



- CUTTING SEQUENCE - 'A' END:**
1. REMOVE WELD BETWEEN INNER HOPPER SHEET AND ANGLE AS SHOWN.
 2. REMOVE WELD BETWEEN HOOD AND INNER HOPPER SHEET AS SHOWN.
 3. CUT THRU HOOD SHEET AND REMOVE FROM CAR - DISCARD.
 4. REMOVE WELD BETWEEN INNER HOPPER SHEET AND TOP OF CENTER SILL AS SHOWN.
 5. CUT THRU INNER HOPPER SHEET AS SHOWN AND REMOVE FROM CAR - DISCARD.
 6. REMOVE CENTER SILL SPREADER AND DISCARD. CUT THRU INNER HOPPER ANGLE, BRAKE PIPE AND CENTER SILL AS SHOWN. CENTER SILL CUT TO BE MADE AS SHOWN IN 'CENTER SILL CUTTING' VIEW WITH BEVEL ON ALL EDGES.

- CUTTING SEQUENCE - 'B' END:**
1. REMOVE WELD BETWEEN INNER HOPPER SHEET AND ANGLE AS SHOWN.
 2. REMOVE WELD BETWEEN HOOD AND INNER HOPPER SHEET AS SHOWN.
 3. CUT THRU HOOD SHEET AND REMOVE FROM CAR - SAVE FOR REAPPLICATION.
 4. REMOVE WELD BETWEEN INNER HOPPER SHEET AND TOP OF CENTER SILL AS SHOWN.
 5. CUT THRU INNER HOPPER SHEET AS SHOWN AND REMOVE FROM CAR - SAVE FOR REAPPLICATION.
 6. REMOVE CENTER SILL SPREADER AND SAVE FOR REAPPLICATION. CUT THRU INNER HOPPER ANGLE, BRAKE PIPE AND CENTER SILL CUT TO BE MADE AS SHOWN IN 'CENTER SILL CUTTING' VIEW WITH NO BEVEL.

CUTTING NOTES

1. CHARGE AIR SYSTEM AND CHECK OPERATION AND ADJUSTMENT OF GATES.
2. OPEN ALL GATES, GAG ALL SPRING ASSIST AND DISCONNECT THE RODS FROM THE OPERATING BEAM.
3. JACK THE CAR AND PLACE SUPPORTS UNDER THE SECTION TO BE REMOVED AND PLACE ROLLING SUPPORTS UNDER THE 'A' AND 'B' END SECTIONS ADJACENT TO THE CUTTING PLANE.
4. UNBOLT OPERATING BEAM SUPPORTS AND CENTER SILL SPREADERS TO DROP BEAM. MARK THE 'A' END OF THE BEAM.
5. CUT THROUGH THE SIDES AND CENTER SECTION AS SHOWN IN THE CUTTING VIEWS. FLAME KERF ALLOWANCE MUST BE TO INSIDE OF CUT DIMENSIONS. CUT DIMENSION MUST BE TO CUT EDGE AFTER BURNING. REMOVE THE SECTION.
6. MEASURE AND CUT THE OPERATING BEAM AS SHOWN IN THE OPERATING BEAM CUTTING VIEW.
7. WHERE NECESSARY, GRIND THE BURNED EDGES TO BE REWELDED.
8. INSURE THAT ALL PERSONNEL ARE CLEAR OF GATES PRIOR TO OPERATION.
9. INSURE THAT STRUCTURE IS PROPERLY SUPPORTED AND STABLE PRIOR TO CUTTING.

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DRAWN:	SCL	DATE:	9/7/03
CHECKED:		DATE:	
TOLERANCES: UNLESS NOTED:			
DIMS:	± 1/8"		
ANGLES:	± 1°		
HOLE Ø:	± 1/32"		
SCALE:	1=16	NEXT ASSEMBLY NO.:	
REV.	BY	DATE	
DRAWING NO. GS21-GA1			SHT. 1/1