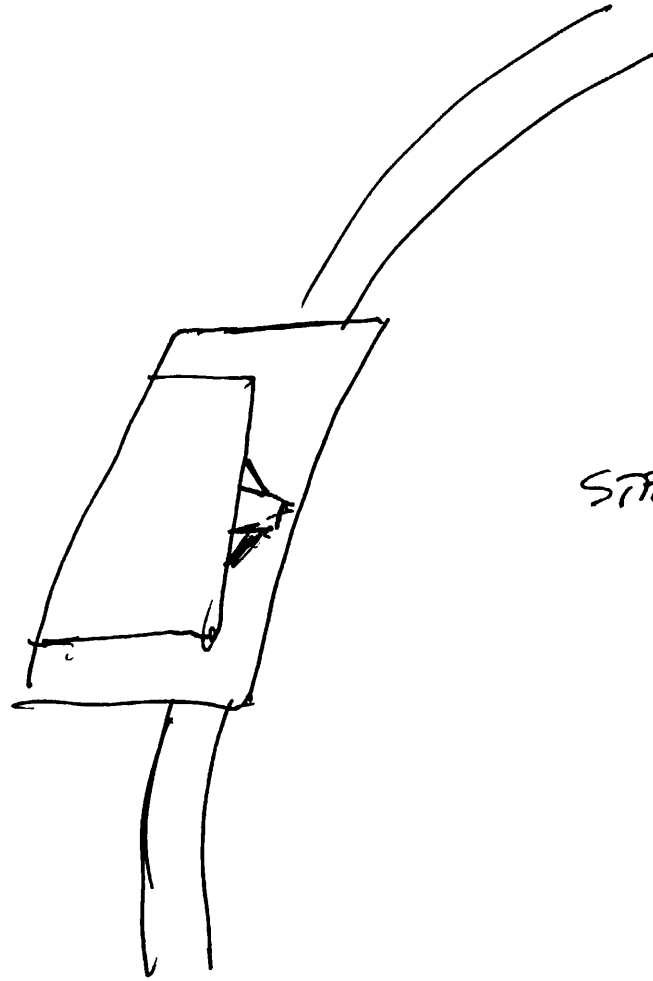
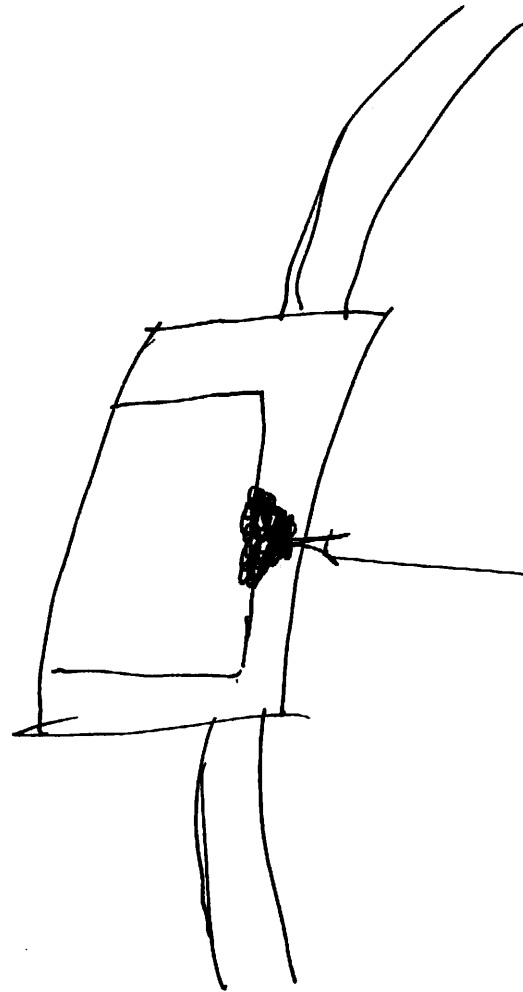


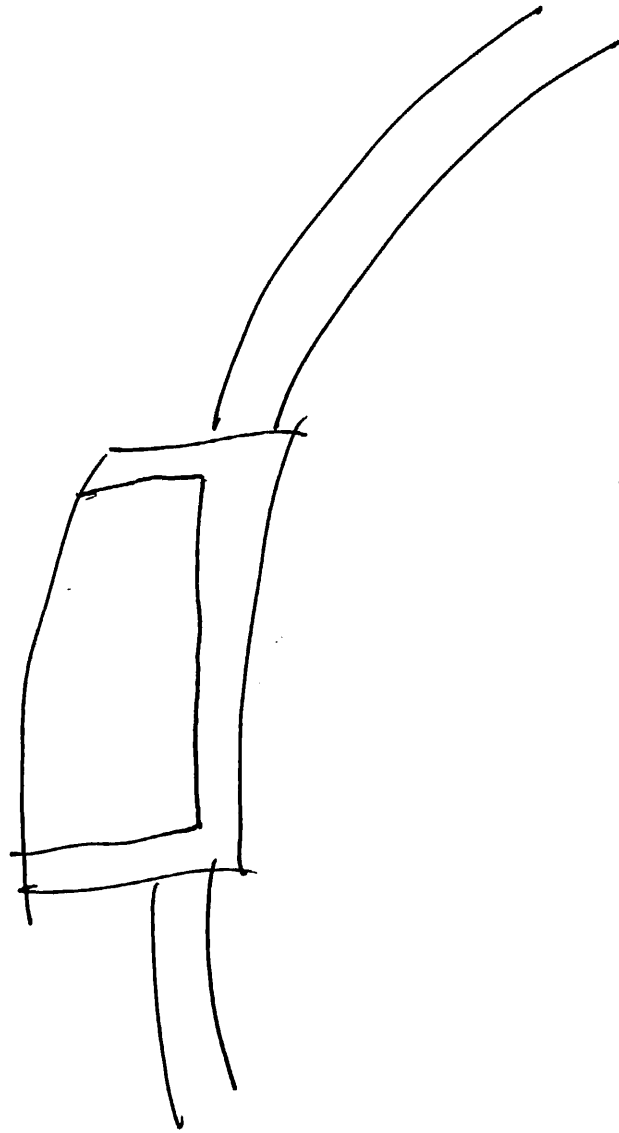
EXISTING CONDITION  
(OUT OF ANGULAR  
POSITIONS.)



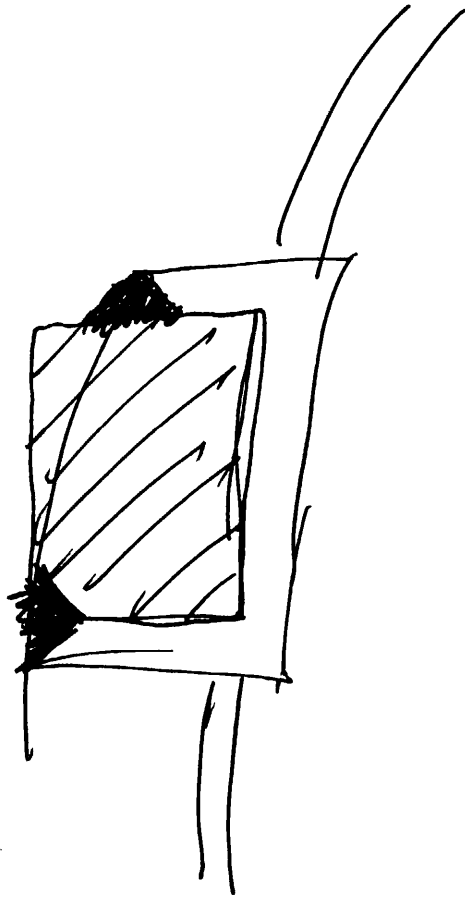
STEP 1 : BORE & CHAMFER  
FOR WELDING



STEP 2: WELD BOTTOM OF  
HOLE

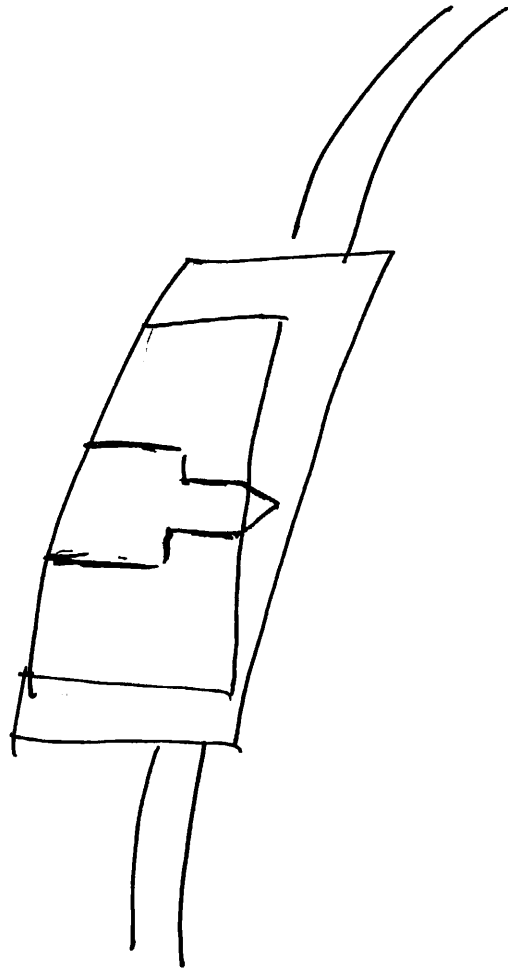


STEP 3: RE-FACE  
BUILDUP FLAT.



STEP 4: WELD INSERT  
IN PLACE.

← MCM 625



STEP 5: REMACHINE  
HOLE & FACE  
ON LOCATION.