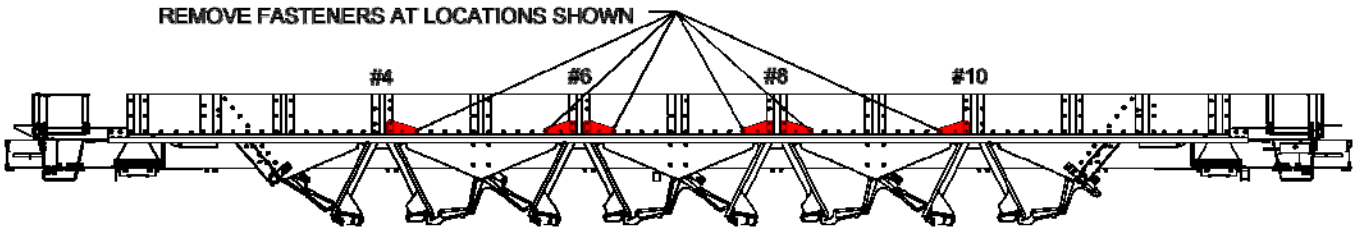
Side Sill Repair Procedure	**Side Sill @ Crossridge Connection Repair AutoFlood III™ Issued August 10, 2010**	FreightCar America

This Procedure was developed for AF III built with M102792-00X side sills and may not be applicable to all AutoFlood III's. Please consult your original drawings or contact FreightCar America Inc. for details.



Procedure:

1. This procedure is for the application of stiffeners to the side sill at crossridge area.
2. Open doors, then completely drain the air from the door system.
3. Inspect the side sill for a crack in the vertical and horizontal legs.
   A. If there is no crack proceed to application section.
   B. If a crack is recognized, drill stop the crack terminus if it is has not gone beyond the vertical leg that secures the side sheet. Otherwise drill stopping is not necessary. Also drill stop the crack terminus if the crack is in the horizontal section of the side sill. **(Drill stop criteria sketch, page 2)**

• Application Drawing A107018-000

BILL OF MATERIAL

Per Car

• (24)	10231-010	Lockbolt, C50L30-BR20-16GA
• (12)	10231-011	Lockbolt, C50L30-BR20-20GA
• (36)	10231-013	5/8" Collar, 3LC-2R20GAL
• (36)	10264-003	Una-Driv Bolt, 5/8" X 2"
• (36)	10264-004	Nut 5/8" Una-Driv Stover
• (11 ft/car)	10246-739	3" x 216' PE Foam Tape
• (15 ft/car)	10246-937	14" x 216' PE Foam Tape
• (6)	A106979-010	Reinforcement, Side Sill
• (6)	A106979-020	Reinforcement, Side Sill
• (4)	M107007-000	Reinforcement Angle, Side Sill

Side Sill Reinforcement Application (ref. dwg A107018-000):

1. At each of the (12) crossridge side stake areas identified above, remove (4) fasteners as shown. Protect the side sill and side stake from heat damage when removing the fasteners.
2. Apply PE foam tape to back side of the side sill reinforcement (A106979-010, A106979-020 and M107007-000) where it will contact existing aluminum parts.
3. Fasten (6) A106979-010 and (6) A106979-020 side sill reinforcements to side stake (only) in the holes made in step 1. Assure that the horizontal leg of the reinforcement stays in contact with the horizontal leg of the side sill. Refer to Drawing A10718-000 for fastener designation.
4. Apply and tighten a temporary fit up bolt to the hole furthest from the side stake.
5. Using the side sill reinforcement as a template, drill (24) 11/16" diameter holes through the horizontal leg of the side sill.
6. Remove all temporary fit up bolts.
7. Fasten all remaining fasteners in the reinforcements at locations #4 & #10.
8. Apply side sill reinforcement angle M107007-000 to the underside of the horizontal leg of the side sill at locations #6 & #8 only.
9. Fasten all remaining fasteners in the reinforcements.

Note, **Torque range required for Uni-Drive bolts**
A, When driving nut is in contact with Aluminum, 110-160 FT LBS of torque is required.
B, When driving nut is in contact with Steel, 170-210 FT LBS of torque is required.

Drill stop criteria sketch,