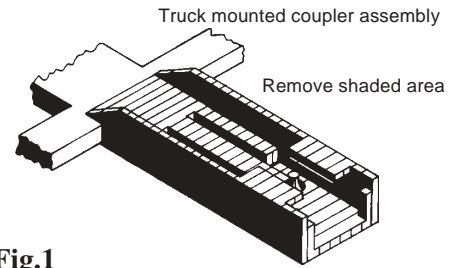


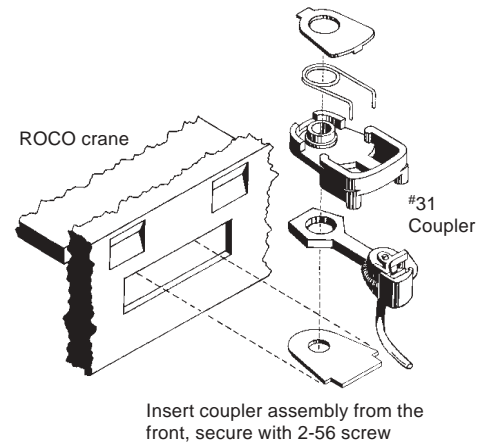
## ROCO #31 COUPLER CONVERSION

## 200 TON CRANE

1. Remove the trucks from the underbody by lightly grasping and pulling on the trucks two center wheel journal boxes to snap them loose from the underframe of the crane.
2. Cut off the truck mounted coupler box forward of the truck bolster crossbrace and remove the remaining ridge on top of the crossbrace, see Fig.1.
3. Remove the two screws holding the underframe from the main underframe lifting it out. There will be two pieces of metal on each end for weights with two small pieces of card stock for spacers. Leave these parts in.
4. From 1/16" plastic sheet stock cut two pieces to fit within the recessed areas on the bottom truck side of the chassis and glue in place with a plastic compatible cement.
5. After the glue has set measure a centerline on the new plastic space which can then be reinserted onto the bottom of the main chassis molding. Press the parts together until they stop at the intended level.
6. Reassemble the trucks to the chassis underbody to assist in determining the correct coupler height and center hole location for mounting the coupler box.
7. Assemble the coupler as described in the instructions with the Torsion Spring on top of the coupler.
8. Place the coupler box assembly through the opening at the end of the chassis, lightly tacking it in place with plastic compatible cement and on the centerline of the car.
9. Spot drill through the coupler box hole with a #52 drill, then drill through both layers of plastic with a #50 tap size drill. Tap the hole with a 2-56 tap.
10. Mount the coupler to the chassis with a 2-56 plastic screw. Cut to the correct length so as not to protrude through the plastic chassis.
11. Press the sub-chassis into the main chassis making sure it is pressed home to the built in stops. If it has a tendency for the ends to bend out after the screws have been inserted, it can be solvent cemented at the corners.
12. Check for correct coupler height, function, and clearance and make any adjustments necessary.



**Fig.1**



**Fig.2**

### #31 Installation