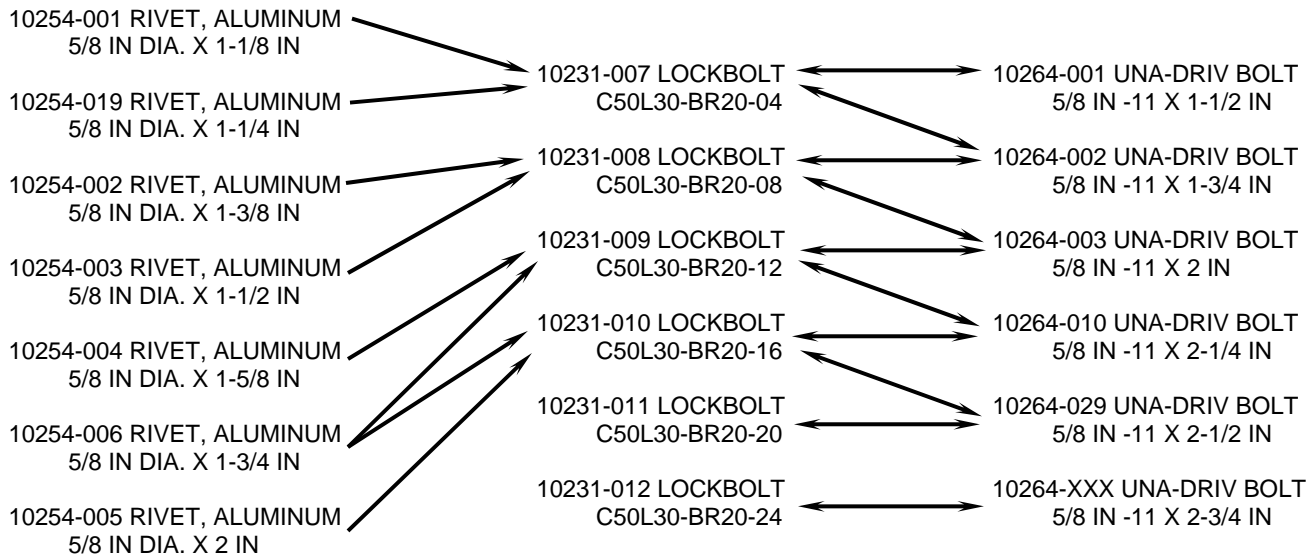


This Procedure was developed as a general guide and may not be applicable to all cars. Please consult your original drawings or contact FreightCar America, Inc for details.

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5/8" DIAMETER



Notes:

1. Rivets are to be pressed per AAR Manual of Standards & Recommended Practices
2. Lockbolts
 - A. "Stick out" (the relationship between the pin at the break off point and the collar top edge) must be from 1/16" below to 3/8" above the collar top.
 - B. When using flanged collars, .156" should be subtracted from the lockbolt's recommended grip range.
3. Una-Driv bolts (5/8" dia.) must have a min 2.4 (.218") & max. 9.3 (.845") threads showing beyond the top of the lock nut. Use .688" for the flanged nut thickness when determining required bolt length.
Bolt length = Grip length (material thickness) + .688" (nut thickness) + .218" min stick out ROUNDED UP TO NEXT .250" INCREMENT.