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ISO 13920 Welder Construction		
Nom. Size	Class	
<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	Hamt	Ypl.
ISO 2768 General Tolerances		
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 ±
ISO 13920 Welder Construction		
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	

Isometric view

Section view C-C
Scale: 1:2
Typical


View from D
Scale: 1:2
Typical

Section view B-B
Scale: 1:1
Typical

Detail A
Scale: 1:1
Typical

Technical Specifications					
Technical Document					
Fixture/Mould Asset ID:	02	Drawing Update	09/01/2024	A. Türkmen	
Coating/Heat Tre./Roughness	01	Drawing Update	09/01/2024	M. Cojocar	
Paint/Color	Modif. No	Modification Description	Date	Sign	

Edge without dimension according to DIN ISO 13715	Tolerance for holes and shafts without marks on drawing
$\begin{matrix} \text{---}0.3 \\ \text{---}+0.3 \end{matrix}$	Hole H12-Shaft h12

For profile dimensions refer to drawing: GZ10.21.12.99000					
			AW 6063 T66		29,1
No	Parça Adı Designation Name of Item	Adet Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Ölçü Dimension
	ISO 21920-1 EN 15085-2 Certification Level	ISO 8015 CL1 CL3	ISO 2553 Weld Pro. Cast Steel	ISO 2768 A Ln2	mX B Sm2
Approved	L. Giovinnazzo	30/01/2023	Scale	 Turkish Railway Vehicles Industry Inc.	
Checked	M. Borlo	30/01/2023	1:5		
Prepared	M. Cojocar	30/01/2023			
			Outer_Lower_Panel		
			-		
			GZ10.21.12.26001		
			Sheet: 1/1		Size: A1
			Rev: 02		