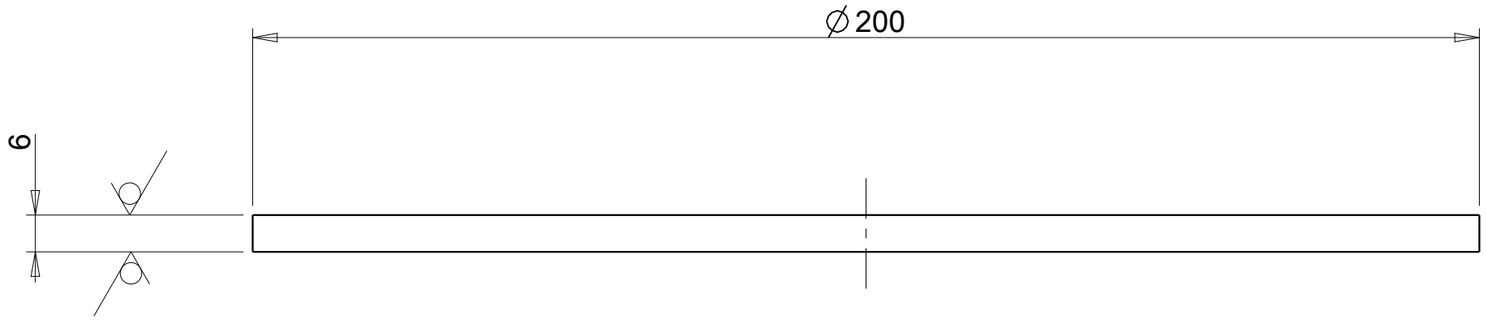

TS 12708 Steel Casting		
<1000	6,0	0,8
<630	4,0	0,7
<400	3,0	0,6
<250	3,0	0,4
100	2,0	0,3
40	1,5	0,2
L mm	Raw	Form
Nom. Size	Class	

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	

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	

Edge without dimension according to DIN ISO 13715

-0.3 +0.3

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 Ad Designation Name of Item	Adet Qty.	Resim No / Norm Drawing No / Norm	Malzeme Material	Ölçü Dimension	Ağirlik Weight (Kg)
				S355J2 EN 10025		1.5

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

Plate

Date:02/07/2018

TÜVASAS
Turkish Wagon Industry

EM20.24.09.30.013

Sheet:1/1 Size:A3 Rev:00

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