

*This procedure was developed for orders 160031 and may not be applicable to all car types.
Please consult your original drawings or contact FreightCar America Inc. for details.*

BILL OF MATERIAL

Per Car

Item Number	Description	Qty
M116397-000	GUSSET, REINFORCEMENT	3

Description – Addition of three reinforcement gussets to center partition to increase strength of cracked weld were center partition and cross ridge cap meet caused by corrosion.

Procedure:

1. Clean all debris away were center partition and cross ridge cap meet. Both sides of partition.
2. Repair any cracks by grinding and rewelding center partition to cross ridge cap.
3. Position part number M116397-000 per drawings below. Areas must be ground and clean of corrosion.
4. One gusset centered one side and the other two spaced per dimensions below on the other side. (Doesn't matter which side the single or double gussets are placed)

3D Model view of the reinforcement gussets on each side of the center partition. (Side sheet removed for clarity)

* M116397-000 circled below.



