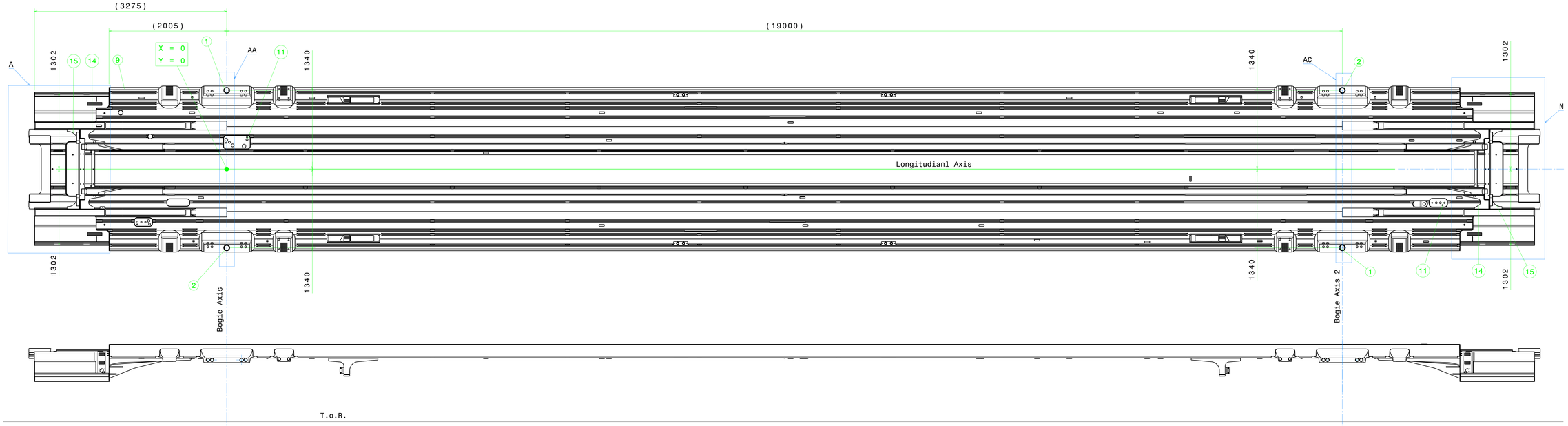
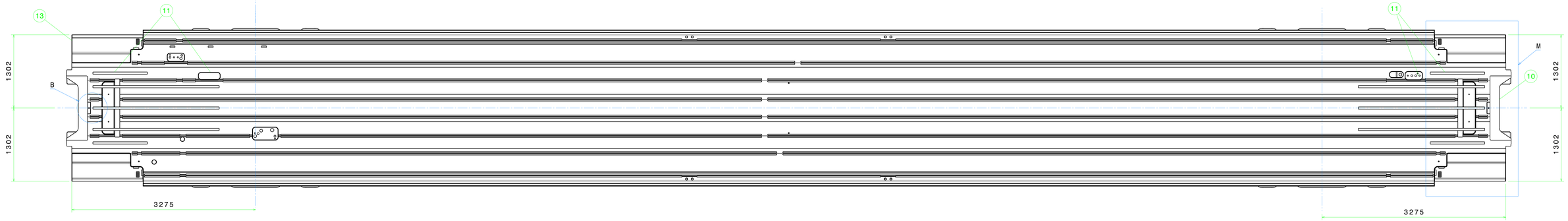
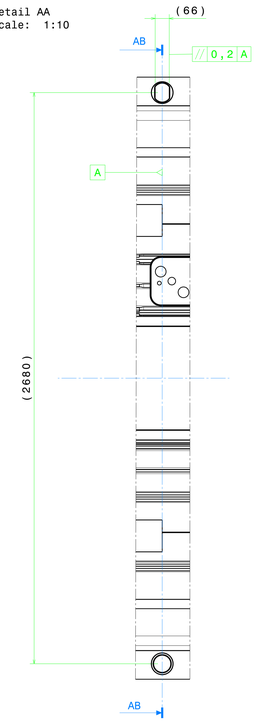
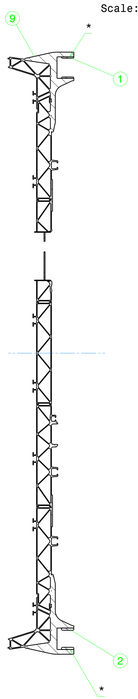




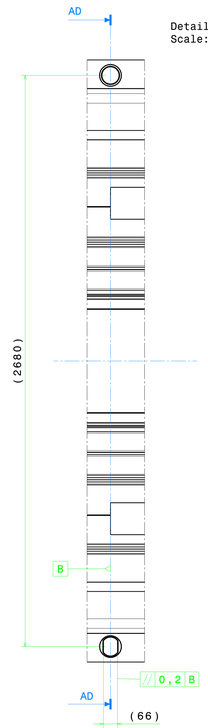
Detail AA
Scale: 1:10



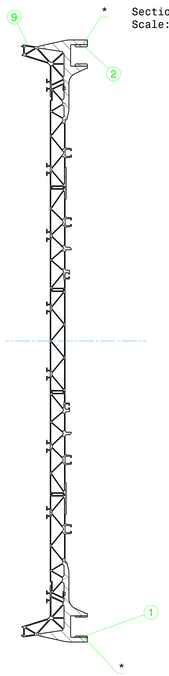
Section cut AB-AB
Scale: 1:10



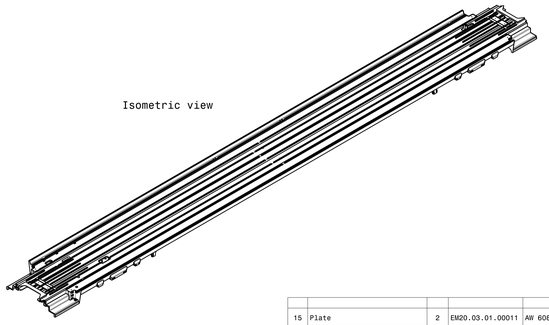
Detail AC
Scale: 1:10



Section cut AD-AD
Scale: 1:10



Isometric view



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	-	-	18,321
12	Bodyshell_SKA1_Sub_Assembly_3	2	FT20.03.00.04000	-	-	18,321
11	Underframe_Weld_Parts	1	FT24.03.01.19000	-	-	39,964kg
10	Complete_Underframe_Sub_Assembly_2	2	EM20.03.01.03000	-	-	7,784 kg
9	Underframe_Machining_Phase_2	1	FT24.03.01.01000	-	-	3697,166kg
8	Plate	2	EM20.03.01.00009	AW 6082 T6	-	10,454kg
7	Bending_Sheet	2	EM20.03.01.00008	AW 6082 T6	-	4,184kg
6	Plate	2	EM20.03.01.00006	AW 6082 T6	-	0,416 kg
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	-	1,334kg
1	Block	2	EM20.03.01.00001	42CrMo4H	-	1,285 kg
						3870,2

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

* 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

Technical Specifications					
Technical Document					
Fixture/Mould Asset ID					
Coating/Heat Tre./Roughness		R01	Drawing updated.	26/03/2026	E.M.ERDOGAN
Paint/Color	-	Modif. No	Modification Description	Date	Sign

ISO 1302	ISO 8015	EN 22553	General Tol.
EN 15085-2 Certification Level			Weld Pro.
			Cast Steel

ISO 2768	f ☐	m☒	k☐	h☒
ISO 13920	A☒	B☐	C☒	F☐
ISO 12708	Lm2☐	Ln2☐	Sm2☐	Sn2☐

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

TYP

Complete_Underframe

-

TURASAS
Türkiye Rayli Sistem Araçlari San. A.Ş.

FT24.03.01.00000

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	Hem	Yat

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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