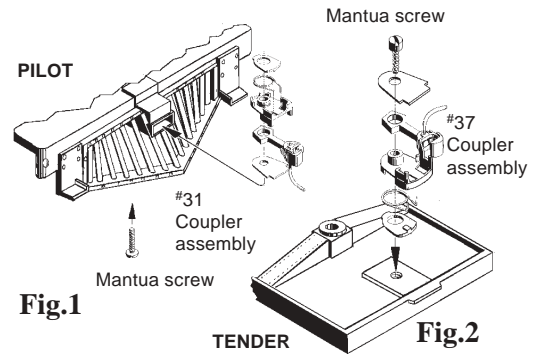


# MANTUA

# 4-4-0 AMERICAN

## #31 PILOT, #37 TENDER COUPLER CONVERSION

1. Remove existing couplers, save screws.
2. Check pilot coupler opening with 30-Series Draft Gear Box. If not wide enough, remove material equally from both sides until opening is 5/16" wide.
3. For pilot: Assemble the #31 Coupler with Torsion Spring on top, Coupler on bottom. Install coupler in pilot from the front and secure with Mantua screw.
4. For tender: Assemble #37 Coupler with Torsion Spring on top, Coupler on bottom. Install coupler onto tender from below and secure with Mantua screw.
5. Check for correct coupler height, function, and clearance and make any adjustments necessary.



**#31 Pilot, #37 Tender Installation**