

MANTUA

0-8-0 USRA SWITCHER

#27 PILOT, #37 TENDER COUPLER CONVERSION

1. Remove existing couplers.
2. For pilot: Widen coupler opening by removing material equally from both sides until opening is 5/16" wide. Drill existing coupler mounting hole on pilot deck with a #52 drill. Modify 20-Series Box by cutting off 3/32" from end (up to centerpost). See Fig. 1.
3. Install #27 Coupler by slipping Centering Spring on top, then Coupler in from front. Align modified 20-Series box centerpost with center hole on coupler and spring, then secure with 0-80 by 1/4" long screw and 0-80 nut. See Fig. 1.
4. For tender: Assemble #37 Coupler with Torsion Spring on bottom and Coupler and Lid on top. Install coupler onto tender from below and secure with 0-48 by 1/4" self-tapping screw and 0-80 washer. See Fig. 2.
5. Check for correct coupler height, function, and clearance and make any adjustments necessary.

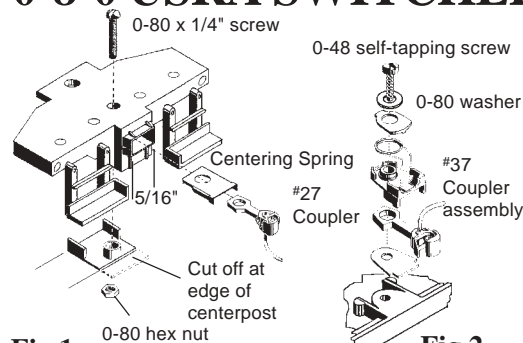


Fig.1
#27 pilot
Installation

Fig.2
#37 Tender
Installation