

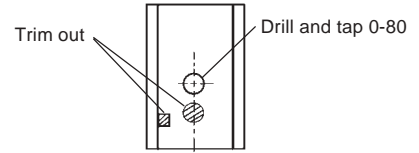
# MANTUA

# EMD GP-20

## #28 COUPLER CONVERSION

1. Remove the outside truck frame by slipping a small screwdriver into the back end of the truck and carefully pry off the stirrup clip. Remove and discard coupler.
2. We recommend not using the original post. This makes the spring protrude out of the box too far and may hamper proper function of the coupler.
3. Trim the centerpost and sidewall protrusion off, file smooth and flat. See Fig. 1.
4. Place the #28 Centering Spring into the box with the end even with the edge. Mark the hole along the centerline. Drill and tap an 0-80 hole (#55 drill). Thread a 1/8" x 0-80 screw in from the top so the threaded end becomes a post in the box. Place one of the thick-walled bushings (small hole), included in the #28 Coupler kit, over the end of the screw and cement in place with a solvent cement (such as Tenax 7R).
5. Place the #28 Centering Spring and coupler over the bushing and carefully slip the truck frame back together and snap the stirrup clip in place. If needed, carefully bend the truck mounting plate, that acts as a bottom lid, so there's no droop in the coupler.
6. Check for correct coupler height, function, and clearance and make any adjustments necessary.

**Fig.1**  
**Detail**



**Fig. 2**

## #28 Installation

