APPLICABLE FROM TRAINSET 100+ AS PER BASELINE 10.3.1

SELF INSPECTION SHEET

APPLICATION REFERENCE

MOUNTING	DRAWING	DESCRIPTION	STATION	CAR TYPE						WORK INSTRUCTION	SAFETY ?
				TC1	M4	M1	M2	M3	TC2		
☐ DTR30225487/3	AAD0001278566	CARBODYSHELL M1 ASSEMBLY	CB1210			X				PRA.CB1210.DTR30225487/3.V25	YES
☐											

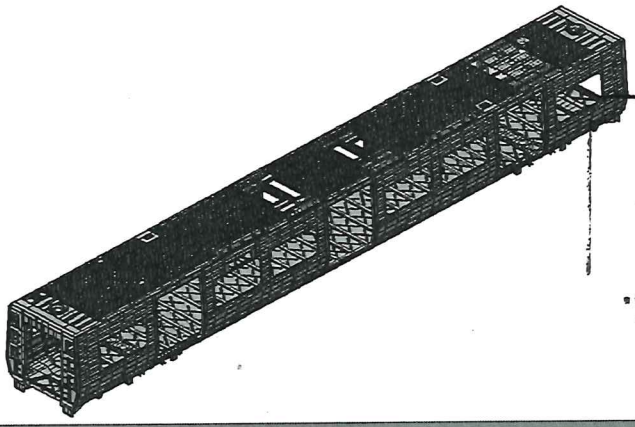
REV	DATE	MODIFICATION CONTENT	RESPONSIBLE	NAME	DATE
0	10/01/2018	GIBELA NEW CREATION	APPROVER	Itumeleng Modiba	10/01/2018
			CHECKER	Nosizo Pindela	10/01/2018
			COMPILER	Thanyani Mathegu	10/01/2018
1	2018/05/18	Team leader and Quality Technician to sign Change final signature from PME Manager to Quality 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	
			CHECKER	Bongane Masina	06/08/2020
			REVISED BY	Bongane Masina	
20	19/04/2021	New Baseline change 10.3	APPROVER	Timothy Maimela	
			CHECKER	Bongane Masina	19/04/2021
			REVISED BY	Bongane Masina	
21	17/08/2021	ADDED DIMENSIONS BEFORE WELDING	APPROVER	Mbhombi collins	
			CHECKER	Mpho Mulaudzi	17/08/2021
			REVISED BY	Mpho Mulaudzi	
25	19/02/2022	New Baseline change 10.3.1	APPROVER	Mbhombi collins	
			CHECKER	Andani Muthelo	19/02/2022
			REVISED BY	Andani Muthelo	
26	14/04/2023	Addition of welding consumable traceability	APPROVER	Ntuli Vanessa	
			CHECKER	Mohlampe Amogelang	14/04/2023
			REVISED BY	Mohlampe Amogelang	
27	27/07/2023	Added verification of loaded parts	APPROVER	Ngobeni Tyson	
			CHECKER	Zwane Ntokozo	27/07/2023
			REVISED BY	Mohlampe Amogelang	
28	07/11/2023	Addition of welding traceability	APPROVER	Ngobeni Tyson	
			CHECKER	Andani Muthelo	07/11/2023
			REVISED BY	Ntokozo Zwane	

TRAINSET	CAR	OPERATOR NAME& ALPS NO	DATE	SELF INSPECTION NUMBER	PAGES
TS 213	M1	Itumeleng 40081	20.02.24	SI.CB1210.254.V28	17

GIBELA	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

Car: M1	NCR:	Work station: CB1210

Safety Related



GIBELA
2024 -03- 21
INDUSTRIAL QUALITY
MAINLINE

I - Documentation and Instruments Control

I.1 - Documentation Control

Document	Type of car TC1	M1	M2	M3	M4	TC2	Revision	Obsevation	OK	NOK	Rework	Signature/Date (Manufacturing)	Signature/Date (Quality)
DTR30225487/3		✓					28		OK			20.02.24	20/2/24

I.2 - Instruments Control

Monitoring and Measuring Instrument Control - Used for Special Process

Instruments	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
(30m) TAPE	GIBTP0084	2023/03/31	OK		20.02.24	20/2/24
Tubular Laser TAPE	2273 / 12542924	2023/08/03 / 2024/01/08	OK		20.02.24 / 20.2.24	20/2/24

1.3 Consumables

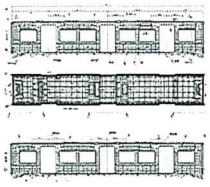
Welding Consumable Control - Used for Special Process

Filler Material	Heat Number	Welding Process	OK	NOK	Signature/Date (Manufacturing)	Signature/Date (Quality)
ER 308 LSi	314018	MIG	OK		20.02.24	20/2/24
ER 308 L 1.6 mm	99687-70822	1/6	OK		20.02.24	

GIBELO	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28 Date 07/11/2023	Project: PRASA SI.CB1210.254.V28

II - Self Inspection - Items to Check

II.1 - Items to check

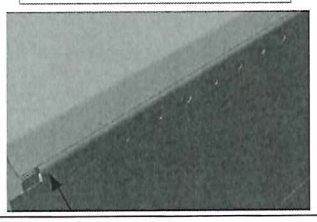
Item	Picture/Drawing	Description	Acceptance criteria / Record	OK	NOK	Rework	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	Verification of correct parts loaded (Sidewalls,Endframes,Roof and Underframe)	DT00000311225	✓			20.02.24	29/02/24
02	N/A	Carshell free of significant flaws which compromise the appearance or functionality	DTD0000210675		✓		20.02.24	
03	REFER TO ANNEXURE A	Spot welding inspected and approved according to procedure	**IND-SAL-WMS-016 e DTD0000210675**	✓			20.02.24	
04	REFER TO ANNEXURE B	Arc welding inspected and approved according to procedure	**IND-SAL-WMS-016 REFER TO GIB - TYPDEF - ARC - 0000**	✓			20.02.24	29/02/24
05		Cleaning of all Stainless Steel Surface	**According TO GIB-WEL - PROC-0002**	✓			20.02.24	
06		Functionals dimensions approved according drawing or complementary document approved by Alstom engineering and registered in this document	Approved according specified on pages below.	✓			20.2.24	29/02/24
07	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 welds (weld ring) and fillet sampling as described in DTD0000210658.	As the welding procedure IND-SAL-WMS-018 and DTD0000210658.	✓			20.02.24	

GIBELO
2024 -03- 21
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

Welder Traceability

Roof ring welds



LHS

Boiler maker (Name & Sign): Innocent Welder (Name & Sign): Thabang

RHS

Boiler maker (Name & Sign): Innocent Welder (Name & Sign): Siphokazi

END 1

LHS

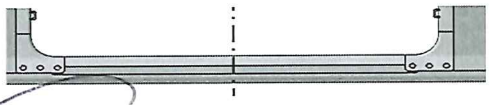
Boiler maker (Name & Sign): Welder (Name & Sign): Thabang

RHS

Boiler maker (Name & Sign): Welder (Name & Sign): Siphokazi

END 2

Door ring welds



LHS

Boiler maker (Name & Sign):

Welder (Name & Sign): Thabang

RHS

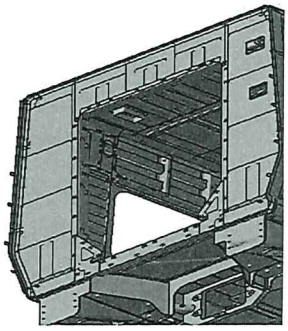
Boiler maker (Name & Sign):

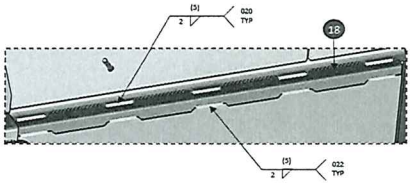
Welder (Name & Sign): Thabang

GIBELA
2024 -03- 21
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28 Date 07/11/2023	Project: PRASA SI.CB1210.254.V28

EUF Reinforcement Plates



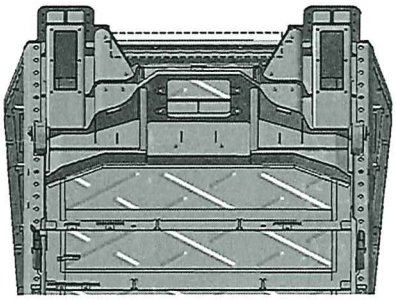


END 1

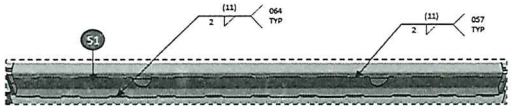
Boiler maker (Name & Sign): Stan

Welder (Name & Sign): SIPHOKAZI

END 2



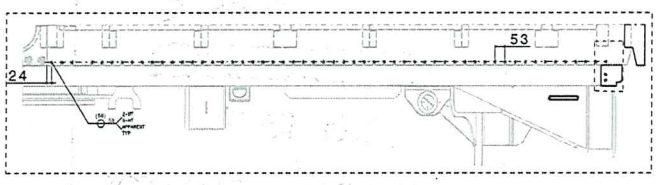
Underneath the CAR



END 2

Boiler maker (Name & Sign): Justice

Welder (Name & Sign): THABANG



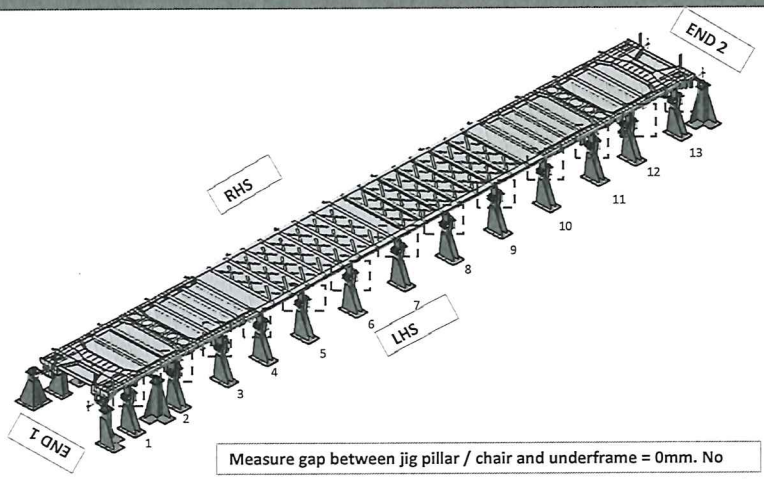
FEDOLI

OPERATOR: LUNGA

GIBELA
2024 -03- 21
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

Specifications of Details for CBS measurement



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

After loading and clamping

Fill in the gap foundon 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	1	1	0	0	1	0	0	0	0	0	1
Right Hand Side	0	0	0	1	0	0	0	0	0	0	0	0	0

Signature Operations: [signature] Date: 20.02.24

After Welding.

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

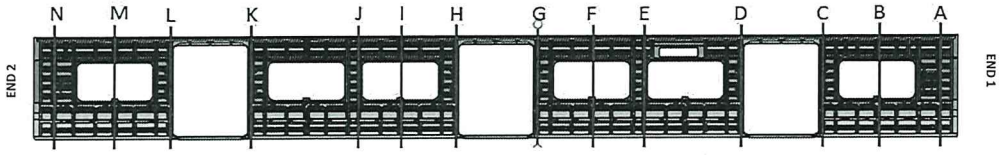
	1	2	3	4	5	6	7	8	9	10	11	12	13
Left Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0
Right Hand Side	0	0	0	0	0	0	0	0	0	0	0	0	0

Signature Industrial Quality: [signature] Date: 21/03/24

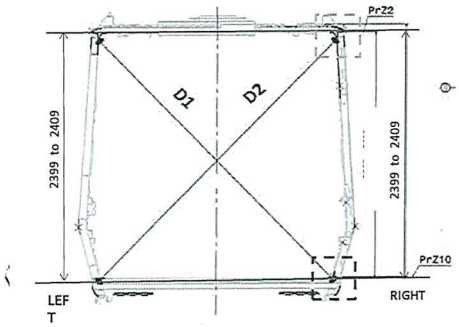
GIBELA
2024 -03- 21
INDUSTRIAL QUALITY
MAINLINE

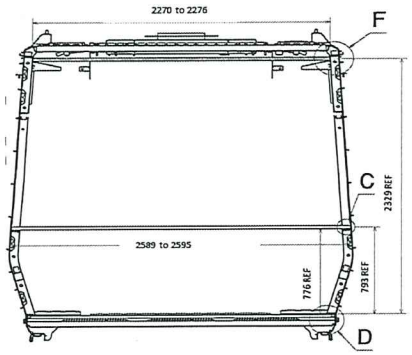
GIBELO	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA
		Date 07/11/2023	SI.CB1210.254.V28

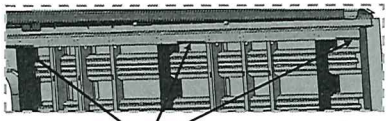
Specifications of Details for CBS measurement



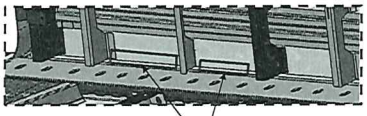
9



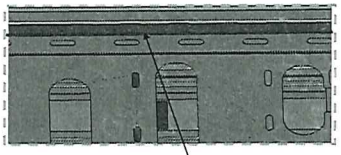




Measurement positions on roof rail and sidewall omega corner.



Measurement positions on sidewall and side sill corner.

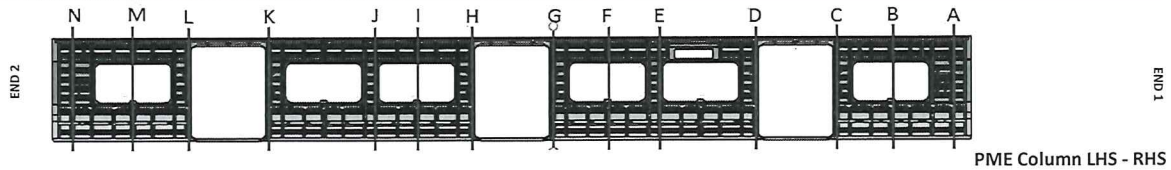


Reinforcement area measurement positions on roof reinforcement area.

GIBELO
2024 -03- 21
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA
		Date 07/11/2023	SI.CB1210.254.V28

Specifications of Details for CBS measurement



PME Column LHS - RHS should be ≤2MM on each point.

BEFORE WELDING

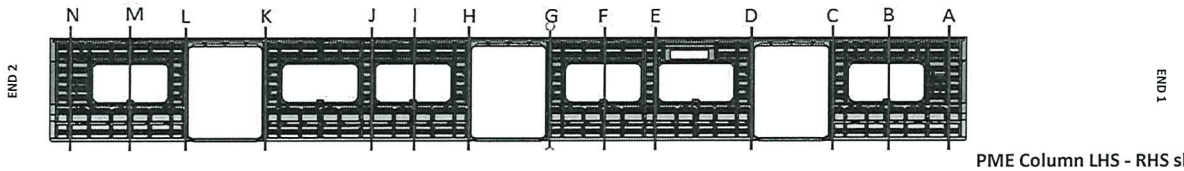
	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3268	3269	1	2406	2406	0
B	3270	3272	2	2405	2406	1
C	3267	3267	0	2406	2405	1
D	3268	3268	0	2406	2406	0
E	3274	3275	1	2405	2404	1
F	3272	3270	2	2406	2406	0
G	3267	3267	0	2405	2406	1
H	3268	3268	0	2404	2406	2
I	3273	3270	3	2405	2406	1
J	3276	3275	1	2406	2407	1
K	3266	3266	0	2406	2406	0
L	3267	3267	0	2404	2405	1
M	3269	3267	2	2405	2406	1
N	3265	3265	0	2405	2406	0

20.02.24

GIBELA
2024 -03- 21
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA
		Date 07/11/2023	SI.CB1210.254.V28

Specifications of Details for CBS measurement



PME Column LHS - RHS should be ≤2MM on each point.

AFTER WELDING

	Record D1 values	Record D2 values	D1-D2 ≤ 5mm	2399 to 2409	2399 to 2409 (RHS)	LHS-RHS ≤ 2
A	3296	3296	0	2404	2404	0
B	3269	3267	2	2404	2406	2
C	3298	3298	0	2406	2406	0
D	3297	3297	0	2406	2406	0
E	3276	3276	0	2405	2405	0
F	3273	3272	1	2406	2404	2
G	3298	3298	0	2404	2404	0
H	3296	3296	0	2406	2406	0
I	3270	3272	2	2406	2405	1
J	3274	3275	1	2404	2407	3
K	3297	3298	1	2405	2406	1
L	3298	3298	0	2406	2404	2
M	3269	3270	1	2405	2405	0
N	3297	3297	0	2406	2406	0

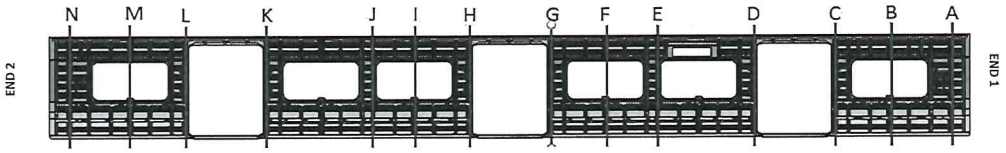
20.02.24

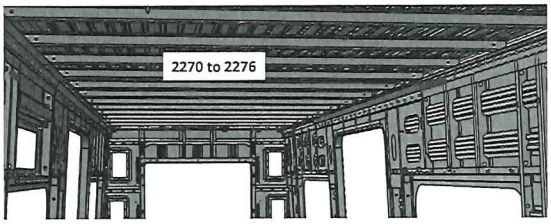
GIBELA
2024 -03- 21
INDUSTRIAL QUALITY
MAINLINE

GIBELO	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

CBS measurement

BEFORE WELDING



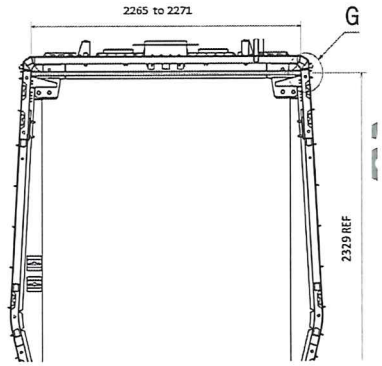


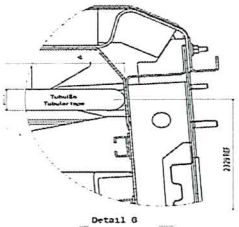
Do not consider reinforcement (Take measurements top area of zee profile

2270 to 2276

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

1990 to





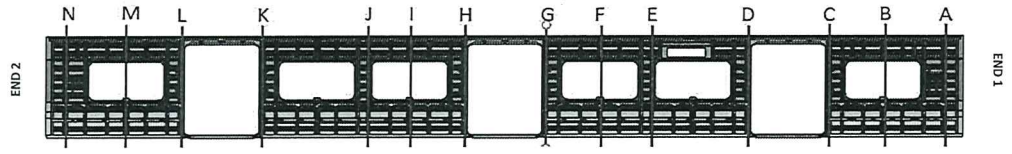
GIBELO
2024 -03- 21
INDUSTRIAL QUALITY MAINLINE

20.02.24

GIBELA	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

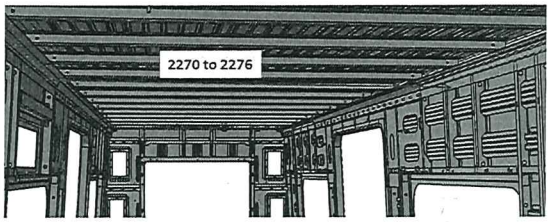
CBS measurement

AFTER WELDING

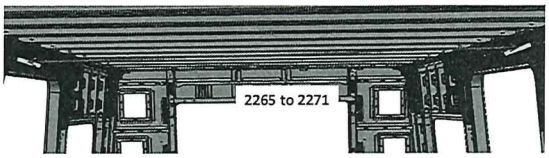


	2265 to 2271	2270 to 2276
A	2267	N/A
B	N/A	2272
C	2268	N/A
D	2269	N/A
E	N/A	2276
F	N/A	2273
G	2267	N/A
H	2269	N/A
I	N/A	2275
J	N/A	2276
K	2266	N/A
L	2277	N/A
M	N/A	2273
N	2269	N/A

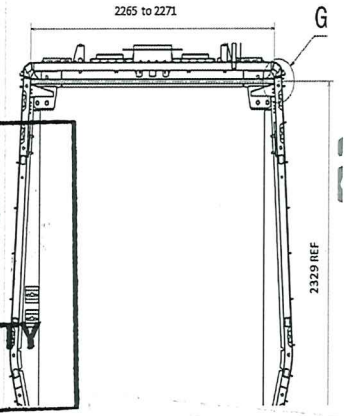
END 2



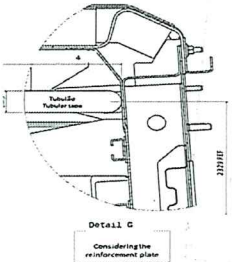
Do not consider reinforcement (Take measurements top area of zee profile



Take measurement close to radius (considering reinforcement)



GIBELA
2024 -03- 21
2265 to 2271
INDUSTRIAL QUALITY
MAINLINE

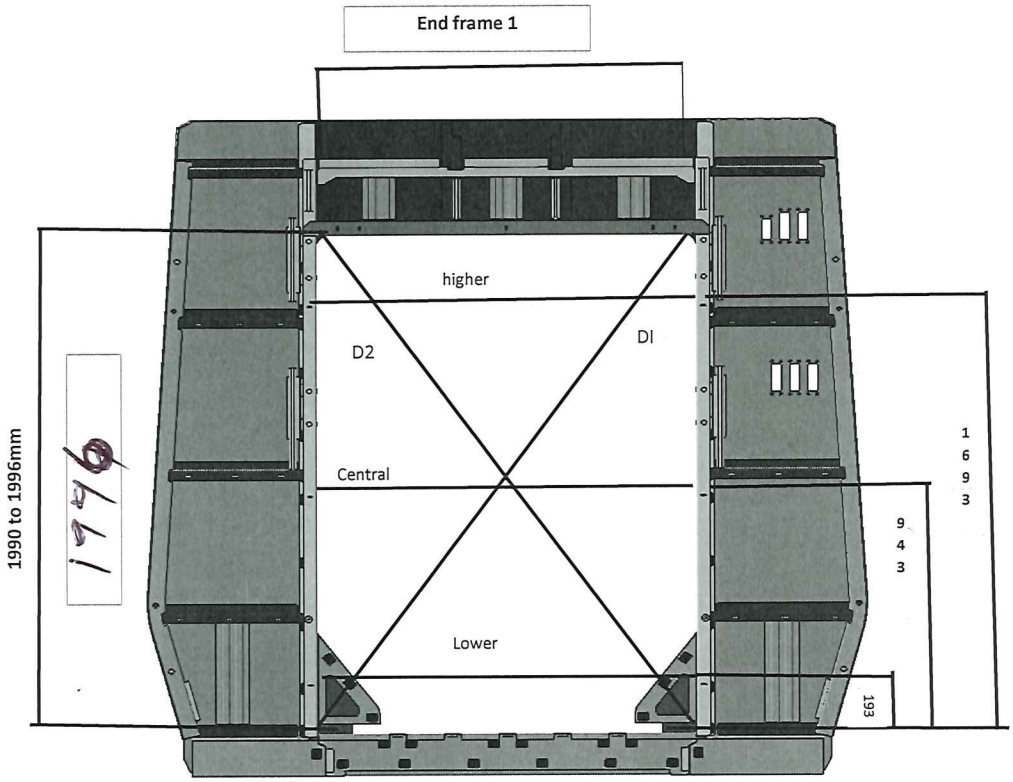


2265 to 2271

20.02.24

GIBELA	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA
		Date 07/11/2023	SI.CB1210.254.V28

Specifications of Details for CBS measurement



1380 to 1382 mm

DIAGONAL DIFFERENCE **D1-D2** ≤ 3mm

Higher Dimension	1381	D1	2418
Central Dimension	1380	D2	2415
Lower Dimension	1380	D1-D2	3

20.02.24

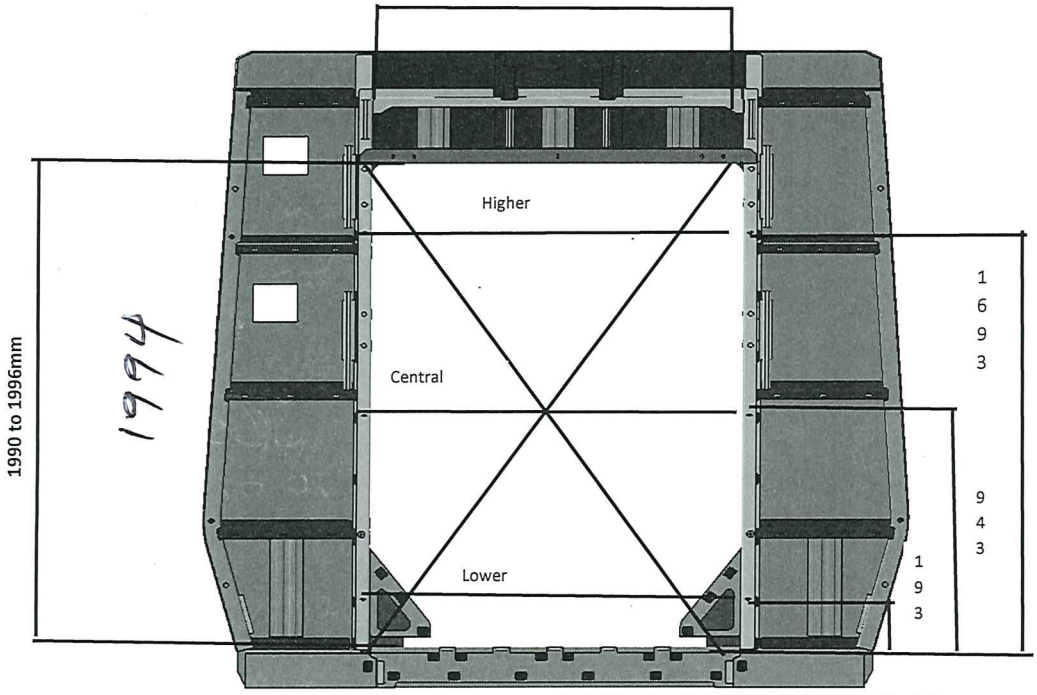
GIBELA
2024 -03- 21
INDUSTRIAL QUALITY
MAINLINE

GIBELO	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA SI.CB1210.254.V28
		Date 07/11/2023	

Specifications of Details for CBS measurement

Endframe 2

1380 to 1382 mm



1380 to 1382 mm

DIAGONAL DIFFERENCE **D1-D2** ≤ 3mm

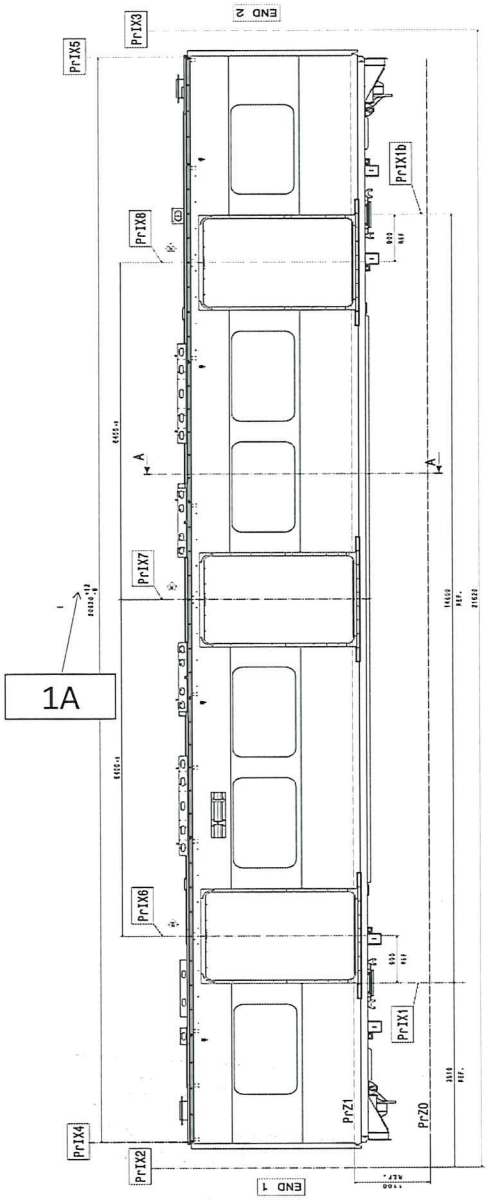
Higher Dimension	1380	D1	2417
Central Dimension	1381	D2	2415
Lower Dimension	1381	D1-D2	2

20.02.24

GIBELO
2024 -03- 21
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA
		Date 07/11/2023	SI.CB1210.254.V28

Specifications of Details for CBS measurement



	LEFT SIDE	
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20630

	RIGHT SIDE	
	SPECIFICATION SIZE	ACTUAL SIZE
1A	20632 - 20614	20628

20.02.24

GIBELA
2024 -03- 21
INDUSTRIAL QUALITY
MAINLINE

Dye penetrant test

Dye-penetration test to be performed by quality personnel

GIBELO	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28 Date 07/11/2023	Project: PRASA SI.CB1210.254.V28

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	NOK	Rework	Signature/Date (Manufacturing)	Signature/Date (Quality)
01	N/A	To complete REX	Refer to REX. New defects must be added on the REX					

GIBELO
2024 -03- 21
INDUSTRIAL QUALITY
MAINLINE

GIBELA	CARBODYSHELL M1 ASSEMBLY DTR30225487/3	Rev. 28	Project: PRASA
		Date 07/11/2023	SI.CB1210.254.V28

Self Inspection - Final Result

				DATE	NAME	SIGNATURE
HOLD POINT		GO	(If activities are not complete, the missing activities must not impact the next stage)	20.02.24	Tumelo Operations	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.)	12/03/2024	*pp Ntokozo Zwane Industrial Quality	
		NO GO	There are activities pendings 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

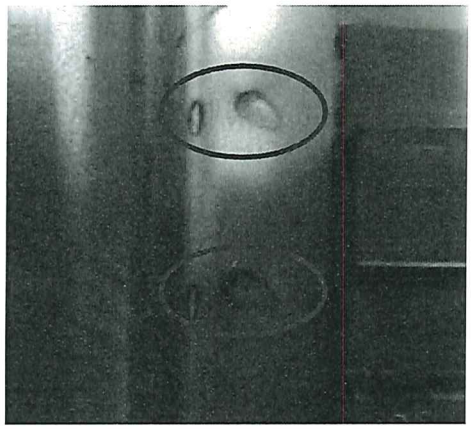
Operations

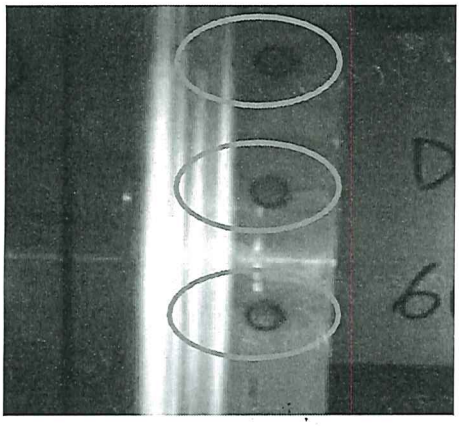
Quality

*ACCEPTED ACCORDING TO DEROGATION PRASA - DERSU - 1177

GIBELA
2024 -03- 21
INDUSTRIAL QUALITY MAINLINE

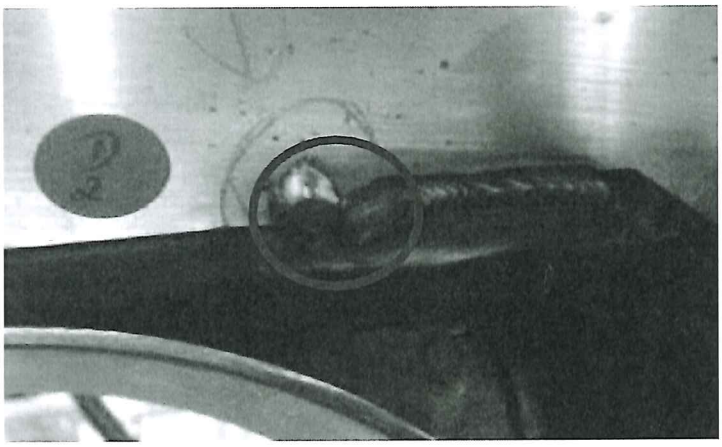
ANNEXURE A: Spot Welding Quality Acceptance Standard





GIBELA
2024 -03- 21
INDUSTRIAL QUALITY
MAINLINE

ANNEXURE B: Arc Welding Quality Acceptance Standard



GIBELA
2024 -03- 21
INDUSTRIAL QUALITY
MAINLINE