



Reproduction, dissemination or use of this document in full or in part without the prior written permission of TÜVASAS is prohibited. All rights reserved in the event of the use of this document for any purpose other than the one intended.

ISO 2768 General Tolerances	<1000	6,0	0,8
	<630	4,0	0,7
ISO 13920 Welded Construction	<400	3,0	0,6
	<250	3,0	0,4
ISO 13920 Welded Construction	100	2,0	0,3
	40	1,5	0,2
ISO 2768 General Tolerances	L mm	Ham	L
	Nom. Size	Class	
ISO 2768 General Tolerances	<4000	2,0	0,4
	<2000	1,2	0,4
ISO 13920 Welded Construction	<1000	0,8	0,3
	<400	0,5	0,3
ISO 2768 General Tolerances	30-120	0,3	0,2
	2-30	0,2	0,1
ISO 13920 Welded Construction	L mm	m ±	K ±
	Nom. Size	Class	
ISO 2768 General Tolerances	>20000	9,0	8,0
	<20000	8,0	7,0
ISO 13920 Welded Construction	<16000	7,0	6,0
	<12000	6,0	5,0
ISO 2768 General Tolerances	<8000	5,0	4,0
	<4000	4,0	3,0
ISO 13920 Welded Construction	<2000	3,0	2,0
	<1000	2,0	1,5
ISO 2768 General Tolerances	<400	1,0	1,0
	30-120	1,0	0,5
ISO 13920 Welded Construction	2-30	1,0	0,5
	L mm	A ±	E ±
ISO 2768 General Tolerances	Nom. Size	Class	

#### 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 Inspector (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-

#### 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: R5
- Not dimensioned chamfer 0.5x45°
- Non specified machined surface roughness: Ra 6.3
- All dimension shall be measured before painting

Radiographic inspection (EN12681)

Technical Specifications	-					
Technical Document	-					
Fixture/Mould Asset ID.	-					
Coating/Heat Tre./Roughness	-					
Paint/Color	-					
Modif.No	1	CHANGED MATERIAL		24/09/18	S.Ponzo	
Modification Description				Date	Sign	

				GE360 DIN EN10293-2015		3.7
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.	ISO 2768	f □ m <input checked="" type="checkbox"/> H □ K <input checked="" type="checkbox"/>
EN 15085-2 Certification Level		CL1 □ CL2 □	Weld Pro.	ISO 13920	A <input checked="" type="checkbox"/> B □ E <input checked="" type="checkbox"/> F □	
Approved		P.Farina	Scale	ISO 12708	Lm2 □ Lr2 □ Sm2 □ Sr2 □	
Checked		M.Borlo	1:1	<b>TUVASAS</b> Turkish Wagon Industry		
Prepared		Marco EID				
Support				EM20.24.09.30028		
Date: 30/08/2018				Sheet: 1/1	Size: A1	Rev: 01