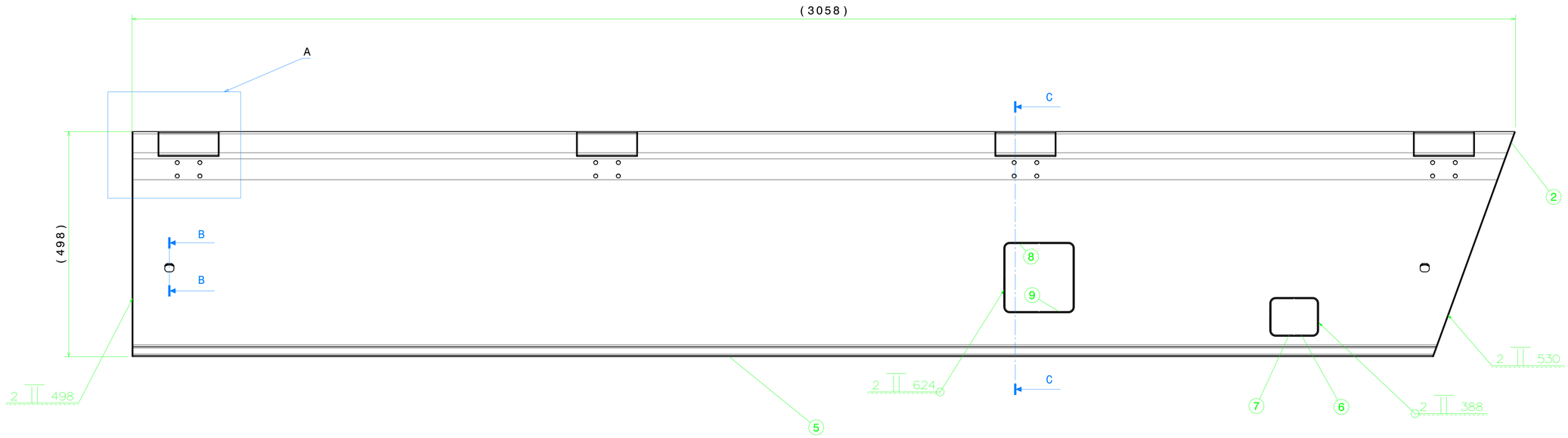
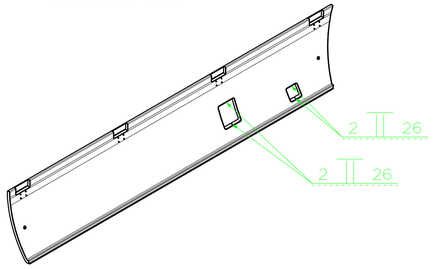


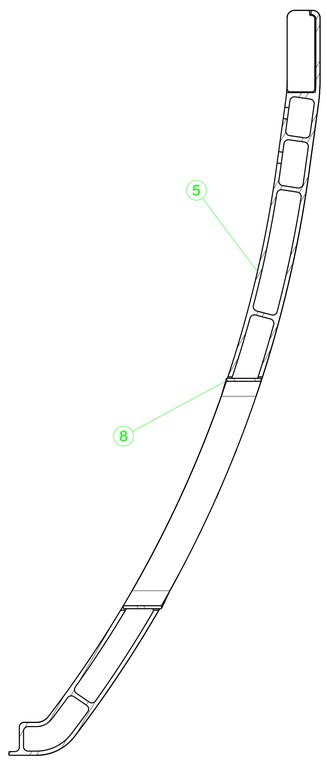
Section view C-C
Scale: 1:2
Typical

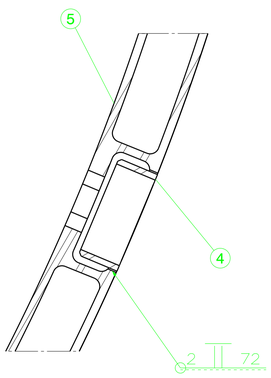
Detail A
Scale: 1:1
Typical

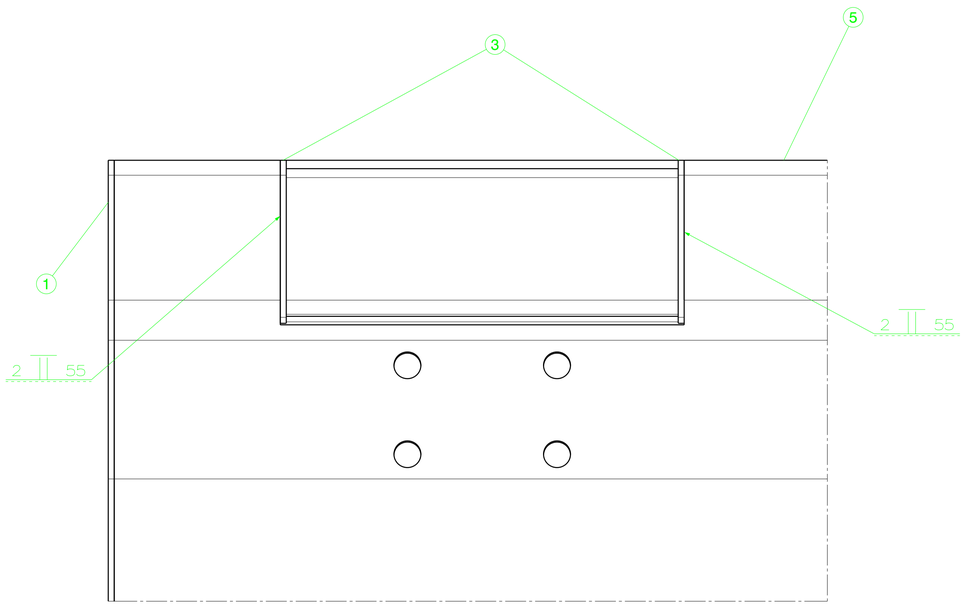
Isometric view



Section view B-B
Scale: 1:1
Typical







ISO 13920 Welded Construction		
<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	

ISO 2768 General Tolerances		
<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	

TS 12708 Steel Casting		
>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 ◎

No	Parça Adý Designation Name of Item	Adet Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Ölçü Dimension	Aðýrlýk Weight (Kg)
10	-	-	-	-	-	-
9	Bending_Sheet	1	GZ10.21.12.26005	AW 5754 H22	-	0,038 kg
8	Bending_Sheet	1	GZ10.21.12.26004	AW 5754 H22	-	0,038 kg
7	Bending_Sheet	1	GZ10.21.12.26003	AW 5754 H22	-	0,024 kg
6	Bending_Sheet	1	GZ10.21.12.26002	AW 5754 H22	-	0,024 kg
5	Outer_Lower_Panel	1	GZ10.21.12.26001	AW 6063 T66	-	29,045kg
4	Tube	2	GZ10.21.12.11009	AW 5052 H112	-	0,008 kg
3	Plate	8	GZ10.21.12.11008	AW 5754 H22	-	0,005 kg
2	Plate	1	GZ10.21.12.11003	AW 5754 H22	-	0,069 kg
1	Plate	1	GZ10.21.12.11002	AW 5754 H22	-	0,065 kg
						29,4

Technical Specifications							
Technical Document							
Fixture/Mould Asset ID.							
Coating/Heat Tre./Roughness		01	From Glue to Welding Assembly,Eliminated Items 10	15/01/2024	A.Türkmen	TYP	
Paint/Color		Modf. No	Modification Description	Date	Sign		

ISO 21920-1	ISO 8015	ISO 2553	General Tol.	ISO 2768	f ☐ m☒ H☐ K☒
EN 15085-2 Certification Level		CL1☐ CL2☐ CL3☒	Weld Pro.	ISO 13920	A☒ B☐ E☐ F☐
			Cast Steel	ISO 12708	Lm2☐ Lr2☐ Sm2☐ Sr2☐
Approved	L.Giovinazzo	17/02/2023	Scale		
Checked	M.Borlo	17/02/2023	1:5		
Prepared	M.Cojocaru	17/02/2023			

Welded_Assembly

-

TÜRASAS
Turkish Railway Vehicles Industry Inc.

GZ10.21.12.26000

Date: 17/02/2023 | Sheet : 1/1 | Size:A1 | Rev: 01

Reproduction, dissemination or use of this document or its all contents in any form without the prior written permission of TUVASAS, 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.