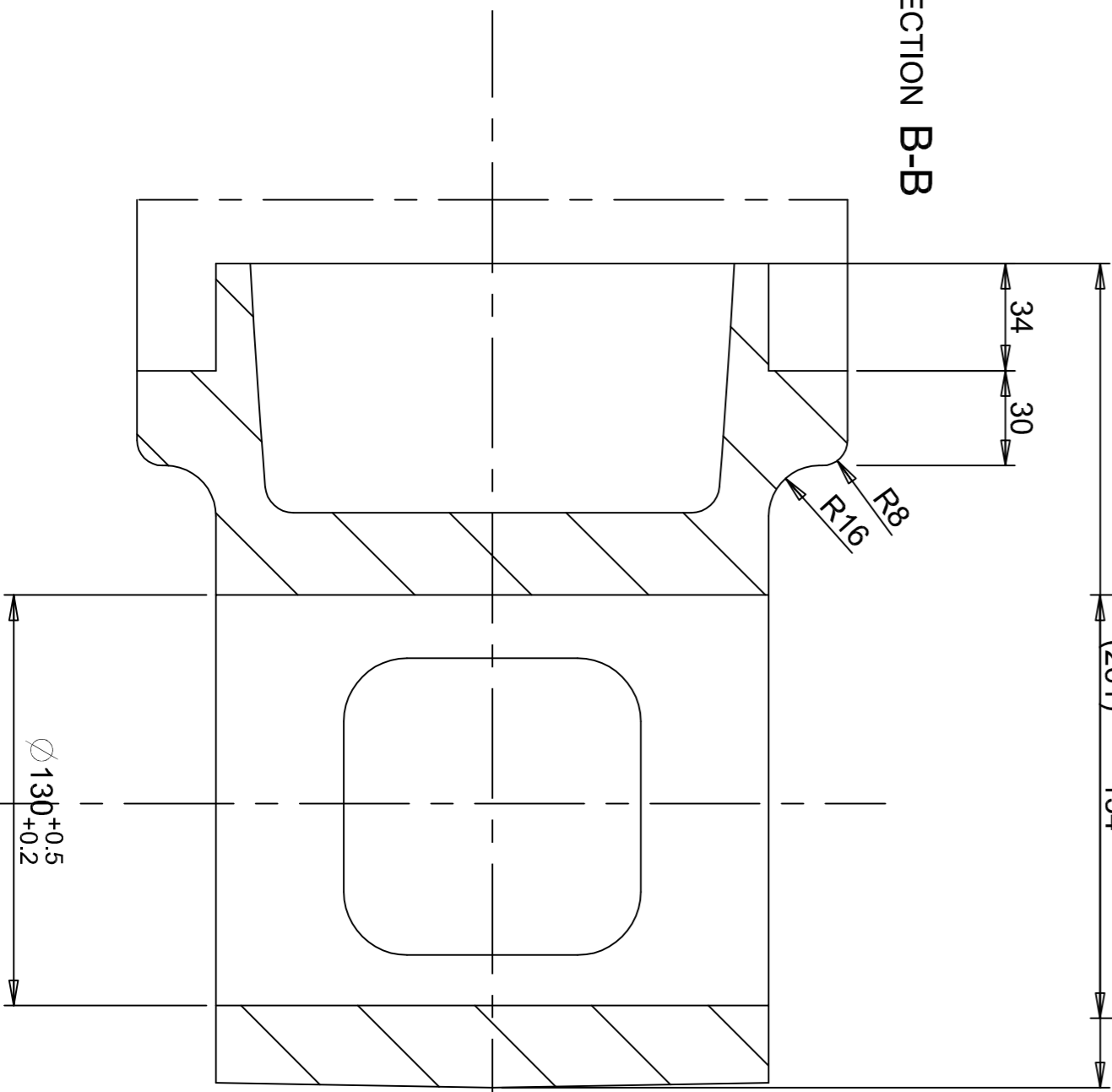


SECTION B-B



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 (BNF) or A3 (SCRATA)

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

ISO 1

ISO 1

ISO 1

ISO 2

Radiographic inspection (EN12681)

Technical Specifications	-		
Technical Document	-		
Fixture/Mould Asset ID	-		
Coating/Heat Tre./Roughness	-		
Paint/Color	-		

- MACHINING PART**
- Sharp edge pulled down
 - Not dimensioned radius: R1.5
 - Not dimensioned chamfer 2x45°
 - Non specified machined surface roughness: Ra 6.3
 - All dimension shall be measured before painting

MARKING

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

No	Purpose Add	Adet	Ream No / Norm	MatZemre	Dimçü	Weight (kg)
ISO 1302	Designation Name of Item	Qty.	Drawing No / Norm	Material	Dimension	Weight (kg)
ISO 8015	EN 22553		General Tol.	ISO 2768	ISO 13920	ISO 13920
EN 15065-2	Certification Level	CL1 CL2 CL3 CL4 CL5	Weld Proc.	ISO 12708	ISO 12708	ISO 12708
Approved	P.FARINA		Scale			
Checked	M.BORLO		1:2			
Prepared	Marco EID					
Turkish Wagon Industry						
EM20.24.03.51016						
Sheet: 1/1						Size: A1 Rev 02