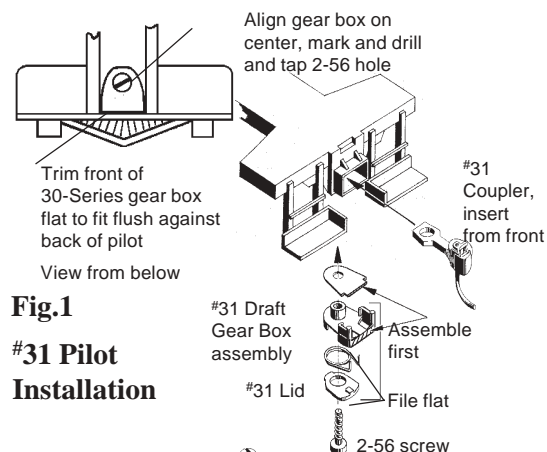


# IHC (SLOVENIA)

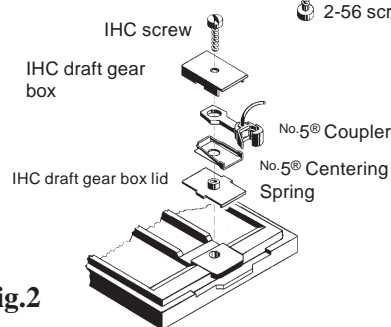
## 4-6-2 PACIFIC

### #31 PILOT, No.5® TENDER COUPLER CONVERSION

1. For the pilot: Remove pilot wheel assembly (don't loose spring) and remove dummy coupler by pulling straight out.
2. Enlarge coupler pocket opening by filing equally on both sides until coupler shank slips through. The bottom may also need some filing. Do not file the top of pocket.
3. Assemble the Torsion Spring half of the #31 Draft Gear Box according to 30-Series instructions (do not assemble coupler and lid yet). Modify box and lid by filing wide end flat so they will fit flush against the inside of the pilot.
4. Place gear box behind coupler pocket opening and slip coupler through opening into box. Place lid on box. Secure assembly with rubber band. Move coupler back and forth checking function and clearance and height. Make necessary adjustments.
5. Center gear box, mark hole on platform, remove coupler assembly and carefully drill and tap a 2-56 hole. Reassemble coupler as before and secure to platform with a plastic 2-56 screw. Trim screw flush with top of platform. Check again for correct function clearance and height. Make necessary adjustments.
6. Reassemble pilot wheels and check for clearance. If screw head interferes, file screw head down.
7. For tender: Remove IHC draft gear assembly. Save screw, lid and box. Discard existing couplers.
8. Place the No.5® spring and coupler on the post of the IHC lid and reassemble the box. See Fig.2. Be sure the Centering Spring is not caught between lid and box.
9. Secure assembly to tender coupler mounting pad with IHC screw.
10. Check for correct coupler height, function, and clearance and make any adjustments necessary.



**Fig.1**  
**#31 Pilot**  
**Installation**



**Fig.2**  
**No.5® Tender Installation**