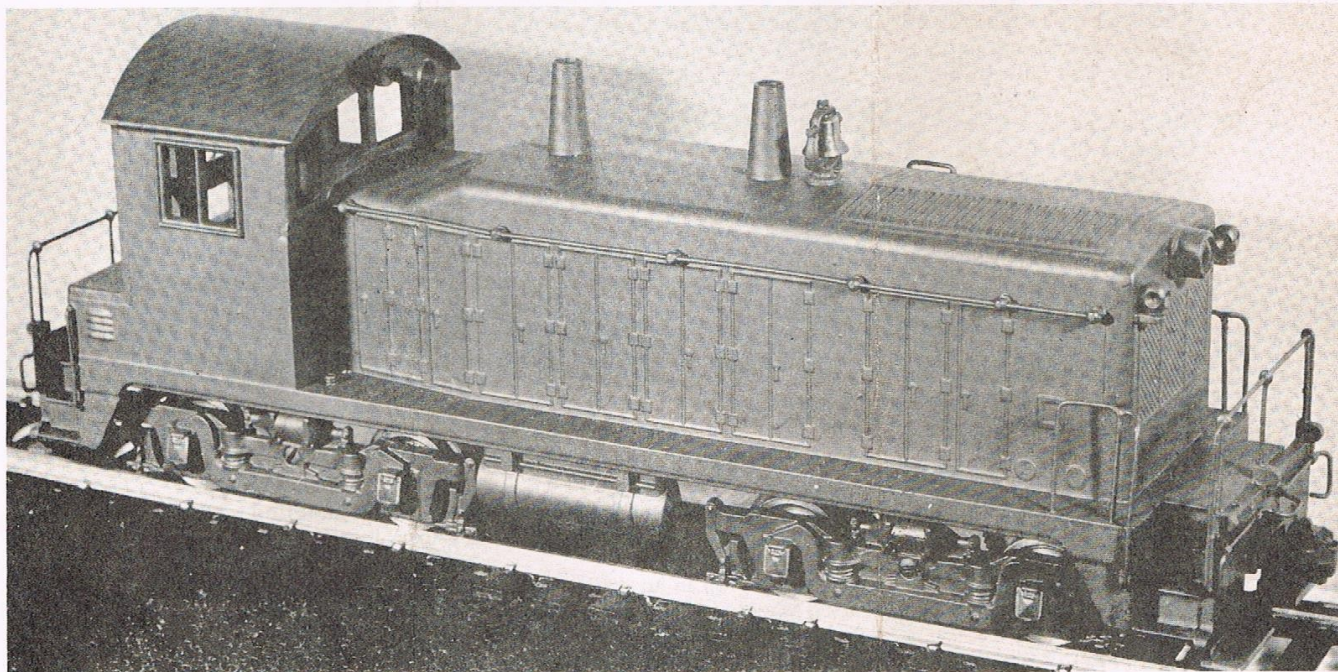


ALL-NATION



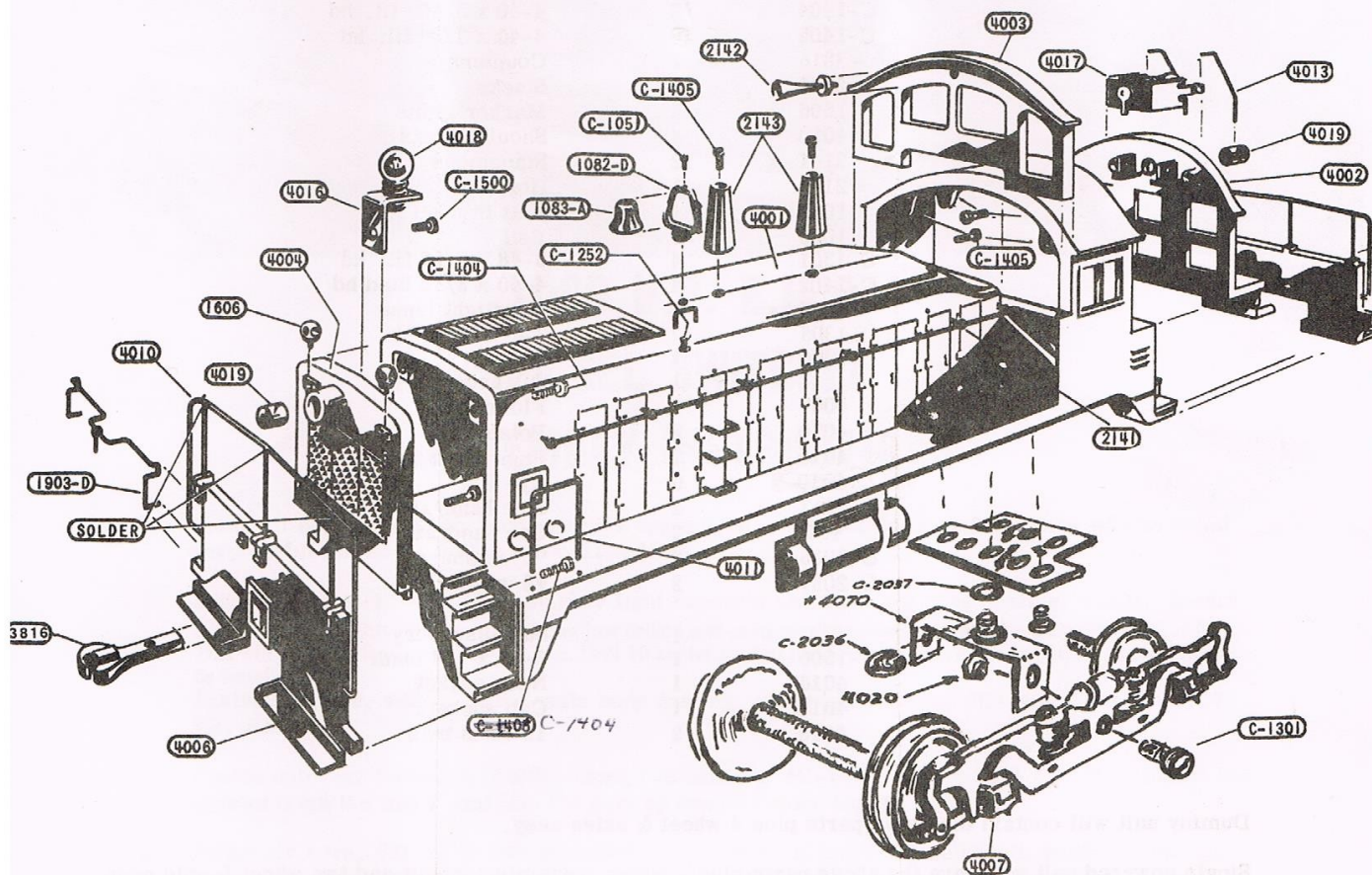
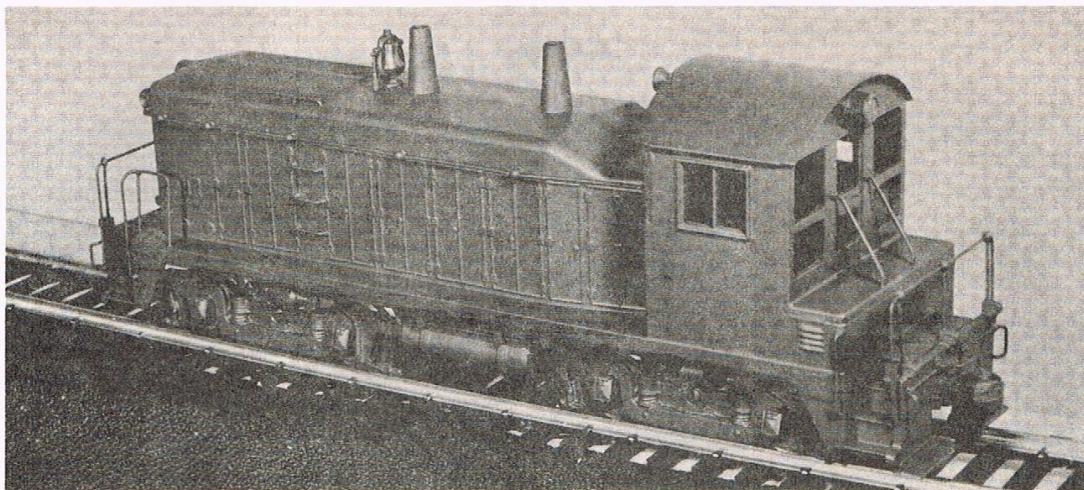
1000 H.P. E.M.D. DIESEL SWITCHER ASSEMBLY INSTRUCTIONS

1. Clean all burrs and flash from castings using files. A set of Swiss pattern files will be found very useful for this. Do not use coarse files.
2. Drill two holes (1/16 drill) in marker light brackets on the diesel nose casting, #4004. Insert the two marker lights, #1606, in the holes just drilled and peen over the stud on the underside of the marker light. This will hold the lights securely in place. Drill 10 center market locations on sides of body #56 for stanchions to be installed later.
3. Fasten the nose, #4004, to the main body casting, using two screws, #C-1404. #4-40 x 5/16" Fil. Hd.
4. Fasten cab rear bulkhead, #4002, using two screws, #C-1405, 4-40 x ^{5/16"}~~3/8"~~ Fil. Hd. Insert the screws from the inside and line the part up evenly before tightening.
5. Insert air horn, #2142, in hole provided in top center of cab front bulkhead, #4003. This may be peen or cross drill the stud and insert a piece of wire to hold the horn in position. The front bulkhead is fasten in place as shown using method describe in #4.
6. A little filing may now be necessary to give a perfectly smooth surface where the nose and cab castings join the body casting. If this is done carefully, the joints will not show after painting.
7. The next step is to install the front and rear pilots, #4006. These are fastened in place using screws #C-1405. NOTE: If coupler release rods are going to be installed, the mounting bosses should be drilled using a #64 drill before pilots are mounted.
8. Clean the flash and raised lettering from couplers. Mount on bosses using # C-1305 screws (3-48 x ^{5/16"}~~3/8"~~ RHMS) and # C-1306 bushings that are packaged with the pre-drilled couplers.

9. The two smoke stacks, #2143, are mounted using two screws, #C-1405. The bell bracket, #1082, is mounted using screw, #C-1252, and the bell, #1083, is mounted using screw, #1051.
NOTE: The bell should be removed before painting and replaced later.
10. The handrails may now be installed. Take six handrail stanchions, #2141, and thread on a length of the .032 brass wire, #1903D. Starting next to the cab, tap one stanchion in part way. Proceed to the next one and so on until all six are part way in. Proceed to tap them all the way in making sure that the wire is kept taut. The same procedure should be followed on the opposite side. The balance of the handrails are preformed and may be installed by following the drawing. The three step on the left side and the hand hold on the top of hood may be installed if desired using a piece of the .032 wire to form the parts. Holes will have to be drilled using a #66 drill for a press fit.
11. The body is now ready to be painted. First clean thoroughly using lacquer thinner. A coat of primer should first be applied and then sanded smooth with very fine sandpaper. The final coat may now be applied. Spraying both the prime coat and the finish coat will produce the most satisfactory results. The colors used will depend upon the prototype followed.
12. Before mounting trucks in place, the two headlight lenses, #4019 should be installed. These are pressed into position from the inside. Then install socket as shown in drawing.
13. The assembly of trucks is shown on the plan in an exploded view. This should be self explanatory. Remember to keep insulated wheels on one side in each truck, to prevent short circuit.
14. Mount dummy trucks to floor plates. Place one #C-2037, #8 washer, over kingpin to act as a spacer. Then put kingpin through floor plate as shown on drawing and lock in place with #C-2036, 'C' washer.
15. The final step is the installation of the trucks to the body. This is done by using #C-1402, #4-40 x 3/16" Bind. Hd. screws. These are placed through the holes in the floor plates and into the threaded holes in the body as shown drawing.

For mounting power trucks, see instructions that are given with the transmission units.

For the discriminating builder, use ALL-NATION super model railroad lacquers. "THE ONLY LACQUER THAT GIVES YOU A PERFECT SPRAY JOB"



NOTE

NOSE
END



Kingpins of Trucks
should be inserted
into holes marked (X)

Also note direction
bolsters are facing.

CAB
END



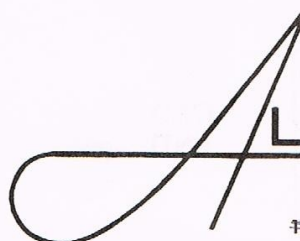
PARTS LIST

<u>PART No.</u>	<u>QUANTITY</u>	<u>DESCRIPTION</u>
4001	1	Body casting
4002	1	Rear bulkhead
4003	1	Front bulkhead
4004	1	Nose.
4006	2	Pilots
1903-D	3	.032 x 10" wire
1905	1	#20 x 10" wire
2490	1	Sub accessory
4007	4	Sideframes
2491	1	Sub accessory
C-1051	1	0-80 x 1/8" fil. hd
C-1252	1	2-56 x 3/16" R.H
C-1404	12	4-40 x 5/16" fil. hd
C-1405	2 10	4-40 x 3/8" fil. hd
3816	2	Couplers
2143	2	Stacks
1606	2	Marker lights
4020	4	Shoulder nuts
2141	12	Stanchions
2142	1	Horn
1082	1	Bell bracket
1083	1	Bell
C-1301	4	3-48 x 5/32 fil. hd
C-1402	4	4-40 x 3/16 bind hd
4019	2	Headlight lense
C-1305	2	3-48 x 3/8 RHMS
C-1306	1	Bushing
2492	1	Sub accessory
4067	2	Floor plate
4070	2	Bolster
4010	2	Front & rear handrail
4077 4010-B	6	Eye Pin
4011	2	Side handrail
4013	2	Cab handrail
C-2036	2	'C' washers
C-2037	2	#8 washers
2498	1	Sub assessor
C-1500	1	5-40 x 1/8 bind. hd
4016	1	Nose socket
4017	1	Cab socket.
4018	2	12 volts bulb

Dummy unit will contain the above parts plus 4 wheel & axles assy.

Single powered unit will have the above parts plus a power transmission unit and two wheel & axle assy.

Double powered unit will have the above parts plus a power transmission unit and auxiliary transmission unit.


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 DIVISION OF SCALE RAILROAD EQUIPMENT, INC.
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