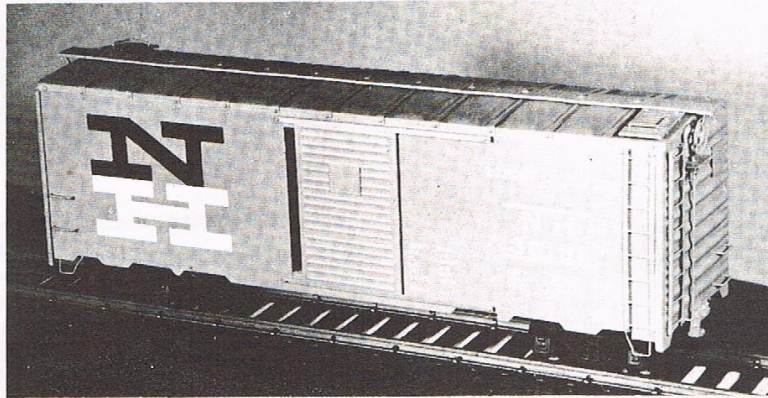


# ALL-NATION 40' STEEL BOX CAR

## For Scale or Tinplate in "O" Scale



READ these instructions carefully before proceeding with the construction of your **ALL NATION BOX CAR**. For best results follow the sequence of operations as outlined below.

1. Assemble and mount metal underframe to wood floor. This assembly is held in place by means of the two bolster mounting blocks, part #3049. The round portions of the blocks fit into the predrilled holes in the wood floor as shown in drawing and held in place by means of two #4-40 screws used with two flat washers. Proper placement of cross braces can be determined by referring to the drawing and to the metal sides to be used.
2. Assemble wood ends, wood roof, and wood floor together using #20 wire brads and cement if desired. Make certain that the wood body is assembled with the floor, roof, and ends square with each other.
3. Use a #70 drill to drill the holes necessary for mounting the brake platform, ladders, brake housing, and roof walk supports and a #70 drill for the grab iron mounting holes and brake wheel mounting hole. The location of these can be determined by referring to the drawing. Before fastening metal ends to wood body, check fit of metal roof over the metal ends. If too tight, sand off ends of wood roof until metal roof fits snugly over metal ends. The ends may now be mounted, making sure that they are centered from side to side and are flush at the roof, so that the metal roof will fit down properly over the ends.
4. Press the metal roof down over the wood roof making sure that it overlaps the ends and that it is down all the way. PLEASE NOTE: In our roof stamping operation, a curved corner results due to the die cut-off. File this small corner (or tip) flat with plane of end and side flange. Fasten down by nailing through each of four holes about 1/4" from each end. Next nail roof ribs in the center after which the ribs are gently bent over the edge of the roof and nailed in place. There are only 11 roof ribs on this car. The first rib on each end is 7/8" from the end. For cars with wood roof walks: Cut 10 pieces 11/32 long from 1/16 sq. bass wood strip. File or sand one side of each piece to match contour of roof at center. Cement these pieces in center of raised roof panel sections using Walthers Goo or Adron Alpelcement or Epoxy. Make sure they are centered on the roof and edges are in a straight line. Cement roof walk to these pieces, centering the walk over the ends. Cut four pieces from 1/16 sq. basswood long enough for end walk supports. Cement first piece to roof 1/8" from end, second piece 1/2" from end. Cement end walk to these pieces. Drill holes for roof grabs through both end walk and supports.

For Cars With Brass Blaw-Knox Roof Walks: Trim ends of roof walk to 10 and 9/16" overall; this will leave a crossbar at each end. Lay on roof ribs and center both ways. Glue or solder sides of walk to roof ribs. Pin roof walk end supports to end of car so that the walk is supported straight out from the last rib. Glue or solder the walk to the support. Fasten end walks flush to roof walk with outer end fastened to roof. Drill for corner grabs thru perforations in end walk. If you choose to solder roof walks in place, start at center and work to the ends making sure the walk stays lined up over center of roof. After this is done, roof walk supports, roof end platforms, and roof hand holds can be installed. Fasten AB brake set in place using model airplane cement and mount coupler pockets, first drilling mounting holes. (Coupler pocket on scale car only).

5. Before installing the painted and lettered sides, the entire car as built so far should be painted. The roof, ends, and underbody are painted according to the paint and scheme list which is included in the kit. The matching colors for the **All-Nation** kit are stated on the carton label. The metal parts should of course be cleaned with a good solvent such as naphtha or lacquer thinner to remove traces of oil or solder flux. At the same time the car is painted the ladders, steps, grab irons, door channels and doors which will be used on the sides should also be painted.
6. The final step in completing this kit is to install the sides, mount the doors and hardware, and touch up the heads of the escutcheon pins used to mount the sides and hardware: The sides are mounted by sliding them underneath the side overlap on the ends, and fastening in place with escutcheon pins. It may be necessary to trim the ends to ensure the sides laying flat. Do this carefully, removing the same amount from each end.

Every effort has been made to bring you the finest "O" scale car kit on the market. Don't spoil your model with a hurried or careless assembly job.

All-Nation

# 40 Foot Steel Box

For Scale and Tinplate in "O" Ga

**SPRUNG DRAFT GEAR**  
Another Specialty by All-Nation

Easily Adaptable To All Cars



# 3006 Kit

For Realistic Starts and Stops

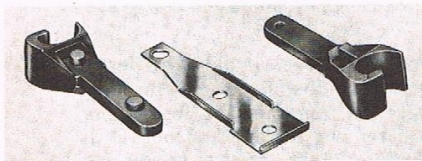
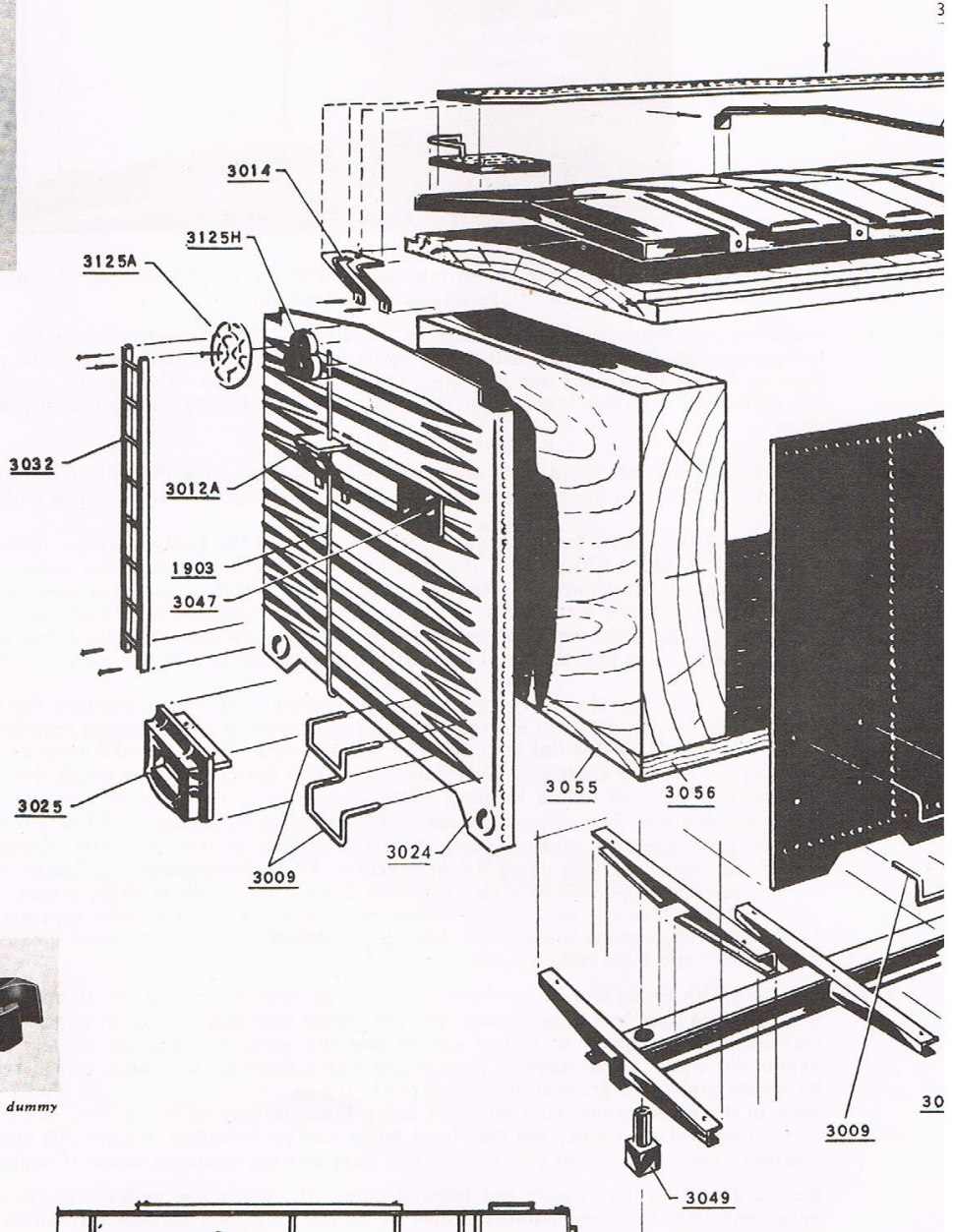
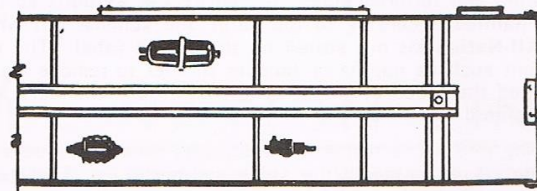
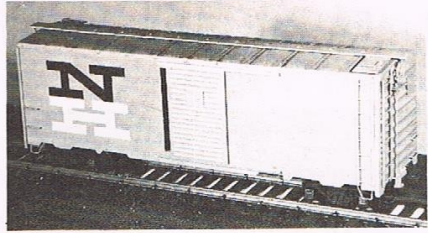


Illustration showing top and bottom of tinplate dummy coupler with bolster adapter before mounting.

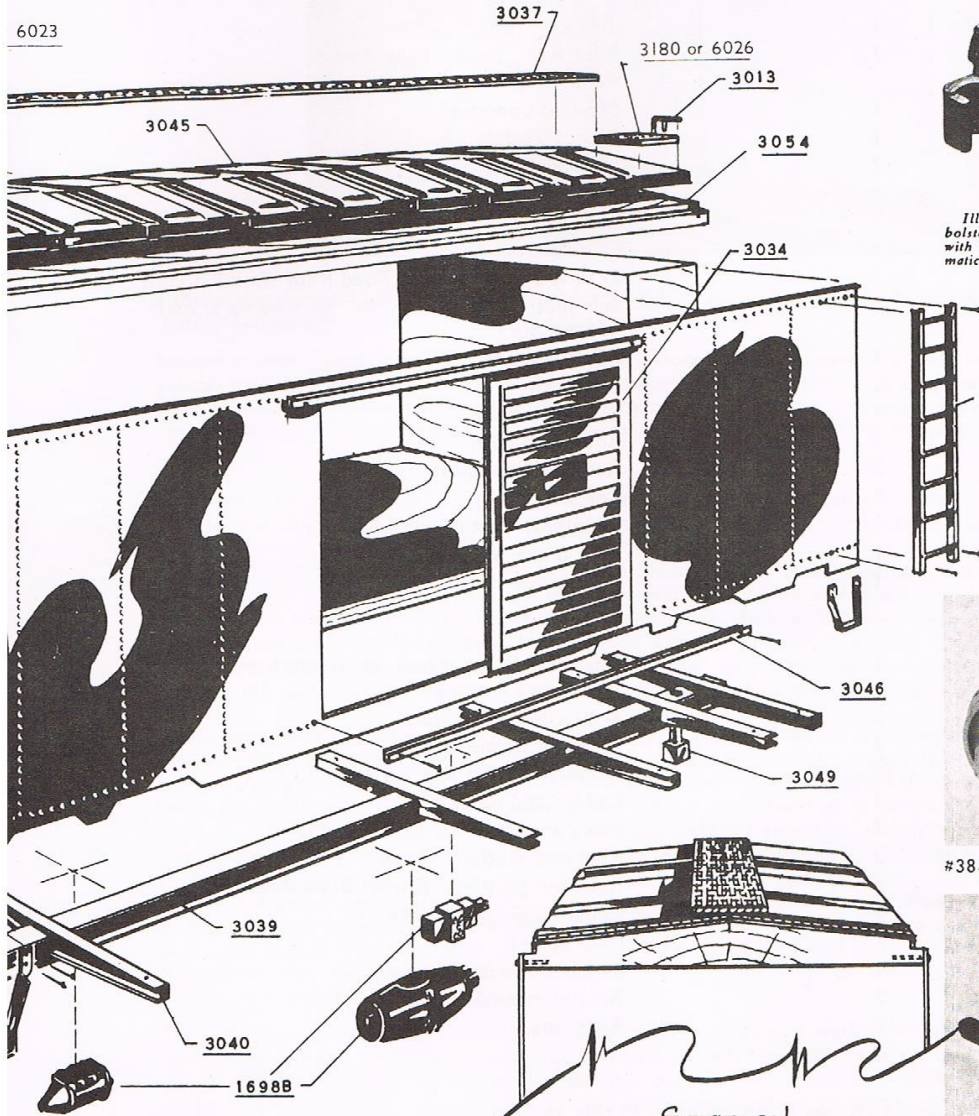


DRILL COUPLER POCKET  
MTG. HOLES AS REQD.

# Car



6023



## COUPLERS - ADAPTERS

for TINPLATE OPERATION

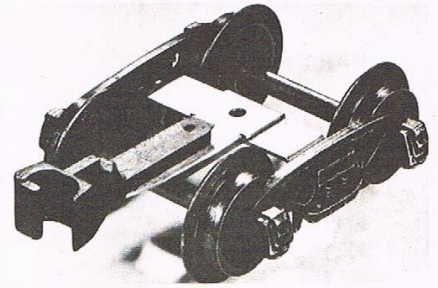
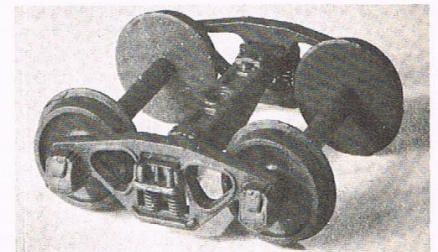
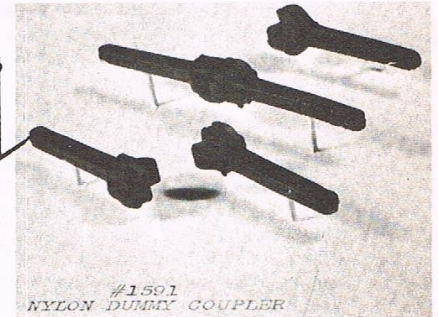


Illustration showing tinplate dummy coupler and bolster adapter mounted in position on scale truck fitted with tinplate wheels allowing operation with Lionel automatic couplers.

KITS DO NOT INCLUDE TRUCKS



#3845 SPRUNG BETTENDORF TRUCK



#1591 NYLON DUMMY COUPLER



## PARTS LIST

PART NO.	QUANTITY	DESCRIPTION
1903	1	.032 x 5' wire
6023	1	Roof Walk, Brass, Blaw-Knox
or 3181		Roof Walk, Wood
3039	1	Channel underframe
3045	1	Roof, Metal
3024	2	PS-1 Ends
3054	1	Roof (wood)
3055	2	End (wood)
3056	1	Floor (wood)
	1	1/16 X 8" Basswood (Wood Roof Walk Kit Only)
2478	1	Sub section, steel box, 40', wire forms & roof accessory
1698-B	1	AB Brake set
3009	8	Grab iron
3012-A	1	Brake Platform
3013	2	Roof hand hold
3014	2	Roof walk supports
3022	4	Car steps
3025	2	Coupler pocket (scale kit only)
3125-A	1	Ajax brake wheel
3125-H	1	Ajax brake housing
2479	1	Sub section, steel box. 40', underframe & accessory
C-1404	2	4- 40 x 5/16 Fil. Hd.
C-2029	2	#5 brass washer
680	80	Escutcheon Pin #24 x 3/8"
3032	4	Ladder and rungs
3034	2	Box car door
3180	2	Roof end platform, Wood
or 6026	2	Roof end platform, Brass, Blaw-Knox
3040	8	Underframe cross brace
3046	4	Door Slides
3047	4	Placard boards
3049	2	Bolster mounting block
3155	11	Roof ribs

Scale kit has scale couplers in this section.  
Tinplate kit has tinplate couplers and adapters.

***A*LL NATION LINE**  
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