



- Longitudinal underframe flatness tolerance:  
each 1m of length ±2mm

ISO 1302	ISO 1302	ISO 1302	ISO 1302
Surface Texture	Surface Texture	Surface Texture	Surface Texture
<1000	6.0/0.8	<1000	6.0/0.8
<630	4.0/0.7	<630	4.0/0.7
<400	3.0/0.6	<400	3.0/0.6
<250	3.0/0.4	<250	3.0/0.4
<100	2.0/0.3	<100	2.0/0.3
40	1.5/0.2	40	1.5/0.2
L mm	mm	L mm	mm
Nom. Size	Class	Nom. Size	Class
<4000	2.0/0.4	<4000	2.0/0.4
<2000	1.2/0.4	<2000	1.2/0.4
<1000	0.8/0.3	<1000	0.8/0.3
<400	0.5/0.3	<400	0.5/0.3
30-120	0.3/0.2	30-120	0.3/0.2
2-30	0.2/0.1	2-30	0.2/0.1
L mm	mm	L mm	mm
Nom. Size	Class	Nom. Size	Class
>20000	9.0/0.0	>20000	9.0/0.0
>20000	8.0/0.0	>20000	8.0/0.0
>10000	7.0/0.0	>10000	7.0/0.0
>12000	6.0/0.0	>12000	6.0/0.0
>8000	5.0/0.0	>8000	5.0/0.0
>4000	4.0/0.0	>4000	4.0/0.0
>2000	3.0/0.0	>2000	3.0/0.0
>1000	2.0/0.0	>1000	2.0/0.0
>400	1.0/0.0	>400	1.0/0.0
30-120	1.0/0.0	30-120	1.0/0.0
2-30	1.0/0.0	2-30	1.0/0.0
L mm	mm	L mm	mm
Nom. Size	Class	Nom. Size	Class

No	Perçay	Adet	Resm No / Norm	Malzeme	Ölçü	Ağırlık
Designation	Name of Item	Qty.	Drawing No / Norm	Material	Dimension	Weight (Kg)
13	Sidewall_Die_3	2	0210.03.02.96000	AW 6005A T6		
12	Sidewall_Die_1	2	0290.09.02.99000	AW 6005A T6		
11	Roof_Die_4	2	0210.03.03.96000	AW 6005A T6		
10	Roof_Die_3	2	0210.03.03.97000	AW 6005A T6		
09	Roof_Die_2	2	0210.03.03.98000	AW 6005A T6		
08	Roof_Die_1	1	0210.03.03.99000	AW 6005A T6		
07	Sidewall_Die_2	2	0210.03.02.96000	AW 6005A T6		
06	Sidewall_Die_1	4	0210.03.02.97000	AW 6005A T6		
05	Sidewall_Die_2	2	0290.09.02.99000	AW 6005A T6		
04	Underframe_Die_4	2	0210.03.01.96000	AW 6005A T6		
03	Underframe_Die_3	2	0210.03.01.97000	AW 6005A T6		
02	Underframe_Die_2	2	0210.03.01.98000	AW 6005A T6		
01	Underframe_Die_1	1	0210.03.01.99000	AW 6005A T6		

Technical Specifications	08	Updated Item 02 03 04 06 13	21/10/2022	D.Barış
Technical Document	07	Updated Item 13	24/01/2022 <th>D.Barış</th>	D.Barış
Feature/Mould Asset ID	06	Updated Item 03 04 10 11 ; Updated quote	20/12/2021 <th>D.Barış</th>	D.Barış
Coating/Heat Tre./Roughness	05	Updated Item 03 04 13	17/11/2021 <th>D.Barış</th>	D.Barış
Paint/Color		Modf. No	Date	Sign

No	Perçay	Adet	Resm No / Norm	Malzeme	Ölçü	Ağırlık
Designation	Name of Item	Qty.	Drawing No / Norm	Material	Dimension	Weight (Kg)
ISO 1302	ISO 8015	EN 22553	General Tol.	ISO 2768	mm	mm
EN 15065-2 Certification Level	CL1	CL2	Weld Proc.	ISO 15629	A3	EX
Approved	M.Gorali	23/04/2021	Scale			
Checked	M.Borlu	23/04/2021	1:50			
Prepared	L.Gilli	23/04/2021				

**TURASAS**  
Türkiye Raylı Sistem Araçları Sanayi A.Ş.  
GZ90.03.00.00006



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