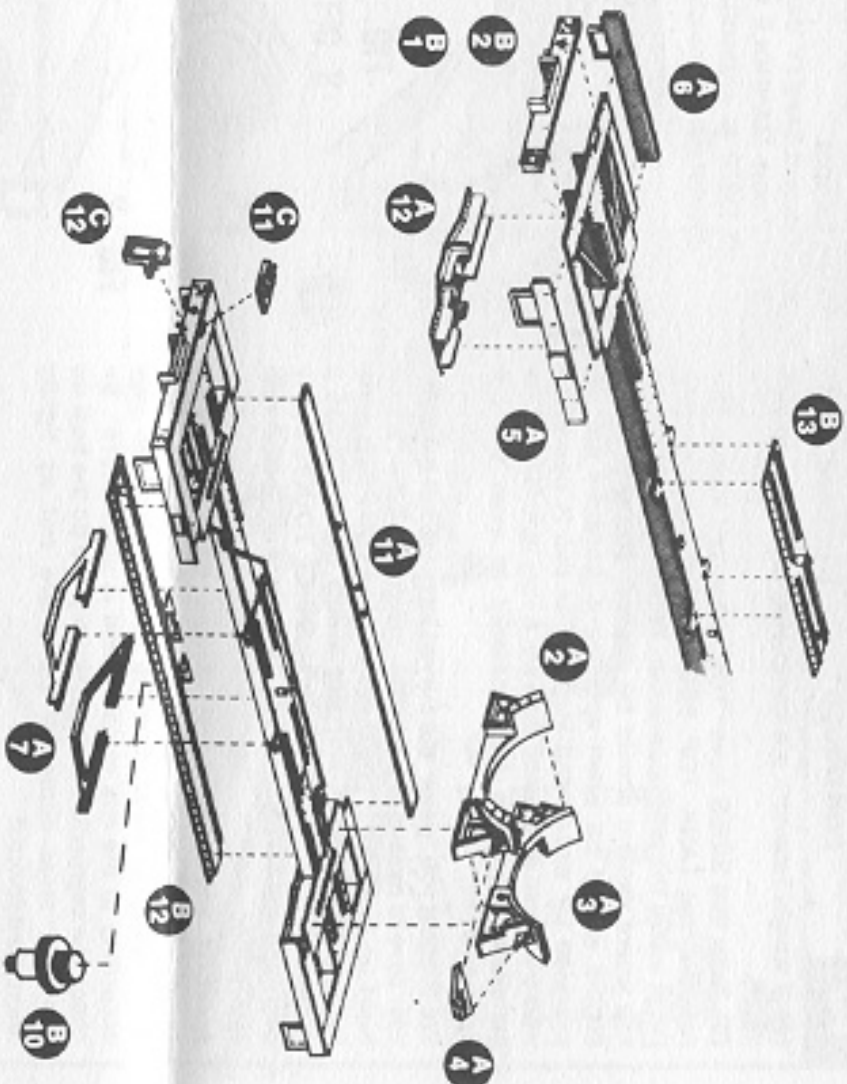


# 1 FRAME ASSEMBLY

For reference, the "B" end, engraved on top of frame, refers to the brake wheel end. In most cases, "Lockout" pins are used to prevent misassembly, and locator pins are used for proper alignment.

- (1) Remove tab gate from frame, file smooth.
- (2) Cement CENTER PLATE B-13 to frame. Note four tabs on bottom of B-13 that fit to ears on frame.
- (3) Remove "sucker" ejector pins from A-2 and A-3. Cement A-2 to A-3. Make two. When cement has set, remove gate scars and file bottom smooth. Just even it out — don't remove too much material.
- (4) Cement STRAP PLATES A-4 to ears on ends of saddles.
- (5) Cement END BEAM B-1 to "A" end of frame.
- (6) Cement END BEAM B-2 to "B" end of frame.
- (7) Cement one BODY BOLSTER A-12 to "A" end ONLY. Other A-12 will be added AFTER trainline is installed.
- (8) Bend TRAINLINE from long (7/8"), .020 wire, in two stages.



## STEP 1 SIDE VIEW

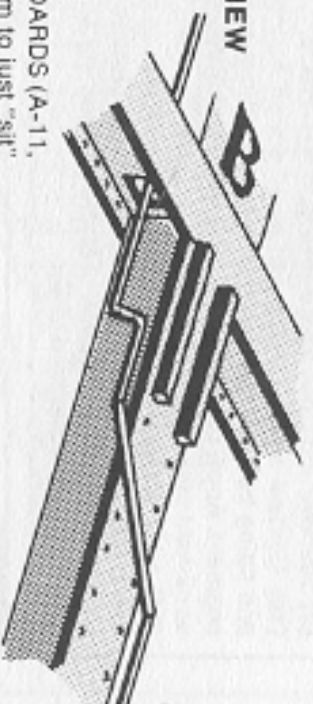
THIS LEG FLAT AGAINST TEMPLATE.

FULL SIZE

THIS SECTION ABOVE TEMPLATE.

## STEP 2

TOP VIEW



- (9) Test fit, insert trainline and cement other A-12 to "B" end. Secure with a drop of ACC at each end and at the point where it crosses frame.
- (10) Cement SILL PLATE B-12 to frame. HINT: Pass cement brush along edges of frame several times.
- (11) Cement SIDE SILLS A-5 and A-6 to frame with stirrup steps at END of car.
- (12) Carefully snap RUNNING BOARD SUPPORTS A-7 over frame with angles facing in. Cement to frame and ears. Note locator tabs on ears to aid alignment.

- (13) Test fit length of RUNNING BOARDS (A-11, and lightly scrape ends to allow them to just "sit" in place. If OK, cement, making sure gate edge is to center of car.
- (14) Cement DRAIN VALVE B-10 in place.
- (15) Cement assembled saddles in place.
- (16) Cement RATCHET PLATE C-11 in recess on "B" end of frame.
- (17) Cement STAFF SUPPORT C-12 to end beam, noting locator tab under beam.

NOTE: BRAKE RIGGING will be installed during final assembly.

## BRAKE RIGGING ASSEMBLY, FIG. 2.

- (10) Cement BRAKE CYLINDER B-6 to brackets.
- (11) Cement BRANCH LINE C-6 to DIRT COLLECTOR, snapping "T" over train line.
- (12) Cement FLOATING LEVER BRACKET C-5 to frame.
- (13) Cement FLOATING LEVER B-7 to Bracket C-5, at "right angle" (90°) to bracket.
- (14) Cement LEVER B-8 to BRAKE CYLINDER CLEVIS, also at right angle.
- (15) Cement BRAKE LEVER GUIDES C-4 (three) to frame.
- (16) Cut brake rodding from .010 wire, to lengths shown FIG. 2. Cement each in place as shown with ACC cement.
- (17) From .020 wire, cut BRAKE STAFF to length. De-burr both ends.
- (18) Cement BRAKE WHEEL C-10 to staff with ACC.
- (19) Insert brake staff into ratchet plate and support with ACC.
- (20) Install GRABIRONS C-13 in eight places on frame.
- (21) Install DOME GRABIRONS C-2 to each side of dome.
- (22) Cement four HAZARD PLACKARDS B-9 to running boards.
- (23) Cement completed PLATFORMS (remember those? Now the cement is dry!) to tank straps. You have to "eyeball" this one, but here's how: The "bolt" on the lower part of the bracket should be over the top row of rivets. Be sure brackets are parallel to tank joint and well secured.
- (24) Cement HANDRAIL BRACKETS C-7 (spares provided) in four places on each side of tank.
- (25) Cement ONE END HANDRAIL C-8 in place.
- (26) Trim the two short pieces of .020 wire to the length shown. HINT: Wire should go from center to center of the two end brackets. De-burr both ends.
- (27) Carefully slide handrails into brackets, butting the one end against the previously installed end handrail.
- (28) Cement other END HANDRAIL C-8 in place, and, for additional strength secure with a TINY drop of ACC.
- (29) Cement LADDER C-9 to each side.

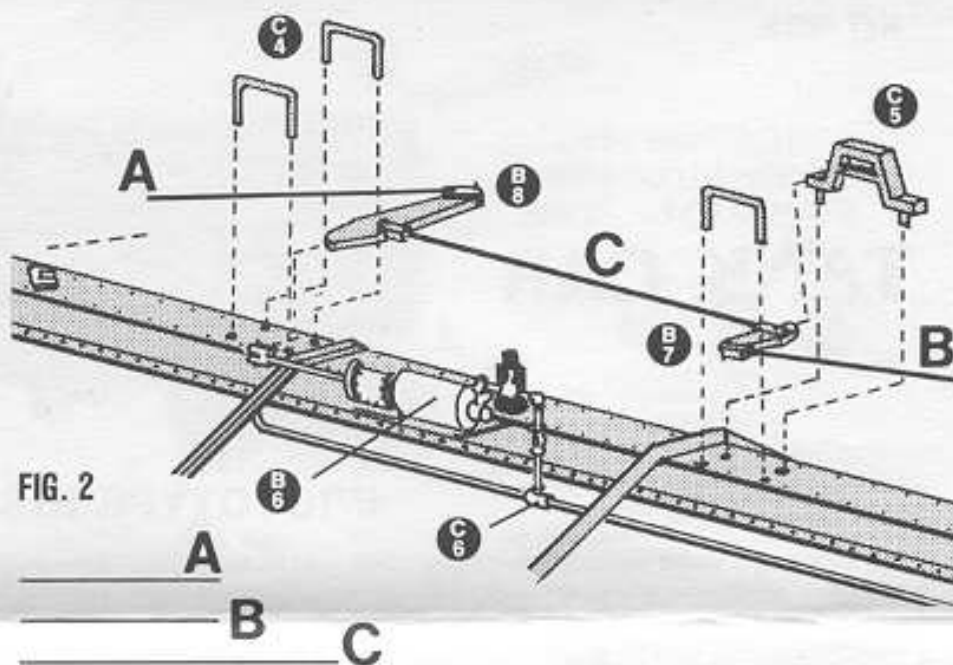


FIG. 2

