

# RIVAROSSO POST 1993

# HEISLER TWO AND THREE TRUCK

## #21 COUPLER CONVERSION

1. Remove the screws in the middle of the trucks, lifting off the bottom plates with the coupler mountings. Be careful with the trucks. The wheels are now exposed and loose.

2. Carefully file off the rivets, from the bottom, that hold the couplers on until they can be pushed through the top of the plate, removing the original couplers.

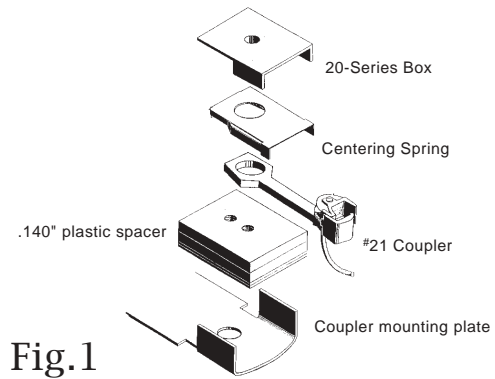
3. The front truck is farther back from the step boards than the rear truck. Two different plastic mounting spacers need to be constructed from shim stock. A spacer thickness of .140" is required for correct coupler height. Fabricate .140" thickness from several pieces of plastic sheet stock glued together with a plastic compatible cement. After cement has dried, make a front truck spacer .140" thick by .400" long by .360" wide. For the rear spacer, cut a .140" thick by .290" long by .360" wide piece.

4. The front (larger) spacer requires two holes to be drilled and tapped. Fit the spacer into place, slide it back flush with the "step down" where the coupler extension meets the widest part of the plate, see Fig.1. Mark, drill and tap a 2-56 hole for the mounting screw. Measure forward .093" (3/32") from the first hole, drill and tap as before. For the second spacer, slip it into the plate, as the first, mark, drill and tap like the first one.

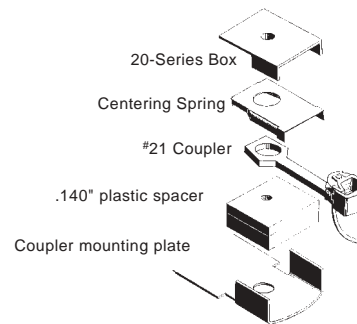
5. Assemble the #21 coupler per instructions, on top of the spacers. On the front (larger) one cut a 2-56 plastic screw to secure spacers into plate. Cut another 2-56 screw to secure the #21 coupler to the spacer. For the rear, the 2-56 screw must go through the coupler, spacer and plate with a nut on the end, then trim to the appropriate length.

6. When reassembling the plates to the truck it will be necessary to manipulate the couplers through the step boards. Gently twisting the couplers, insert the pin first, then the lip past the foot boards.

7. Follow the instructions included with the couplers for assembly and adjustment.



**Fig.1**  
**FRONT TRUCK**



**REAR TRUCK AND TENDER**

**Fig. 2**  
**#21 INSTALLATION**