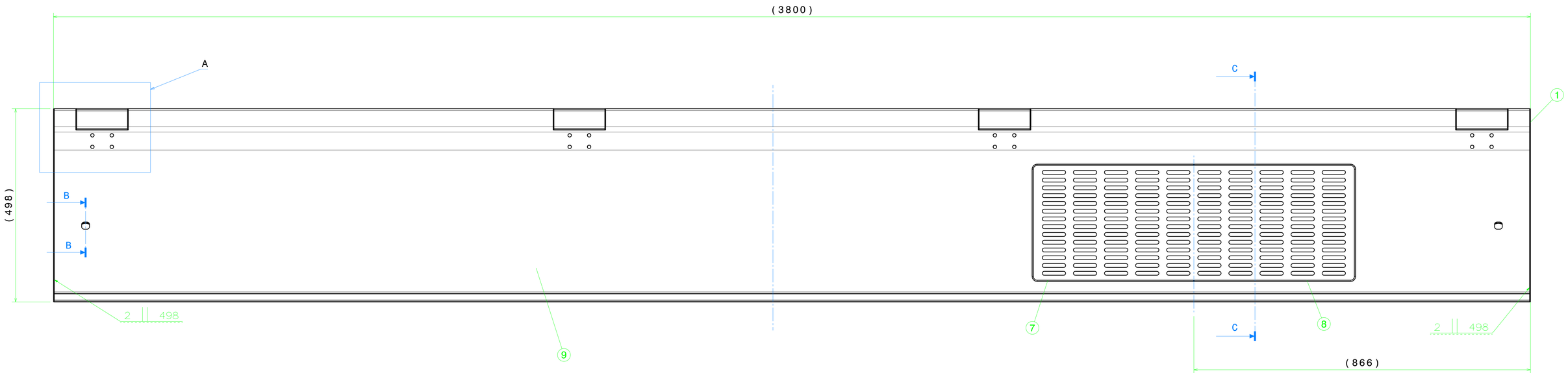
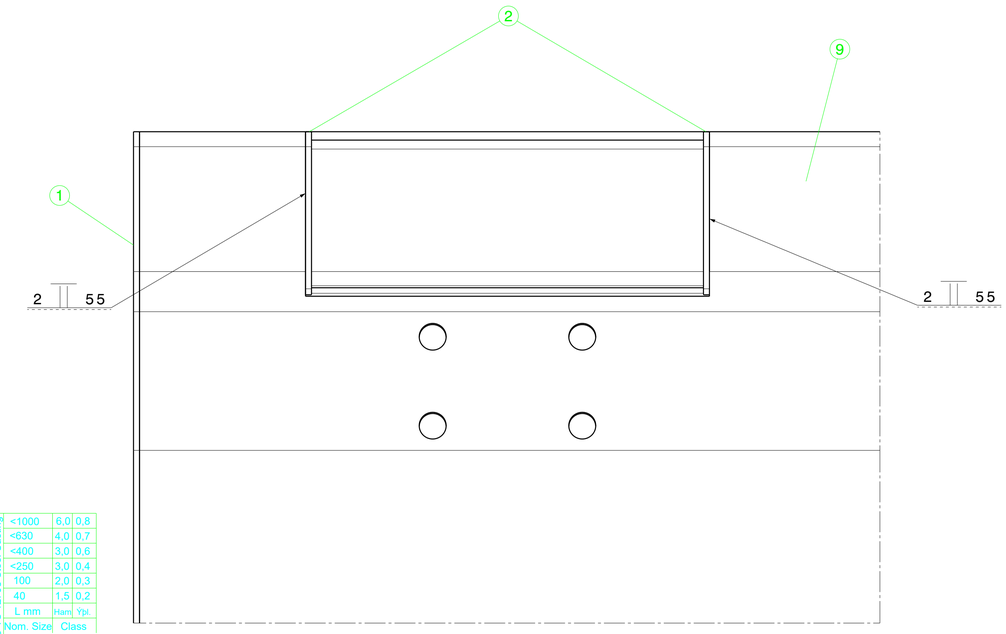
Reproduction, dissemination or use of this document or its all contents in any form without the prior written permission of TÜRASAŞ, is prohibited. Offenders will be liable for the payment of damages. All rights reserved in the event of the grant of a patent, utility model or ornamental design registration.

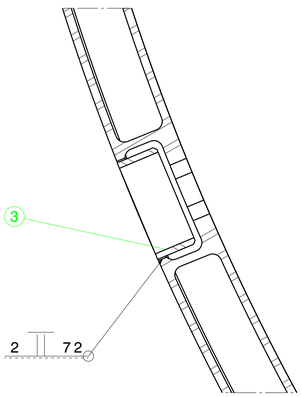


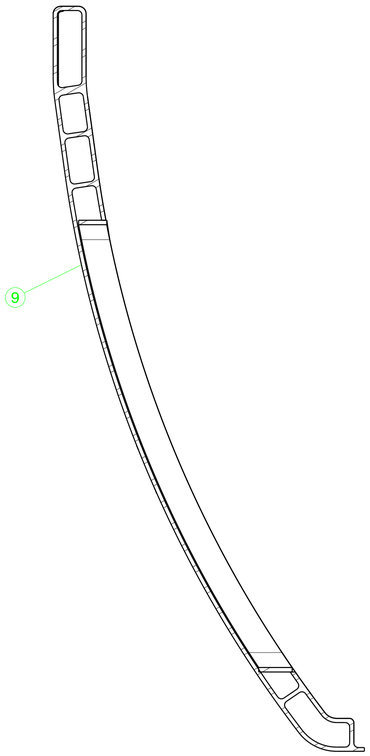
Detail A
Scale: 1:1
Typical

Section view C-C
Scale: 1:2

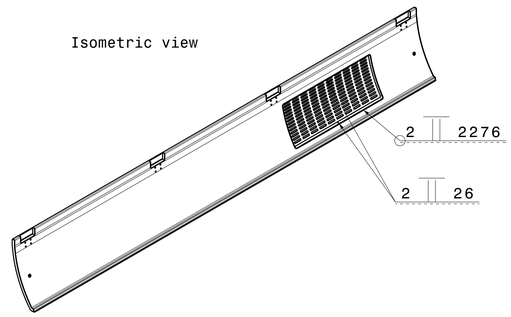


Section view B-B
Scale: 1:1
Typical





Isometric view



9	Outer_Lower_Panel	1	GZ11.21.12.32001	AW 6063 T66	-	34,72 kg
8	Bending_Sheet	1	GZ10.21.12.42004	AW 5754 H22	-	0,186 kg
7	Bending_Sheet	1	GZ10.21.12.42003	AW 5754 H22	-	0,186 kg
6	-	-	-	-	-	-
5	-	-	-	-	-	-
4	-	-	-	-	-	-
3	Tube	2	GZ10.21.12.11009	AW 5052 H112	-	0,008 kg
2	Plate	8	GZ10.21.12.11008	AW 5754 H22	-	0,005 kg
1	Plate	2	GZ10.21.12.11002	AW 5754 H22	-	0,065 kg
						35,3

No	Parça Adý Designation Name of Item	Adet Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Ölçü Dimension	Aðýrlýk Weight (Kg)

ISO 21920-1	ISO 8015	ISO 2553	General Tol.	ISO 2768	f☐	mX☐ H☐ KX☐
EN 15085-2 Certification Level		CL1☐ CL2☐ CL3X☐	Weld Pro.	ISO 13920	A X☐	B☐ E☐ F☐
			Cast Steel	ISO 12708	Lm2☐	Lr2☐ Sm2☐ Sr2☐

Approved	L.Giovinazzo	15/02/2023	Scale	TÜRASAŞ
Checked	M.Borlo	15/02/2023	1:5	Turkish Railway Vehicles Industry Inc.
Prepared	M.Cojocaru	15/02/2023		
TYP	Welded_Assembly -			GZ11.21.12.31000
Date:15/02/2023			Sheet : 1/1	Size:A1 Rev: 01

Technical Specifications						
Technical Document						
Fixture/Mould Asset ID.						
Coating/Heat Tre./Roughness		01	From Glue to Welding Assembly,Eliminated Items 04.05.06, Added Items 07.08.09	15/01/2024	A.Türkmen	
Paint/Color		Modf. No	Modification Description	Date	Sign	

GENERAL WELDING REQUIREMENTS

Welding classification and controlling according to technical specification BLUE_TS_WLD_01

WELDING PERFORMANCE CLASS	CP C3

Painting in accordance with TD-GZ.10.0055
-Protect from painting all threaded holes and machined surfaces marked with ◯
-Protect only with primer all surfaces marked with ◎

ISO 13920 Welded Construction			ISO 2768 General Tolerances			TS 12708 Steel Casting		
<1000	6,0	0,8	<4000	2,0	0,4	40	1,5	0,2
<630	4,0	0,7	<2000	1,2	0,4	100	2,0	0,3
<400	3,0	0,6	<1000	0,8	0,3	<250	3,0	0,4
<250	3,0	0,4	<400	0,5	0,3	<400	3,0	0,6
100	2,0	0,3	30-120	0,3	0,2	<630	4,0	0,7
40	1,5	0,2	2-30	0,2	0,1	<1000	6,0	0,8
L mm	Ham	Ýpl.	L mm	m ±	K ±	L mm	A ±	E ±
Nom. Size	Class		Nom. Size	Class		Nom. Size	Class	
<4000	2,0	0,4	>20000	9,0	8,0	<8000	5,0	4,0
<2000	1,2	0,4	<20000	8,0	7,0	<4000	4,0	3,0
<1000	0,8	0,3	<16000	7,0	6,0	<2000	3,0	2,0
<400	0,5	0,3	<12000	6,0	5,0	<1000	2,0	1,5
30-120	0,3	0,2	<8000	5,0	4,0	<400	1,0	1,0
2-30	0,2	0,1	<4000	4,0	3,0	30-120	1,0	0,5
L mm	m ±	K ±	<2000	3,0	2,0	2-30	1,0	0,5
Nom. Size	Class		<1000	2,0	1,5	L mm	A ±	E ±
			<400	1,0	1,0	Nom. Size	Class	