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|           |       |      |
|-----------|-------|------|
| <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 |      |



|                                |   |                        |
|--------------------------------|---|------------------------|
| ISO 13920 Welded Construction  | ISO 2768 General Tolerances   | TS 12708 Steel Casting |
| ISO 21920-1                    | ISO 8015  | ISO 2553               |
| EN 15085-2 Certification Level | CL1 <input type="checkbox"/> CL2 <input type="checkbox"/> CL3 <input checked="" type="checkbox"/> | Weld Pro. Cast Steel   |
| Approved                       | L.Giovinazzo  | 17/02/2023             |
| Checked                        | M.Borio   | 17/02/2023             |
| Prepared                       | M.Cojocar   | 17/02/2023             |
| Scale 1:5                      |   |                        |

### GENERAL WELDING REQUIREMENTS

Welding classification and controlling according to technical specification BLUE\_TS\_WLD\_01

WELDING PERFORMANCE CLASS

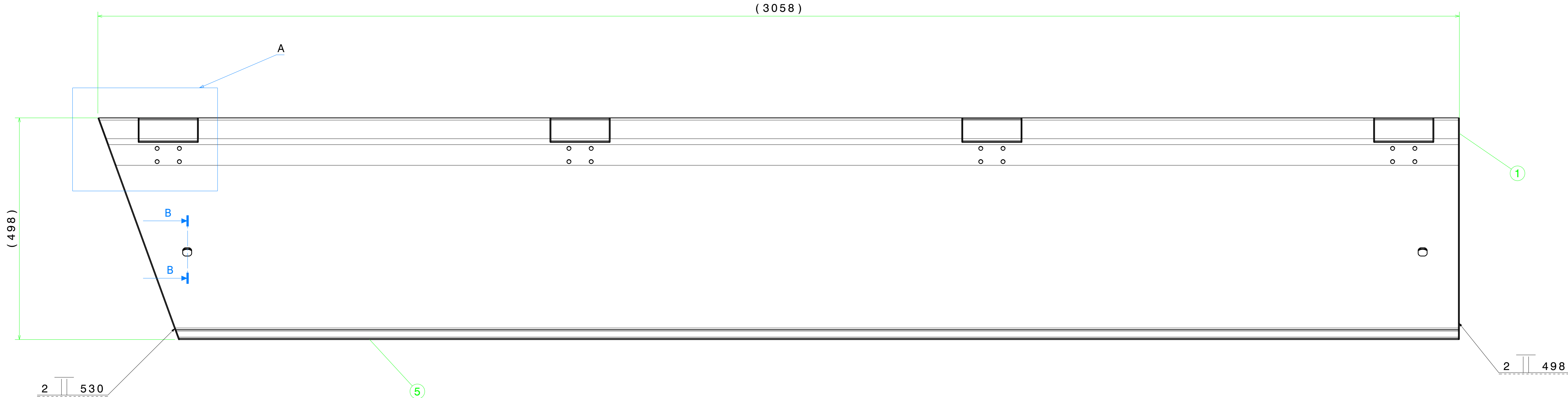
CP C3

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 Item 06 | 15/01/2024 | A.Turkmen |  |
| Modification Description    |    |   | Date       | Sign      |  |

TYP Date: 17/02/2023

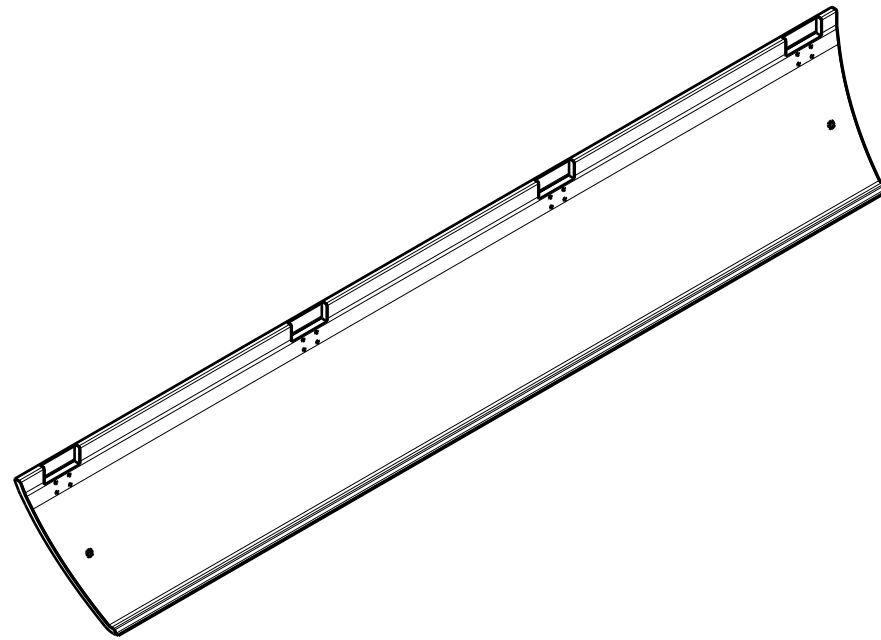
Sheet: 1/1 Size: A1 Rev: 01



Detail A  
Scale: 1:1  
Typical

Section view B-B  
Scale: 1:1  
Typical

Isometric view



|    |  |   |                                      |                     |   |   |
|----|--|---|--------------------------------------|---------------------|---|---|
| 6  | -                                      | -   | -                                    | -                   | -   | -   |
| 5  | Outer_Lower_Panel                      | 1   | GZ10.21.12.21001                     | AW 6063 T66         | -   | 29,74<br>8kg  |
| 4  | Tube                                   | 2   | GZ10.21.12.11009                     | AW 5052 H112        | -   | 0,008<br>kg   |
| 3  | Plate                                  | 8   | GZ10.21.12.11008                     | AW 5754 H22         | -   | 0,005<br>kg   |
| 2  | Plate                                  | 1   | GZ10.21.12.11003                     | AW 5754 H22         | -   | 0,069<br>kg   |
| 1  | Plate                                  | 1   | GZ10.21.12.11002                     | AW 5754 H22         | -   | 0,065<br>kg   |
|    |  |   |                                      |                     |   | 29,9  |
| No | Parça Adı<br>Designation Name of Item  | Adet<br>Qty.  | Resim No / Norm<br>Drawing No / Norm | Malzeme<br>Material | Ölçü<br>Dimension   | Ağırlık<br>Weight<br>(Kg)   |
|    | ISO 21920-1                            | ISO 8015  | ISO 2553                             | General Tol.        | ISO 2768  | f <input type="checkbox"/> mX <input type="checkbox"/> H <input type="checkbox"/> KX <input type="checkbox"/>       |
|    | EN 15085-2 Certification Level         | CL1 <input type="checkbox"/> CL2 <input type="checkbox"/> CL3 <input checked="" type="checkbox"/> | Weld Pro.                            | ISO 13920           | A <input type="checkbox"/> B <input type="checkbox"/> E <input type="checkbox"/> F <input type="checkbox"/> |   |
|    | Approved                               | L.Giovinazzo  | 17/02/2023                           | Scale               | ISO 12708   | Ln2 <input type="checkbox"/> Lr2 <input type="checkbox"/> Sm2 <input type="checkbox"/> Sr2 <input type="checkbox"/> |
|    | Checked                                | M.Borio   | 17/02/2023                           | 1:5                 |   |   |
|    | Prepared                               | M.Cojocar   | 17/02/2023                           |                     |   |   |
|    | Welded_Assembly                        |   |                                      |                     |   |   |
|    | -                                      |   |                                      |                     |   |   |
|    | GZ10.21.12.21000                       |   |                                      |                     |   |   |
|    | Turkish Railway Vehicles Industry Inc. |   |                                      |                     |   |   |
|    | Date: 17/02/2023                       |   |                                      |                     |   |   |
|    | Sheet: 1/1                             |   |                                      | Size: A1 Rev: 01    |   |   |