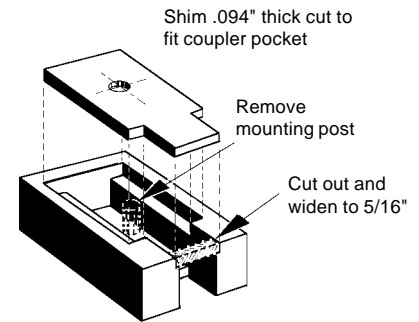


AHM (RIVAROSS)**PLYMOUTH MDT SWITCHER****#27 COUPLER CONVERSION**

1. Remove loco body from chassis per AHM instructions. Remove weight and discard couplers.
2. Cut out cross bar at front of coupler pocket, and mounting post and widen pocket opening to fit centered 20-Series Draft Gear Box (5/16") as shown in Fig.1.
3. Fabricate a shim .094" thick to fit bottom of coupler pocket. Drill and tap a 2-56 threaded hole in shim 1/4" from front of pocket on pocket centerline.
4. Assemble #27 Coupler and install on shim with 2-56 screw. Place shim in pocket bottom and secure assembly.
5. Check for correct coupler height, function, and clearance and make any adjustments necessary.

**Fig.1****#27 Installation**