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

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

TUE	CAR	OPERATOR NAME	DATE	SELF INSPECTION NUMBER	PAGES
Ts 214	M3	Andrew	18/03/24	**SI.FT1140.52**	01/08

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Rev:09	Projet: PRASA	SI.FT1140.52
Date: 5/31/2022		

Car:

NCR:

Safety Related

Work Station: FT1140

1 - Document and Instrument Control

1.1 - Documents control

Document	TC1	M1	M2	M3	M4	TC2	Revision	Remark	OK	NOK	Signature/Date
PRA.FT1140.04											
PRA.FT1140.05				✓							
PRA.FT1140.05									✓		18/03/24

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

Instruments description	Serial number	Calibration or Verification Validation Date	OK	NOK	Signature/Date
Measuring tape	GIBTA 028	23/11/23-23/11/24	✓		18/03/24
Vernier Caliper	GIBVR 0050	21/11/23-21/11/24	✓		18/03/24
Torque Wrench 330 N.m	A9630053	21/03/23-21/03/24	✓		18/03/24
Torque Wrench 150 N.m	B7217566	07/08/23-07/08/24	✓		18/03/24
Torque Wrench 35 N.m	D25U023	07/08/23-07/08/24	✓		18/03/24

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Rev:09	Projet: PRASA	SI.FT1140.52
Date: 5/31/2022		

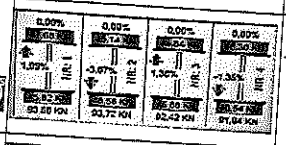
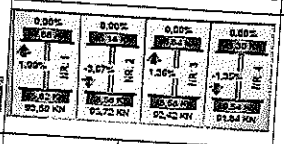
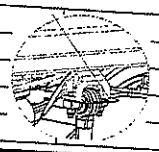
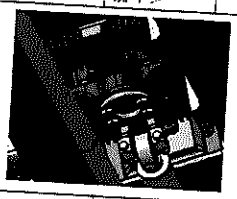
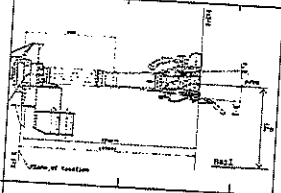
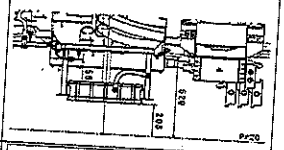
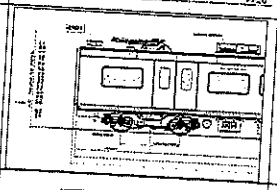
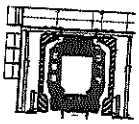
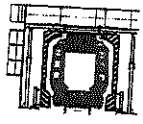
II - Self Inspection - Items to Check

II.1 - Items to Check

Item	Picture/Sketch	Description	Criteria/Record	OK	NOK	N/A	Signature/Date
01		Ensure that the average pressure valve (APV) is isolated by capping the two input pipes at the fittings installing the blanking fitting on the pipes highlighted		✓			18/03/24
02		Check underframe pipe system Air tightness. Test performance according to WI PRA.FT1130.15.	The test was performed and no leak was observed. Initial pressure (IP): 7,39 bar Final pressure (FP): 7,86 bar FP - IP = 0,47 bar APPROVAL CRITERIA: After 5-minutes the pressure cannot drops more than 0,2 bar	✓			18/03/24
03		Movement performed at least 50m to shudder the car. And position on the leveled load cell, with wheels on the center.		✓			18/03/24
04		Measurement Inspection was done with car on condition AW0 and the rail levelled. (The load cells system must be levelled and calibrated)	Calibration Validation Date 19/12/2023	✓			18/03/24
05		In case of the equipments not installed, equivalent weight of the item should be added in the same place to simulate the equipment. (Any simulated weight, add on pending list)	EQUIPMENT DESCRIPTION / WEIGHT (kg) GANGWAY 260	✓			18/03/24
06		The pressure difference between air spring on each bogie when raise the pressure was maintened < 0.3 bar.		✓			18/03/24
07		Measuremet recorded with empty suspention and loaded are on conformity with tolerances of the project.		✓			18/03/24
08		All levelling measurements are according to the reference. (Values out of reference must be recorded on "Description of defects")		✓			18/03/24

SELF INSPECTION INDUSTRIAL QUALITY

Rev:09	Projet: PRASA	SI.FT1140.52
Date: 2022/05/31		

Item	Picture/Sketch	Description	Criteria/Record	OK			Signature/Date
09		Check that the levelling rods are torqued and have torque marker.		✓			15/03/24
10		The difference of weight between the left and right wheels of each axis, must be ≤ 4%. (Verify on the T&C equipment if all arrows are in green).		✓			18/03/24
11		Remove the car, move back onto the load cells and repeat the step 09. Confirm if both are in the tolerance of ≤ 4%.		✓			18/03/24
12		1 - Record shims thicknes used on rod. 2 - All screws were torqued and have torque marker.	THICKNESS (mm) I 0 II 0 III 0 IV 0	✓			18/03/24
13		Pivot fixation	1- M20 x 90 screws with application of torque according to PRA.FT1140.04 / 05	✓			18/03/24
14		FOR TC CARS F= Height of the center of Automatic coupler F = 695mm (+5 / -10mm) (Using levelled rail)	TC CAB #1= _____ mm				N/A
15		FOR TC CARS Height of Eurobalise Antenna = 205mm(+/-10mm) (Using levelled rail)	TC CAB #1= _____ mm				N/A
16		Check pantograph piping air tightness. Test performance according to WI PRA.FT1140.17.	The test was performed and no leak was observed. -Roof piping connection fittings. -Room piping connection fittings(Roof arch and door trimming)				N/A
17		Pantograph does not come in contact with the higher height gauge when passing through.	No Contact with Pantograph and Gauge -GO Contact with Pantograph and Gauge - NO GO				N/A
18		Car does not come into contact with the gauge.	No Contact with Car and Gauge -GO Contact with Car and Gauge - NO GO	✓			18/03/24

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

END#1

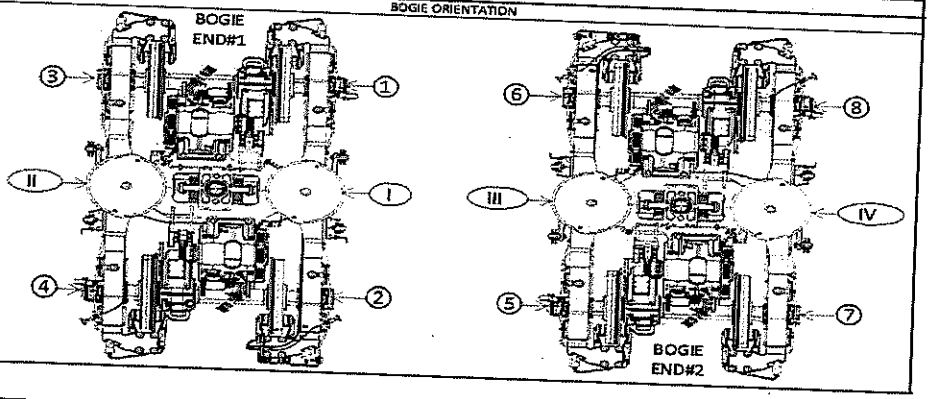
DESCRIPTION	TOLERANCE		LEFT SIDE 6	5	4	3	2	1	RIGHT SIDE 1	2	3	4	5	6	
AIR SPRING HEIGHT (EMPTY)	N/A	A`II													A`I
AIR SPRING HEIGHT (FULL)	min 254 max 261	AII		256	255	255	255	254	249	252	255	254	255		AI
FLOOR COVERING HEIGHT	min 1096 max 1116	EII													EI
AIR SPRING PRESSURE	≤ 0.3 (CI - CI)	CII		2,69	2,63	2,74	2,78	2,87	2,52	2,62	2,71	2,81	2,78		CI
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D3													D1
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D4													D2
PIVOT VERTICAL GAP	min 25 max 32	KII													KI
PIVOT LATERAL STOP GAPS DIFFERENCE	≤ 4 (JII - JI)	JII													JI
QTY OF TURNS OF LEVELLING ROD	N/A	XII		½	0	0	0	1/2	1	1	0	3/4	0		XI
SHIMS OF ANTI-ROLL BAR	N/A	YII													YI
DESCRIPTION	**TOLERANCE**		6	5	4	3	2	1	1	2	3	4	5	6	
AIR SPRING HEIGHT (EMPTY)	N/A	A`III													A`IV
AIR SPRING HEIGHT (FULL)	min 254 max 261	AIII		253	255	250	246	244	249	251	255	255	256		AIV
FLOOR COVERING HEIGHT	min 1096 max 1116	EIII													EIV
AIR SPRING PRESSURE	≤ 0.3 (CV - CIV)	CIII		2,80	2,84	2,77	2,62	2,50	2,05	2,78	2,74	2,65	2,70		CIV
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D5													D7
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D6													D8
PIVOT VERTICAL GAP	min 25 max 32	KIII													KIV
PIVOT LATERAL STOP GAPS DIFFERENCE	≤ 4 (JIV - JIII)	JIII													JIV
QTY OF TURNS OF LEVELLING ROD	N/A	XIII		0	3/4	1	1	1	1	1	0	3/4	0		XIV
SHIMS OF ANTI-ROLL BAR	N/A	YIII													YIV

LEFT SIDE — END#2 — RIGHT SIDE

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

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

BOGIE ORIENTATION



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

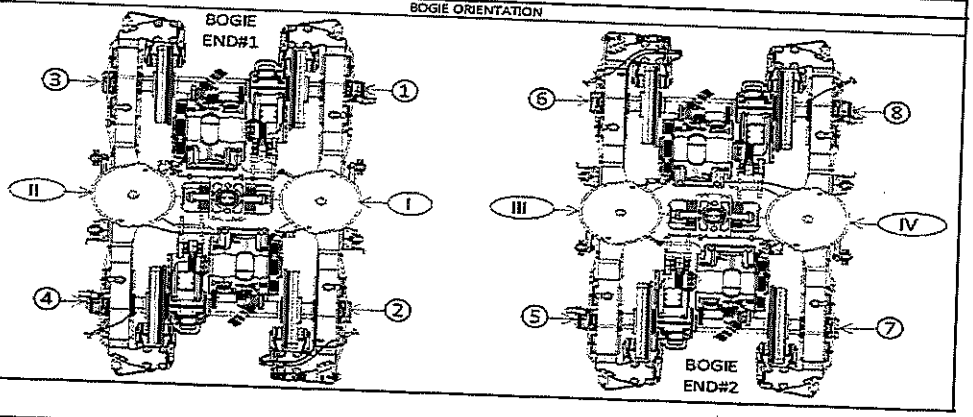
DRAFT TO MEASUREMENTS DURING LEVELLING (ALL UNITS MUST BE IN mm/bar/kg)

DESCRIPTION	TOLERANCE		LEFT SIDE 6	5	4	3	2	1	END#1	1	2	3	4	5	6	RIGHT SIDE
AIR SPRING HEIGHT (EMPTY)	N/A	$A`_{II}$														$A`_{I}$
AIR SPRING HEIGHT (FULL)	min 254 max 261	A_{II}														A_{I}
FLOOR COVERING HEIGHT	min 1096 max 1116	E_{II}														E_{I}
AIR SPRING PRESSURE	≤ 0.3 (C_{II} - C_{I})	C_{II}														C_{I}
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D_3														D_1
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D_4														D_2
PIVOT VERTICAL GAP	min 25 max 32	K_{II}														K_{I}
PIVOT LATERAL STOP GAPS DIFFERENCE	≤ 4 (J_{II} - J_{I})	J_{II}														J_{I}
QTY OF TURNS OF LEVELLING ROD	N/A	X_{II}														X_{I}
SHIMS OF ANTI-ROLL BAR	N/A	Y_{II}														Y_{I}
DESCRIPTION	**TOLERANCE**		6	5	4	3	2	1		1	2	3	4	5	6	
AIR SPRING HEIGHT (EMPTY)	N/A	$A`_{III}$														$A`_{IV}$
AIR SPRING HEIGHT (FULL)	min 254 max 261	A_{III}														A_{IV}
FLOOR COVERING HEIGHT	min 1096 max 1116	E_{III}														E_{IV}
AIR SPRING PRESSURE	≤ 0.3 (C_{IV} - C_{III})	C_{III}														C_{IV}
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D_5														D_7
PRIMARY SUSPENSION	SEE TABLE (ONLY REF)	D_6														D_8
PIVOT VERTICAL GAP	min 25 max 32	K_{III}														K_{IV}
PIVOT LATERAL STOP GAPS DIFFERENCE	≤ 4 (J_{IV} - J_{III})	J_{III}														J_{IV}
QTY OF TURNS OF LEVELLING ROD	N/A	X_{III}														X_{IV}
SHIMS OF ANTI-ROLL BAR	N/A	Y_{III}														Y_{IV}
			LEFT SIDE						END#2							RIGHT SIDE

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

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

BOGIE ORIENTATION



SELF INSPECTION INDUSTRIAL QUALITY

Rev:09		
Date: 5/31/2022	Projet: PRASA	SI.FT1140.52

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

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

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

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

BOGIE ORIENTATION

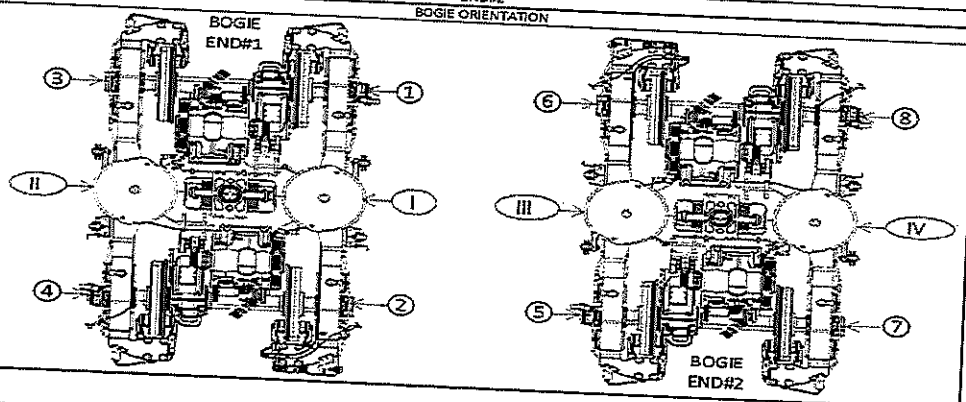


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Table 1 - Reference Values and Measurement Tolerances for the Car Levelling.

ITEM			THEORETICAL VALUES											
			TC1 CAR		M4 CAR		M1 CAR		M2 CAR		M3 CAR		TC2 CAR	
			TBext	TBint	MB1	MB1	MB1	MB2	MB2	MB1	MB1	MB1	TBint	TBext
Pivot lateral stop gaps difference [mm]	Jn-Jn+1 (I≤N)	Fig. 4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4	≤4
Air Spring height (mm)	A_n (I≤N)	Fig. 5	255^{+6}_{-1}	255^{+6}_{-1}	255^{+6}_{-1}	255^{+6}_{-1}	255^{+6}_{-1}	255^{+6}_{-1}	255^{+6}_{-1}	255^{+6}_{-1}	255^{+6}_{-1}	255^{+6}_{-1}	255^{+6}_{-1}	255^{+6}_{-1}
Air spring pressure at AW0 [Bar]	$C_{n\,(I\leq N)}$	Fig. 5	3,76 (Ref.)	2,82 (Ref.)	2,87 (Ref.)	2,83 (Ref.)	3,02 (Ref.)	2,91 (Ref.)	3,07 (Ref.)	2,85 (Ref.)	2,83 (Ref.)	2,87 (Ref.)	2,83 (Ref.)	3,76 (Ref.)
	$C_I - C_{II}$ $C_{III} - C_{IV}$		0,3 Máx.	0,3 Máx.	0,3 Máx.	0,3 Máx.	0,3 Máx.	0,3 Máx.	0,3 Máx.	0,3 Máx.	0,3 Máx.	0,3 Máx.	0,3 Máx.	0,3 Máx.
Primary Suspension gaps [mm]	$D_1; D_5$ $D_2; D_6$ $D_3; D_7$ $D_4; D_8$	Fig. 6	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}	35^{+12}_{-5}
Carbody Floor height [mm]	$E_{n\,(I\leq N)}$	Fig. 7	1106^{+10}_{-10}	1106^{+10}_{-10}	1106^{+10}_{-10}	1106^{+10}_{-10}	1106^{+10}_{-10}	1106^{+10}_{-10}	1106^{+10}_{-10}	1106^{+10}_{-10}	1106^{+10}_{-10}	1106^{+10}_{-10}	1106^{+10}_{-10}	1106^{+10}_{-10}
Bolster height [mm]	$N_{n\,(I\leq N)}$	Fig. 7	850^{+3}_{-7}	850^{+3}_{-7}	850^{+3}_{-7}	850^{+3}_{-7}	850^{+3}_{-7}	850^{+3}_{-7}	850^{+3}_{-7}	850^{+3}_{-7}	850^{+3}_{-7}	850^{+3}_{-7}	850^{+3}_{-7}	850^{+3}_{-7}
Coupling End height [mm]	F_1	Fig. 8	895 (Ref.)		760 (Ref.)		760 (Ref.)		760 (Ref.)		760 (Ref.)		895 (Ref.)	
	F_2	Fig. 9	760 (Ref.)		760 (Ref.)		760 (Ref.)		760 (Ref.)		760 (Ref.)		760 (Ref.)	
Pivot Vertical gap [mm]	K_n	Fig. 10	30^{+15}_{-5}	30^{+15}_{-5}	30^{+15}_{-5}	30^{+15}_{-5}	30^{+15}_{-5}	30^{+15}_{-5}	30^{+15}_{-5}	30^{+15}_{-5}	30^{+15}_{-5}	30^{+15}_{-5}	30^{+15}_{-5}	30^{+15}_{-5}

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		Date: 5/31/2022		

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

References for secondary suspention empty
A`n Air spring height empty

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

Item	Reference [mm]	END#1				END#2			
		Right Side		Left Side		Left Side		Right Side	
A'n	N/A	A'I	241	A'II	241	A'III	238	A'IV	239
An	254 to 261	AI	257	AII	258	AIII	256	AIV	258
Bn = An - A'n	N/A	BI	16	BII	17	BIII	18	BIV	19
En	1106 ±10 mm	EI	1112	EII	1111	EIII	1109	EIV	1110

Item	Reference [bar]	END#1				END#2			
		Right Side		Left Side		Left Side		Right Side	
Cn	Table 02 (*)	CI	2,77	CII	2,69	CIII	2,77	CIV	2,69
Cn - Cn+1	Diference ≤ 0,3	CI - CII	0,08			CIII - CIV	0,08		
Gauge serial number	N/A	GIBO5875		GIBO5875		GIBO5875		GIBO5875	

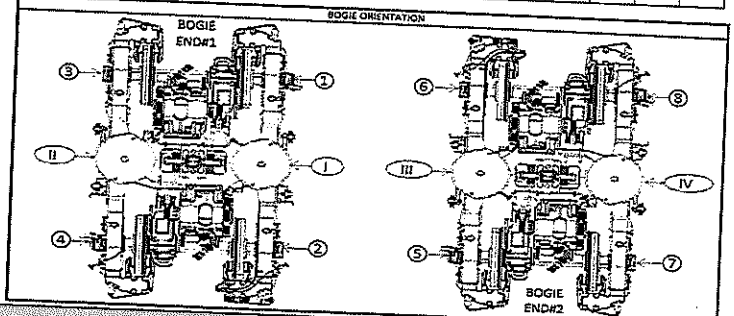
Item	Reference [mm]	END#1				END#2			
		Right Side		Left Side		Left Side		Right Side	
Dn	Table 01 (*)	D1	46,40	D3	46,41	D5	45,80	D7	46,62
		D2	46,77	D4	46,87	D6	45,60	D8	46,80
Kn	25 to 45	KI	35,08			KII	35,95		
Jn	Diference ≤ 4	JI	24,49	JII	25,35	JIII	25,80	JIV	25,08

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

Table 01 D Theorethical Values	TC1		M4		M1		M2		M3		TC2	
	Tbex	TBin	Mb1	Mb1	Mb1	Mb2	Mb2	Mb1	Mb1	Mb1	Tbin	Tbex
D=	35 +12 −5	35 +12 −5	35 +12 −5	35 +12 −5	35 +12 −5	35 +12 −5	35 +12 −5	35 +12 −5	35 +12 −5	35 +12 −5	35 +12 −5	35 +12 −5

Table 02 C Theorethical Values	TC1		M4		M1		M2		M3		TC2	
	Tbex	TBin	Mb1	Mb1	Mb1	Mb2	Mb2	Mb1	Mb1	Mb1	Tbin	Tbex
C=	3.76	2.82	2.87	2.83	3.02	2.91	3.07	2.85	2.83	2.87	2.83	3.76

BOGIE ORIENTATION



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

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

Item	Description of defects				Signature/Date

IL2 - Check List REX

Check List Items

Item	Picture/Drawing	Description Description	Criteria /Record	OK			Signature/Date
01	N/A	To complete REX	Refer to REX, New defects must be added on the REX	✓			18/03/24

Self Inspection - Final Result

			Is the car good to advance to the next workstation/process? (Approval of Operations Manager/Team Leader and Industrial Quality)	DATE	NAME	SIGNATURE
HOLD POINT		CLS	If activities are not complete, the missing activities must not impact the next stage!	18/03/24	Operations Manager	
			Every auto inspection performed conforms to specification or in case of discrepancy the same is approved by the competent party.	18/03/24	Industrial Quality	
			There are activities pendings that impact/stop the activities of the next process Obs: (To describe problems below)		Operations Manager	
			There are non-conformities impact the quality of the product and there is no corrective action defined yet)		Industrial Quality	

In case of "NO GO", describe blocking problems

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

Item	Description	Action	Responsible		Status

Operations Manager / Team Leader

Quality Manager / Team Leader

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GIBELA

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Reception: +27 (0)10 600 0651

TRAIN SET 214	REF: GIB0000001672_J0 PRASA WEIGHT BALANCE EN
	PC09 WEIGHING REPORT

M3	Balance across front and rear bogies	Front Bogie [Tons]	Rear Bogie [Tons]	Longitudinal Imbalance [%]	Criteria Longitudinal Imbalance ≤ 3%	
		17.91	17.89	0.06%	PASS	
	Weight Mesured vs Predicted	Weight Mesured [Tons]	Weight Predicted [Tons]	Weight Difference [%]	Tolerance [%]	Criteria Min≤Diff≤Max
		35.80	35.90	0.28%	1.36%	PASS

Test Participants

Name	Company	Department	Signature	Date
E. Lu, S	GIBELA	EOC	[signature]	18/03/24