

**VARNEY****ORE CAR****#37 COUPLER CONVERSION**

1. Remove existing trucks and discard couplers.
2. Remove end coupler stirrup and file or cut back truck bolster boss to fit 30-Series Draft Gear Box. See Fig.1.
3. Drill and tap a 2-56 coupler mounting hole 15/64" from end of car on car centerline.
4. Assemble the #37 Coupler with Coupler on bottom, Torsion Spring on top. Glue assembly together with a plastic compatible cement applied sparingly along seams only.
5. Install Coupler and secure with a 2-56 screw. See Fig. 2.
6. Check for correct coupler height, function, and clearance and make any adjustments necessary.

