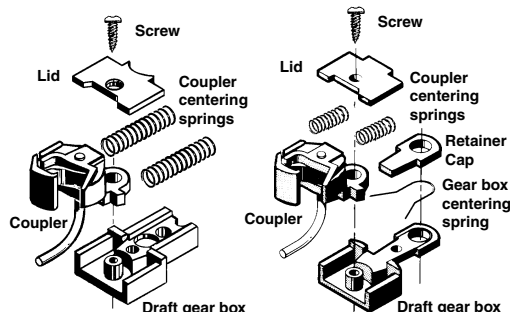


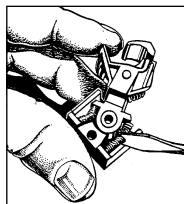
794 / 1794 Ins.

ASSEMBLY

IMPORTANT: Before assembling remove burrs or flash (if any) from all parts. Burnish (polish) all friction bearing surfaces with #231 Greas-em dry graphite lubricant.



To assemble the coupler follow the illustrations in these instructions. Make sure the gear box lid is tightly secured with the screw. Add a "puff" of our #231 Greas-em into the draft gear box. Make sure the coupler flexes back and forth freely.



Rear View of Gearbox

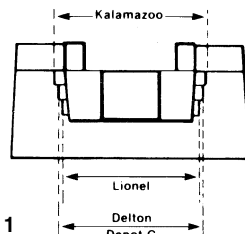


Fig. 1

MOUNTING Tender -

Remove truck assembly. Remove old coupler. Please note the tabs on the shank of the Kadee® coupler gear box. For mounting on these cars, the tabs must be filed down equally until they will just slide into place (see Fig. 1). Place new Kadee® coupler in correct location as shown in Fig. 2. Making sure the draft gear box is straight, mark the new screw hole location, remove coupler and drill a 3/32" hole (this can be done by hand with a sharp drill). Install Kadee® coupler with supplied screw. Do not overtighten. The screw can be filed or ground to proper length. Place car on track and check coupler height. If too low, remove coupler and place one or two white .010" shim(s) in location as shown in Fig. 3. If too high, place a shim under front of gear box.

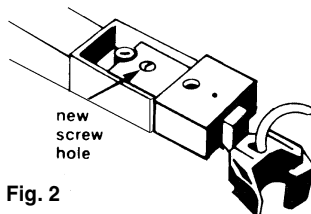


Fig. 2

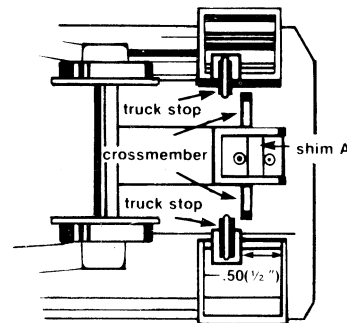
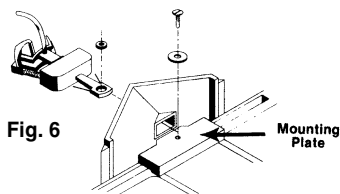
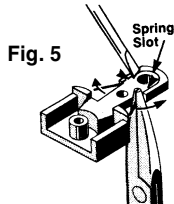
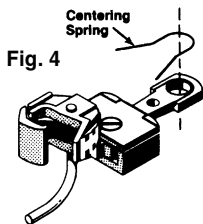


Fig. 3

Locomotive -

Install a gear box centering spring in the groove in the gear box (Fig. 4). To hold the spring in the groove use a small screwdrivers pointed corner as shown in (Fig. 5). Applying pressure will wedge plastic over the spring. This should be repeated in the three locations shown and then the surface should be filed smooth. Burnishing contact areas of the locomotive and gear box with "Greas-em" will insure free movement. Remove the old coupler. Place the mounting plate in position on the loco (Fig. 6) with the lip of the plate toward the loco. Now slip the coupler gear box assembly through the opening in the loco lining up the mounting hole with the screw hole of the loco. Place the supplied bushing in the hole and secure with the washer and #4 x 1/2" screw. Place the loco on a track and check the coupler height. If a little low or high the mounting plate can be filed to adjust. Test the gear box centering action for freedom of movement by swinging it to one side and releasing it. If gear box centering action seems sluggish or favors one side, which is not caused by a burr or overtightened mounting screw, one or both spring legs can be bent a little more as shown in Fig. 2. If more side movement of the gear box is needed the sides of the gear box shank can be filed equally.



Bottom view of 4-4-2

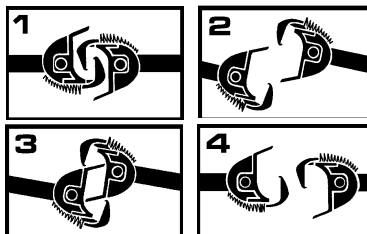
COUPLER OPERATION COUPLER OPERATION TO COUPLE -

Simply push cars together until knuckles bypass each other and lock into position.

FOR DELAYED UNCOUPLING -

1) Stop with the couplers over an uncoupler and back up slightly with the couplers still over the uncoupler, allowing slack to occur between couplers. 2) Pull forward slightly. Couplers are now in the delayed position. 3) Back up, pushing the car(s) to the desired location. Do not permit slack to develop between couplers. 4) Pull forward, leaving the car(s) where desired. Couplers automatically return to normal coupling position.

Use Kadee® Greas-em, the dry lubricant recommended for use with all Kadee® Magne-Matic® couplers. Grease-em will not attract the dirt and dust that gums up the



NOTE: If couplers swing open too far when uncoupling, lower magnet slightly to correct.

inside of couplers like oil, grease or other lubricants will. Use our #829 #1-Scale or #880 G-Scale Height Gauge to check for the correct coupler height and trip pin clearance. The N.M.R.A. standard for coupler height is the centerline of coupler is 1 1/16" (1.0625") for #1-Scale & 1 1/8" (1.125") G-Scale.

Note: We include extra knuckle springs. The Replacement Knuckle Spring used on Kadee® #1-Scale couplers are sold as the #875 (#820-828 couplers) or #1875 (1700 & 1800 series couplers) Knuckle Spring. The Knuckle Spring used on Kadee® G-Scale couplers are sold as the #860 Knuckle Spring.

For Delayed Action Uncoupling use our #842 Uncoupler, #844 Portable Uncoupler, or our #840 Uncoupler mounted in LGB track.

Kadee® coupler conversion list & coupler conversions are on the Kadee® web site for your convenience.

www.kadee.com/conv/convpl.htm

MAGNE-MATIC®

Kadee
Quality products co.

673 Avenue C
White City, OR 97503

Made in the U.S.A.