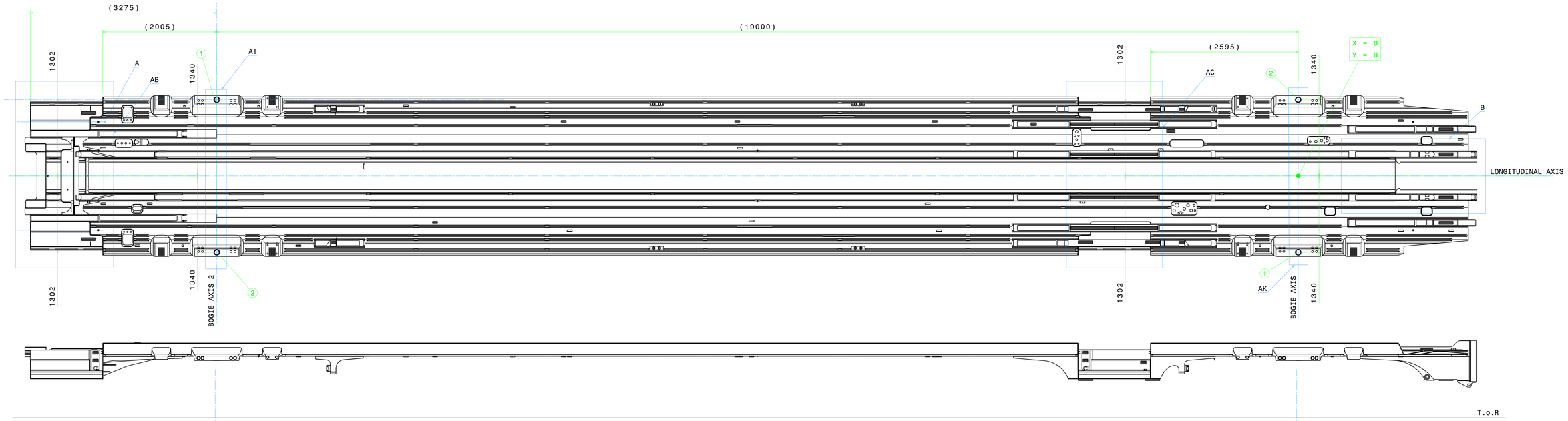
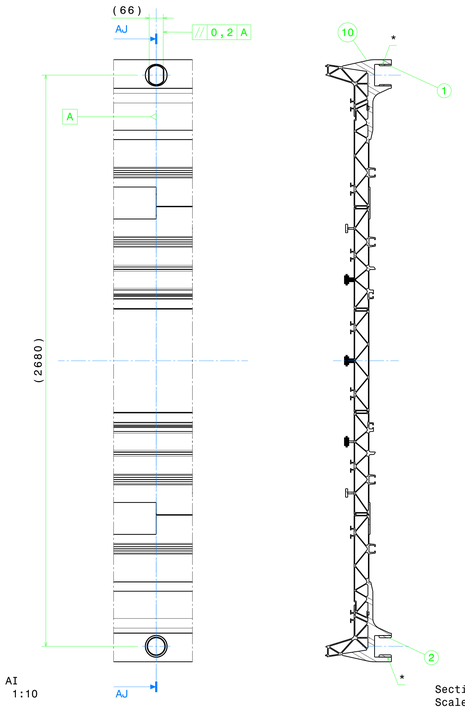
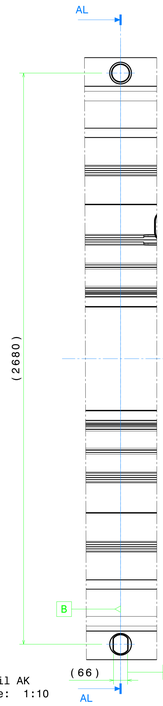


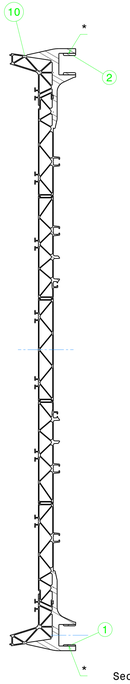


Detail AI
Scale: 1:10

Section cut AJ-AJ
Scale: 1:10

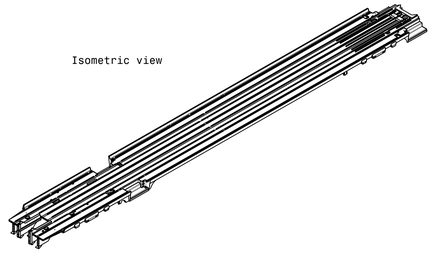


Detail AK
Scale: 1:10



Section cut AL-AL
Scale: 1:10

Isometric view



GENERAL WELDING REQUIREMENTS

Welding classification and controlling according to technical specification BLUE_TS_WLD_01

WELDING PERFORMANCE CLASS	C2

* Installed using the Adhesive LOCTITE 638 GREEN

21	Plate	1	EM20.03.01.00011	AlI 6082 T6	-	0,4kg
20	Complete_Underframe_Sub_Assembly_6	1	EM20.03.01.07000	-	-	96,6kg
19	Plate	1	EM20.03.01.00010	AlI 6082 T6	-	1kg
18	Bodyshell_SKA1_Sub_Assembly_5	1	FT20.03.00.06000	-	-	18,3kg
17	Bodyshell_SKA1_Sub_Assembly_4	1	FT20.03.00.05000	-	-	19,3kg
16	Bodyshell_SKA1_Sub_Assembly_3	1	FT20.03.00.04000	-	-	18,3kg
15	Bodyshell_SKA1_Sub_Assembly_2	1	FT20.03.00.03000	-	-	19,3kg
14	Plate	2	EM20.03.01.04003	AlI 5454 H22	-	0,041kg
13	Underframe_Weld_Parts	1	FT20.03.01.19000	-	-	66kg
12	Complete_Underframe_Sub_Assembly_2	1	EM20.03.01.03000	-	-	7,8kg
11	Complete_Underframe_Sub_Assembly_1	1	EM20.03.01.02000	-	-	96,6kg
10	Underframe_Machining_Phase_2	1	FT20.03.01.01000	-	-	3763,3kg
9	Plate	1	EM20.03.01.00009	AlI 6082 T6	-	10,5kg
8	Bending_Sheet	1	EM20.03.01.00008	AlI 6082 T6	-	4,2kg
7	-	-	-		-	-
6	Plate	1	EM20.03.01.00006	AlI 6082 T6	-	0,4kg
5	Plate	2	EM20.03.01.00005	AlI 6082 T6	-	1kg
4	Plate	1	EM20.03.01.00004	AlI 6082 T6	-	1kg
3	Bending_Sheet	1	EM20.03.01.00003	AlI 5454 H22	-	0,2kg
2	Block	2	EM20.03.01.00002	42CrMo4H	-	1,3kg
1	Block	2	EM20.03.01.00001	42CrMo4H	-	1,3kg
						4130,4

No	Parça Adý Designation Name of Item	Adet Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Ölçü Dimension	Aðýrlýk Weight (Kg)

ISO 1302	ISO 8015	EN 22553	General Tol.	ISO 2768	f☐ m☒ H☐ K☒
EN 15085-2 Certification Level		CL1☒ CL2☐ CL3☐ CL4☐	Weld Pro.	ISO 13920	A☒ B☐ E☒ F☐
			Cast Steel	ISO 12708	Ln2☐ Lr2☐ Sn2☐ Sr2☐

Approved	E.M.ERDOĞAN	Scale	1:25
Checked	Y.KARABEL		
Prepared	M.K. TAŞ		

TYP

Complete_Underframe

-

TURASAS
Türkiye Raylı Sistem Araçları San. A.Ş.

FT20.03.01.00000

Technical Specifications					
Technical Document					
Fixture/Mould Asset ID.					
Coating/Heat Tre./Roughness		R01	Missing weld symbols and section views have been added.	27/01/2026	Y.KARABEL
Paint/Color	-	Modif. No	Modification Description	Date	Sign

Date: 02.07.2024 | Sheet : 1/4 | Size:A0 | Rev: 01

<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	Hert Yp.	
Nom. Size	Class	

ISO 2768 General Tolerance

<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	

ISO 13920 Welded Construction

>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	

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