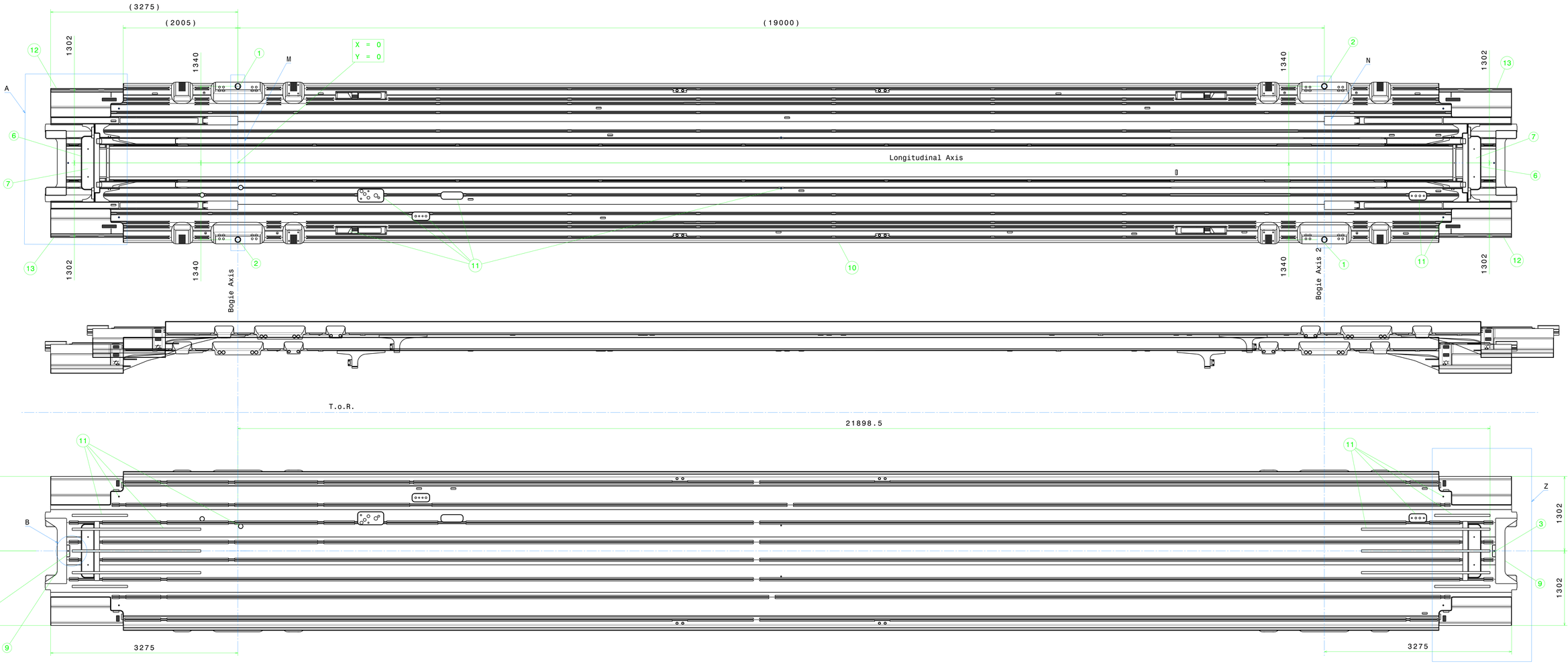

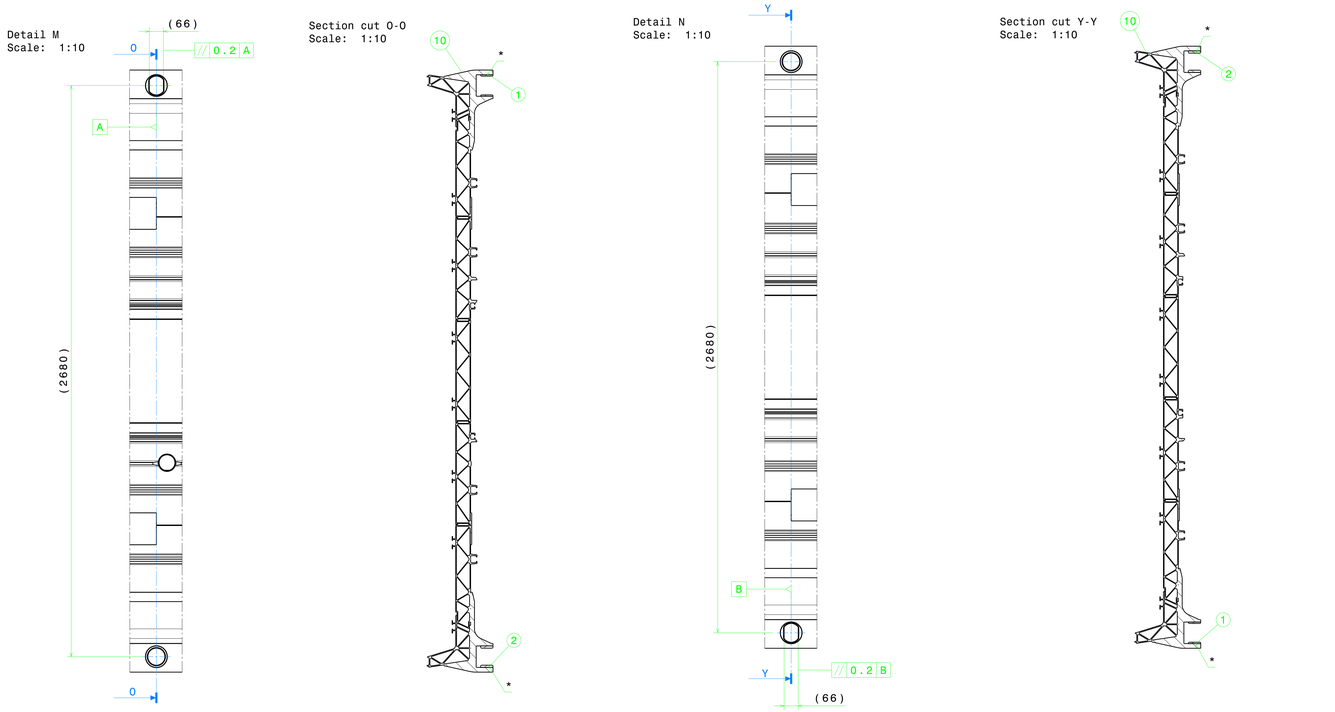

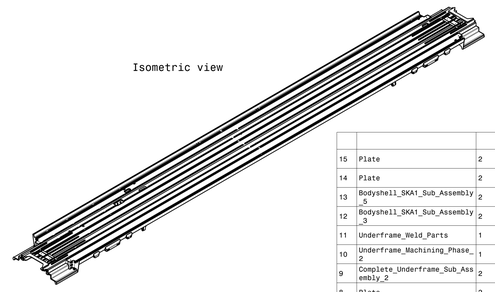

15	Plate	2	EM20.03.01.00011	AW 6082 T6	-	0,416 kg
14	Plate	2	EM20.03.01.00010	AW 6082 T6	-	0,986 kg
13	Bodyshell_SKA1_Sub_Assembly_5	2	FT20.03.00.06000	-	-	18,32 1kg
12	Bodyshell_SKA1_Sub_Assembly_3	2	FT20.03.00.04000	-	-	18,32 1kg
11	Underframe_Weld_Parts	1	FT22.03.01.19000	-	-	39,94 6kg
10	Underframe_Machining_Phase_2	1	FT22.03.01.01000	-	-	3698,124kg
9	Complete_Underframe_Sub_Assembly_2	2	EM20.03.01.03000	-	-	7,784 kg
8	Plate	2	EM20.03.01.00006	AW 6082 T6	-	0,416 kg
7	Plate	2	EM20.03.01.00009	AW 6082 T6	-	10,454kg
6	Bending_Sheet	2	EM20.03.01.00008	AW 6082 T6	-	4,18kg
5	Plate	4	EM20.03.01.00005	AW 6082 T6	-	0,958 kg
4	Plate	2	EM20.03.01.00004	AW 6082 T6	-	0,986 kg
3	Bending_Sheet	2	EM20.03.01.00003	AW 5454 H22	-	0,161 kg
2	Block	2	EM20.03.01.00002	42CrMo4H	-	1,33kg
1	Block	2	EM20.03.01.00001	42CrMo4H	-	1,285 kg
						3871,2

* Installed using the Adhesive LOCTITE 638 GREEN

GENERAL WELDING REQUIREMENTS

Welding classification and controlling according to technical specification BLUE_TS_WLD_01

WELDING PERFORMANCE CLASS	C2

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

ISO 1302	ISO 8015	EN 22553	General Tol.
EN 15085-2 Certification Level		CL1☐ CL2☐ CL3☐ CL4☐	Weld Pro.
			Cast Steel

ISO 2768	f☐	m☐	H☐	K☐
ISO 13920	A☐	B☐	E☐	F☐
ISO 12708	Ln2☐	Lr2☐	Sn2☐	Sr2☐

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

TYP

Complete_Underframe

-

TURASAS
Türkiye Raylı Sistem Araçları San. A.Ş.

FT22.03.01.00000

Date:03.07.2024			Sheet : 1/4	Size:A0	Rev: 00

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

<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	Hard	Ydn
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	

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