Pedregal Power Company
MAN V18 thread repair

Repaired August, 2010
Pacora Power Station
Panama City
Panama
Scope of Work

- Metal stitched two cracks and hand finished all surfaces to match the contours.
- Manufactured 4 special Full-Torque thread repair inserts that match the original holes internally.
- Manufactured special hole boring tool to assure perfect alignment to the lower threaded holes.
- Four men traveled to Panama to work around the clock until repair was complete. Two men stayed an extra day until engine was assembled.
- Set up special boring tool and bored out the damaged holes.
- Tapped each hole using special FT18 Full-Torque taps.
- Installed 3 FT18 repair inserts.
- Installed locking pins to prevent the inserts from ever backing out.
Damaged lower bore A9

Cracks found in lower bore stud hole.
Upper bore damage A9

Crack thru the bore and the stud hole.
Bottom stud hole thread damage

Damaged threads at lower stud hole.
Tapping hole

Mag Drill set up tapping FT18 hole.
Finished repair

Insert installed
With locking pins.

Crack repaired using our Patented Castmaster Stitching pins.
LOCK-N-STITCH Inc.

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