

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

10254-001 RIVET, ALUMINUM 5/8 IN DIA. X 1-1/8 IN	10231-007 LOCKBOLT C50L30-BR20-04	10264-001 UNA-DRIV BOLT 5/8 IN -11 X 1-1/2 IN
10254-019 RIVET, ALUMINUM 5/8 IN DIA. X 1-1/4 IN	10231-008 LOCKBOLT C50L30-BR20-08	10264-002 UNA-DRIV BOLT 5/8 IN -11 X 1-3/4 IN
10254-002 RIVET, ALUMINUM 5/8 IN DIA. X 1-3/8 IN	10231-009 LOCKBOLT C50L30-BR20-12	10264-003 UNA-DRIV BOLT 5/8 IN -11 X 2 IN
10254-003 RIVET, ALUMINUM 5/8 IN DIA. X 1-1/2 IN	10231-010 LOCKBOLT C50L30-BR20-16	10264-010 UNA-DRIV BOLT 5/8 IN -11 X 2-1/4 IN
10254-004 RIVET, ALUMINUM 5/8 IN DIA. X 1-5/8 IN	10231-011 LOCKBOLT C50L30-BR20-20	10264-029 UNA-DRIV BOLT 5/8 IN -11 X 2-1/2 IN
10254-006 RIVET, ALUMINUM 5/8 IN DIA. X 1-3/4 IN	10231-012 LOCKBOLT C50L30-BR20-24	10264-XXX UNA-DRIV BOLT 5/8 IN -11 X 2-3/4 IN
10254-005 RIVET, ALUMINUM 5/8 IN DIA. X 2 IN		

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.**