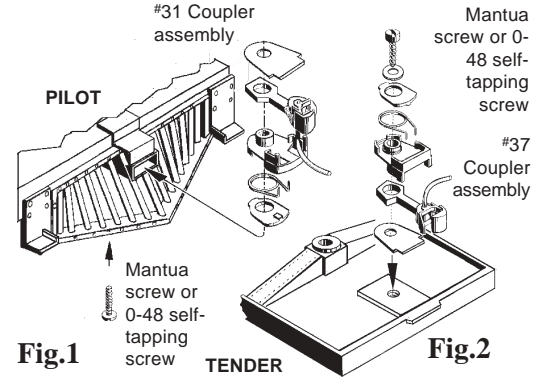


MANTUA

4-6-0 TEN WHEELER (ROGERS)

#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 Coupler on top, Torsion Spring on bottom. Install coupler in pilot from the front and secure with Mantua screw.
4. For tender: Assemble #37 Coupler with Coupler on top, Torsion Spring on bottom. Install coupler onto tender from below and secure with Mantua screw.
5. Note: Instead of Mantua screws, you may wish to use 0-48 self-tapping screws and washer.
6. Check for correct coupler height, function, and clearance and make any adjustments necessary.



#31 Pilot, #37 Tender Installation