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

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

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

9	Outer_Lower_Panel	1	GZ11.21.12.37001	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 Adı Designation Name of Item	Adet Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Ölçü Dimension	Ağırlık Weight (Kg)
	ISO 21920-1	ISO 8015	ISO 2553	General Tol.	ISO 2768	f □ mX □ H □ KX □
	EN 15085-2 Certification Level	CL1 □ CL2 □	Weld Pro. CL3X □	Cast Steel	ISO 13920	A □ B □ E □ F □
	Approved	L.Giovinazzo	15/02/2023	Scale	ISO 12708	Ln2 □ Lr2 □ Sm2 □ Sr2 □
	Checked	M.Borio	15/02/2023	1:5		
	Prepared	M.Cojocar	15/02/2023			
	Welded_Assembly					
	-					
	TURASAS					
	Turkish Railway Vehicles Industry Inc.					
	GZ11.21.12.36000					
	Date:15/02/2023					
	Sheet: 1/1					
	Size:A1					
	Rev: 01					