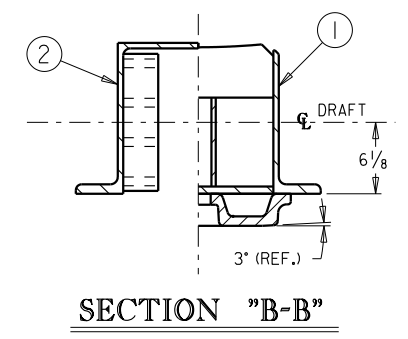
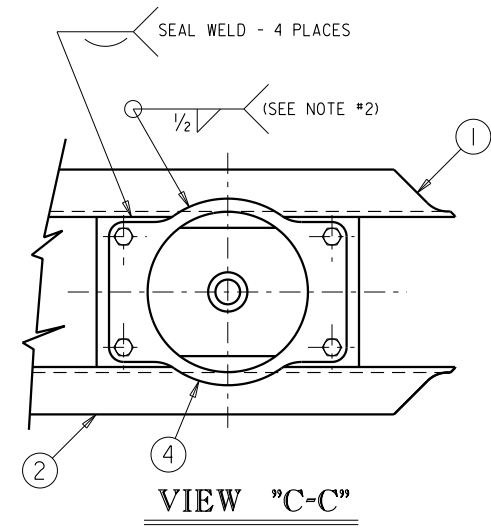
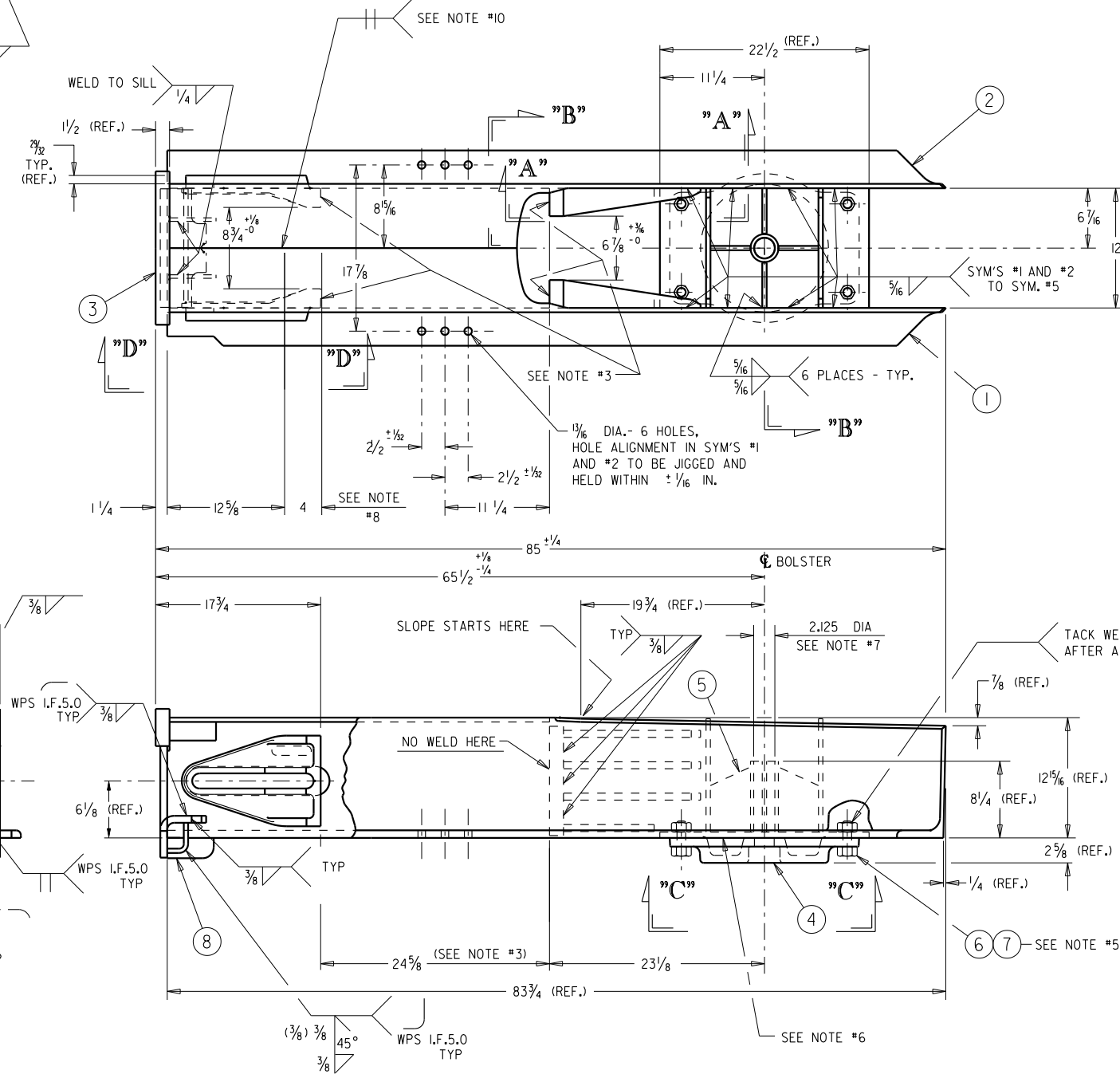


BILL OF MATERIAL					
SYM.	PART NO.	REQ.	DESCRIPTION	MATERIAL	WT. (LBS.)
1	96457-05	1	SILL S/A, "Z" BAR (41.2")	SEE S/A	309
2	96457-06	1	SILL S/A, "Z" BAR (41.2")	SEE S/A	309
3	92395-03	1	STRIKER ASSEMBLY	SEE ASS'Y	68
4	42623-01	1	CENTER PLATE, 14 IN. DIA.	C-1030	95
5	94980-01	1	CENTER FILLER S/A	SEE S/A	127
6	304-4007	4	BOLT, A.S. REG. HEX. HD. 1/8 - 9UNC x 2 3/4 IN. LG.	SAE J429 GR. 5	2.4
7	304-7866	4	NUT, A.S. HVY. HEX 7/8 - 9UNC-2B	A194 GR. 2H	0.76
8	102950-01	2	RECTANGULAR SHAPE W/RADIUSED CORNERS	STEEL	4.72
9	315-4490	1.5*	WIRE WELD, .045 IN. DIA., SPOOLED, E71T-1	A5.2	1.2
10	315-4681	18*	WIRE WELD, 3/32 IN. DIA., SPOOLED, HOBART FABCO #87 (E70T-2)	---	14.4
11					
12					
13					
14					
15					

NOTES:

- ALL WELDS TO BE MADE USING WPS I.F.7.0 UNLESS OTHERWISE NOTED.
- PREHEAT CENTER PLATE CASTING WHEN AMBIENT TEMP. IS LESS THAN 40° F. BEFORE WELDING CENTER PLATE CASTING TO SILL FLANGE (PREHEAT SO THAT CENTER PLATE IS WARM TO HAND).
- THE FACE OF EACH DRAFT LUG MUST BE WITHIN ± 1/32 IN. OF A PLANE AT RIGHT ANGLES TO THE SIDE OF THE DRAFT SILL. THE FACE OF EACH DRAFT LUG MUST BE WITHIN 1/16 IN. OF BEING IN PLANE WITH THE FACE OF THE DRAFT LUG ON THE OPPOSITE SIDE OF THE DRAFT SILL. USE DRAFT SILL COMBINATION GAGE (L-93-49) TO CHECK THESE REQUIREMENTS. (FOR ADDITIONAL INFORMATION REGARDING ESTABLISHED DRAFT LUG TOLERANCING SEE NOTE #10 ON DRAWING 96457.)
- AFTER WELDING, DRAFT SILL MUST BE STRAIGHT WITHIN 1/8 IN. IF NOT, SILL MUST BE STRAIGHTENED.
- UNIFORMLY TORQUE TO 250 FT./LBS., FOUR PER ASSEMBLY.
- FIT-UP BETWEEN SYM. #4 AND #5 MUST BE SUCH THAT 0.001IN. FEELER GAUGE IS "NO-GO" OVER FULL PERIMETER OF CONTACT.
- TOLERANCE NOTE: AFTER ASSEMBLY, I.D. SHOWN MUST BE 2.125 IN. MIN. THRU HOLE.
- WELD IN THE 4 IN. AREA INDICATED TO BE GROUND FLUSH WITH THE TOP OF THE SILL.
- ALL REPAIR WELDING TO BE DONE WITH WPS I.F.5.0.
- BUTT WELD TO BE CONTINUOUS WITH 60% MINIMUM PENETRATION REF. AAR S-266.
- SEE TABLE BEFORE APPLICATION TO TANK, DRAFT SILL ASSEMBLY TO BE POST WELD HEAT TREATED AT 1200°F. FOR ONE HOUR. ASSEMBLY TO BE RESTRAINED SUITABLY TO AVOID DISTORTION DURING HEATING.



REVISION	DATE	BY	REASON
A	MAR 4 1994	BCB	ADDED

DEFAULT TOLERANCES - S/A DRAWING	
ALL DIMENSIONS ARE INCHES UNLESS OTHERWISE NOTED	
FRACTIONAL DIMENSIONS: ± 1/16	
ANGULAR DIMENSIONS: ± 1°	

UNION TANK CAR CO.  
1951 S. HAWKINS AVE.  
EAST CHICAGO, INDIANA 46322

DRAFT SILL S/A (NON-ROBOTICALLY WELDED)  
"E" TYPE SHELF COUPLER  
5'-5 1/2" O.H., 1/4 IN./FT. F.F.

DATE	SCALE	WEIGHT	CHECKED
30 OCT 93	1 1/2 = 12	932*	RZ

96966