

| | | | |
|-------------------------------|---|-------|------|
| ISO 13920 Welded Construction | 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 | | |

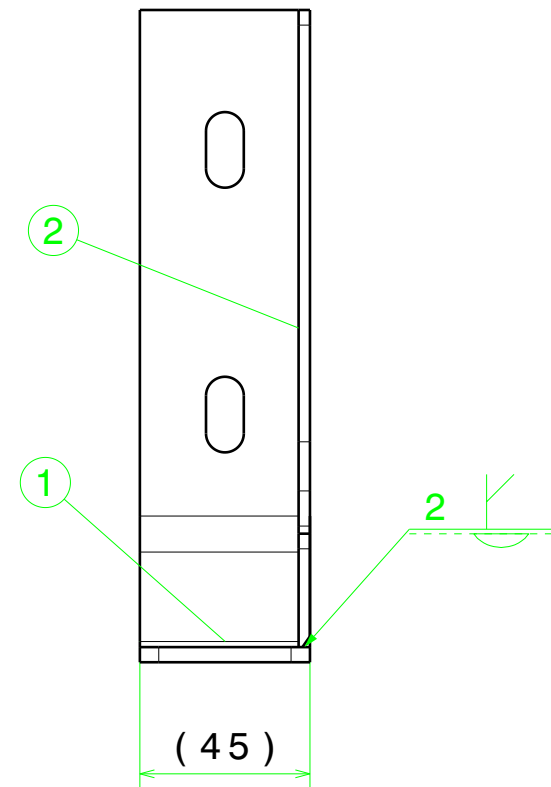
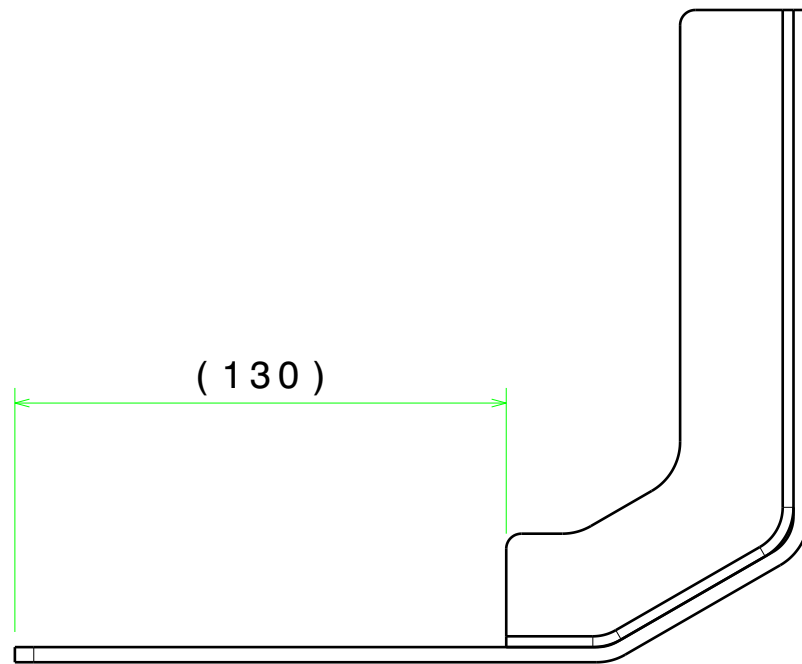
Painting in accordance with TD-GZ.10.0055

- Protect from painting all threaded holes and machined surfaces marked with ○
- Protect only with primer all surfaces marked

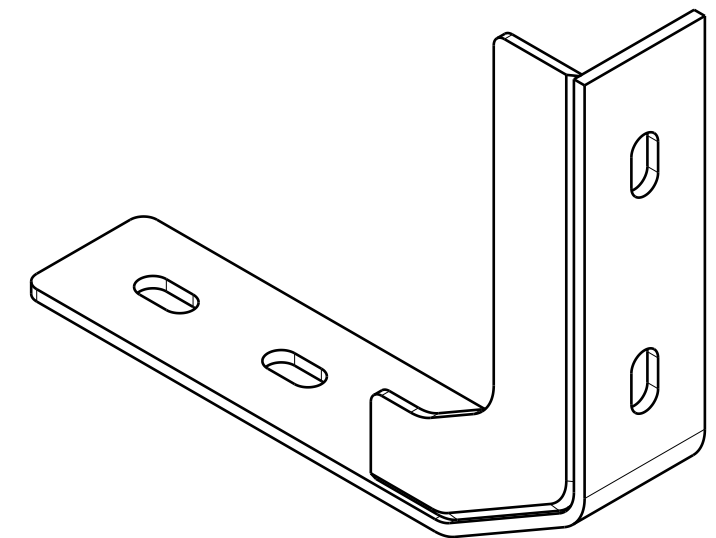
GENERAL WELDING REQUIREMENTS


Welding classification and controlling according
to technical specification BLUE_TS_WLD_01


| | | | | | |
|-----------------------------|--|-----------|--------------------------|------|------|
| Technical Specifications | | | | | |
| Technical Document | | | | | |
| Fixture/Mould Asset ID. | | | | | |
| Coating/Heat Tre./Roughness | | | | | |
| Paint/Color | | Modif. No | Modification Description | Date | Sign |





Isometric view




| | | | | | | |
|-----------------|---|--------------|---|---------------------|--|---|
| 2 | Plate | 1 | GZ10.21.12.96002 | S355J2 EN10025 | - | 0,135 kg |
| 1 | Bending_Sheet | 1 | GZ10.21.12.96001 | S355J2 EN10025 | - | 0,481 kg |
| | | | | | | 0,6 |
| No | Parça Adý Designation Name of Item | Adet Qty. | Resim No / Norm Drawing No / Norm | Malzeme Material | Ölçü Dimension | Aðýrlyk Weight (Kg) |
| TYP | ISO 21920-1 | ISO 8015 | ISO 2553 | General Tol. | ISO 2768 | f <input type="checkbox"/> m <input checked="" type="checkbox"/> H <input type="checkbox"/> K <input checked="" type="checkbox"/> |
| | EN 15085-2 Certification Level | | CL1 <input checked="" type="checkbox"/> CL2 <input type="checkbox"/> CL3 <input type="checkbox"/> | Weld Pro. | ISO 13920 | A <input checked="" type="checkbox"/> B <input type="checkbox"/> E <input checked="" type="checkbox"/> F <input type="checkbox"/> |
| | | | | Cast Steel | ISO 12708 | Lm2 <input type="checkbox"/> Lr2 <input type="checkbox"/> Sm2 <input type="checkbox"/> Sr2 <input type="checkbox"/> |
| | Approved | L.Giovinazzo | 25/01/2023 | Scale | <div>TURASAS</div> <div>Turkish Railway Vehicles Industry Inc.</div> | |
| | Checked | M.Borlo | 25/01/2023 | 1:2 | | |
| | Prepared | M.Cojocar | 25/01/2023 | | | |
| |  | | Welded_Assembly | | GZ10.21.12.96000 | |
| | | - | | | | |
| Date:25/01/2023 | | | | Sheet : 1/1 | Size:A3 | Rev: 00 |

| | | | | | | |
|-----------------|---|--------------|---|---------------------|--|---|
| 2 | Plate | 1 | GZ10.21.12.96002 | S355J2 EN10025 | - | 0,135 kg |
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| | | | | Cast Steel | ISO 12708 | Lm2 <input type="checkbox"/> Lr2 <input type="checkbox"/> Sm2 <input type="checkbox"/> Sr2 <input type="checkbox"/> |
| | Approved | L.Giovinazzo | 25/01/2023 | Scale | <div>TURASAS</div> <div>Turkish Railway Vehicles Industry Inc.</div> | |
| | Checked | M.Borlo | 25/01/2023 | 1:2 | | |
| | Prepared | M.Cojocar | 25/01/2023 | | | |
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| | Prepared | M.Cojocar | 25/01/2023 | | | |
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