

PRASA PROJECT

GIBELA

SELF INSPECTION SHEET

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

CONFIDENTIAL INFORMATION

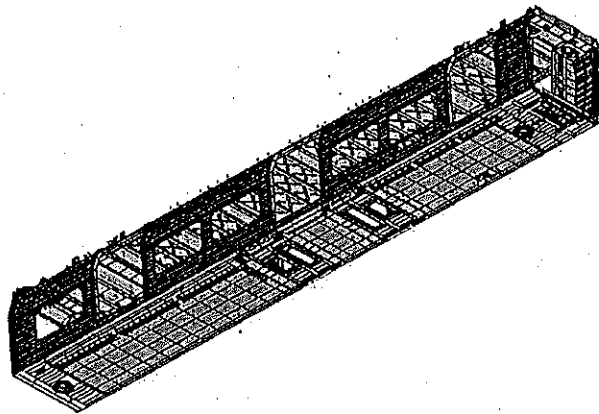
This document and the information contemplated therein have to be considered as Confidential Information pursuant to the provisions of Clause 29 of the MSA, and treated as such.

DRAWING	DESCRIPTION	STATION	TC1	M1	M2	M3	TC2	WORK INSTRUCTION	SAFETY ?
A000001241033	Cashed Assembly TC	CB210	X					PRA.CB2210.DTR3022331	YES
DTR30223319/3								9/3/V25	

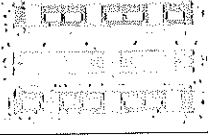
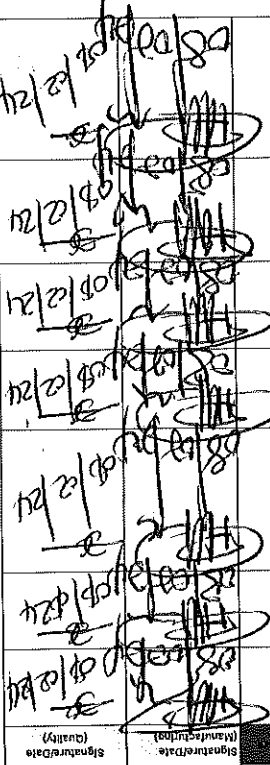
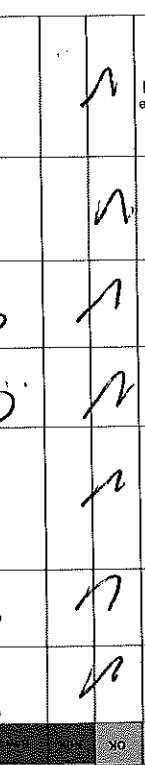
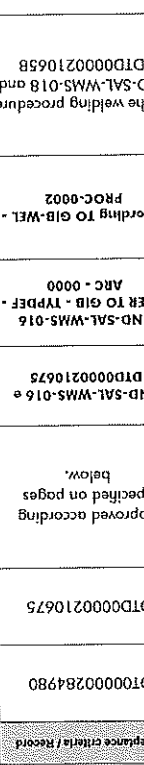
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	09/04/2018	GIBELA NEW CREATION	CHECKER	Nosizo Pindela	09/04/2018
1	2018/05/18	Team leader and Quality Technician to sign Change	APPROVER	Thanyani Mathegu	2018/05/18
2	2018/06/18	MODIFICATION CONTENT	CHECKER	Nosizo Pindela	2018/06/18
3	2018/12/12	Additional checkpoints	APPROVER	Izumeleng Modiba	2018/12/12
5	22/01/2019	As per Baseline 10.2	APPROVER	Izumeleng Modiba	22/01/2019
6	2019/11/03	Record D1 and D2 on Self - Inspection	APPROVER	Izumeleng Modiba	2019/11/03
10	21/08/2019	New Baseline 10.2.5	CHECKER	Nosizo Pindela	21/08/2019
15	06/08/2020	New Baseline 10.2.6	APPROVER	Timothy Mamele	06/08/2020
20	19/04/2020	New Baseline change 10.3	APPROVER	Timothy Mamele	19/04/2020
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi Collins	17/08/2021
25	21/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi Collins	21/02/2022
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	14/04/2023
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobern Tyson	27/07/2023
28	07/11/2023	Addition of welding traceability	APPROVER	Ngobern Tyson	07/11/2023

PAGES	SELF INSPECTION NUMBER	DATE	OPERATOR NAME & ALPS NUMBER	CAR	TRAINSET
16	SI.CB2210.322.V28	28/07/2024	Timothy Mamele	TC2	TC2

Rev. Date Project	Rev. V28 07/11/2023	Date 07/11/2023	Project PRASA	Work station CB2210	Car TC1 & TC2	NCR	DTR30223319/3 Carshell Assembly TC	GIBELD
	Rev. V28 07/11/2023	Date 07/11/2023	Project PRASA	Work station CB2210	Car TC1 & TC2	NCR	DTR30223319/3 Carshell Assembly TC	GIBELD



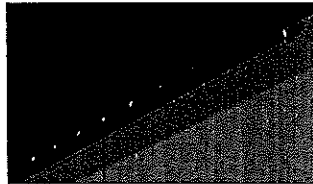
1 - Documentation and Instruments									
1.1 - Documentation Control									
Document: DTR30223319/3 Type of car: ☒ TC1 ☐ TC2 ☐ TC3 ☐ TC4 ☐ TC5 ☐ TC6 ☐ TC7 ☐ TC8 ☐ TC9 ☐ TC10 ☐ TC11 ☐ TC12 ☐ TC13 ☐ TC14 ☐ TC15 ☐ TC16 ☐ TC17 ☐ TC18 ☐ TC19 ☐ TC20 ☐ TC21 ☐ TC22 ☐ TC23 ☐ TC24 ☐ TC25 ☐ TC26 ☐ TC27 ☐ TC28 ☐ TC29 ☐ TC30 ☐ TC31 ☐ TC32 ☐ TC33 ☐ TC34 ☐ TC35 ☐ TC36 ☐ TC37 ☐ TC38 ☐ TC39 ☐ TC40 ☐ TC41 ☐ TC42 ☐ TC43 ☐ TC44 ☐ TC45 ☐ TC46 ☐ TC47 ☐ TC48 ☐ TC49 ☐ TC50 ☐ TC51 ☐ TC52 ☐ TC53 ☐ TC54 ☐ TC55 ☐ TC56 ☐ TC57 ☐ TC58 ☐ TC59 ☐ TC60 ☐ TC61 ☐ TC62 ☐ TC63 ☐ TC64 ☐ TC65 ☐ TC66 ☐ TC67 ☐ TC68 ☐ TC69 ☐ TC70 ☐ TC71 ☐ TC72 ☐ TC73 ☐ TC74 ☐ TC75 ☐ TC76 ☐ TC77 ☐ TC78 ☐ TC79 ☐ TC80 ☐ TC81 ☐ TC82 ☐ TC83 ☐ TC84 ☐ TC85 ☐ TC86 ☐ TC87 ☐ TC88 ☐ TC89 ☐ TC90 ☐ TC91 ☐ TC92 ☐ TC93 ☐ TC94 ☐ TC95 ☐ TC96 ☐ TC97 ☐ TC98 ☐ TC99 ☐ TC100 ☐ TC101 ☐ TC102 ☐ TC103 ☐ TC104 ☐ TC105 ☐ TC106 ☐ TC107 ☐ TC108 ☐ TC109 ☐ TC110 ☐ TC111 ☐ TC112 ☐ TC113 ☐ TC114 ☐ TC115 ☐ TC116 ☐ TC117 ☐ TC118 ☐ TC119 ☐ TC120 ☐ TC121 ☐ TC122 ☐ TC123 ☐ TC124 ☐ TC125 ☐ TC126 ☐ TC127 ☐ TC128 ☐ TC129 ☐ TC130 ☐ TC131 ☐ TC132 ☐ TC133 ☐ TC134 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Rev. V28 Date. 07/11/2023 Project: PRASA SI: CB2210.322.V28		DTR30223319/3 Carshell Assembly TC	
Item 01	Picture/Drawing N/A	Description Verification of correct ports loaded (Sidewalls, Endframes, Roof and Underframe)	DT00000284980
Item 02	Picture/Drawing N/A	Description Carshell free of significant flaws which compromise the appearance or functionality.	DT00000210675
Item 03		Description Functional dimensions approved according drawing or complementary document approved by Astom engineering and registered in this document.	Approved according specified on pages below.
Item 04	Picture/Drawing REFER TO ANNEXURE A	Description Spot Welding Inspected and approved according procedure	IND-SAL-WMS-016 DT00000210675
Item 05	Picture/Drawing REFER TO ANNEXURE B	Description Arc Welding Inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000
Item 06		Description Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002
Item 07	Picture/Drawing N/A	Description Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018.	As the welding procedure IND-SAL-WMS-018 and DT00000210658
Signature/Date (quality)  08/08/24	Signature/Date (Manufacturing)  08/08/24	Acceptance criteria / Record OK	OK  08/08/24

	DTR30223319/3 Carshell Assembly TC	
	Rev. V28	Project: PRASA
Date: 07/11/2023		
SI: CB2210.322.V28		

Welder Traceability

Roof ring welds

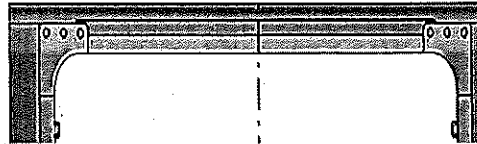


Boiler maker (Name & Sign):	<u>Justin</u>	LHS
Welder (Name & Sign):	<u>Justin</u>	LHS
Boiler maker (Name & Sign):	<u>Justin</u>	RHS
Welder (Name & Sign):	<u>Justin</u>	RHS

END 1

Boiler maker (Name & Sign):	<u>Justin</u>	LHS
Welder (Name & Sign):	<u>Justin</u>	LHS
Boiler maker (Name & Sign):	<u>Justin</u>	RHS
Welder (Name & Sign):	<u>Justin</u>	RHS

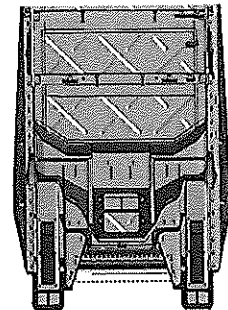
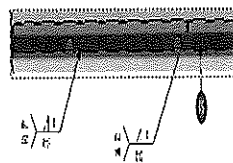
END 2



Boiler maker (Name & Sign):	<u>Justin</u>	LHS
Welder (Name & Sign):	<u>Justin</u>	LHS

Boiler maker (Name & Sign):	<u>Justin</u>	RHS
Welder (Name & Sign):	<u>Justin</u>	RHS

EUF Reinforcement Plates



Information CM

Boiler maker (Name & Sign):	Innocent Mw
Welder (Name & Sign):	Katu K. K. K.

END 2



Operator:	Lawrence E. Mw
-----------	----------------

FED01

After loading Underframe and Clamping.

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

Date:

After Welding.

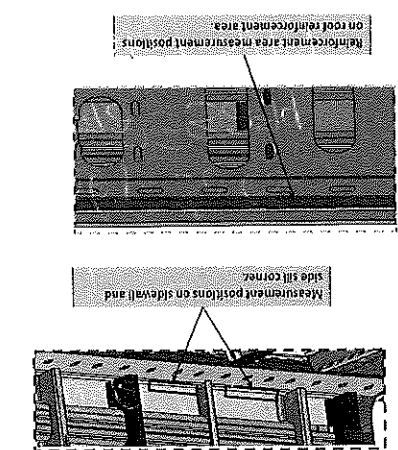
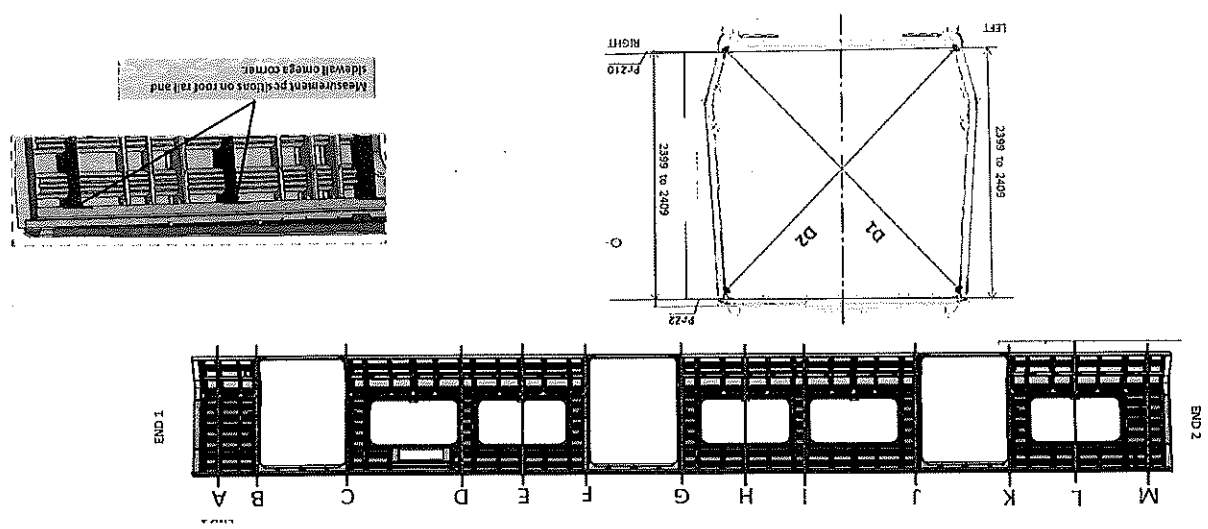
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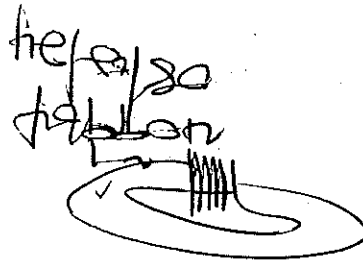
Signature Industrial Quality:

Date:

Rev. Date- 07/11/2023 SI, CB2210, 322, V28 Project: PRASA SI, CB2210, 322, V28	DTR30223319/3 Carshell Assembly TC	GIBBIA
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Specifications of Details for CBS measurement





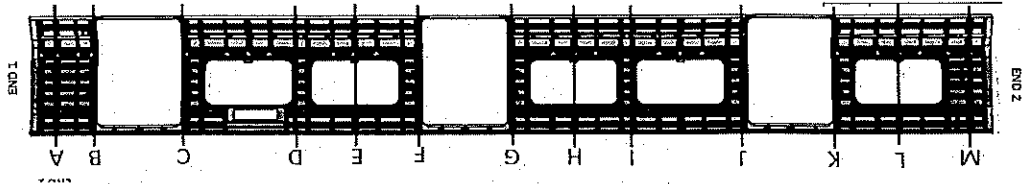
0	same	same	0
1	same	same	1
e	same	same	4
1	same	same	e
1	same	same	0
1	same	same	e
e	same	same	1
0	same	same	e
1	same	same	0
1	same	same	0
0	same	same	1
1	same	same	e
0	same	same	1

LHS-RHS ≤ 2 2399 to 2409 (RHS) 2399 to 2409 D1-D2 ≤ 5mm

3069	3069
3071	3071
3073	3073
3065	3065
3067	3067
3075	3075
3077	3077
3079	3079
3081	3081
3083	3083
3085	3085
3087	3087
3089	3089

Record D1 values Record D2 values

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

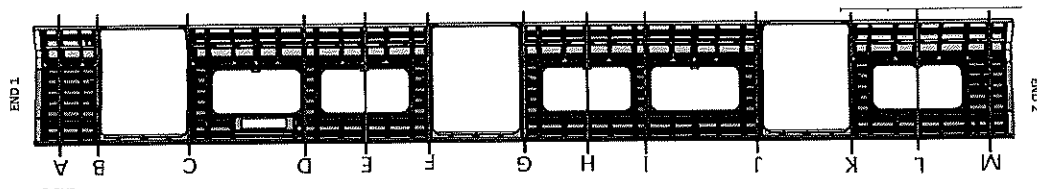


BEFORE WELDING

Specifications of Details for CBS measurement			
Rev.	DTR30223318/3 Carshell Assembly TC		
Project: PRASA	Date: 07/11/2023	SI:CB2210.322.V28	

Specifications of Details for CBS measurement

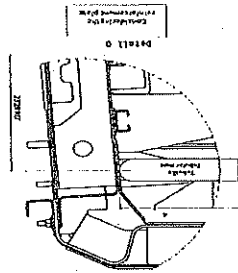
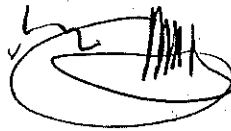
AFTER WELDING



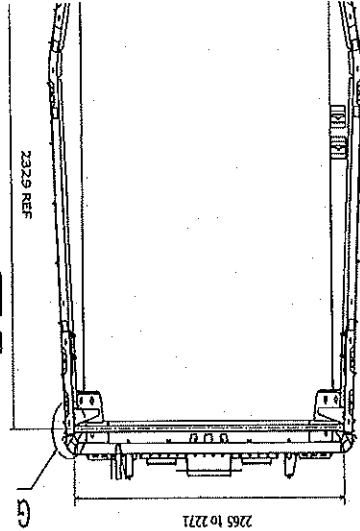
PME: The difference in Height values measured on the LHS and RHS should be $\leq 2\text{MM}$ on each point.

[illegible]

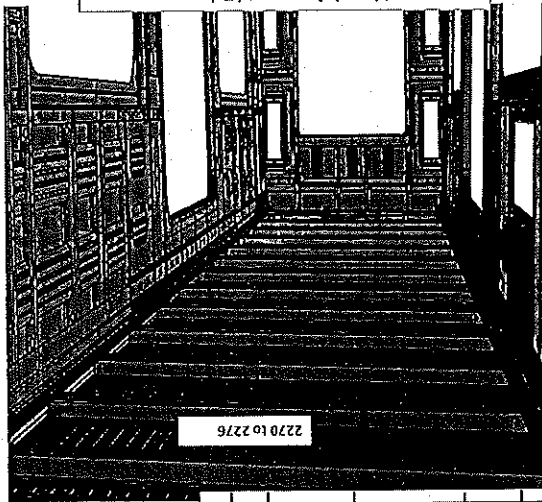
Refer 80
1966/64



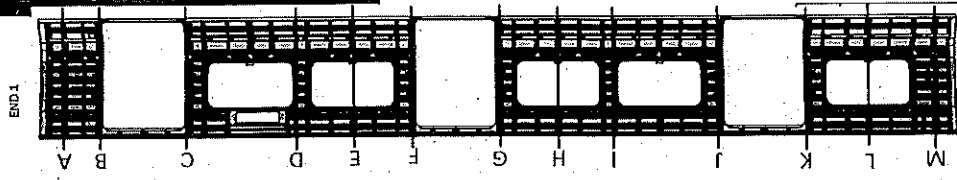
2265 to 2271



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

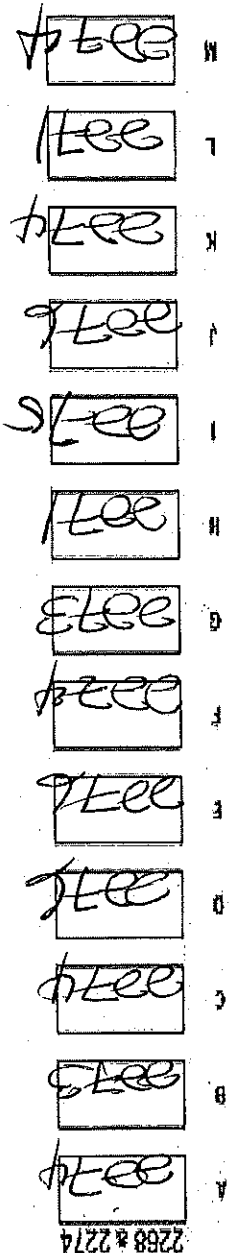


2270 to 2276



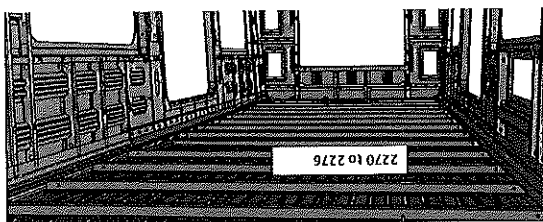
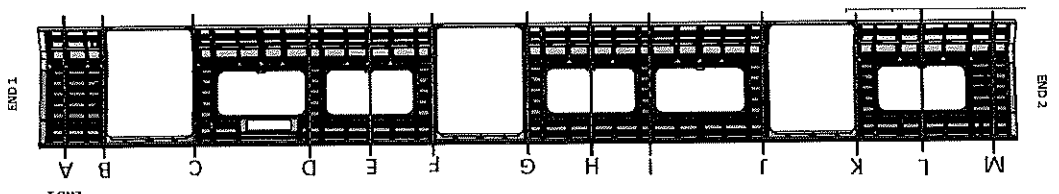
BEFORE WELDING

END 2

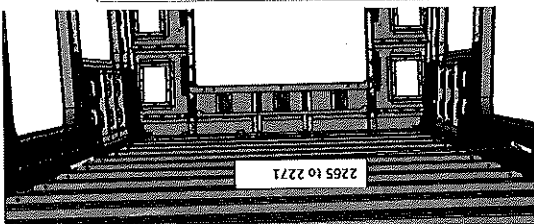


2270 to 2276

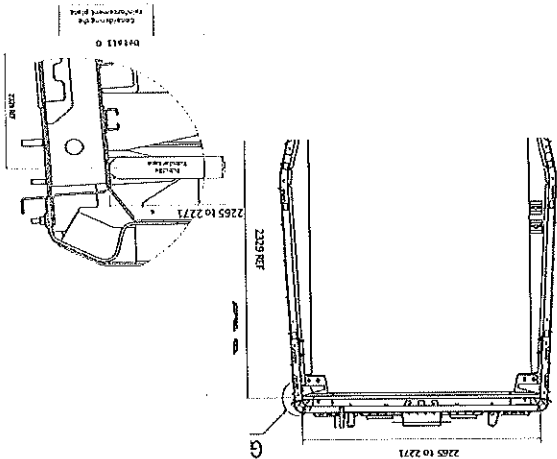
CBS measurement			
	DTR3022331913 Carshell Assembly TC		
	Rev.	Date-	
	V28	07/11/2023	
Project: PRASA		SI: CR2210.322.V28	



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



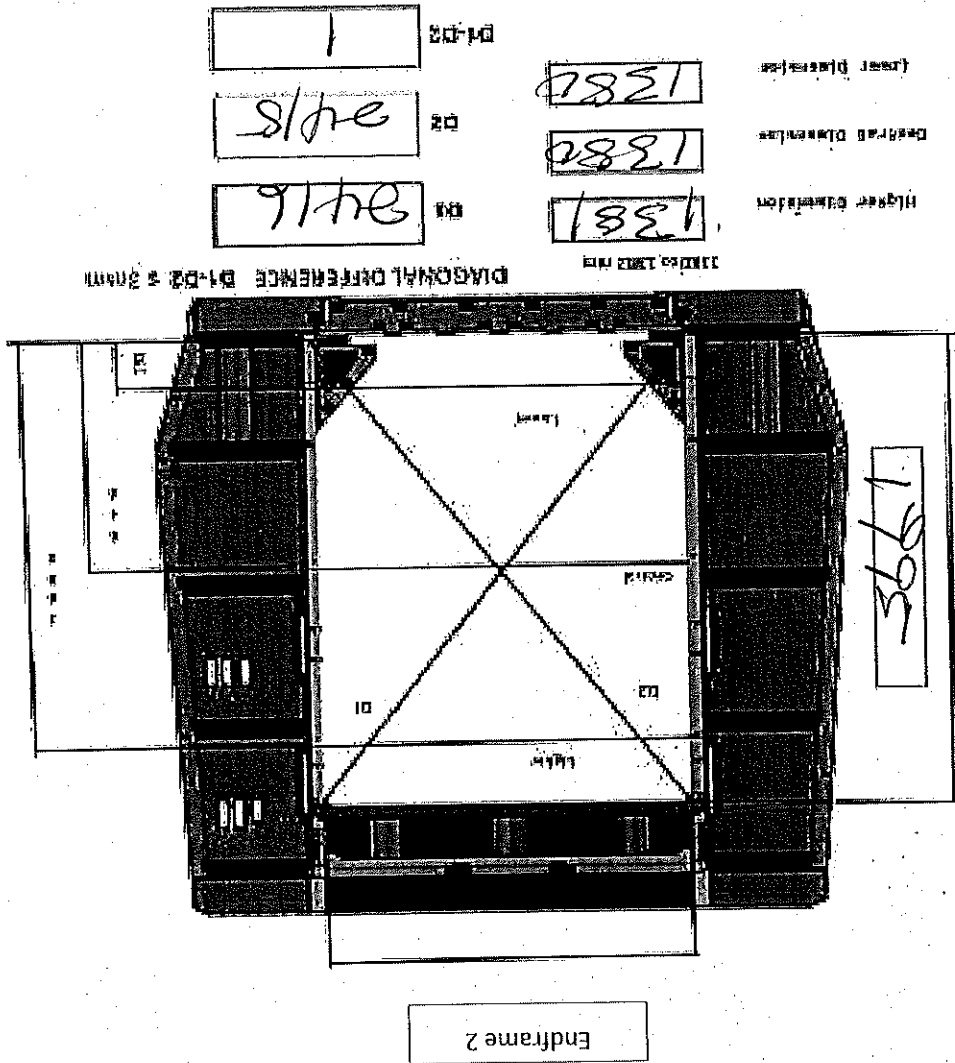
Take measurement close to radius (considering reinforcement)



2265 to 2271	2270 to 2276	A	STEEL	N/A	E	N/A	STEEL	F	STEEL	N/A	G	STEEL	N/A	H	N/A	I	N/A	J	STEEL	N/A	K	STEEL	N/A	L	N/A	STEEL	N/A	M	STEEL	N/A
--------------	--------------	---	-------	-----	---	-----	-------	---	-------	-----	---	-------	-----	---	-----	---	-----	---	-------	-----	---	-------	-----	---	-----	-------	-----	---	-------	-----

Handwritten notes and a circular diagram with internal lines.

08/08/2023
 08/08/2023
 08/08/2023



DIAGONAL DIFFERENCE D1-D2 = 30mm

1	D1-D2
2/15	D2
2416	D1

1381
1380
1381

Height Dimension
 Overall Dimension
 (Total Dimension)

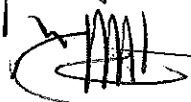
	DTR0223319/3 Carshell Assembly TC
Rev. V20 Date- 07/11/2023	Project: PRASA SI: CB2210.322.V28

Specifications of Details for CBS measurement

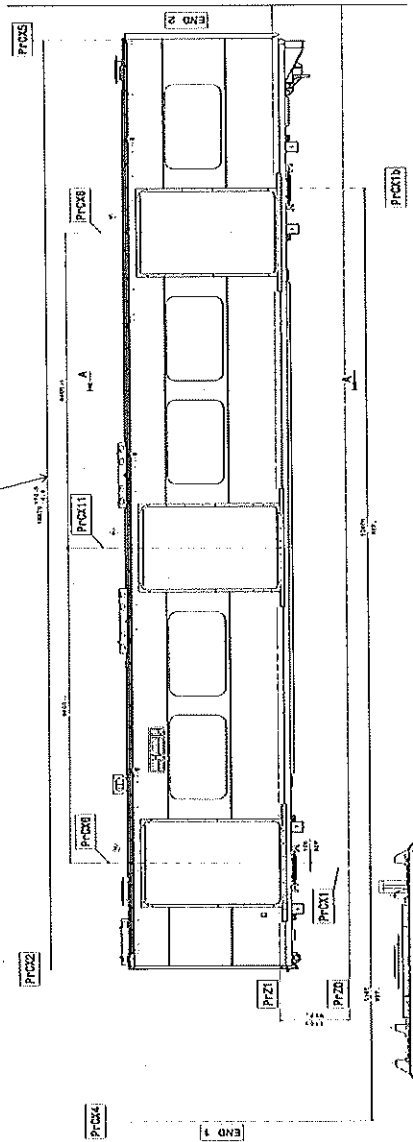
Specifications of Details for CBS measurement

LEFT SIDE		1A
SPECIFICATION SIZE	18870 +10.5 -4.5	
ACTUAL SIZE	18874	

RIGHT SIDE		1A
SPECIFICATION SIZE	18870 +10.5 -4.5	
ACTUAL SIZE	18874	


 2409960
 08/09/2024

1A



Dye penetrant test

Dye penetration test to be performed by quality personnel



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

Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.

There are activities pending that impact the activities of the next process (To describe problems below)

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	Action	Responsible	Due date	Status

Operations

Quality



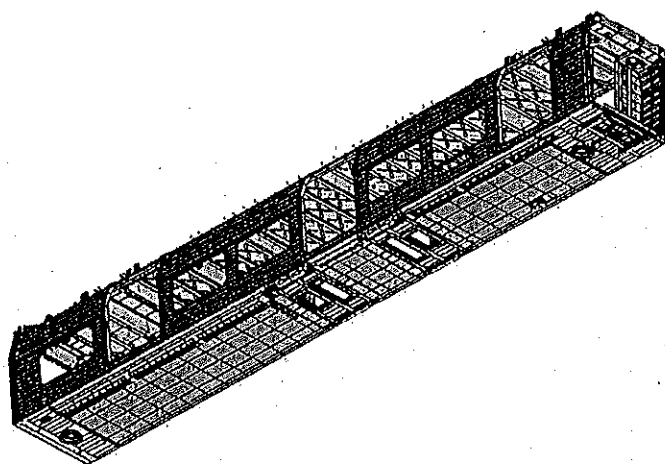
APPLICATION REFERENCE									
STATION	DESCRIPTION	DATE	TIME	TYPE	NAME	DATE	TIME	TYPE	NAME
STATION	DESCRIPTION	DATE	TIME	TYPE	NAME	DATE	TIME	TYPE	NAME

STATION	DESCRIPTION	DATE	TIME	TYPE	NAME	DATE	TIME	TYPE	NAME
STATION	DESCRIPTION	DATE	TIME	TYPE	NAME	DATE	TIME	TYPE	NAME

REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	09/04/2018	GIBELA NEW CREATION	CHECKER	Nosiso Pindela	09/04/2018
1	23/05/2018	Team leader and Quality Technician to sign Change	CHECKER	Nosiso Pindela	23/05/2018
2	05/07/2018	Certain dimensional checks added and others moved to CB1210 and CB1230	APPROVER	Nosiso Pindela	05/07/2018
3	2018/06/12	Certain dimensional checks added and others moved to CB1210 and CB1230	APPROVER	Nosiso Pindela	2018/06/12
5	24/01/2019	As per Baseline 10.2	APPROVER	Nosiso Pindela	24/01/2019
6	13/03/2019	Added D1 and D2 on Self - Inspection length measurements	COMPLER	Nosiso Pindela	13/03/2019
7	20/05/2019	Removed roof width	APPROVER	Nosiso Pindela	20/05/2019
10	22/08/2019	New Baseline 10.2.5	APPROVER	Nosiso Pindela	22/08/2019
15	06/08/2020	New Baseline 10.2.5	APPROVER	Nosiso Pindela	06/08/2020
20	19/04/2021	New Baseline 10.2.6	APPROVER	Nosiso Pindela	19/04/2021
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Nosiso Pindela	17/08/2021
25	20/02/2022	New Baseline 10.2.6	APPROVER	Nosiso Pindela	20/02/2022
26	14/06/2022	Update minimum temperature requirement for sealant application	APPROVER	Nosiso Pindela	14/06/2022
27	19/10/2022	Addition of traceability for sealant application and welding	APPROVER	Nosiso Pindela	19/10/2022
28	14/04/2023	Added sealant batch number & welding consumables traceability	APPROVER	Nosiso Pindela	14/04/2023

GIBELQ 	DTR30223319/2 Carshell Assembly TC		Rev. 29	Project: PRASA	SI:CB2220.323.V29
			Date: 28/10/2023		

Carro	TC1, TC2	NGR:	Work station: CB2220
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I - Documentation and Instruments

I1 - Documentation Control		Type of Car		Document		DTR30223319/2	
Signature/Date (Quality)	Signature/Date (Manufacturing)	Signature/Date (Manufacturing)	Signature/Date (Quality)	Operation	Revision	OK	OK

I2 - Instruments Control

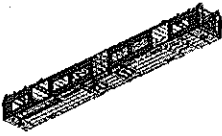
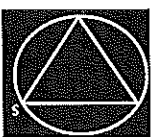
Monitoring and Measuring Instrument Control - Used for Special Process		Instrument		Validation		Calibration or Verification		Signature/Date (Manufacturing)		Signature/Date (Quality)	
		Measuring tape		02/13		03/08/2024		✓		✓	

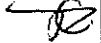
I3 Consumables

Welding Consumable Control - Used for Special Process		Title/Material		Part Number		Verifying Process		Signature/Date (Manufacturing)		Signature/Date (Quality)	
		308 10mm		314018		MIG		02/02/23		02/02/23	

II - Control Activities of Production

II.1 - Items to check

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 fitment for all reinforcement brackets.	DTR30223319/2	✓	09/02/24	09/02/24
02	N/A	Corshell free of significant flaws which compromise the appearance or functionality.	DTD0000210675	✓	09/02/24	09/02/24
03	REFER TO ANNEXURE A	Spot Welding inspected and approved according procedure	IND-SAL-WMS-016 e DTD0000210675	✓	09/02/24	09/02/24
04	REFER TO ANNEXURE B	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000	✓	09/02/24	09/02/24
05		Cleaning of all Stainless Steel Surface	According TO GIB-WEL - PROC-0002	✓	09/02/24	09/02/24
06	N/A	Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	✓	09/02/24	09/02/24
07		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 as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658	✓	09/02/24	09/02/24
08	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 (°C) : 10°C - 35°C Relative humidity Min - Max (%) : 25% - 80%	Sealant Batch No: 70-03 Exp Date: 12/21/24 Temperature: 20 Humidity: 60	✓	09/02/24	09/02/24

		DTR30223319/2 Carshell Assembly TC		Rev. 29	Date- 28/10/2023	Project: PRASA SI.CB2220.323.V29		
09	NA	Verification of sealant application in certain regions in the drawing.	AAD0001241033	Sealant must be: -Applied straight and even -Free of gaps,cracks,damage (1.5mm) -Refer to Annexure B	✓		09/10/24 	09/12/24 
10	NA	Verification of sealant application on the roof and sidewall finishers			✓		09/12/24 	09/12/24 

GIBBIA

DTR30223319/2 Carshell Assembly TC

Rev.
29

Date-
28/10/2023

SI.CB2220.323.V29

Project: PRASA

END 1
SEALANT

OPERATOR
(Name & sign):

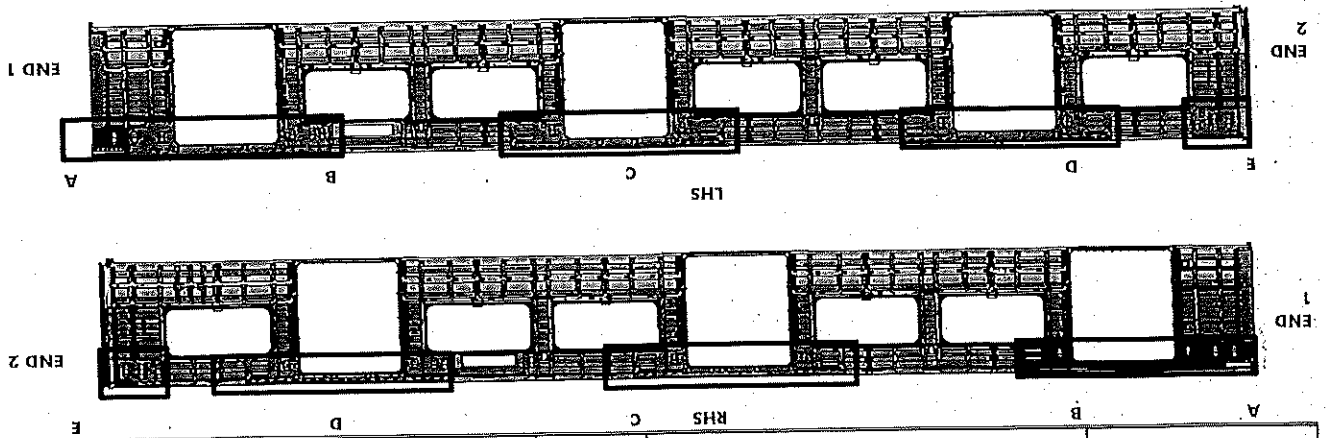
M. b. h. 102151

OPERATOR
(Name & sign):

M. b. h. 102151



CIBELQ 	DTR30223319/2 Carshell Assembly TC		Rev.	29
	Project: PRASA		Date-	28/10/2023
SI:CB2220.323.V29				



REINFORCEMENT WELDING

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

AREA	DESCRIPTION	OPERATOR	DATE	TIME
C-RAILS	INSTALLATION	Operator (Name&sign):		
	Operator (Name&sign):			
DOOR MECHANISMS:	Operator (Name&sign):			
	Operator (Name&sign):			
TAPPING PADS	Operator (Name&sign):			
	Operator (Name&sign):			
SEAT & LUGGAGE BRACKETS:	Operator (Name&sign):			
	Operator (Name&sign):			
SEAT BRACKETS VERIFICATION:	Operator (Name&sign):			
	Operator (Name&sign):			
WELDING	Operator (Name&sign):			
	Operator (Name&sign):			

	DTR30223319/2 Carshell Assembly TC		Rev. 29 Date- 28/10/2023 Project: PRASA SI.CB2220.323.V29

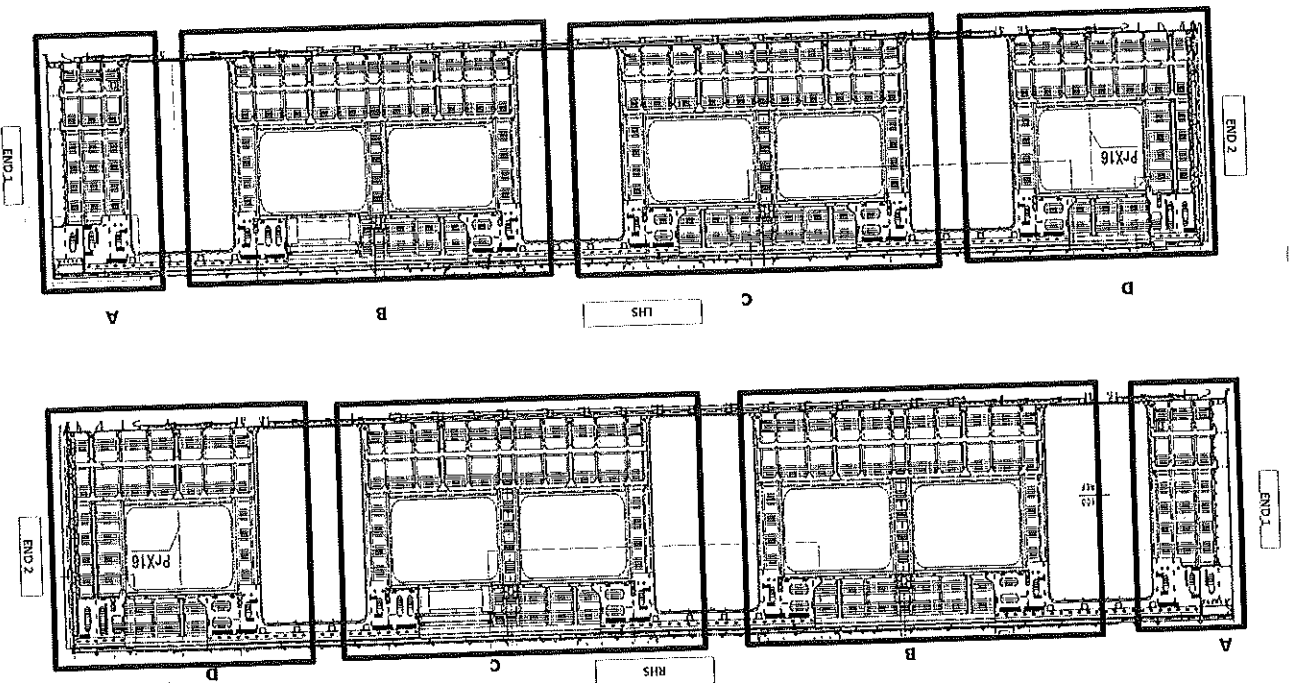
ENDS

END 1 TAPPING PADS WELDING: Operator (Name&sign): N/A

END 2 TAPPING PADS WELDING: Operator (Name&sign): MARQUE MORA

	DTR30223319/2 Carshell Assembly TC	
	Rev.	29
	Date-	28/10/2023
Project: PRASA		SI.CB2220.323.V29

TC BRACKET INSTALLATION



QUANTITIES (TC)

SECTION		QUANTITY	OK	NOK
C-RAILS	A	4	✓	
	B	8	✓	
	C	4	✓	
	D	6	✓	
SEAT BRACKETS	A	0	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	1	✓	
	B	4	✓	
	C	4	✓	
	D	2	✓	

ROOF ENDS:

CRAILS 2 OFF END 2

EARTH BUSH 4 OFF END 2

VERIFICATION BY: *Mosh*

LHS

SECTION		QUANTITY	OK	NOK
C-RAILS	A	4	✓	
	B	8	✓	
	C	4	✓	
	D	12	✓	
SEAT BRACKETS	A	0	✓	
	B	21	✓	
	C	21	✓	
	D	13	✓	
EARTH BUSH	A	1	✓	
	B	4	✓	
	C	5	✓	
	D	4	✓	

ROOF ENDS:

CRAILS 2 OFF END 2

EARTH BUSH 4 OFF END 2

VERIFICATION BY: *Mosh*

RHS

GIBCO

DTR30223319/2 Carshell Assembly TC

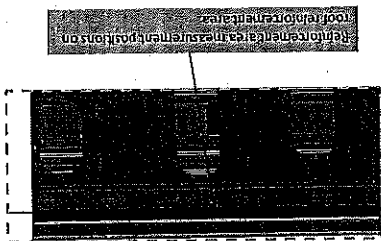
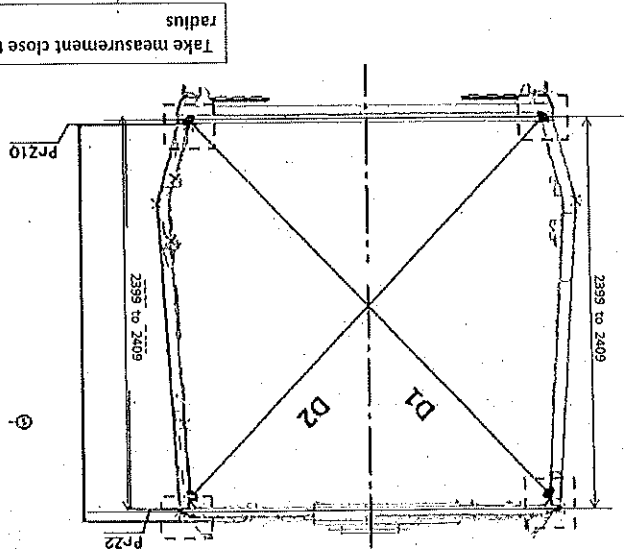
Rev.

29

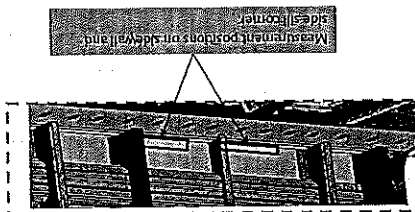
Date-
28/10/2023

Project: PRASA

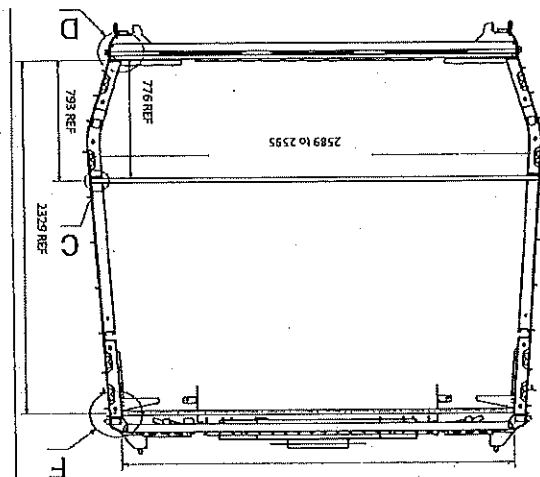
SI.CB2220.323.V29

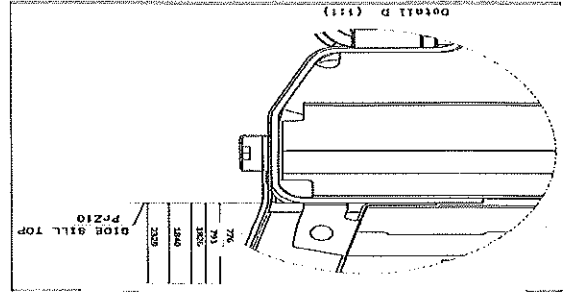
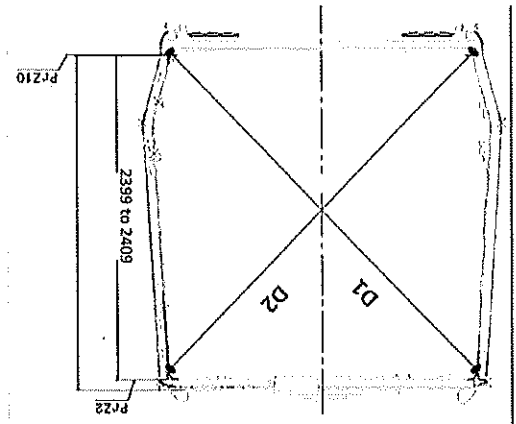
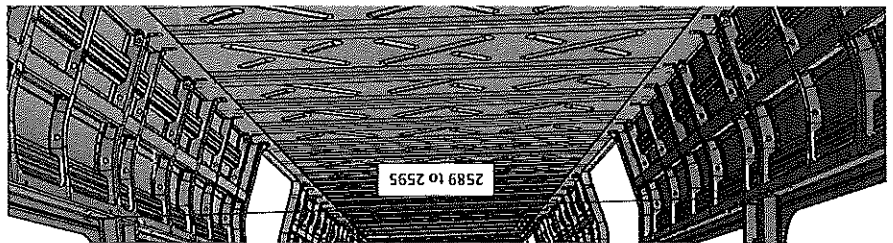
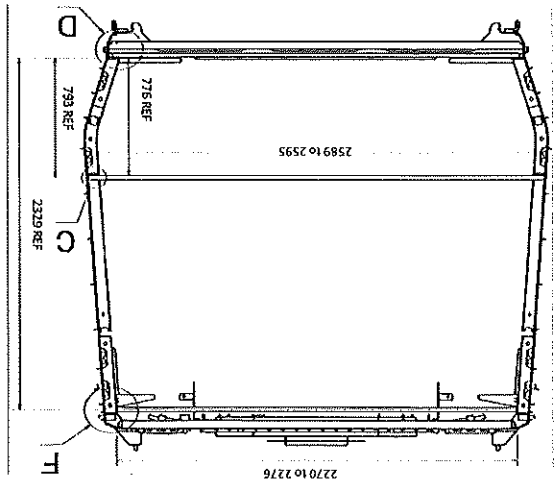


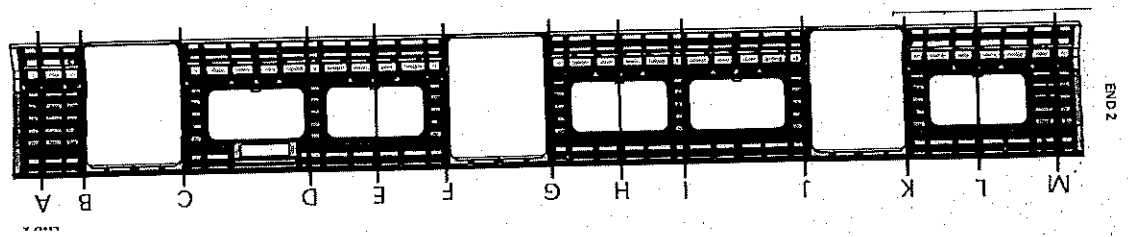
Measurement position on roof and side wall on corner



Measurement position on side wall and roof on corner





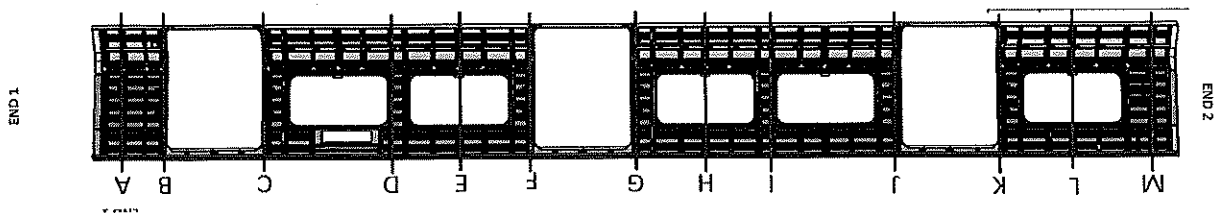


BEFORE WELDING

Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
3263	3268	5	-
3290	3292	2	-
3297	3298	1	-
3268	3268	0	-
3264	3264	0	-
3294	3292	2	-
3290	3295	5	-
3264	3265	1	-
3268	3268	0	-
3298	3298	0	-
3295	3297	2	-
3265	3266	1	-
3298	3298	4	-

END 1

END 2



Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2589 to 2595
A 3294	3294	0	2594
B 3292	3293	1	2589
C 3297	3298	1	2592
D 3267	3268	1	2592
E 3264	3265	1	2589
F 3293	3295	2	2591
G 3294	3291	3	2593
H 3264	3267	3	2592
I 3268	3268	0	2594
J 3295	3299	4	2593
K 3298	3296	2	2593
L 3267	3265	2	2591
M 3297	3293	4	2595

	DTR30223319/2 Carshell Assembly TC	Rev. 29	Project: PRASA
		Date- 28/10/2023	SI.CB2220.323.V29

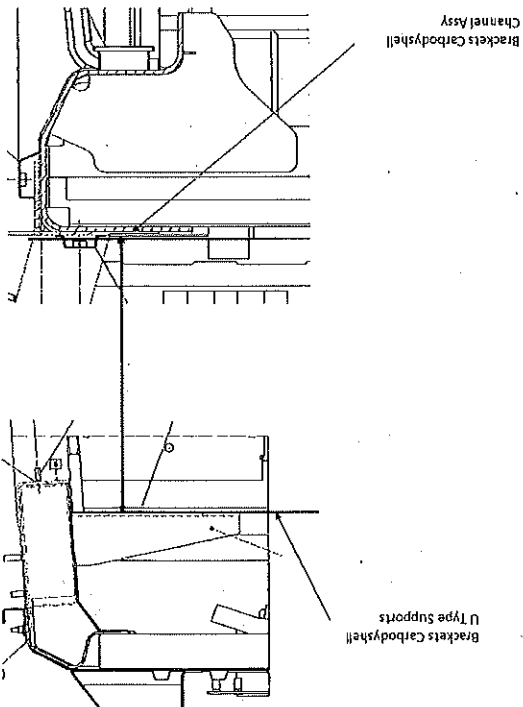
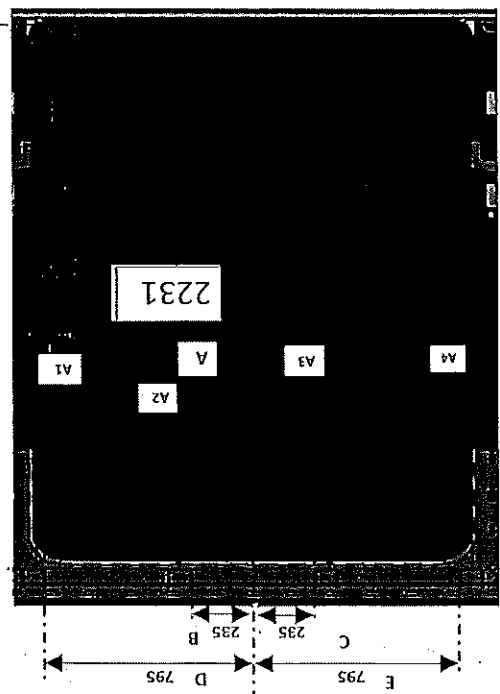
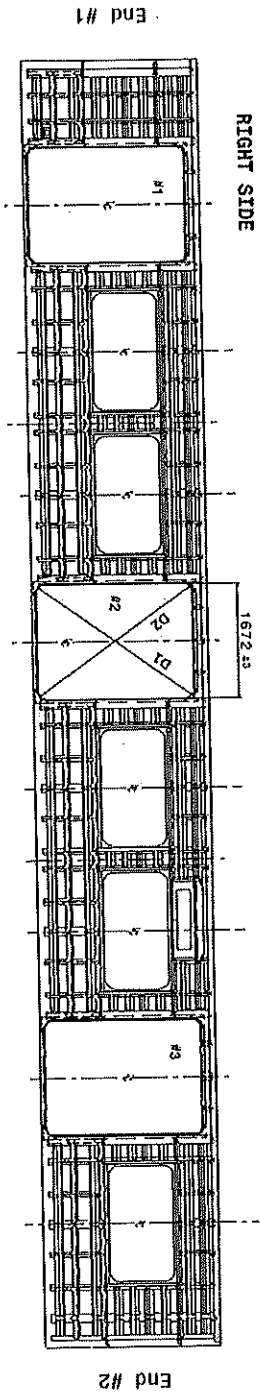


Figure 1 displays six histograms showing the distribution of the number of doors per house for different door types. The vertical axis represents the frequency (A1 through E) and the horizontal axis represents the value (VALUE).

- Door 1 - RH:** The distribution is centered around 2232-2237, with a peak frequency of approximately 2232.
- Door 2 - RH:** The distribution is centered around 2232-2237, with a peak frequency of approximately 2232.
- Door 3 - RH:** The distribution is centered around 2232-2237, with a peak frequency of approximately 2232.
- Door 1 - LH:** The distribution is centered around 2232-2237, with a peak frequency of approximately 2232.
- Door 2 - LH:** The distribution is centered around 2232-2237, with a peak frequency of approximately 2232.
- Door 3 - LH:** The distribution is centered around 2232-2237, with a peak frequency of approximately 2232.

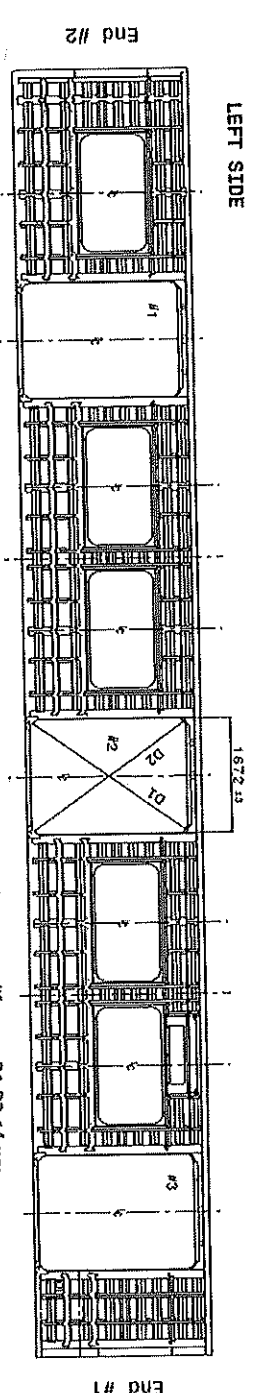
Specifications of Details for CBS measurement			
	DTR30223319/2 Carshell Assembly TC	Rev.	Project: PRASA SI.CB2220.323.V29
		Date-	
		28/10/2023	

Specifications of Details for CBS measurement



Doors Length - 1672.23mm					
#1	#2	#3			
1673	1673	1673	HIGHER DIMENSION		
1672	1672	1672	CENTRAL DIMENSION		
1672	1672	1673	LOWER DIMENSION		

Doors diagonal D1-D2 maximum difference ≤ 4 mm					
D1	D2	D1-D2	#1	#2	#3.
2148	2150	2	2148	2149	2147

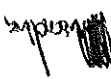
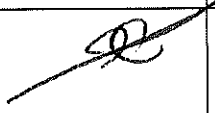


Vão de Portas - 1672 ±3mm					
Doors Length - 1672 ±3mm					
#1	#2	#3			
1671	1672	1673	DIMENSÃO SUPERIOR		
1672	1672	1674	HIGHER DIMENSION		
1671	1672	1675	CENTRAL DIMENSION		
			LOWER DIMENSION		
Diagonal da portac - diferença D1-D2 ≤4 mm					
D1	D2	D1-D2	#1	#2	#3
2151	2149	2	2149	2148	2149
2149	2147	2	2147		
2			2		

Project: PRASA SI, CB2220.323.V29	Rev.	29
	Date-	28/10/2023
DTR30223319/2 Carshell Assembly TC		
Specifications of Details for CBS measurement		
Dye penetrant test		
 Dye penetration test to be performed by quality personnel		
Item	Description of the issue	QTY
Signature/Date (Quality)	Signature/Date (Manufacturing)	
Check List Items		
II.2 - Check List REX		
Item	Picture/Drawing	Description
		Criteria/Record
Signature/Date (Manufacturing)	Signature/Date (Quality)	
N/A		To complete REX
Refer to REX. New defects must be added on the REX		

Self Inspection - Final Result

Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)

SIGNATURE	NAME	DATE	GO		HOLD POINT
			Operations	Industrial Quality	
	M. Choudhury	09/09/2024	If activities are not complete, the missing activities must not impact the next stage!	Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	
	M. Choudhury	11/02/2024	There are activities pending that impact the activities of the next process Obs: (To describe problems below)	There are non-conformities impact the quality of the product and there is no corrective action defined yet!	
			Operations	Industrial Quality	

In case of "NO GO", describe blocking problems

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

Item	Description	Action	Responsible	Due date	Status

Operations

Quality

APPLICABLE FOR TRAINSET 100+ ONLY AS PER BASELINE 10.3.1

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.

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CIBELQ

D100000223319 Carshell Assembly TC

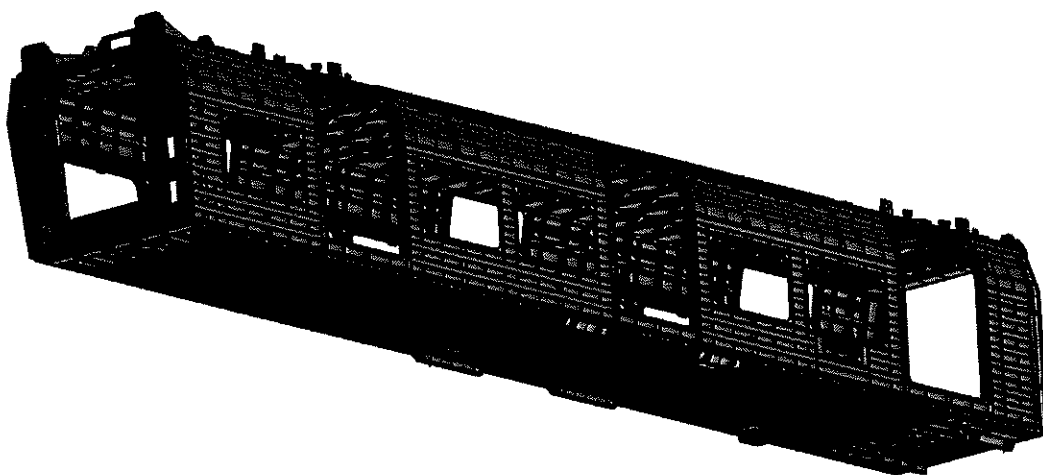
Rev. 30
Date- 06/11/2023
Project: PRASA
SI.CB1230.324.V29

Work station:
CB1230

NCR:

Carro

Safety Related



I - Documentation and Instruments

I.1 - Documentation Control

Type of car		Revision		Observation		Signature/Date (Operations)		Signature/Date (Quality)	
TC1									
M1									
M2									
M3									
M4									
TC2									
Document		Revision		Observation		Signature/Date (Operations)		Signature/Date (Quality)	
DT00000223319						06/11/2023		06/11/2023	

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments		Validation		Calibration or Verification		Signature/Date (Operations)		Signature/Date (Quality)	
measuring tape		418170084		2023/03/31		06/11/2023		06/11/2023	
4x vibration square		418150140		26/06/2024		06/11/2023		06/11/2023	
vibration		223/6		2023/02/10		06/11/2023		06/11/2023	

I.3 Consumables

Welding Consumable Control - Used for Special Process

Welding Consumable Control - Used for Special Process		Welding Process		Signature/Date (Manufacturing)		Signature/Date (Quality)	
Filler Material		Weld Number		06/11/2023		06/11/2023	
308		0851566		06/11/2023		06/11/2023	
308		73092		06/11/2023		06/11/2023	

Rev. 30 Date- 06/11/2023 Project: PRASA SI.CB1230.324.V29	DT00000223319 Carshell Assembly TC	
	II - Control Activities of Production	
	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° DT00000223319	DT00000223319	-	12/02/24 MBSda.	12/02/24 MBSda.
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality.	DTD00000210675	-	12/02/24 MBSda.	12/02/24 MBSda.
03	REFER TO ANNEXURE A	Arc Welding inspected and approved according procedure.	IND-SAL-WMS-016 DTD00000210675	-	12/02/24 MBSda.	12/02/24 MBSda.
04	N/A	Functional dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document.	Approved according specified on pages below.	-	12/02/24 MBSda.	12/02/24 MBSda.
05	N/A	Perform visual inspection of welds in 100% of the project. Run by penetrant testing in electric arc welding (weld ring) as IND-SAL-WMS-018. Run by penetrant testing as described in DTD00000210658.	As the welding procedure IND-SAL-WMS-018 and DTD00000210658	-	12/02/24 MBSda.	12/02/24 MBSda.
06	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 (1) Min-Max 10°C - 35°C Relative humidity Min - Max (1) Min-Max 25% - 80%	Sealant Batch No: 20019H35P Exp Date: 1/02/2024 Actuals Temperature: 25,8°C Humidity: 49%	-	12/02/24 MBSda.	12/02/24 MBSda.
07	N/A	Verification of sealant application in regions of roof and sideframe finishers.	Sealant must be: -Applied straight and even (1.5mm) -Free of gaps, cracks, damage and debris (flashes, dirt, dust) Refer to Annexure B	-	12/02/24 MBSda.	12/02/24 MBSda.

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DT00000223319 Carshell Assembly TC

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Project: PRASA

END 1
SEALANT

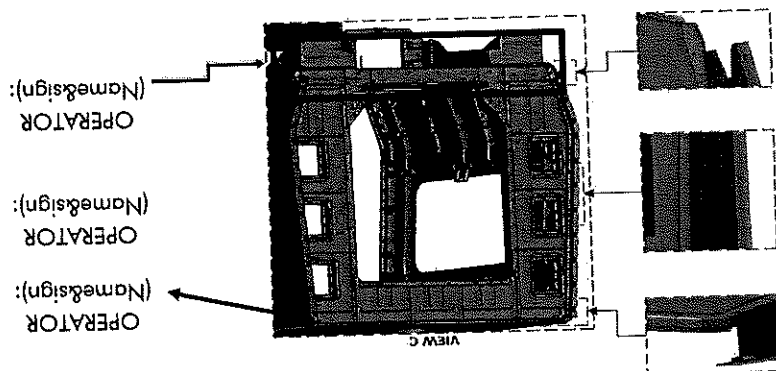
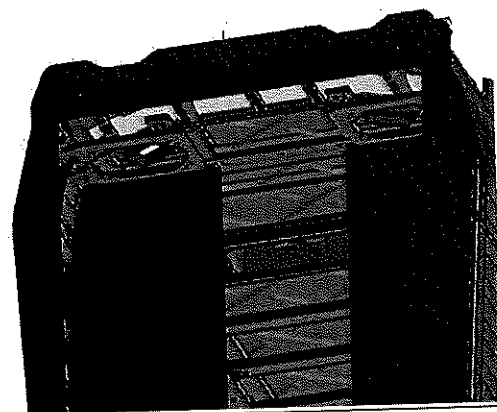
OPERATOR

(Name & sign):

(Name & sign):

Buile 18/10/19

Boilerm 10 1/2



OPERATOR

(Name)

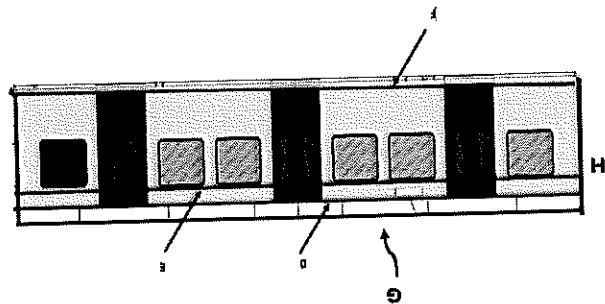
:(u6isx0a0n

2angle

29 April

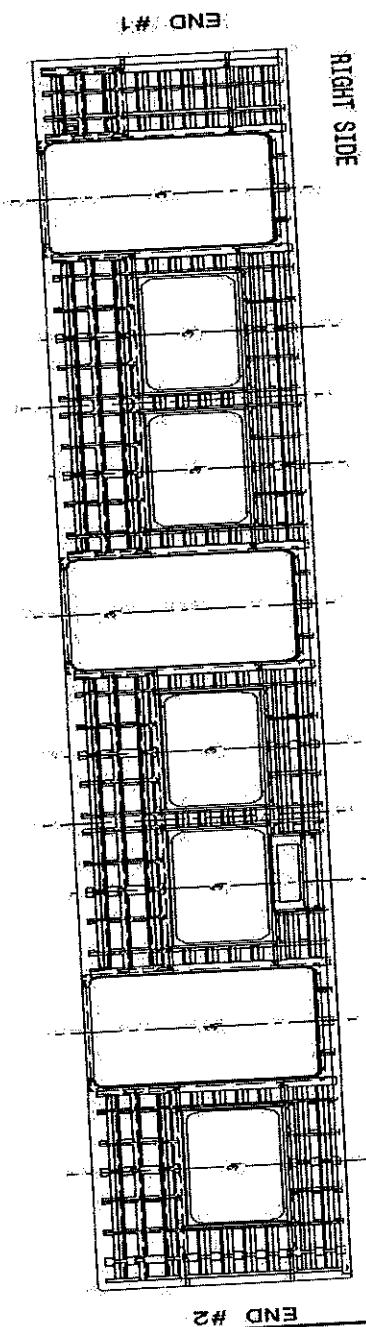
29762

[Faint handwritten notes]

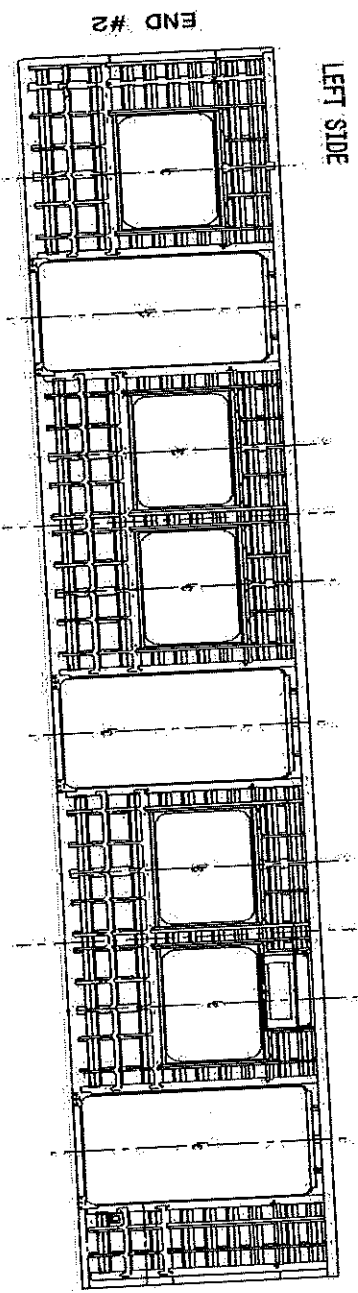


Area D,E,F,G,H,I	Operator (Name & sign) :	<u>DEF, G, H, I</u>	LHS
Operator (Name & sign) :	<u>Both Bulk Assembly</u>		
Operator (Name & sign) :	<u>Both Bulk Assembly</u>		
Operator (Name & sign) :			
Operator (Name & sign) :			
Operator (Name & sign) :			

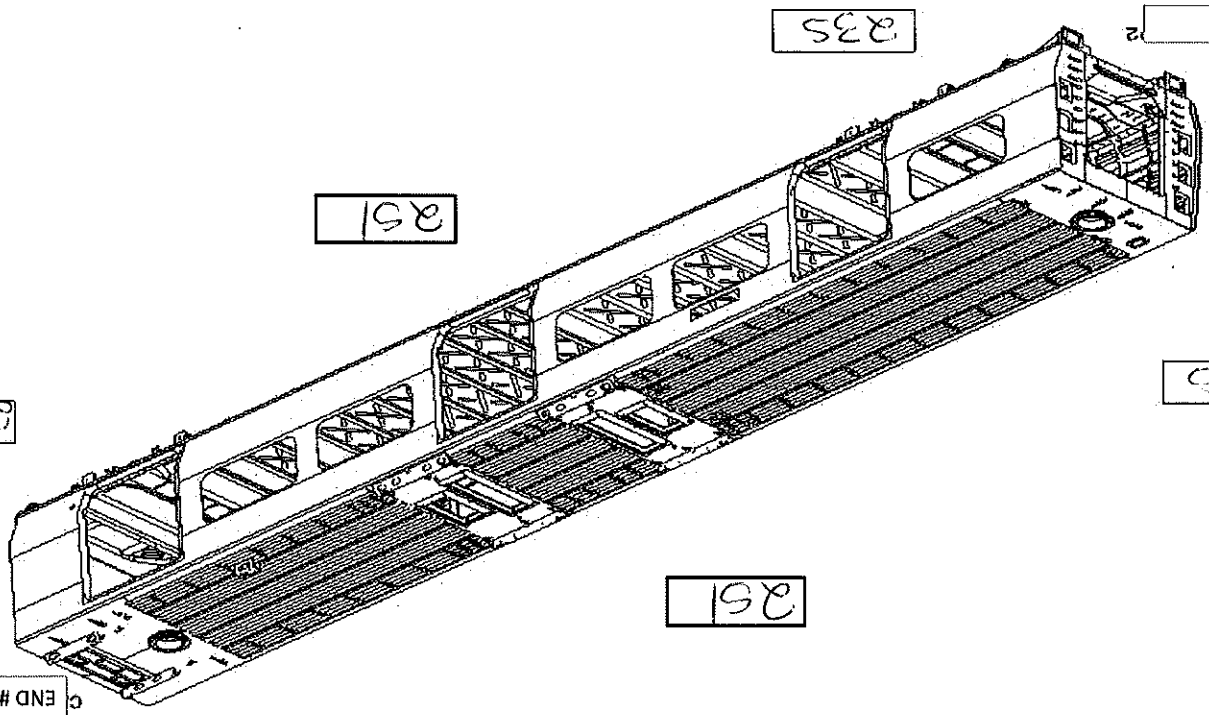
Flatness side left and right maximum of 2mm in the valley to peak
 measured in 900mm. Recod the maximum and minimum value foundand
 indicate the corresponding region.



MAXIMUM 1
 MINIMUM 1.2



MAXIMUM 0.3
 MINIMUM 1



MEASURED CAMBER VALUES

RIGHT	16
LEFT	16

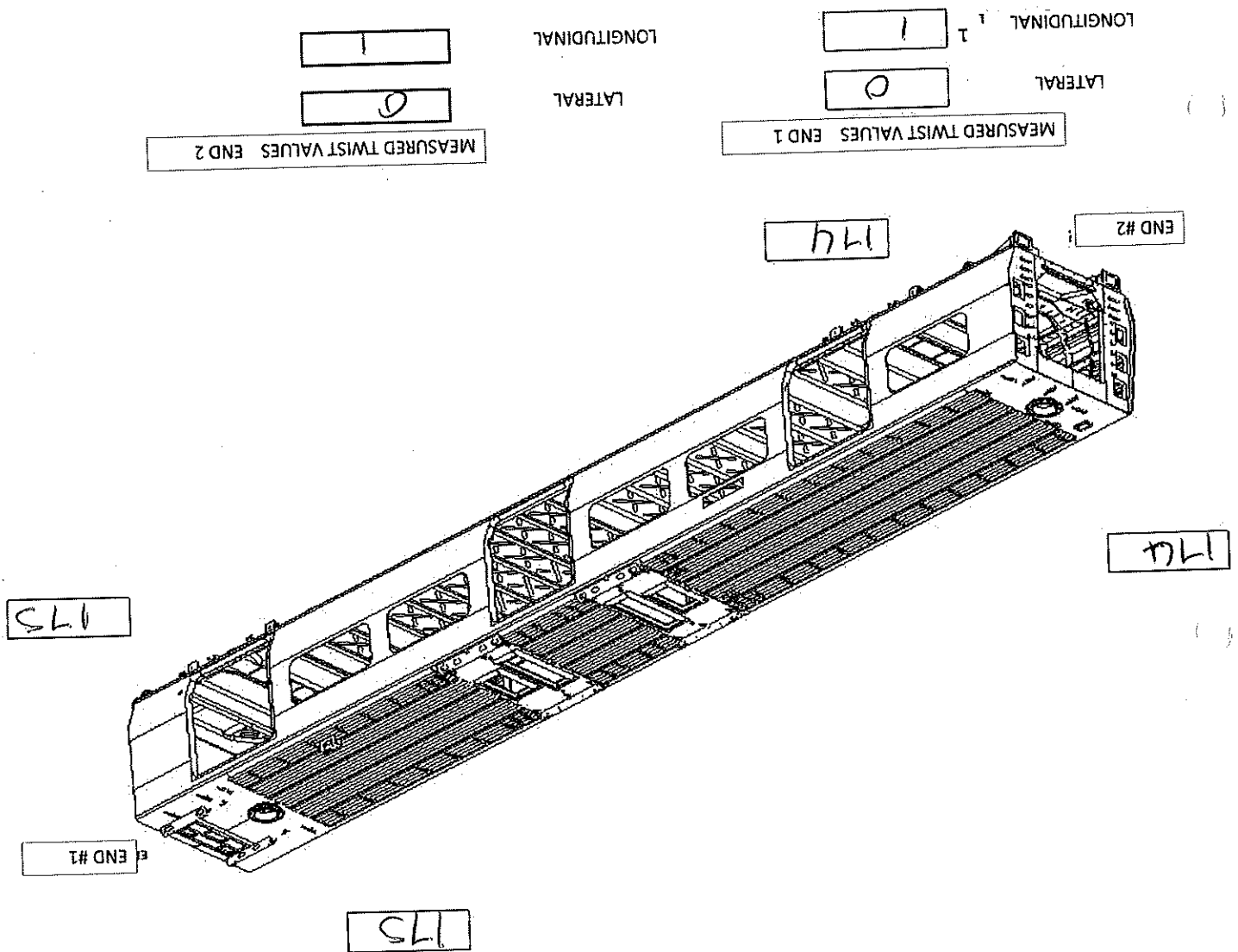
Specified Camber for car out of jig is 16mm (-0mm + 2mm)

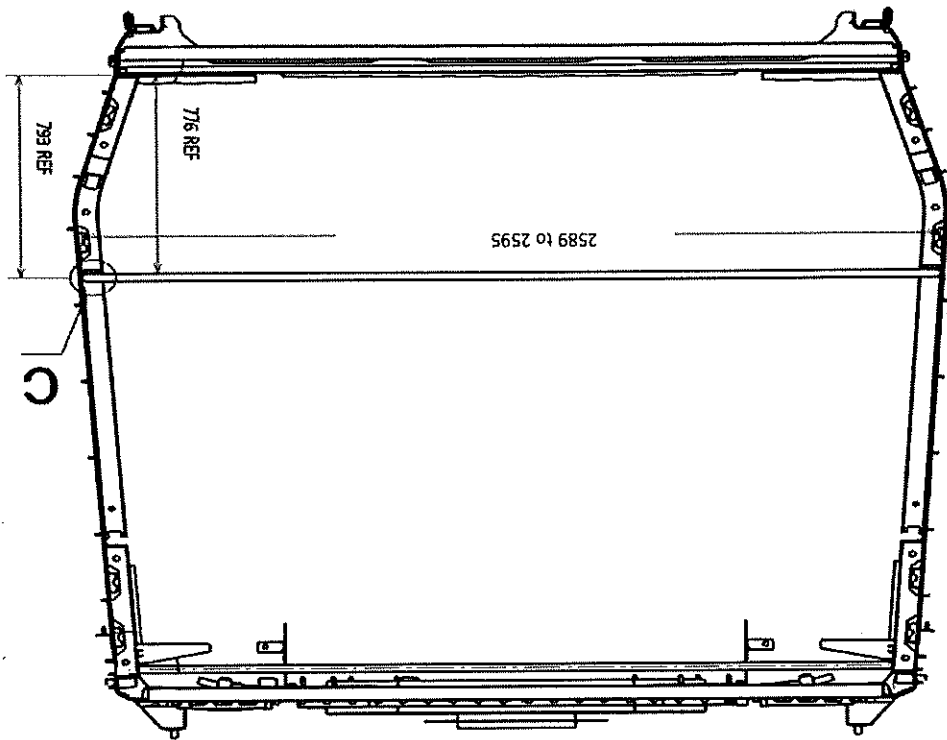
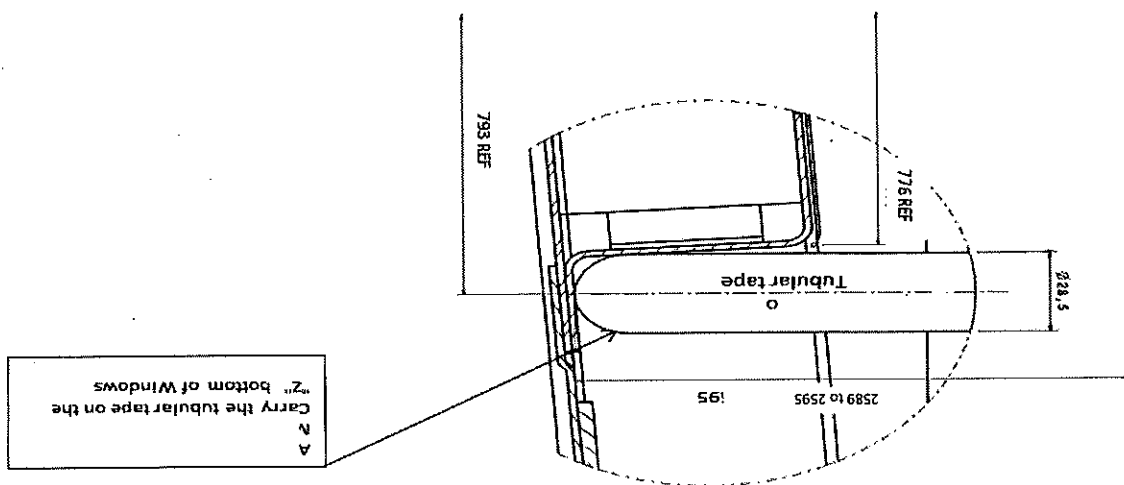
Specifications of Details for CBS measurement CB1230

Project: PRASA SI.CB1230.324.V29	Rev.	30
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	DT00000223319 Carshell Assembly TC	

CIBELA

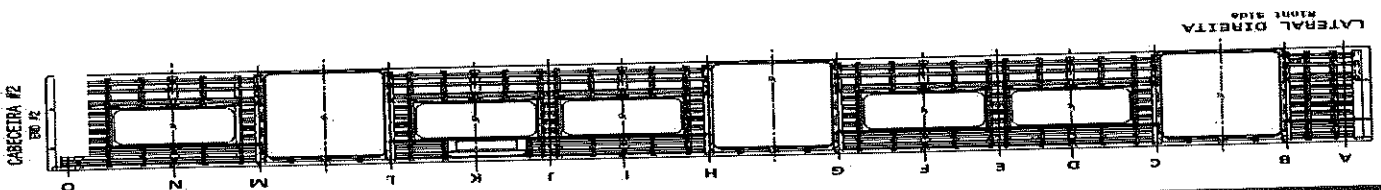
Twist measured in transversal and longitudinal = Maximum 3mm. Measure twist on air spring plates (LHS and RHS), both End 1 and End 2 following twist measurement document.





Specifications of Details for CBS measurement

CIBELA 	DT00000223319 Carshell Assembly TC Project: PRASA SI.CB1230.324.V29 Rev. 30 Date: 06/11/2023
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2589 to 2595mm

25 95

25 93

25 90

25 89

25 91

25 94

25 95

25 94

25 95

25 94

25 89

25 90

25 92

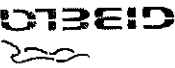
25 95



Threshold Verification					
Door 1	38	38	38	38	38
Door 2	38	38	38	38	38
Door 3	38	38	38	38	38
Door 4	38	38	38	38	38
Door 5	38	38	38	38	38
Door 6	38	38	38	38	38

Nominal value: 38

BOILER MAKER: *Frederico*WELDER: *Marcelo**PRASA*

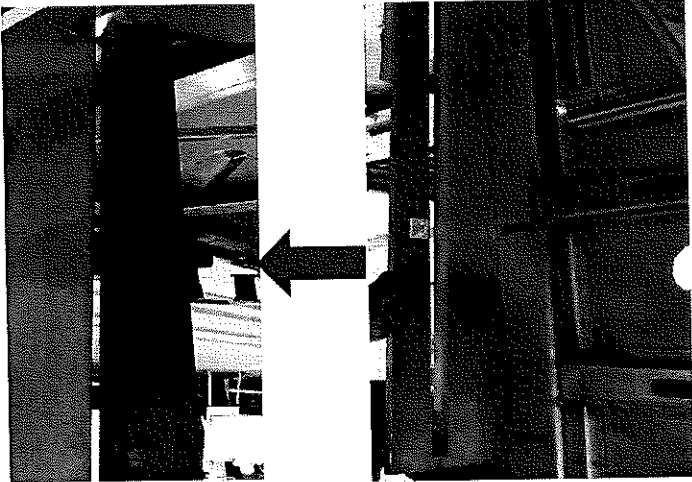
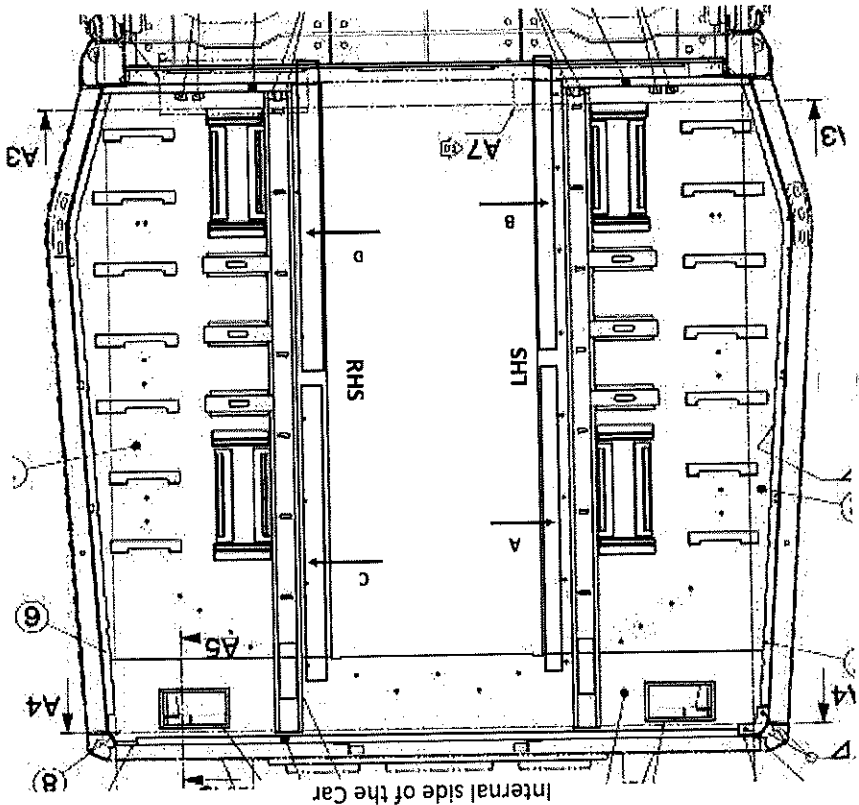
 DT0000223319 Carshell Assembly TC	Rev.	30
	Date-	06/11/2023
	Project: PRASA SI.CB1230.324.V29	

Specifications of Details for CBS measurement

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

ruler and taper gauge.

Specified Maximum Flatness deviation on Cab Fire Barrier = 2mm



Measured Values			
	Minimum	Maximum	Deviation
A	9.3	10.3	2
B	9.9	9.9	0.1
C	9.2	9.2	1
D	9.3	10.1	0.8

A black and white photograph showing three 500ml bottles of 50/50 Vodka. The bottles are arranged in a row, slightly overlapping, and are illuminated from below, creating a strong glow and highlighting the condensation on the glass. The labels on the bottles are visible, showing the '50/50' branding.

Dye-penetration test to be performed by quality personnel

Dye penetrant test

DT00000223319 Carshell Assembly TC

Project: PRASA
SI.CB1230.324.V29

Rgv.	30	Date-	06/11/2023
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Operations

Quantity

Self Inspection - Final Result					
DT00000223319 Carshell Assembly TC		Project: PRASA		SI.CB1230.324.V29	
Rev.	Date-				
30	06/11/2023				
Is the car good to advance to the next workstation/process? (Approval of Operations and Industrial Quality)					
	DATE	NAME	SIGNATURE		
If activities are not complete, the missing activities must not impact the next stage!	12/02/2024	m makhopela	Makhopela		
Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	12/02/2024	Indani	[Signature]		
There are activities pending that impact 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			
HOLD POINT					
In case of "NO GO", describe blocking problems					
In case of "NO GO", the operations manager must define below action plan to ensure "GO":					
Status	Due date	Responsible	Action	Description	Item