

Assembly Instructions

for

3/16" Scale Built Up Arch Bar Truck

Manufactured by

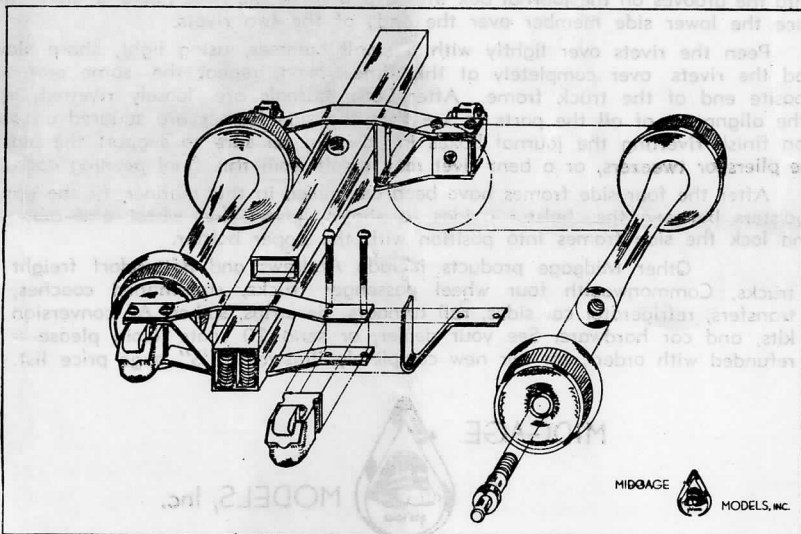
MIDGAGE MODELS, Inc.

MANUFACTURERS OF "S" GAGE MODEL RAILROAD EQUIPMENT

This Kit contains the following parts, from which, with reasonable care and patience you can build up a pair of well detailed Arch Bar Trucks in "S" Gauge:

- 4-Brass Wheel and Axle Assemblies
- 8-Stamped upper and lower side frame members

- 8-Stamped bolster guides
- 8-Die Cast Journal Boxes
- 16-1/32 dia. Brass Rivets
- 2-Plastic Upper Bolsters
- 2-Plastic Lower Bolsters
- 2-4 x 3/4" R. H. Wood Screws (King Pins)



The exploded diagram of this truck assembly is almost self explanatory, and little additional instruction should be needed to assemble the parts in the proper manner. However a few simple suggestions may speed up assembly materially, and result in a more satisfactorily built job for you.

First, remove all burrs from the castings and plastic parts, and check to see that no parts are missing. There is some variation in the lengths of the blunt escutcheon pins or rivets, and since these pins are of relatively soft brass to allow easy rivetting they should be checked to see that they are not too long, or excessive heading or rivetting will be necessary, which may cause the pin to distort or bend beside the journal box casting.

File or clip off these pins until they are just slightly over $\frac{1}{4}$ " long for best results. When they are inserted through the holes in the side frame and bolster guide stampings, with the journal box in place, they should not protrude over $\frac{1}{64}$ ".

Hold the upper side member and bolster guide in alignment and drop the two rivets through the punched holes. Next turn this assembly over and rest the rivet heads on an anvil or steel block for support in rivetting. Place the journal box between the two rivet shanks, after checking to be sure that the box is right side up. Now hold the two rivets into the grooves on the journal box with a pair of needle nose pliers or blunt tweezers, and place the lower side member over the ends of the two rivets.

Peen the rivets over lightly with a small hammer, using light, sharp blows. Do not head the rivets over completely at this time. Next, repeat the same procedure on the opposite end of the truck frame. After both journals are loosely rivetted in place, check the alignment of all the parts to see that the side frames are squared up properly, and then finish rivetting the journal boxes in position. Be sure to support the pins again with the pliers or tweezers, or a bent rivet may result from this final peening operation.

After the four side frames have been assembled in this manner, fit the upper and lower bolsters between the bolster guides as shown, insert the wheel and axle assemblies and lock the side frames into position with the upper bolster.

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