

INSTRUCTIONS FOR ASSEMBLING 50' EXPRESS REFRIGERATOR CARS

GENERAL

Before beginning construction, familiarize yourself with the drawings and parts in the kit. During assembly, try each piece in its intended location before applying cement and fastening in place permanently. Wipe off excess cement squeezed out of joints before the cement hardens, to insure a neater appearance. Finally, be patient and work carefully. The results will be worthwhile.

FRAME

Shave center sill and needlebeams as per templates, drilling holes where required for the pipes and rods, etc. Assemble the various parts to the floor-piece to complete the underframe as shown in the perspective views. When drilling truck mounting holes, use care to get them perpendicular to the floor to avoid a lopsided car.

BODY

Cement floor assembly, end blocks, center blocks, end sheathing, and roof together to form the basic body. Roof is flush with the outer face of end sheathing. To form curved roof end eaves, roll 1/16 square stripwood under a round pencil or dowel until desired curve is obtained. When adding side panels to body, proceed as follows: lay a left and right hand panel face down on a flat, waxed paper covered surface, with an unlettered center panel between them. Trim the ends of the center panel until the total length of the panels is slightly longer than the car body. When tracing the center panel make all cuts along scribed grooves, to insure an invisible joint when viewed from the printed side. Cement the three panels together, placing a book or other weight on the back of the side panels while drying. Use only enough cement to hold the panels together, to avoid squeezing any excess out on the painted surface. Before cementing the finished side to the body, the door outline may be scribed, or it may be drawn in black India ink. Add fascia strips. Notice that the cars sides overlap the edges of the end sheathing, whereas the end fascia overlaps the ends of the side fascia.

FITTINGS

Drill holes in roof to mount ice hatches (if used). Mount roof walk, ladders, grab irons, steps, brakewheel and platform, etc. Drill holes before pinning steps, etc., in place to avoid splitting the wood.

CENTER SILL

The center sill is built up with 5/16 x 3/16 and 1/32 x 3/8 stripwood after forming over templates.

BRAKE SYSTEM

A typical brake installation is shown. Levers are made from scraps of 1/32 x 3/32 stripwood. Use 1/32 wire for piping, 1/64 wire for pull rods. Safety irons are "U" shaped wire brackets pressed into car floor, to support brake lever. The ends of the brake, signal, and steam pipes are bent down at the car ends to form the hose connections. A short length of electrical "spaghetti" may be slipped on the pipe to form the hose. Thin paper strips may be wrapped around the air reservoirs (dowels) to represent steel mounting straps.

PAINTING

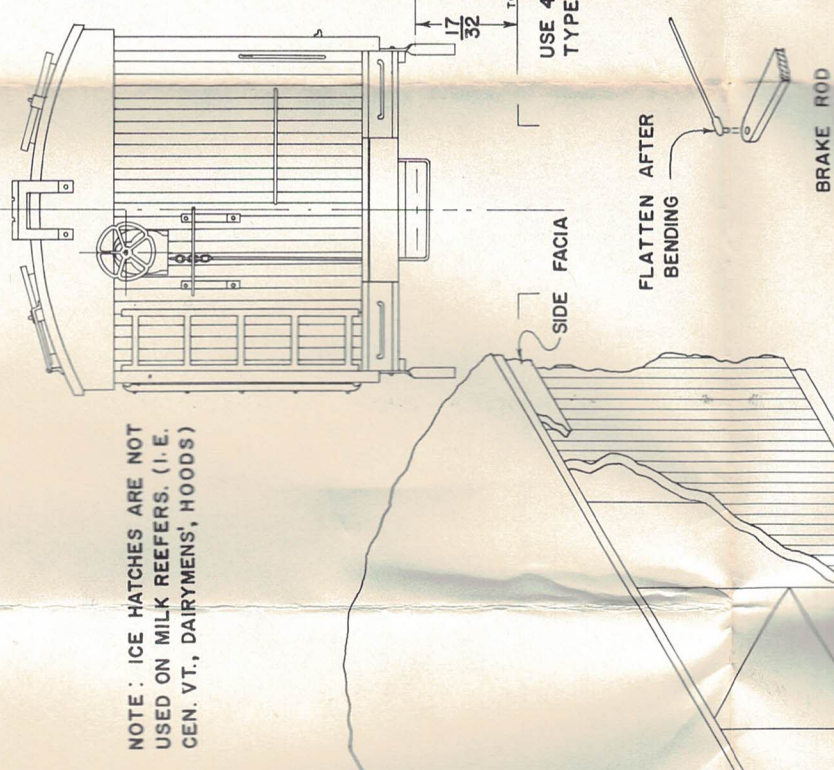
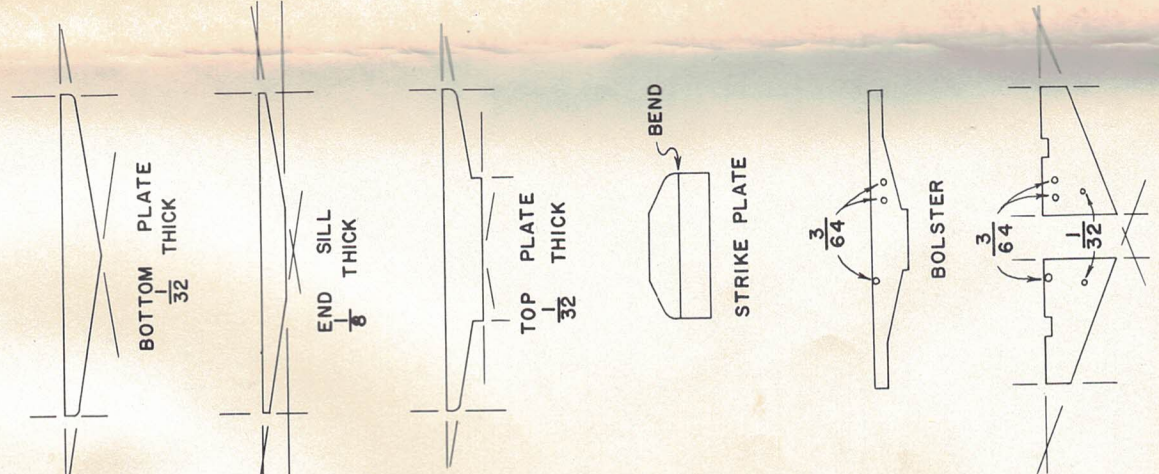
Individual cars are painted and lettered as listed below

CAR	ENDS	POSITION OF LETTERING
Pacific Fruit Express	Pullman Green	Lettering right
Pennsylvania	Tuscan Red	"BWIX" left
Milwaukee	Orange	Emblem right
Northern Pacific	Pullman Green	(maroon end fascia)
Bordens	Coach Green	Number left
Illinois Central	Pullman Green	Number left
Railway Express	Box Car Green	Emblem right
Central Vermont	Silver	Number left
Dairymen's League	Coach Green	Number left
Hoods	Pullman Green	Grade "A" left

Roofs, underframe, side and end sills, trucks and hardware are dull black.

A heater job will result if ladders, grabirons, door hinges, edges of roofs and edges of printed side fascia are painted before assembly. Floquil paint in matching paint for these cars should be used. When car is placed on trucks, couplers should be 17/32 above the rail. Depending on the trucks used, shave off the bottoms of the bolsters, or add washers between bolsters and trucks, in order to bring couplers to this height.

For American Flyer trucks, cut center sill at points shown on template. Discard all underframing between ends of center sill and end of car. Cement a 1/2" square piece of 1/16 thick sheet wood at truck center location. End sill may be mounted higher on car end to clear A.F. couplers.



NOTE: ICE HATCHES ARE NOT USED ON MILK REEFERS. (I.E. GEN. VT, DAIRYMEN'S, HOODS)

3/32 DRILL