

IHC MEHANO

0-4-0 DOCKSIDE

#27 PILOT AND REAR COUPLER CONVERSION

1. For the pilot: Remove the body and dummy coupler.
2. Cut coupler pocket opening even on both sides to 5/16" (the width of a No.5® box). Do not remove any of the upper lid of the pocket.
3. Cut a shim to fit between the frame about .272" wide x .356" long and .060" thick. File to fit snugly, flush with the bottom of the upper lip forming a level platform. Cement in place with a solvent cement. See Fig.1.
4. Assemble the #27 Coupler in a No.5® Draft Gear Box per instructions and glue the Lid on. Trim the ears off the box, slide it into the frame on the platform.
5. Make sure to check the coupler height with the #205 Height Gauge. You can either cement the box in place with a solvent cement or mark and drill and tap for a 2-56 screw.
6. For the rear: Fit a .060" shim, .265" x .265", between the frame flush with the bottom front crossbar. Cement in place with a solvent cement. See Fig. 2.
7. Use a No.5® Box Lid with the ears trimmed off. Place the spring and coupler on the lid and place them on the platform.
8. Mark and drill and tap a 2-56 hole in the platform. Use a 2-56 plastic screw from the top and secure coupler into the mount. Carefully put a small amount of solvent cement around screw head. File screw head down to where it's just about .010" thick, the body shell will fit right on top of it. Reassemble loco.
9. Check for correct coupler height, function, and clearance and make any adjustments necessary.

Drill and tap 2-56 hole on centerline

.060" thick by .272" by .356" coupler mounting platform. Glue in place between frame members and flush with top of frame

Widen coupler opening to 5/16". Remove material equally from both sides

#27 coupler assembly in No.5® Box (furnished with 20-Series Couplers). Cut off side mounting lugs flush with sides

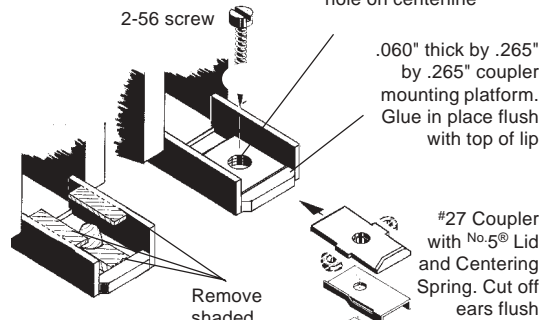
Fig.1

#27 Pilot Installation

Drill and tap 2-56 hole on centerline

2-56 screw

.060" thick by .265" by .265" coupler mounting platform. Glue in place flush with top of lip



Remove shaded areas

Fig.2

#27 Rear Installation

#27 Coupler with No.5® Lid and Centering Spring. Cut off ears flush