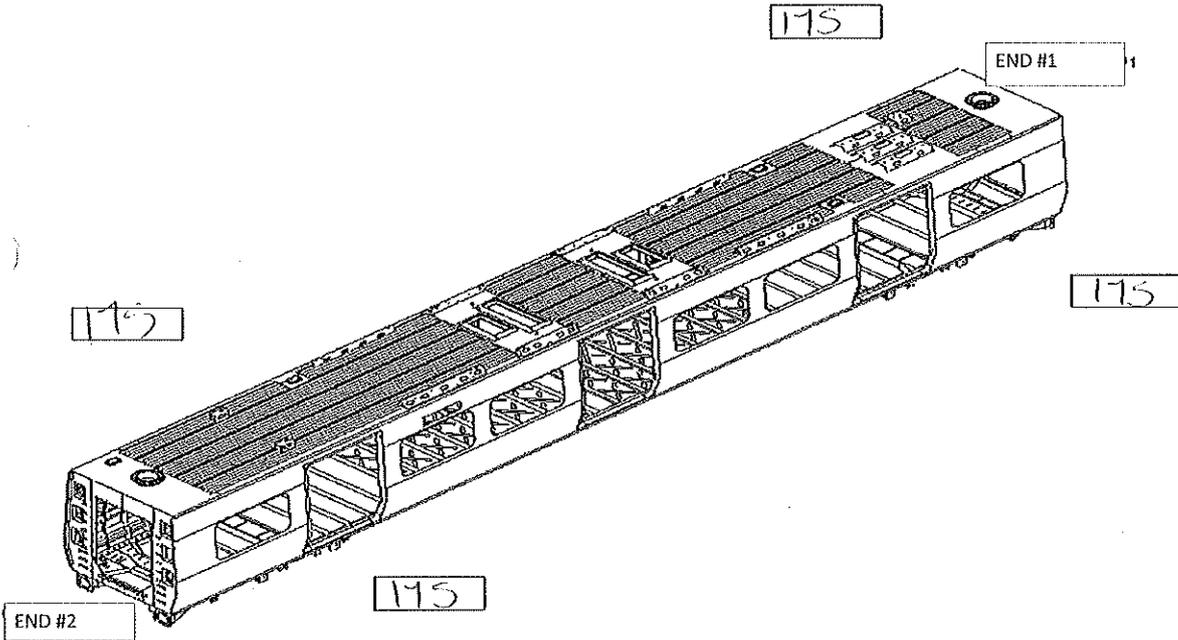
CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.  
30  
Date  
06/11/2023

Project: PRASA  
SI.CB2230.256.V29

Specifications of Details for CBS measurement CB1230

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



TWIST FOUND ON END 1

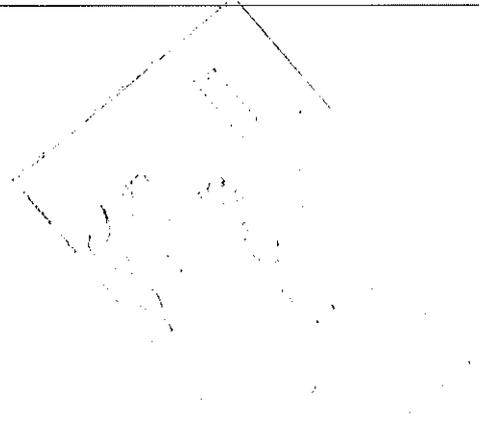
TRANVERSE

LONGITUDINAL

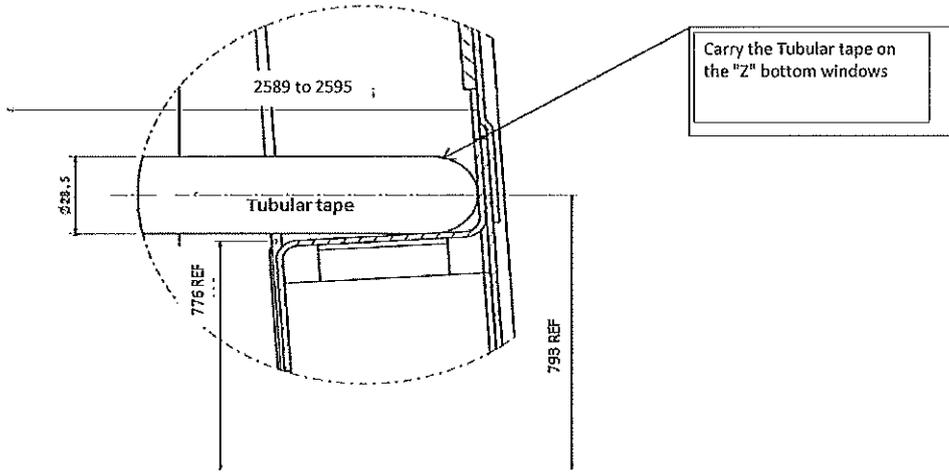
TWIST FOUND ON END 2

TRANVERSE

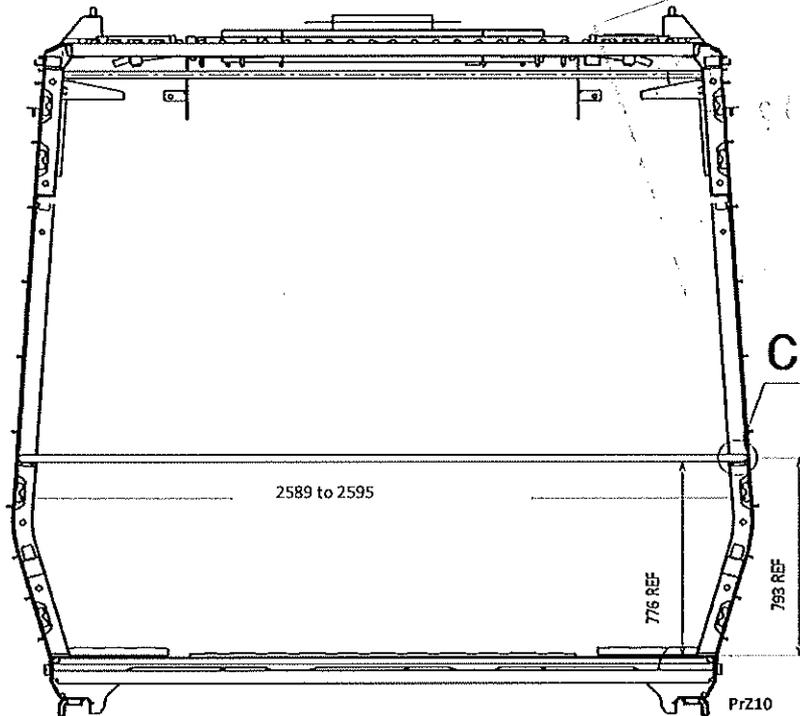
LONGITUDINAL



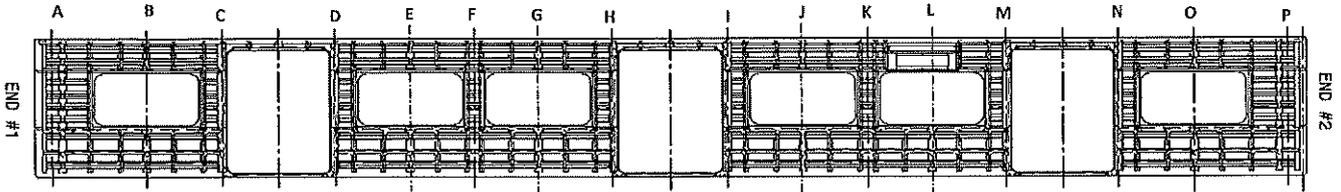
Specifications of Details for CBS measurement CB1230



Detail C

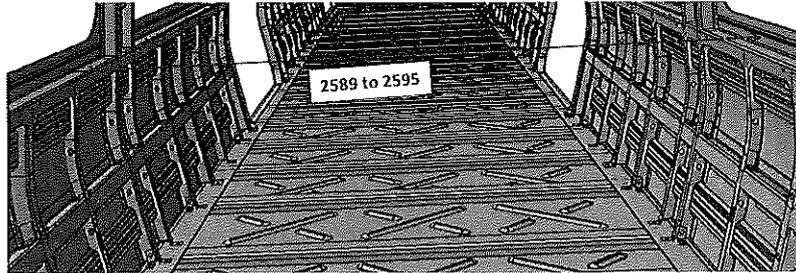


Specifications of Details for CBS measurement CB1230



2589 to 2595mm

A	2591
B	2592
C	2596
D	2595
E	2592
F	2591
G	2594
H	2590
I	2591
J	2592
K	2593
L	2590
M	2591
N	2592
O	2594
P	2591



Threshold verification				Nominal value :38	
Door 1		Door 2		Door 3	
L	R	L	R	L	R
38	38	37	37	37	38
Door 4		Door 5		Door 6	
L	R	L	R	L	R
37	38	38	38	37	37

BOILER MAKER: Honkkinla

WELDER: Zanele

Dye penetrant test

Dye-penetration test to be performed by quality personnel







CARBODYSHELL M1,M3,M4 ASSEMBLY  
DT00000225487

Rev.  
30  
Date  
08/11/2023

Project: PRASA  
SI.CB2230.256.V29

**Self Inspection - Final Result**

Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)		DATE	NAME	SIGNATURE	
HOLD POINT	GO  (If activities are not complete, the missing activities must not impact the next stage)	20/06/24	T. Bonhlanhka Operations		
		20/06/2024	AMOGELANG Industrial Quality		
	NO GO  There are activities pending that impact/stop the activities of the next process Obs: (To describe problems below)			Operations	
				Industrial Quality	
There are non-conformities impact the quality of the product and there is no corrective action defined yet)					

In case of "NO GO", describe blocking problems

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

Item	Description	Responsible	Due date	Status

Operations

Quality



ANNEXURE A: Arc Welding Quality Acceptance Standard

