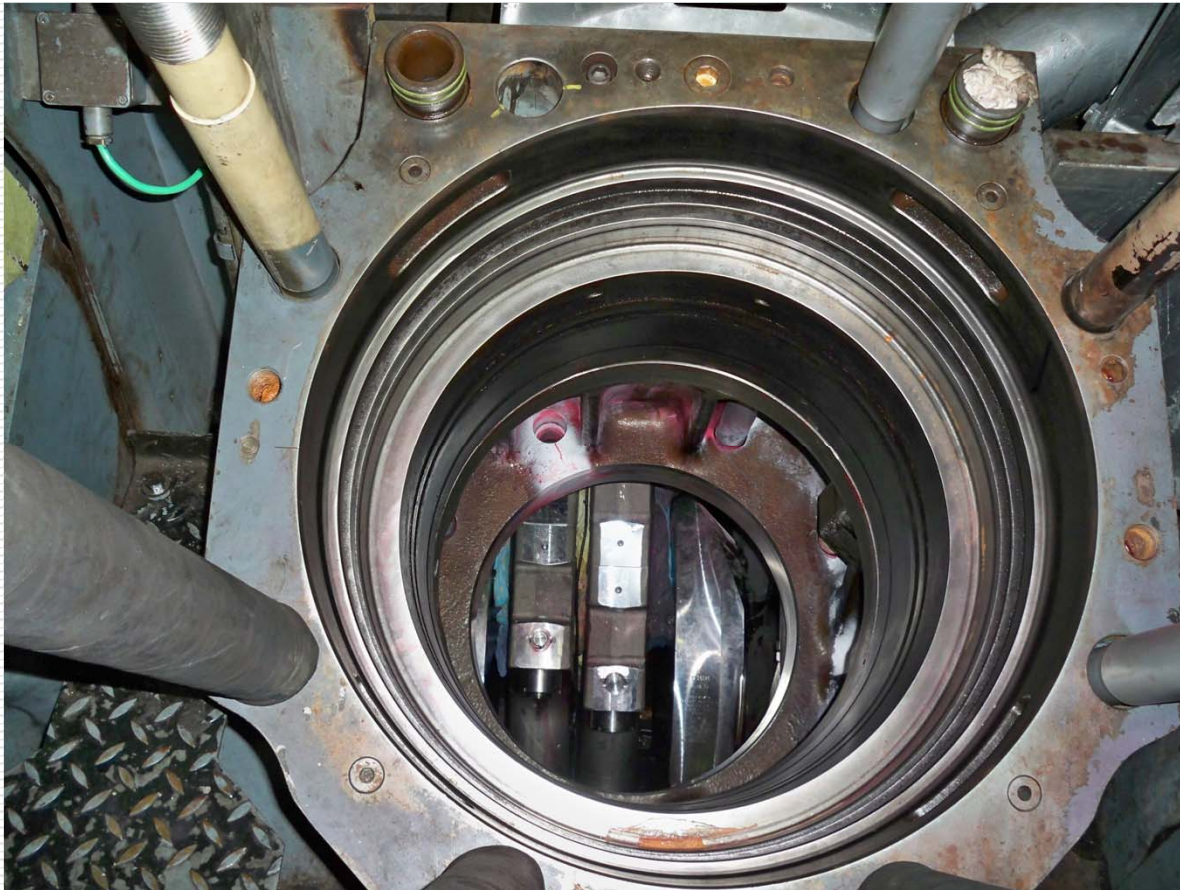


Pedregal Power Company MAN V18 thread repair



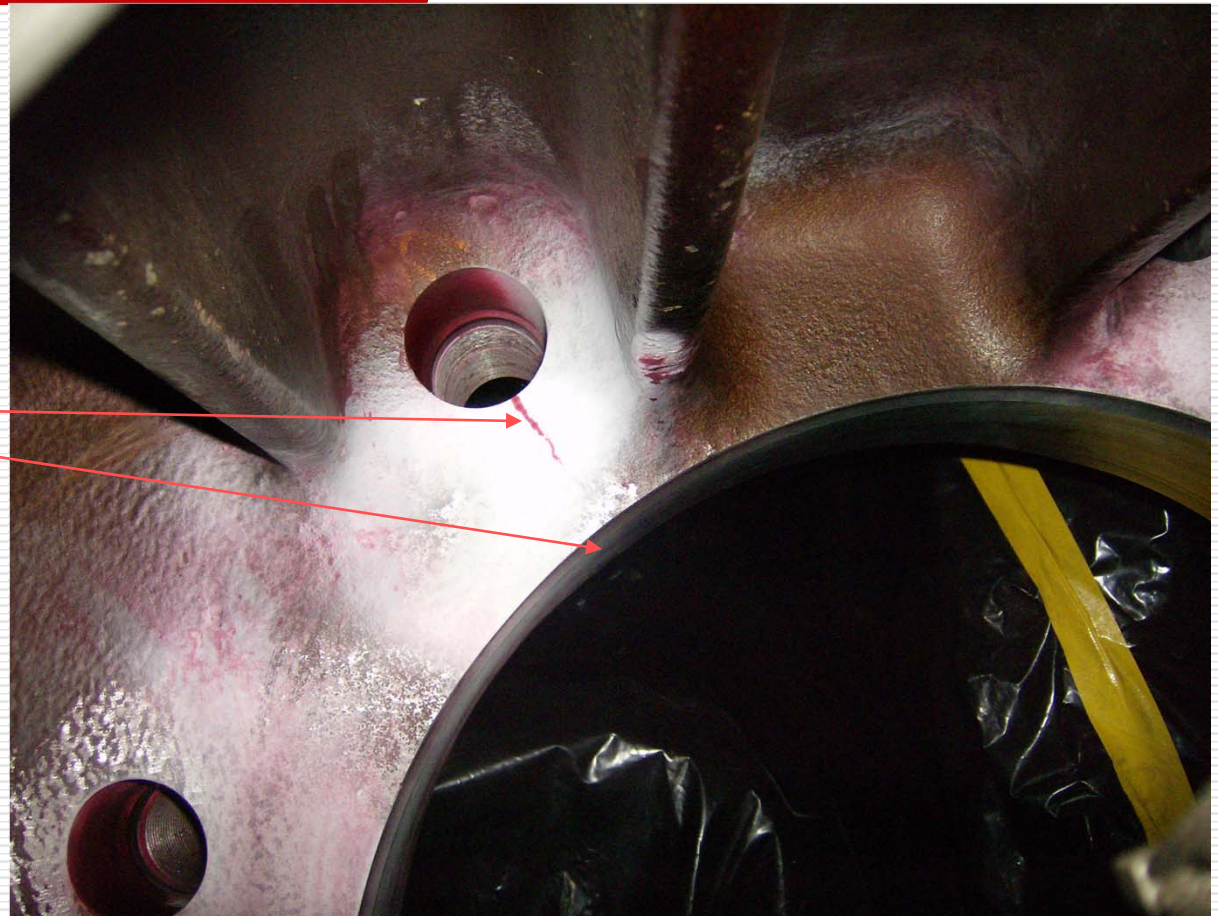
Repaired August, 2010
Pacora Power Station
Panama City
Panama

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.



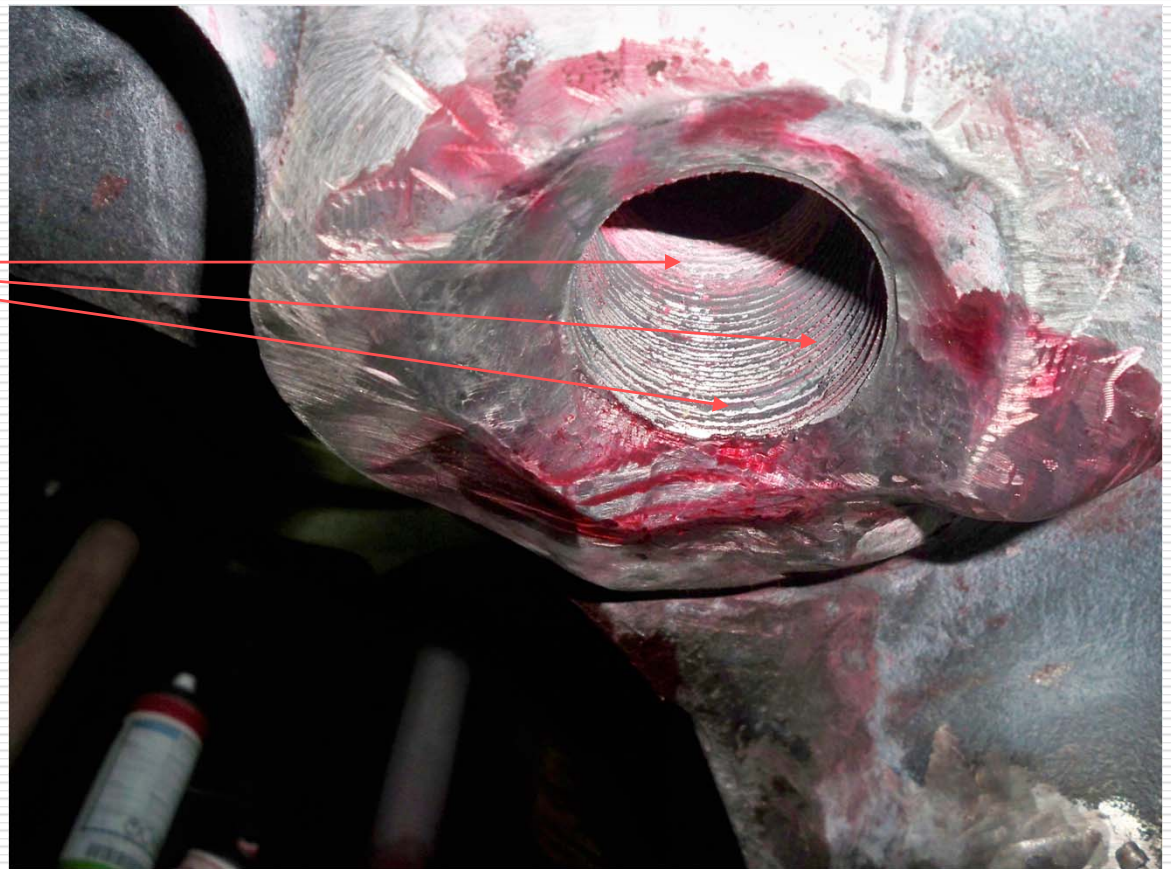
Upper bore damage A9

Crack thru the
bore and the
stud hole.



Bottom stud hole thread damage

Damaged threads
at lower
stud hole.



Tapping hole

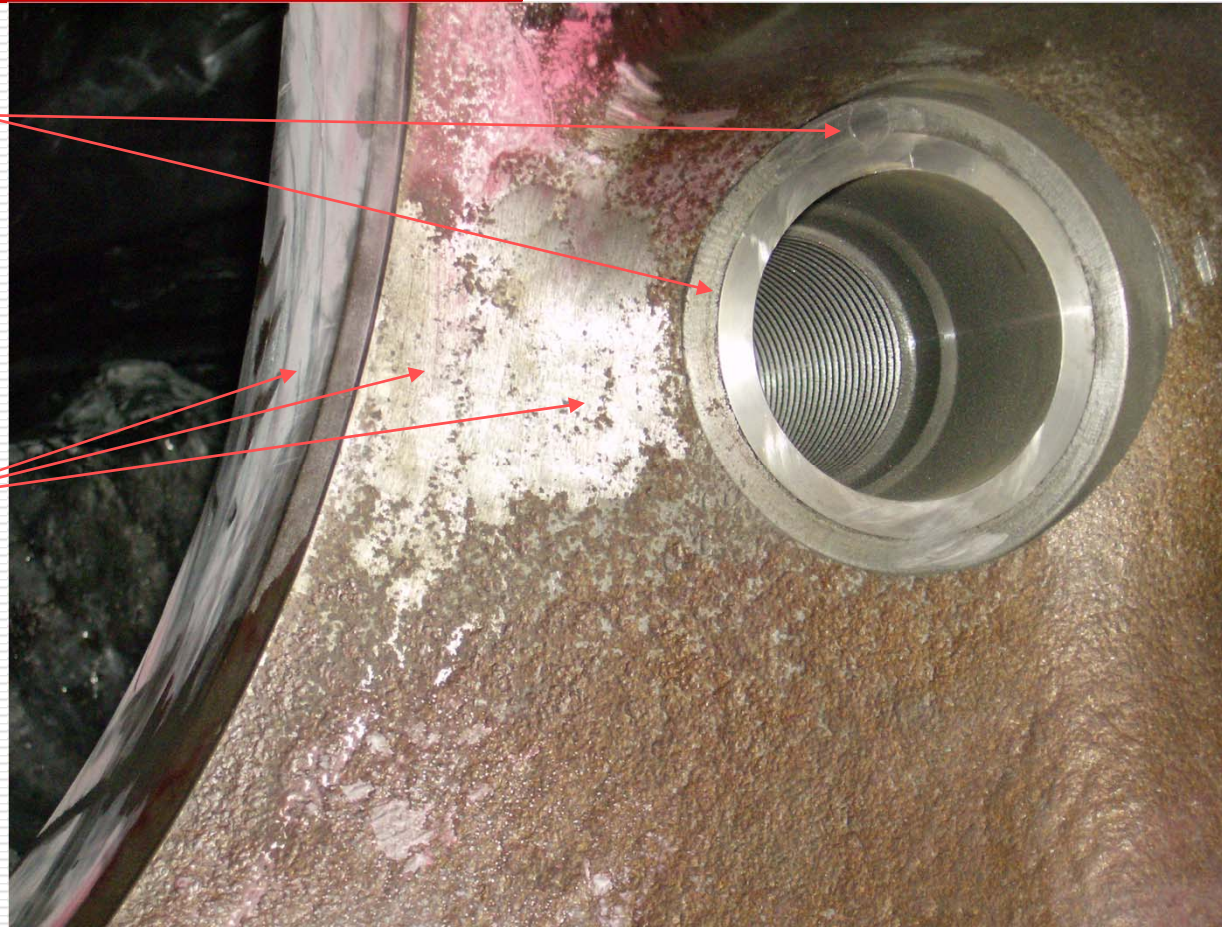
Mag Drill set
up tapping
FT18 hole.



Finished repair

Insert installed
With locking pins.

Crack repaired
using our
Patented
Castmaster
Stitching pins.



LOCK-N-STITCH Inc.

David Silva, Sales Manager

1015 S Soderquist Road

Turlock, CA 95380

(209) 632-2345 ext 227

(209) 648-2670 mobile

dsilva@locknstitch.com
