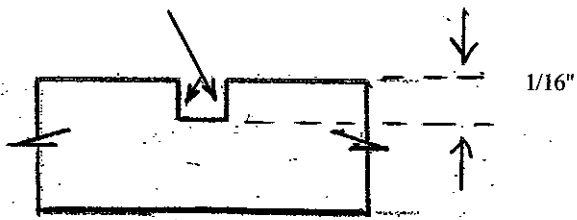
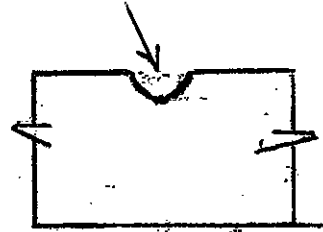


GRIND TO REMOVE STRESS RISERS



SAW CUTS PRIOR TO REPAIR

BEVEL USING 1/2" BALL CARBIDE BURRER



BEVEL OF SAW CUTS

FIGURE FOR LONGITUNAL FLANGE REPAIRS