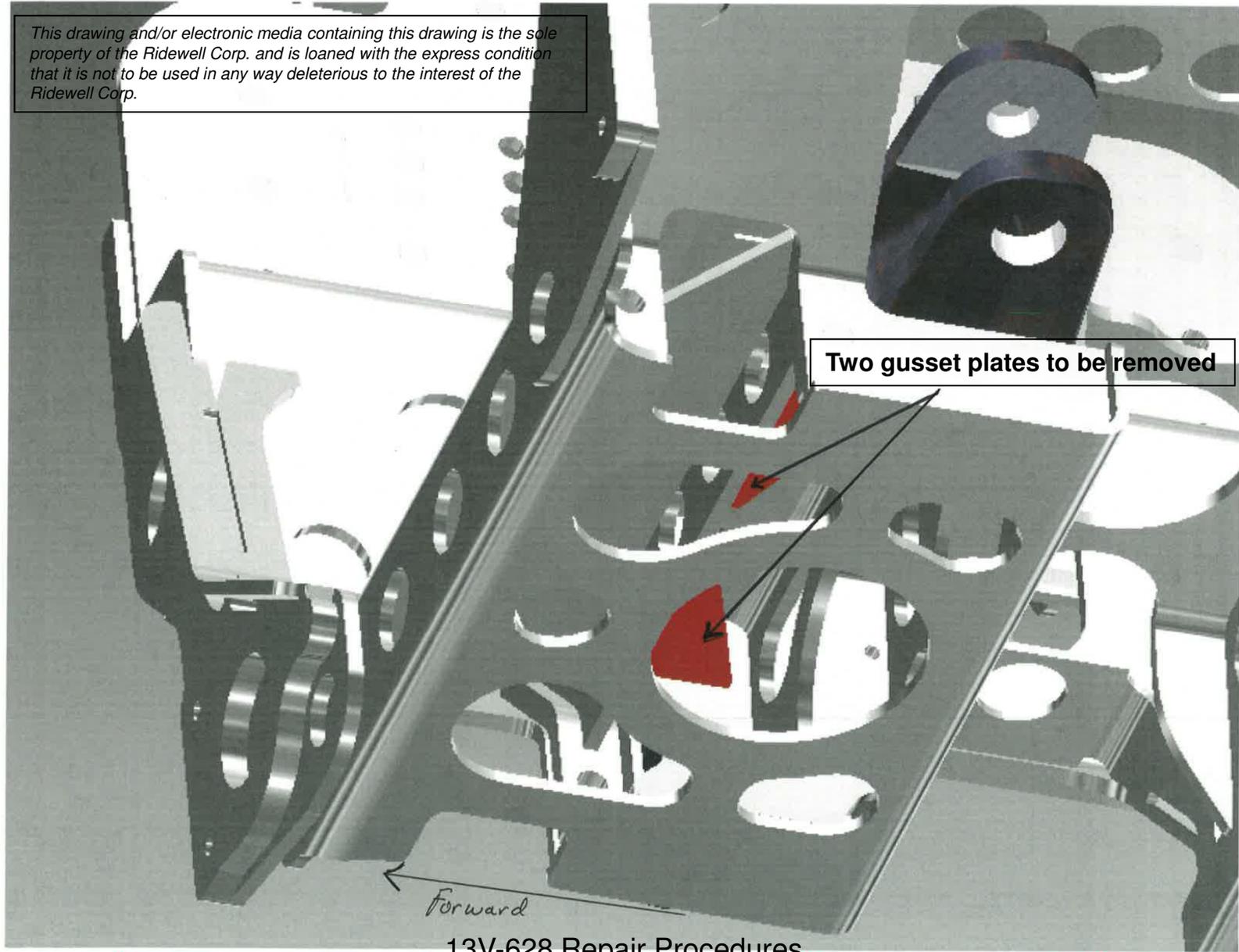


Ridewell IFS Field Repair Procedure

- Repairs to be made only by Ridewell technicians experienced in this specific repair process.
- Step 1: Remove the two existing gusset reinforcing plates using a plasma cutter
- Step 2: Grind the area smooth where the gusset plate welds were cut and restore the surface to it's original condition

Gusset Plate Removal (Step 1)

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Two gusset plates to be removed

Forward

13V-628 Repair Procedures

Ridewell Field Repair Procedure

- Step 3: If the vertical welds are cracked the welds are 100% removed using a die grinder and a groove is ground through a minimum of 50% of parent material to prepare the joint for repair.
- Step 4: Area to be welded is cleaned and prepped using a die grinder to remove all potential contaminants from the weld zone

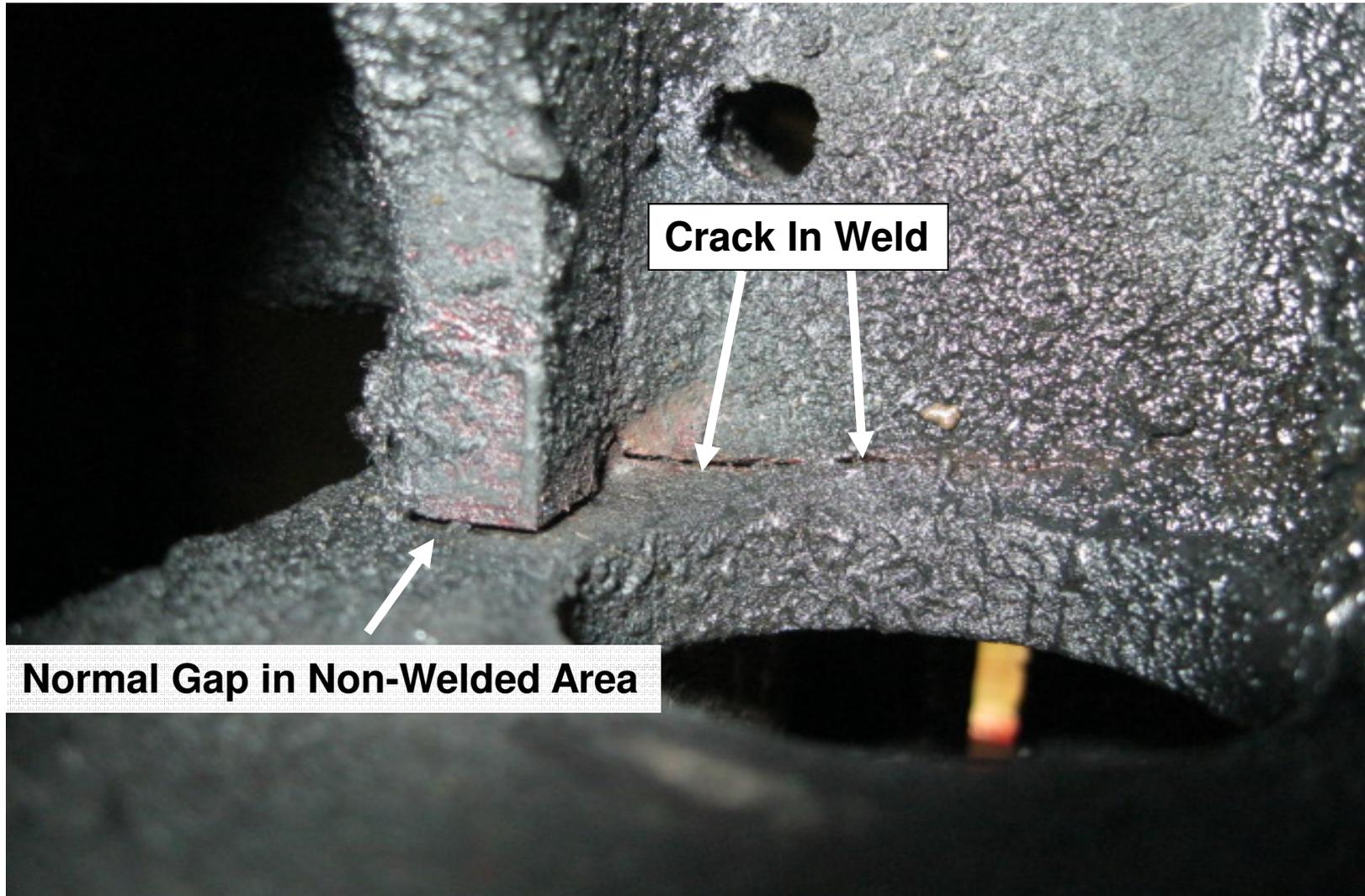
Vertical Weld Inspection and Repair

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**INSPECT VERTICAL WELD JOINTS and REPAIR AS REQUIRED
(right side weld joint shown)**

FORWARD

Vertical Weld Joint Crack

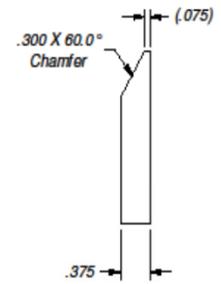
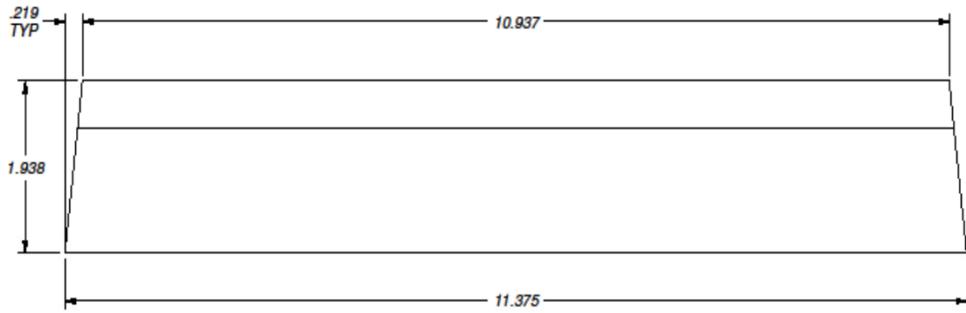
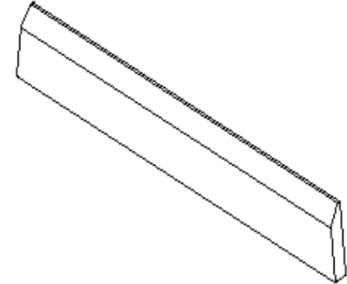


Ridewell Field Repair Procedure

- Step 5: Joint is repaired using MIG welding
- Step 6: IFS field repair kit can now be installed in the IFS unit
- Step 6a: All weld zones for repair kit installation are surface prepped using a die grinder
- Step 6b: Repair kit backing plate is installed using MIG welding with welds along the length of the bottom of the plate and the two sides of the plate

Ridewell Field Repair Procedure

- Step 6c: Repair kit L section component installed using MIG welding with welds around entire plate and at the backing plate to L section interface
- Step 6d: The flat window plate component is installed between the bottom of the L section and back plates using MIG weld with welds around entire plate.
- The IFS cradle repair kit installation is complete



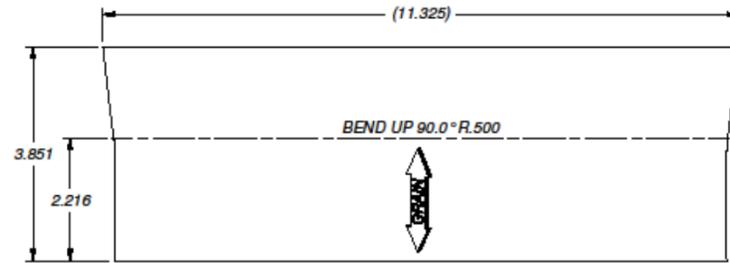
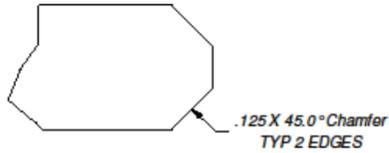
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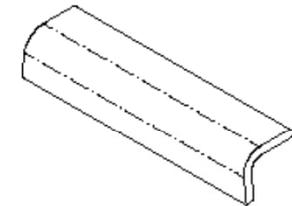
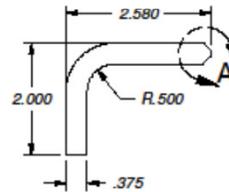
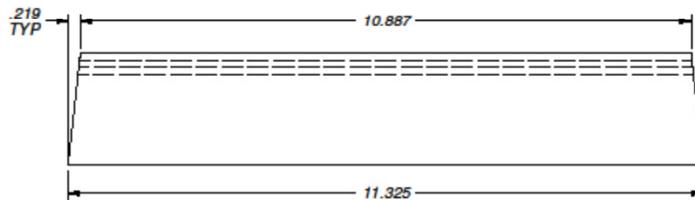
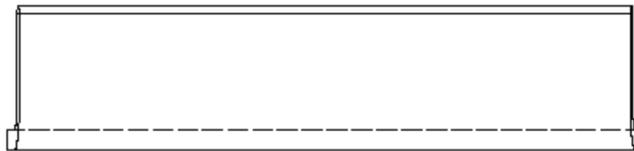
13V-628 Repair Procedures

DATE: 3/25/2013	RIDEWELL CORPORATION PO BOX 4586 SPRINGFIELD, MISSOURI 65808	
APPROVED:	BACK PLATE	
PROJECT: -	SCALE: 1:1	FILE: -
MATERIAL: 0.375 A572 GR50	FINISH: -	QTY: 2.00
0760375A800	STOCK: -	REV: -
TECHNICAL DRAFTER: J. J. JONES	DATE: 3/25/13	PART: 4718
DESIGNED: J. J. JONES	DATE: 3/25/13	REV: 1.0
ISSUED: J. J. JONES	DATE: 3/25/13	REV: 1.0
DATE: 3/25/13	DATE: 3/25/13	REV: 1.0

SHEET 1 OF 1 PART NO: **BACK PLATE** REV: -



FLAT PATTERN

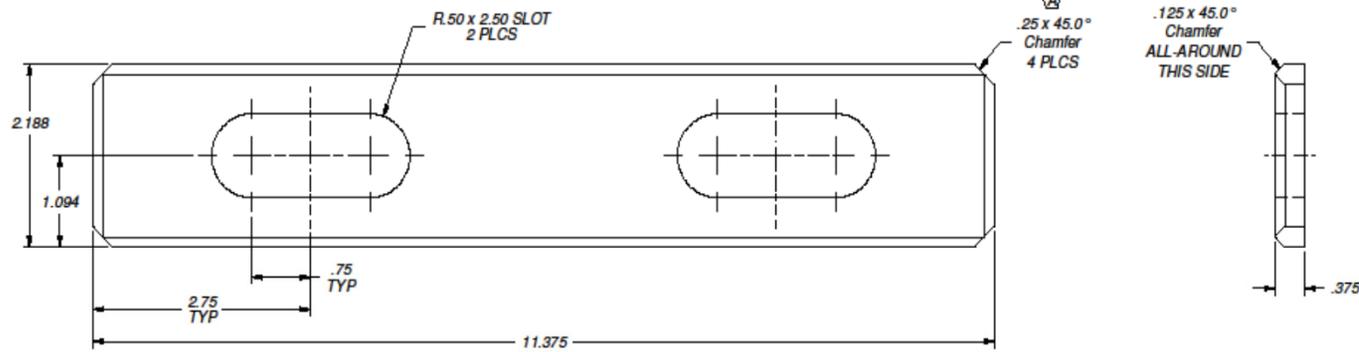
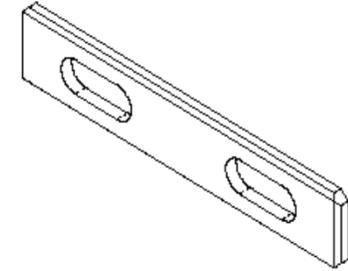
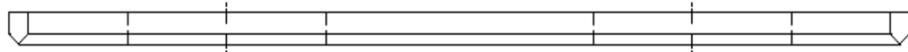


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DATE OF ORDER	3/25/2013	RIDEWELL CORPORATION PO BOX 4586 SPRINGFIELD, MISSOURI 65808
ORDER NO.		
APPROVED		L-PIECE
REVISIONS		
MATERIAL	0.375 A572 GR50 0160375A600	SHEET 1 OF 1 L-PIECE
QUANTITY	1	REV: -

REV	PROJECT	DESCRIPTION	DATE	BY	CHK	APPD



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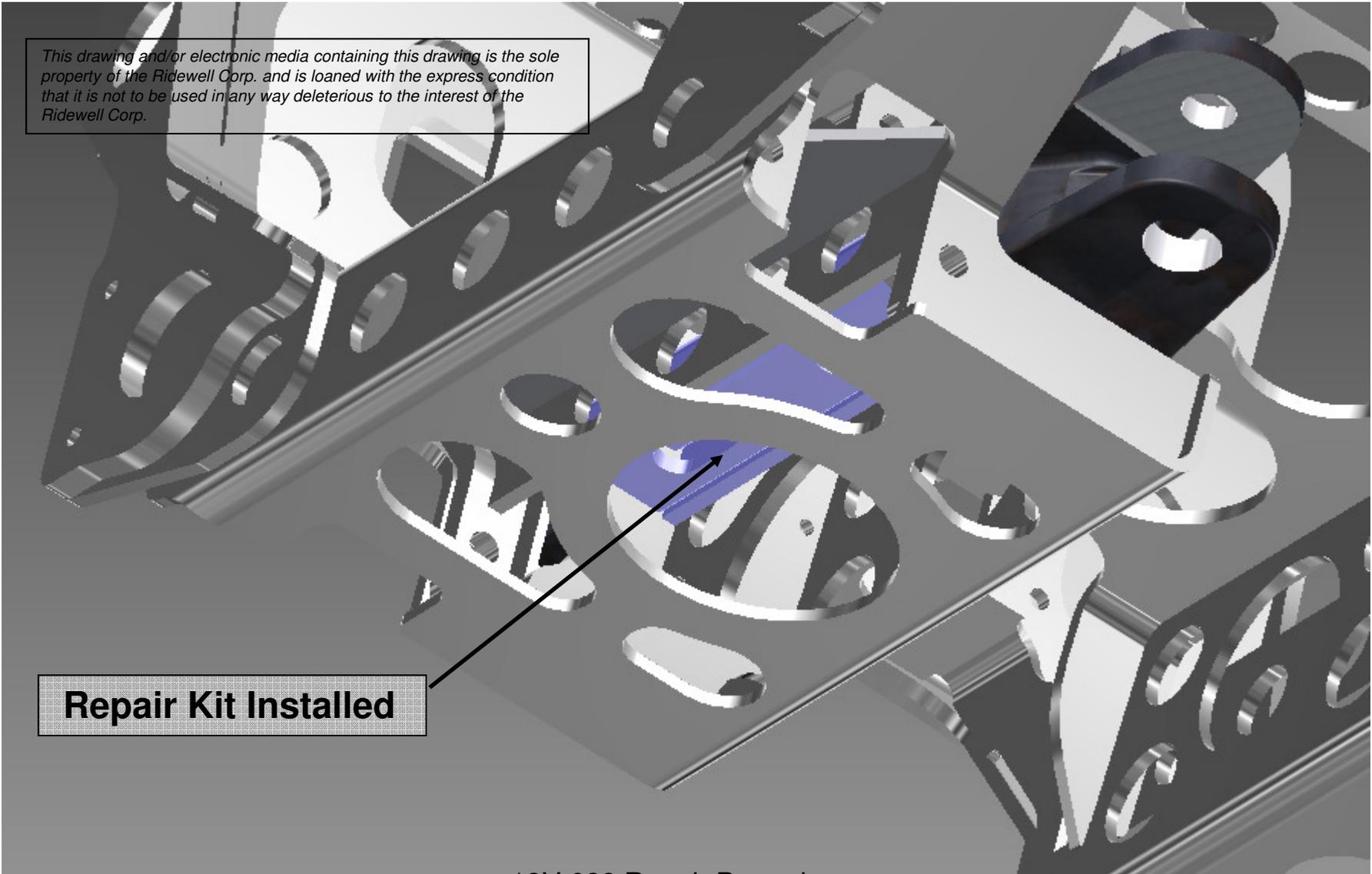
DATE OF REV	4/13	3/25/2013
REV	A	
RIDEWELL CORPORATION PO BOX 4586 SPRINGFIELD, MISSOURI 65808		FLAT WINDOW PLATE
PART NO FLAT WINDOW PLATE	SHEET 1 OF 1	REV A

REV	PROJECT	DESCRIPTION	DATE	BY	CHK	APPD
A	13101	ADDED .25 CHAMFER TO CORNERS	4/13	AAS		

13V-628 Repair Procedures

Bottom View of Repair Kit Installed

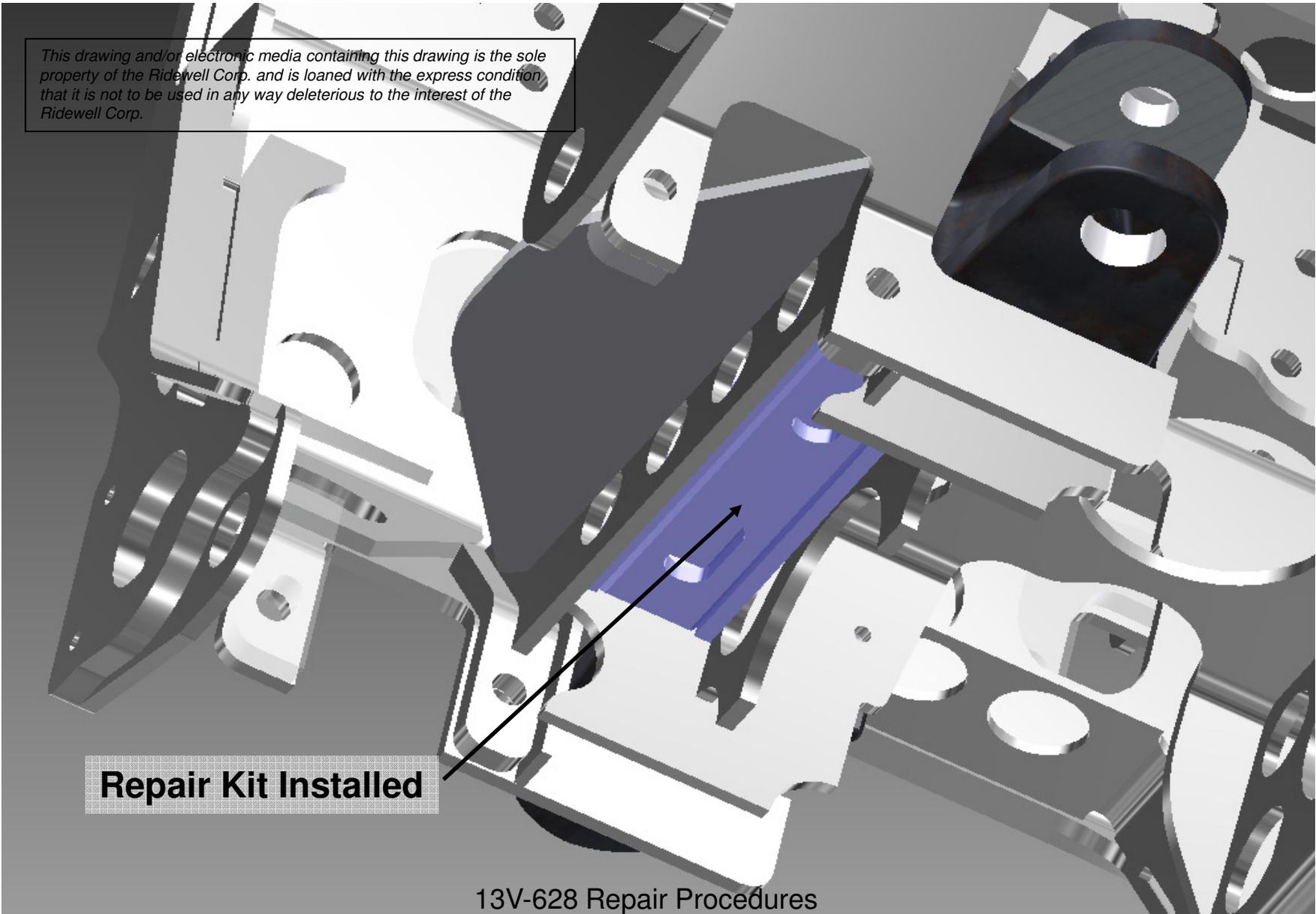
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Repair Kit Installed

Bottom View with Kit Installed (Bottom Plate Removed for Visibility)

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Repair Kit Installed