

**LOCK-N-STITCH** Inc.  
Casting Repair Specialists  
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## Damaged MAK engine block final report

Date: 3-7-13

Part: 1985 MAK engine block

Serial number: 40096

1. Base metal

- cast iron
- ductile iron
- cast steel
- cast aluminum
- other \_\_\_\_\_

2. Machinability

- no previous repairs
- arc-welded
- brazed
- heat-related cracks
- other \_\_\_\_\_

3. Casting shape where cracked

- flat
- inside/outside corner
- radius
- other \_\_\_\_\_

4. Cause of damage

- impact
- heat
- freezing
- normal operation
- other \_\_\_\_\_

5. Length of crack/s

35" @ 3/4"  
13 1/2" @ 1"  
6 1/2" @ 1 1/2"

6. Material thickness

See above

7. Operating pressure

4 bar in water jacket

8. Operating temperature  
180  
\_\_\_\_\_  
\_\_\_\_\_

9. Working environment  
 hot  
 cold  
 safety concerns  
describe: \_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

10. Remachining requirements  
 bolt holes  
 bearing bores  
 machined surfaces  
 other customer to complete  
final machining

13. Inspection method(s)  
Visual, prepared bath and dye penetrant

14. Damage repaired:

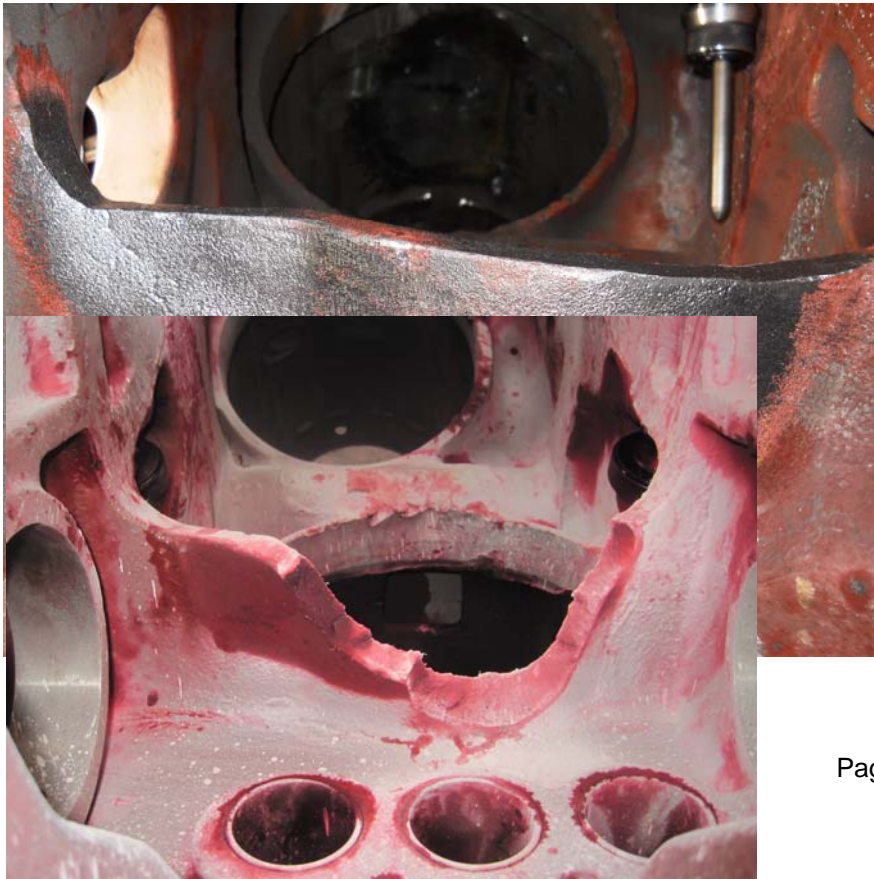
11. Customer's needs  
 permanent repair  
 temporary repair  
 turnaround time  
describe: \_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

12. Accessibility  
 room for the tools?  
 room for the operator/s?  
 need for disassembly?  
describe: \_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

other In Customer Shop











**Conclusion:**

Repair completed March 4, 2013.

**Warranty available:**

This limited warranty covers our materials and workmanship for the repair of your part. Disassembly and downtime are not covered by this warranty. The limited warranty is for a period of one year from the date of completion of the repair. If there should be any failure in our repair during that period of time due to faulty materials and or workmanship, we will again repair the part at our cost including all labor, materials and travel expense, or we could choose to refund the money you paid for the repair in part or full. We reserve the right to make the final decision whether to repair or refund. This is the limit of our liability. Be aware that we are not responsible for failures due to faulty installation or improper operation and maintenance of the part. If the problem that caused the original damage has not been remedied this warranty will become null and void.