

mounting surface for the coupler gear box to raise the coupler.

10. Coupler Height: Set height gauge on track and roll car with a coupler up to the gauge (Fig. 8). The coupler should be the same height as the coupler on the height gauge. If too low, or too high make adjustments as described above.

11. Check Coupler Trip Pin height by setting car on track and rolling car up to gauge. Trip Pin should just skim over top of the gauge. If Trip Pin is too high or too low, adjust as shown in Fig. 5. The standard S-Scale coupler trip pin clearance is 1/16" above rail top as shown in Fig. 8.

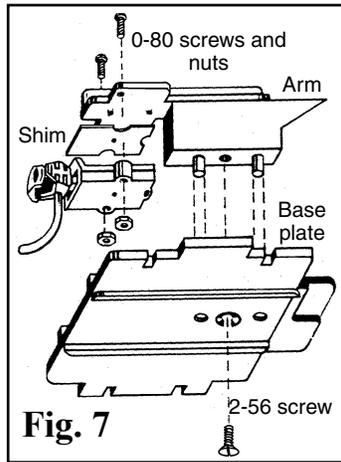


Fig. 7

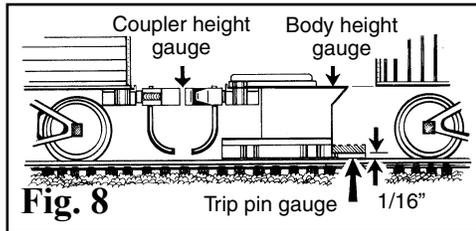


Fig. 8

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050409

WARNING:
CHOKING HAZARD - Small Parts
Not for children under 14 years.

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Kadee® S-Scale Coupler Height Gauge Instructions

Important Note: When the S-Scale coupler is correctly assembled, the coupler knuckle will have .030" or approximately 1/32" of up and down movement. This is normal. The height gauge has compensated for this. The couplers will pull down to the correct centerline height under operating conditions.

ASSEMBLING THE COUPLERS

1. To ready the coupler height gauge for use, prepare all parts by removing flash and burrs. Areas designated with arrows (see Fig. 1) indicate points where burrs may be encountered in the draft gear box, on the coupler shank and draft gear cover plate. Burnish these places with round end of a small twist drill (or file) to smooth away flashing and polish the surfaces. Assemble the

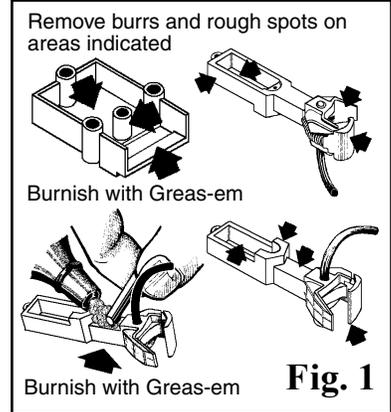


Fig. 1

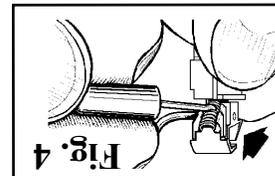


Fig. 4

4. Next, place the draft gear lid over the assembly as shown in Fig. 2. Test the centering action of the coupler by moving it to either side a number of times to be sure it snaps back to center consistently. 5. Coupler knuckle Springs are pre-installed. If one should come out during

and pull the Spring-Pic free. 241 Dual Tool. See Fig. 3. Pick up the large spring and insert the free end into the spring slot behind the boss (post). Cover the spring with a free finger. 3. Insertion of the spring will be made easier with the Kadee®

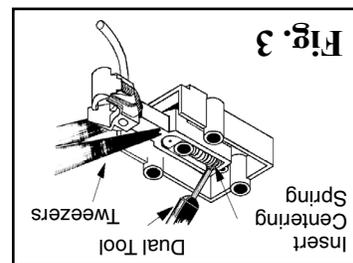


Fig. 3

distort the springs. undue pressure that is liable to any of these methods, avoid between to separate them. With gently work the blade down and between two coiled springs and insert a knife blade lengthwise apart. A third approach is to insert a knife blade lengthwise back and forth to work them cautiously rolling the springs upon the entwined springs, each the flat side of a steel rule lightly them to become uncoiled from surface of a small container, usually this is sufficient to cause the springs around the flat these. One way is to shake or roll the springs together. There are several methods of separating springs when they have become coiled together. There are necessary to separate the tiny and at times it will be found in the package during shipment coupler parts will move about 2. It should be mentioned, coupler in the order described and as shown in Fig. 2.

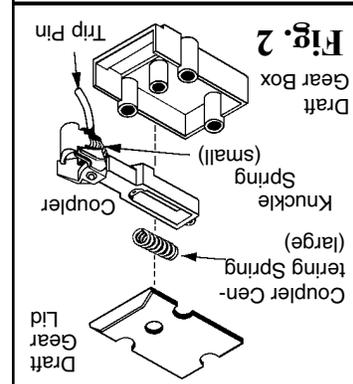


Fig. 2

9. Set the height gauge on track and roll car without coupler up to the body height gauge (Fig. 8). The car underbody should just clear the top of the gauge. If underbody is too high, add shim(s) of appropriate thickness between coupler gear box and the mounting surface to lower the coupler. If too low, add shim(s) between truck and body bolster or cut out a space in the

USING THE "S" HEIGHT GAUGE

to complete the assembly of the S-Scale height gauge. See Fig. 7. 8. Using the 2-56 screw enclosed, the arm can now be attached to the base plate. Insert the screw from the bottom of the base plate up and into the bottom of the arm assembly. The pointed car height gauge of the arm should be on the same end with the base's trip pin height gauge. Tighten the 2-56 screw to complete the assembly of the S-Scale height gauge. See Fig. 7.

ASSEMBLING THE S-SCALE HEIGHT GAUGE

7. It is recommended that you install the coupler assembly to the arm first. Place the .030" notched shim between top of coupler draft gear box and bottom of arm. See Fig. 7. The two pins will help align the box and the arm. Attach with enclosed 0-80 screws and nuts and tighten.

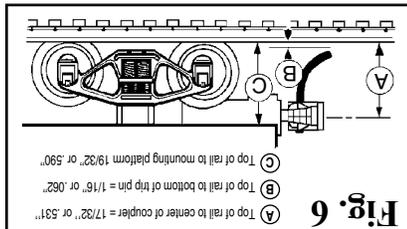


Fig. 6

6. When the coupler is working satisfactorily, it can be attached to the height gauge.

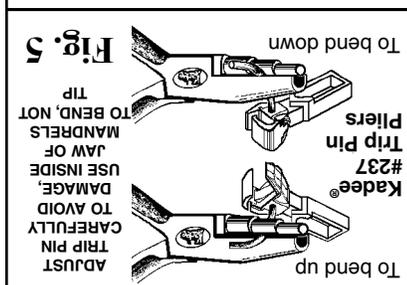


Fig. 5

mounting - replace as follows: Insert 241 Dual Tool (or small jewelers screwdriver) between end coils of spring. Place cone shaped projection in knuckle spring slot, then compress spring until opposite end can be slipped over other cone. Remove Spring Pic, see Fig. 4. Do not substitute any other spring for Knuckle Spring. To assure proper coupler operation, use only Kadee® #847 S-Scale Knuckle Springs. Springs. 6. When the coupler is working satisfactorily, it can be attached to the height gauge.