

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). SIDE STAKES W/ REINFORCING WEAR BARS

A). Side Stake Face (Reinforced):

- If gouges exist in a reinforced stake face in excess of 7/16"* in depth, the stake must be removed and replaced with a new stake.
- Gouges in the aforementioned area less than 7/16"* in depth, should be ground to smooth out sharp edges and blended into the surrounding material.
- In cases where gouges are too large to be effectively repaired, the stake should be removed and replaced with new.
- Dents in the side stake should not exceed 1 inch in depth.
- Side stakes cracked as a result of damage from outside forces (i.e. derailment, dumper damage, etc.) should be replaced.

** - Gouges are to be measured from the outer face of the stake's reinforcement (extreme outer face).*

B). Side Stake Web (Reinforced):

- If gouges exist in a reinforced stake web in excess of 1/8" in depth, the stake must be removed and replaced with a new stake.
- Gouges in the aforementioned area less than 1/8" in depth, should be ground to smooth out sharp edges and blended into the surrounding material.
- In cases where gouges are too large to be effectively repaired, the stake should be removed and replaced with new.
- Dents in the side stake should not exceed 1 inch in depth.
- Side stakes cracked as a result of damage from outside forces (i.e. derailment, dumper damage, etc.) should be replaced.

C). Side Stake Web Flange (Reinforced):

- Side stake flanges are to meet the same criteria as is stated for the web except as follows:
- Flanges may be left in service when the car owner agrees and if a crack is found that:
 - does not progress into any other section of the side stake
 - is located at the top of the side stake
 - does not progress past the second fastener down from the top chord
 - has not allowed the side stake face to protrude more than 3/8" out from the vertical face of the top chord

2). SIDE STAKES W/O REINFORCING WEAR BARS

A). Side Stake Face and Web (Un-reinforced):

- If gouges exist in an un-reinforced stake face, web or flange in excess of 1/8" in depth, the stake must be removed and replaced with a new stake.
- Gouges in the aforementioned area less than 1/8" in depth, should be ground to smooth out sharp edges and blended into the surrounding material.
- In cases where gouges are too large to be effectively repaired, the stake should be removed and replaced with new.
- Dents in the side stake should not exceed 1 inch in depth.
- Side stakes cracked as a result of damage from outside forces (i.e. derailment, dumper damage, etc.) should be replaced.

B). Side Stake Web Flange (Un-reinforced):

- Side stake flanges are to meet the same criteria as is stated for the web except as follows:
- Flanges may be left in service when the car owner agrees and if a crack is found that:
 - does not progress into any other section of the side stake
 - is located at the top of the side stake
 - does not progress past the second fastener down from the top chord
 - has not allowed the side stake face to protrude more than 3/8" out from the vertical face of the top chord

