

ISO 13920 General Tolerances - ISO 2768 Steel Casting			
<1000	6.0	0.8	
<830	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	Max	Ypl	
Norm. 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	mm	in	Class
Norm. Size	Class		
>>2000	9.0	0.8	
>>1000	8.0	0.7	
<16000	7.0	0.6	
<12000	6.0	0.5	
<8000	5.0	0.4	
<4000	4.0	0.3	
<2000	3.0	0.2	
<1000	2.0	0.15	
<400	1.0	0.1	
30-120	1.0	0.5	
2-30	1.0	0.5	
L mm	A1	E	
Norm. Size	Class		

GENERAL WELDING REQUIREMENTS


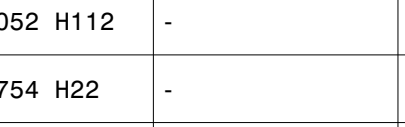

Welding classification and controlling according
to technical specification BLUE_TS_WLD_01

WELDING PERFORMANCE CLASS

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	01	From Glue to Welding Assembly;Eliminated Items 05		15/01/2024	A Turkmen
Paint/Color	Mod. No	Modification Description		Date	Sign

5	-	-	-	-	-	-	-	-							
4	Outer_Lower_Panel		1	GZ10.21.12.31001	AW 6063 T66	-	-	23,08 3kg							
3	Tube		2	GZ10.21.12.11009	AW 5052 H112	-	-	0,008 kg							
2	Plate		6	GZ10.21.12.11008	AW 5754 H22	-	-	0,005 kg							
1	Plate		2	GZ10.21.12.11002	AW 5754 H22	-	-	0,065 kg							
								23.2							
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 <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"/> CL3X <input type="checkbox"/>	Weld Pro. <input type="checkbox"/> Cast Steel <input type="checkbox"/>	ISO 13920	A <input type="checkbox"/>	B <input type="checkbox"/>	E <input type="checkbox"/>	F <input type="checkbox"/>						
	Approved	L.Giovinazzo	09/02/2023	Scale	ISO 12708	Lm2 <input type="checkbox"/>	Lr2 <input type="checkbox"/>	Sm2 <input type="checkbox"/>	Sr2 <input type="checkbox"/>						
	Checked	M.Borio	09/02/2023	1:5	 Turkish Railway Vehicles Industry Inc.										
	Prepared	M.Coşcaru	09/02/2023												
			Welded_Assembly												
			-												
Sign	TYP	Date: 09/02/2023				Sheet : 1/1	Size:A1	Rev: 01							