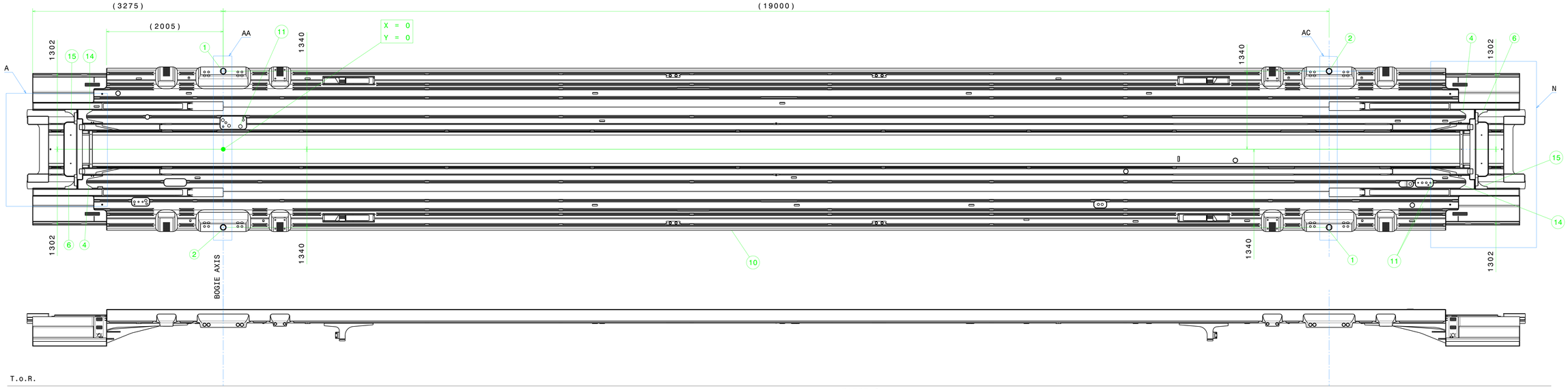
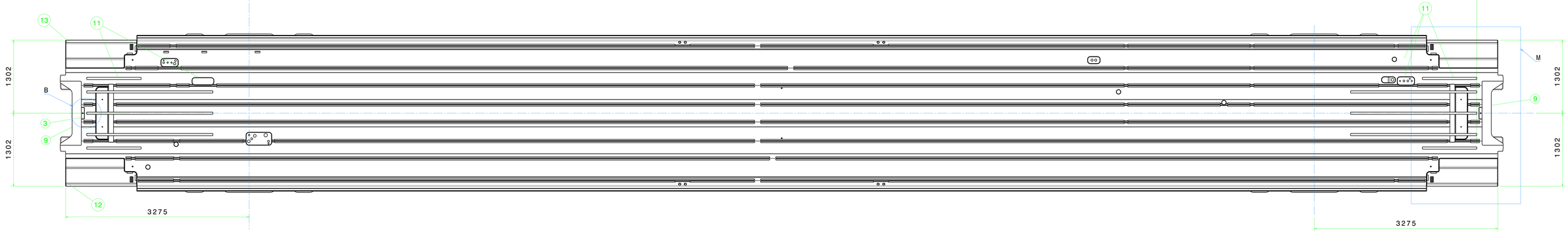
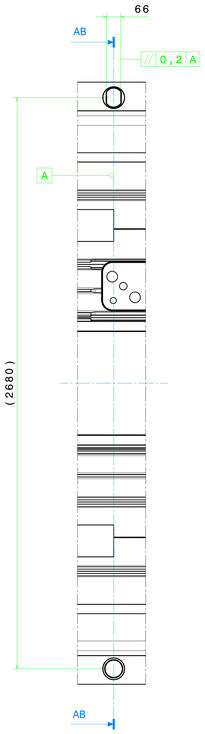
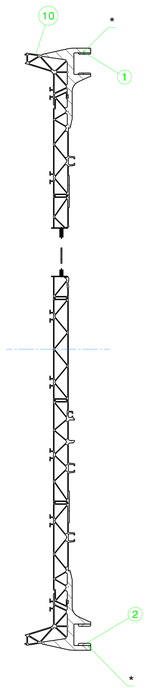




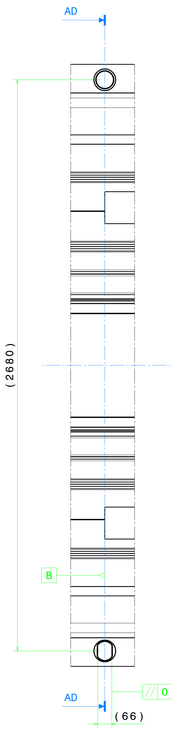
Detail AA
Scale: 1:10



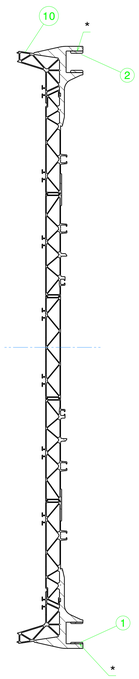
Section cut AB-AB
Scale: 1:10



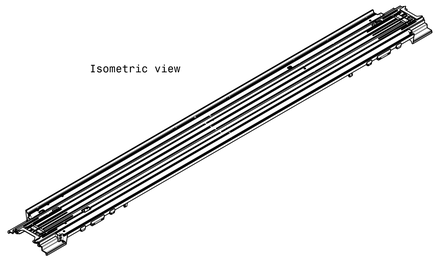
Detail AC
Scale: 1:10



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	-	-	18,321kg
12	Bodyshell_SKA1_Sub_Assembly_3	2	FT20.03.00.04000	-	-	18,321kg
11	Underframe_Weld_Parts	1	FT71.03.01.19000	-	-	42,204kg
10	Underframe_Machining_Phase_2	1	FT71.03.01.01000	-	-	3693,926kg
9	Complete_Underframe_Sub_Assembly_2	2	EM20.03.01.03000	-	-	7,784 kg
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	-	1,330 kg
1	Block	2	EM20.03.01.00001	42CrMo4H	-	1,285 kg
						3869,2

No	Parça Adı / Designation Name of Item	Adet / Qty.	Resim No / Norm / Drawing No / Norm	Malzeme / Material	Ölçü / Dimension	Ağırlık / 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☒	c☐ k☒
ISO 13920	A☒	B☐	E☒ F☐
ISO 12708	Lm2☐	Lv2☐	Sm2☐ Sv2☐

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

TYP

Complete_Underframe

-

TÜRASAS
Türkiye Rayli Sistem Araçları San. A.Ş.

FT71.03.01.00000

Date:02.07.2024 | Sheet : 1/4 | Size:A0 | Rev: 00

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						
Paint/Color	-	Modf. No	Modification Description	Date	Sign	

ISO 1302 Welded Construction	ISO 2768 General Tolerances	BS 17708 Steel Castings		
<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	Yşl.		
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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