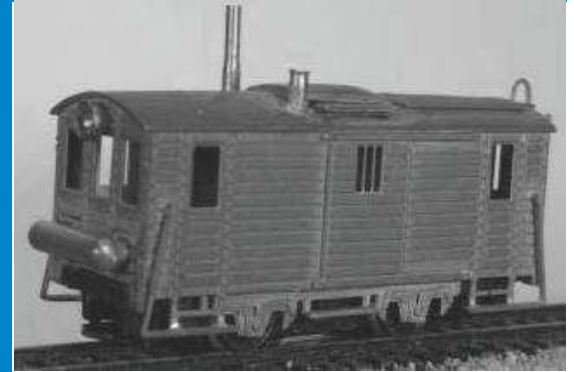
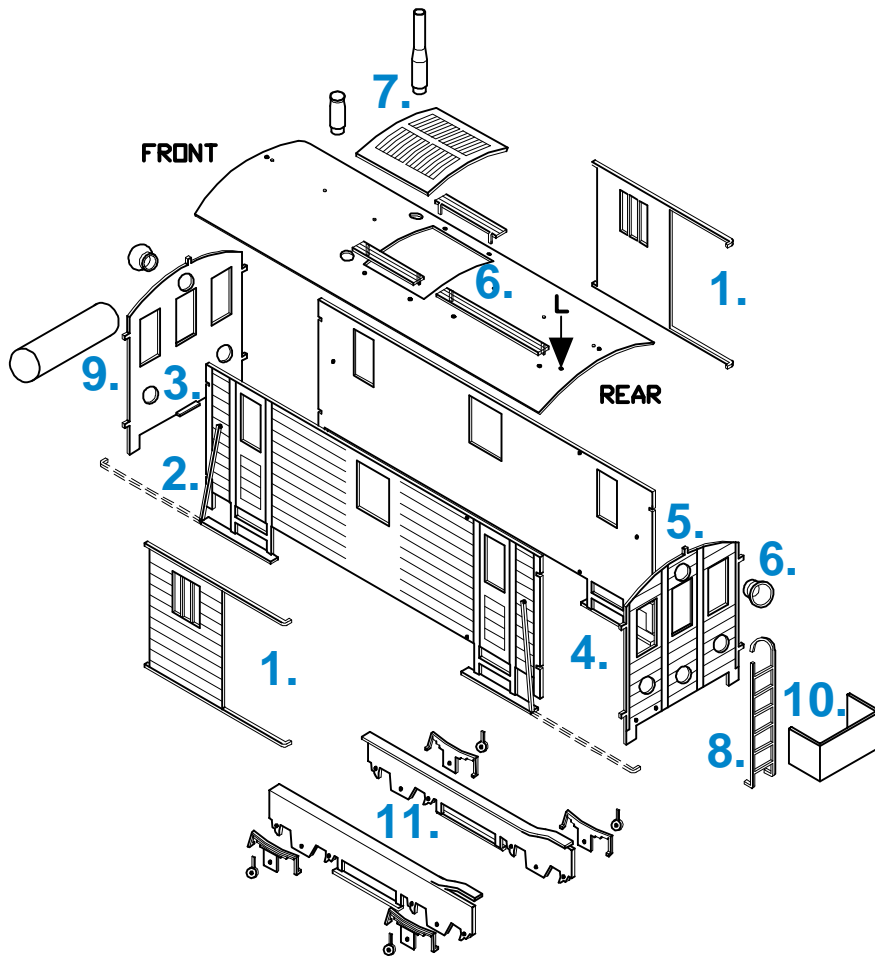


Instructions (shell)



This instruction sheet has been designed for easy use. The numbered steps coincide with the blue numbers on the illustrations. Before cutting the etched brass parts from the fret, carefully study the assembly drawings. Many parts have locator pins which continue on as sprues that hold the fret together. These sprues should be cut very carefully, so they can function as locator pins to help the accurate assembly of parts, to minimize the chance for errors. All etched and drilled holes need to be re-sized with the appropriate drill or reamer. Fold lines are etched into the components, and made with the etched line inside the fold. Use a smooth jawed, wide flat billed plier to make the bends. Soldering. Use a small (2mm+/-) chisel tipped soldering iron. The 0.16 thick brass pieces require approximately 750F soldering iron temperature (25 - 30W). Use a small diameter solid core solder and a good liquid flux with a toothpick or a small brush as an applicator.

1. Bend the small locator pin ends of sliding door tracks, then push them into the corresponding holes of cab sides. Align sliding door with the edges of cab sides, then solder at the top and bottom edges.
2. Bend steps below doors, solder bent corners, then fold handrails, so the 90° locator pins fit into the corresponding holes. After soldering the handrail ends from the back side, solder bent corners of handrails at the step.
3. Fold small tab at the bottom of front panel, then solder full length of bent line.
4. Fit the two pairs of locator pins of front and rear panels into the corresponding notches of sides, then solder. Make sure the components are held square. A continuous solder at the inside of all four corners are recommended.
5. Fit roof over assembled cab, utilizing the top pins of front and rear panels and the corresponding holes of the roof. The roof should be oriented on the way, the single hole for the ladder (marked L) is located at the rear panel. For better fit (if necessary) the top edge of sliding door tracks can be filed in a slight angle. Solder roof to cab from the inside.
6. Fit headlights and roofwalk boards, then solder from inside.
7. Align roof grill slightly overlaying edges of opening, then solder inside. Fit, position and solder smokestacks.
8. Bend / form ladder, so the two locator pins fit into the corresponding holes of rear panel, while the half round top support fits into the hole (L) on the roof.
9. Align gas tank with the center line of larger holes of front panel, then solder inside.
10. Position sand box on the rear panel, so the vertical edges are just outside of the center and right side larger holes, then solder inside of sand box. Make sure the center hole remains fully open and accessible thru the sand box. This hole is designated to hold the shell on the Marklin locomotive chassis.
11. Fold top of side frames, form notched section of both side frames as illustrated, then solder bent line, leaving formed sections open. Fit leaf springs utilizing the bent locator pins, then solder. Final steps are to position and solder the four bearing housings to the side frame assembly. A small pin hdd thru the common holes could help with accurate alignment.