

BACHMANN SPECTRUM

EMD F 40PH

#27 COUPLER CONVERSION

1. The top of the Bachmann coupler pocket side rails and centering post should be filed down to the height of the Centering Spring, allowing for coupler movement but no droop. See Fig.1.
2. Modify the 20-Series Draft Gear Box by cutting off the centerpost and trimming .115" from the side rails leaving a small portion (.060") to fit in front of the Bachmann coupler pocket. See Fig. 2. When installed the box will cover the Bachmann loco coupler pocket and the Centering Spring. See Fig.1 and 2.
3. Assemble the coupler using the original screw and the modified box in place of the Bachmann metal clip.
4. Check for correct coupler height, function, and clearance and make any adjustments necessary.

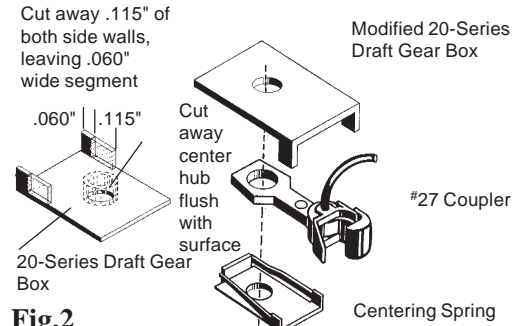


Fig.2

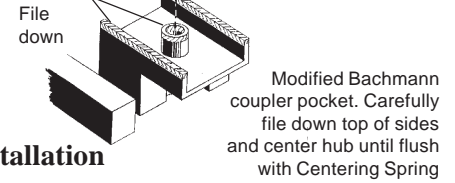


Fig.1

#27 Installation