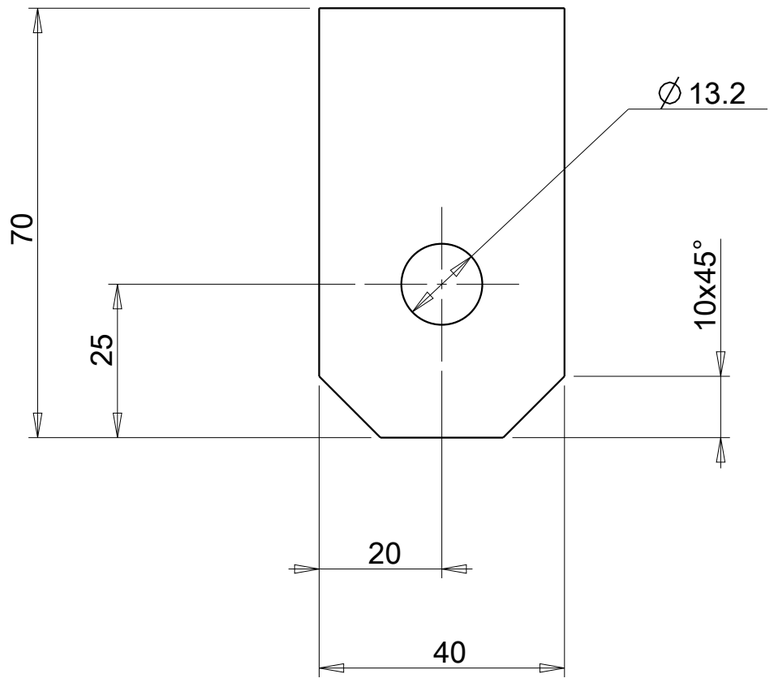
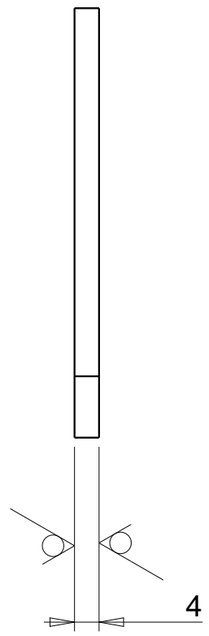


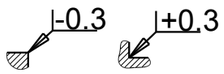


ISO 13920 Welded Construction			
	>20000	9,0	8,0
	<20000	8,0	7,0
	<16000	7,0	6,0
	<12000	6,0	5,0
	<8000	5,0	4,0
	<4000	4,0	3,0
	<2000	3,0	2,0
	<1000	2,0	1,5
	<400	1,0	1,0
	30-120	1,0	0,5
	2-30	1,0	0,5
	L mm	A ±	E ±
	Nom. Size	Class	

ISO 2768 General Tolerance			
	<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	

TS 12708 Steel Casting			
	<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	Raw	Form
	Nom. Size	Class	

Edge without dimension according to DIN ISO 13715



Ra 12.5

( )

STEEL SHEETS NOTES:

Thermal cutting - Classification of thermal cuts - Geometrical product specification and quality tolerances According to EN ISO 9013 - 231

Hot-rolled steel plates 3 mm thick or above - Tolerances on dimensions and shape According to EN10029 - B

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

No	Parça Adý Designation Name of Item	Adet Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Ölçü Dimension	Ağirlik Weight (Kg)
				X5CrNi1810 EN 10088-2		0.1

ISO 1302 ISO 8015 EN 22553		General Tol.	ISO 2768 f ☐ m☒ H☐ K☒
EN 15085-2 Certification Level CL1☐ CL2☐ CL3☐ CL4☐		Weld Prod.	ISO 13920 A☒ B☐ E☒ F☐
		Cast Steel	ISO 12708 Lm2☐ Lr2☐ Sm2☐ Sr2☐
Approved	P.Farina	Scale	
Checked	M.Borlo	1:1	
Prepared	S.Ponzo		

TYP

Flange

TÜVASAS

Turkish Wagon Industry

EM20.24.03.80012

Date:14/11/18 | Sheet:1/1 | Size:A3 | Rev:00

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