

*This Procedure was developed for a typical outside stake aluminum car and may not be applicable to all. Please consult your original drawings or contact FreightCar America, Inc. for details.*

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**BILL OF MATERIAL**

*Per Location*

- (0) ..... 00000-000

- 1). If the side sill is cracked, it should be removed and replaced.
- 2) If the side sill has been gouged in excess of 1/4" deep the side sill should be removed.
- 3) If the side sill has been gouged and the gouge is less 1/4" deep, the side sill may remain on the car provided the gouge is ground smooth (i.e. to a min. 1/2" radius) and the other criteria outlined in this procedure are met.
- 4) If the side sill has taken a permanent deformation of 1/8" or less downward within a 3 foot length of side sill, the side sill may remain on the car unaltered provided the other criteria discussed in this procedure are met. (Deflection measurements should be gauged at the top outside edge of the side sill)
- 5) If the side sill has taken a permanent downward deformation in excess of 5/16", the side sill should be removed and replaced.
- 6) Permanent downward deformations between 1/8" and 5/16" maybe straightened using slow steady pressure, and raising the gage point 1/8" above level (overbending). No hammering should be done to straighten this piece. As a precaution, the area should be dye penetrant tested after straightening.