

Reproduction, dissemination or use of this document or its contents in any form without the prior written permission of TURASAS is prohibited. Offenders will be liable for the payment of damages. All rights reserved in the event of the
Part of a public entity or an institution.

ISO 13920 Welded Construction			
Nom. Size	Class	L mm	Ham. lgl.
<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	
ISO 2768 General Tolerances			
Nom. Size	Class	L mm	Ham. lgl.
>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	L mm	Ham. lgl.

ISO 2768 General Tolerances			
Nom. Size	Class	L mm	Ham. lgl.
>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	L mm	Ham. lgl.

Radiographic inspection (EN12681)

GENERAL SPECIFICATION

Casting manufacturing and test method accordig to Tech. Spec.: BLUE_TS_CST_01

EN 12990

Moulding tooling definition and draft values shall comply with this standard for steel casting obtained by sand method

Dimensional and geometrical tolerances according to EN ISO 8062-3:

- DCTG 8 (Dimensional)
- GCTG 5 (Geometrical)
- RMAG F(Overthickness)

Visual Inspection (VT) according to EN 1370

Surface quality discontinuities (unmachined surfaces):

- roughness quality to be greater than: -3S1 (BNIF) or A3 (SCRATA)

Surface quality discontinuities (machined surfaces): LEVEL -A-

Technical Specifications					
Technical Document		R03	Ø100 ölçüsü Ø130 olarak güncellenmiştir.	25/06/2024	T.ŞABA
Fixture/Mould Asset ID.		R02	CHANGED MATERIAL	03/12/20	H.BELHAJ
Coating/Heat Tre./Roughness		R01	CHANGED MATERIAL	24/09/18	S.Ponzo
Paint/Color		Modif. No	Modification Description	Date	Sign

MARKING

- Material designation
- Model number
- Date of casting
- Identification of batch number
- Supplier code number (optional)

MACHINING PART

- Sharp edge pulled down
- Not dimensioned radius: R3
- Not dimensioned chamfer 2x45°
- Non specified machined surface roughness: Ra 6.3
- All dimension shall be measured before painting

Item No	Designation Name of Item	Qty.	Standard Identification No Company	Material Company Code	Dimension	Weight (Kg)
ISO 21920-1	ISO 8015	ISO 2553	General Tol.	ISO 2768	f <input type="checkbox"/> m <input type="checkbox"/> H <input type="checkbox"/> K <input type="checkbox"/>	37.3
EN 15085-2 Certification Level	CL1 <input type="checkbox"/> CL2 <input type="checkbox"/> CL3 <input type="checkbox"/>	Weld Pro.	Cast Steel	ISO 13920	A <input type="checkbox"/> B <input type="checkbox"/> E <input type="checkbox"/> F <input type="checkbox"/>	
Approved	P.FARINA		Scale	TS 12708	Lm2 <input type="checkbox"/> Lr2 <input type="checkbox"/> Sm2 <input type="checkbox"/> Sr2 <input type="checkbox"/>	
Checked	M.BORLO		1 : 2			
Prepared	Marco EID					
TYP						
Date:	Parts List No:					

TURASAS
Turkish Railway Vehicles Industry Inc.

EM20.24.03.51013

Sheet: 1/1 | Size: A1 | Rev: 03