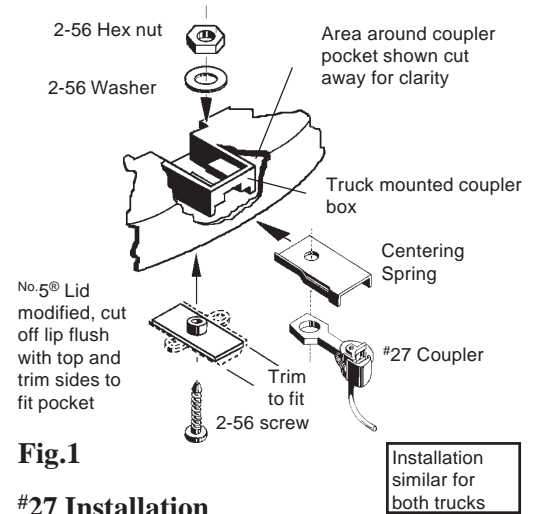


# PMI LIMA

# EMD FP-45

## #27 TRUCK MOUNTED COUPLER CONVERSION

1. Remove trucks and couplers.
2. Widen coupler pocket opening, removing equal amounts from each side, to fit the Centering Spring on both truck ends.
3. Modify coupler pockets on both trucks by removing the bottom center snap arm and the corner tabs on the bottom inboard end. Don't remove any part of the top of the coupler pocket. See Fig.1.
4. Modify a No.5® Lid (included with 20-Series Couplers) by filing sides down equally until lid slips into truck coupler pocket. Slide Centering Spring into pocket with spring end sticking out slightly. Slip the #27 Coupler in the spring. Fit lid down onto the coupler and spring. Use a 2-56 screw through the lid side. It will go between the two lips acting as the platform for the spring. Use a washer or piece of shim, then secure with a hex nut capturing the two lips. See Fig. 2.
5. Check for correct coupler height, function, and clearance and make any adjustments necessary.



**Fig.1**

**#27 Installation**