Kadee

HOn3 SCALE

716

1 Pair

3' - 7"

NON-MAGNETIC METAL TRUCKS

3' - 7" HOn3 TRUCK KIT

Assembly Required

030409

Clean any flash from the spring plank and test for insertion into the truck side frame before starting to assemble the spring plank. Place the spring plank on the Kadee® #715 Assembly Jig with the pins through the eight spring retainer boss holes in the spring plank, Fig 1. Make sure the raised spring retainer bosses around the eight holes are visible in the up position. Use a #11 X-acto blade to open the holes if necessary. Push the spring plank down equally over the pins against the jig. Use a piece of balsa wood or some other soft material so not to damage the plank.

Very carefully clean the flash from the truck bolster. Make sure there are holes in the center of the eight spring retainer bosses on the bottom of the bolster. Also, clean any flashing from the inside of the large hole in the center of the bolster.

This next step must be done before assembly and will take some patience and practice. Insert the center bolster bearing (cone shaped plastic molding) in the center hole of the truck from the top with the small end entering first, Fig 1. Use the plastic sprue to help hold the bearing while inserting and then cut or break off the sprue. The flat portion of a screwdriver blade works

well to push the bearing into place allowing the bushing to freely rotate.

Test trial fit the truck bolster in the sideframes. Note the mating surfaces and carefully remove any flash from interfering with the movement of each of the parts. Be careful not to remove too much material but only enough for the smooth movement of the parts. Also, clean any flash from the other parts of the sideframes at this time.

For this step you may want to place the Kadee® #715 Narrow Gauge Truck Assembly Jig into a shoe box or similar container to help contain any springs that may take flight. Use the Kadee® #241 "Dual Tool" to handle the springs. It is easier to capture the spring when it is against the inside bottom corner and side of the box. Insert the spring pic in between the 1st and 2nd loop of the spring. With the spring captured, place it into one of the pins of the jig and press it down against the spring plank, Fig 1. With the spring in place on the pin, place your finger on top of the spring and remove the spring pic. Gently remove your finger. Do this with all eight pins.

Fit the truck bolster onto the top of the pins so that the tips of the pins enter into the holes

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on the bottom of the truck bolster. Use a pair of Kadee® #1020 Tweezers to hold the spring plank and the truck bolster together. Place the tweezers at the center over the bolster bearing and the spring plank's center hole, Fig 2. At this point do not hold the tweezers at the rear but rather at the front, close to the bolster and spring plank, insuring that the assembly remains together. To remove the assembly from the jig, use an X-acto or pocket knife to move the ends of the spring plank upward and off of the pins. Do this gently, working both ends up alternately until the bolster and spring plank are closed together with the springs completely allowing it to be easily removed from the Jig.

This assembly should have the ends of the bolster and the spring plank even with each another. Care must be taken to prevent the bolster and spring plank from twisting sideways from each other by the springs. Gently skew or shift these two parts in opposite directions lengthwise so the bolster is out a little further on one end then the spring plank, Fig 3-A. This action will expose the end of the bolster so that the truck bolster can be slipped into the tilted truck sideframe opening. Check the

sideframe, the wheel axle cone holes should be facing inward. Gently slide the plank even with the truck bolster inserting the spring plank into the truck sideframe. It will be necessary to squeeze the springs tighter to do this, Fig.3-B. (Note: the wheels are inserted later). Repeat the process for the installation of the second sideframe, Fig. C & D.

After both sides are completed remove the tweezers, Fig. D & E. Check to see that the spring plank is setting flat in the bottom of the sideframe opening. Check also to make sure that the bolster moves freely up and down and will flex easily.

The wheels can now be inserted. Rotate or twist the side frames about the bolster axis in opposite directions enough to allow the axle cones to be inserted in the cones in the back of the sideframe journal boxes. Bring the sideframes back even and repeat the process for the other axle. Doing one at a time will make the process easier.

Test roll the trucks. They can be painted or weathered to match the look of the railroad being modeled. Do not paint the wheel treads.

Clean all the flash from the car body bolster

and attach to the underframe of the car. While supporting the truck body bolster with your finger and thumb, press the plastic bushing in the bolster on to the pin on the car body bolster. If the car body bolster is not used, use a pin, small brad or wire of the same diameter mounted in the substituted body bolster for mounting the trucks either by pressing the truck on the pin or pinning the truck on with a pin into the car bottom.

For best results, add a touch of **Kadee® #231 Greas-em** to bolster openings in side frames and to wheel axle cones.


Center Bolster Bearing
Truck Bolster
Springs
Bottom Spring Plank

Figure 1

Figure 2

Figure 3

Truck side Frame

Tweezers

Shifted truck body bolster

Kadee '1020 Tweezers

Tweezers

Spring plank
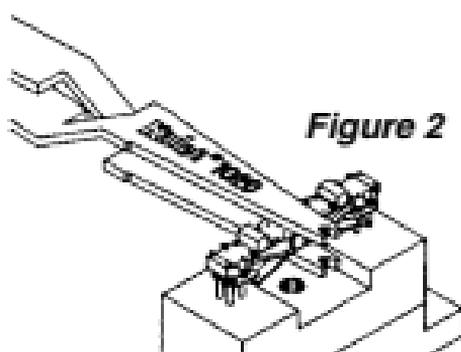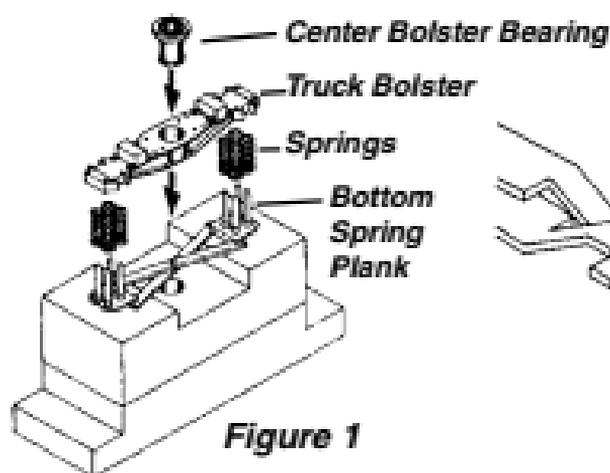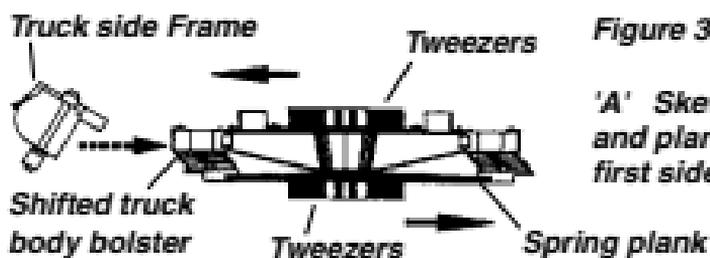
'A' Skew the bolster and plank. Add the first side.

'B' Straighten side and slide plank into side.

'C' Repeat for second side.
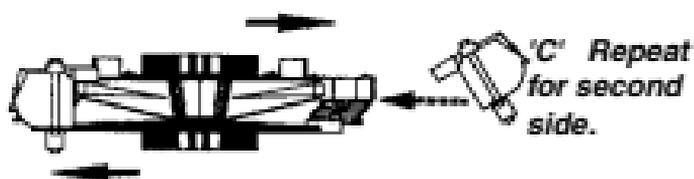
'D' Check assembly, remove tweezers.

Car body bolster

**'E'** Completed front view less wheels.
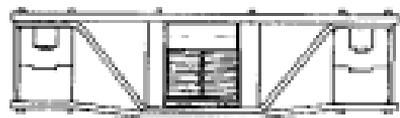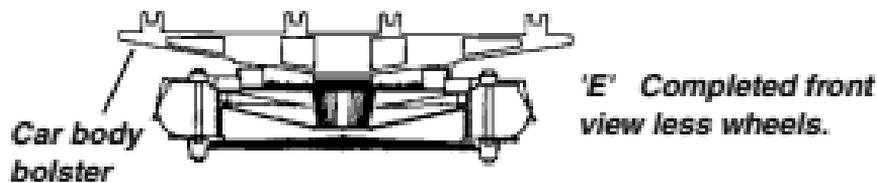
Completed sideframe view less wheels.

#716 HOn3 Trucks

Contents: 2 ea. Body Bolsters, 2 ea. Truck Bolsters, 4 ea. Sideframes, 2 ea. Spring Planks, 4 ea. HOn3 Wheel Sets, 2 ea. 5/16 Metal Pins, 3 ea. Truck Bushings and 20 ea. Truck Springs

To assemble use the Kadee®
"715 HOn3 Truck Assembly Fixture

Assembly Required

3' - 7"
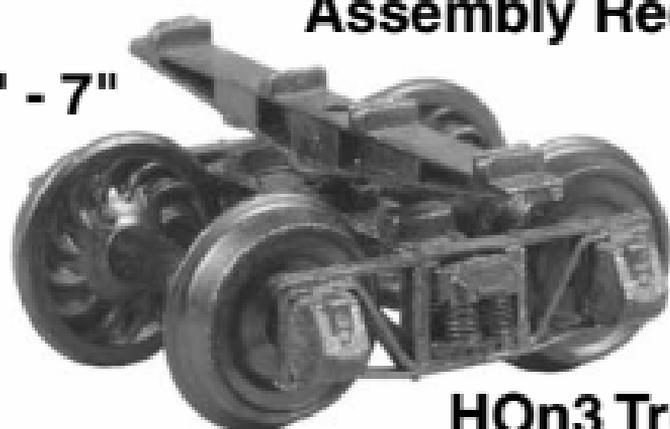
HOn3 Truck Kit

Made In the U.S.A.

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

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