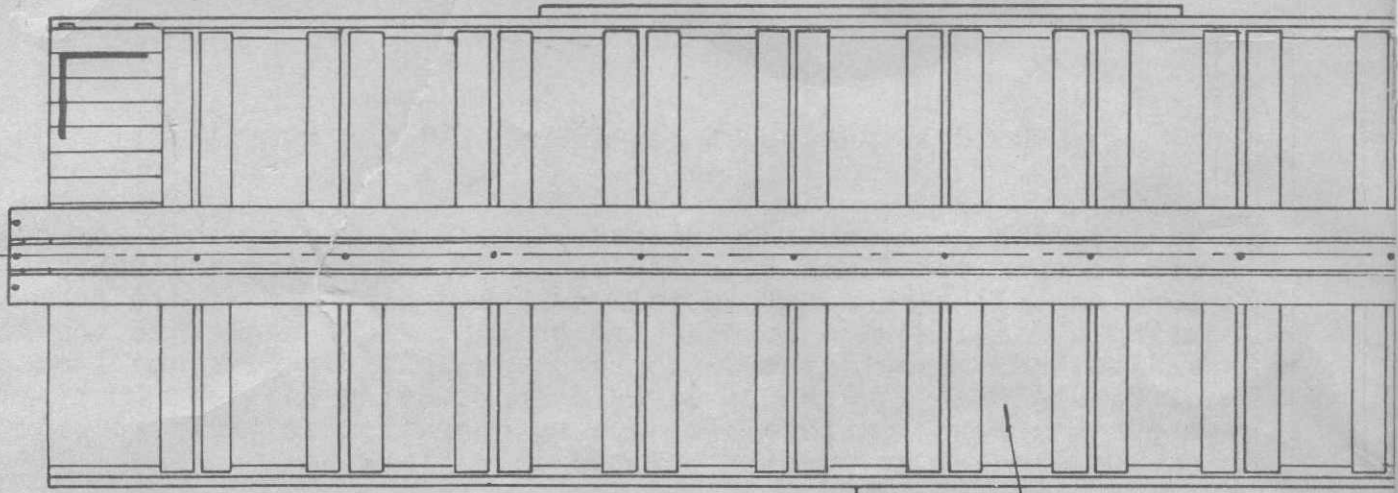


SUGGESTED PROCEDURE FOR ASSEMBLING OUR 40' CAR KIT

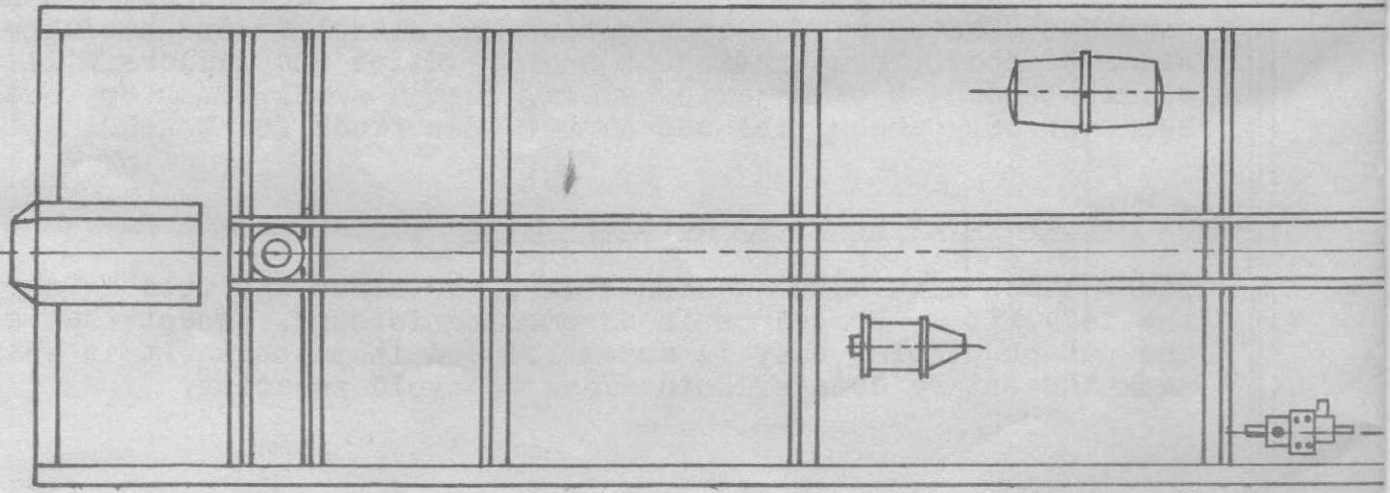
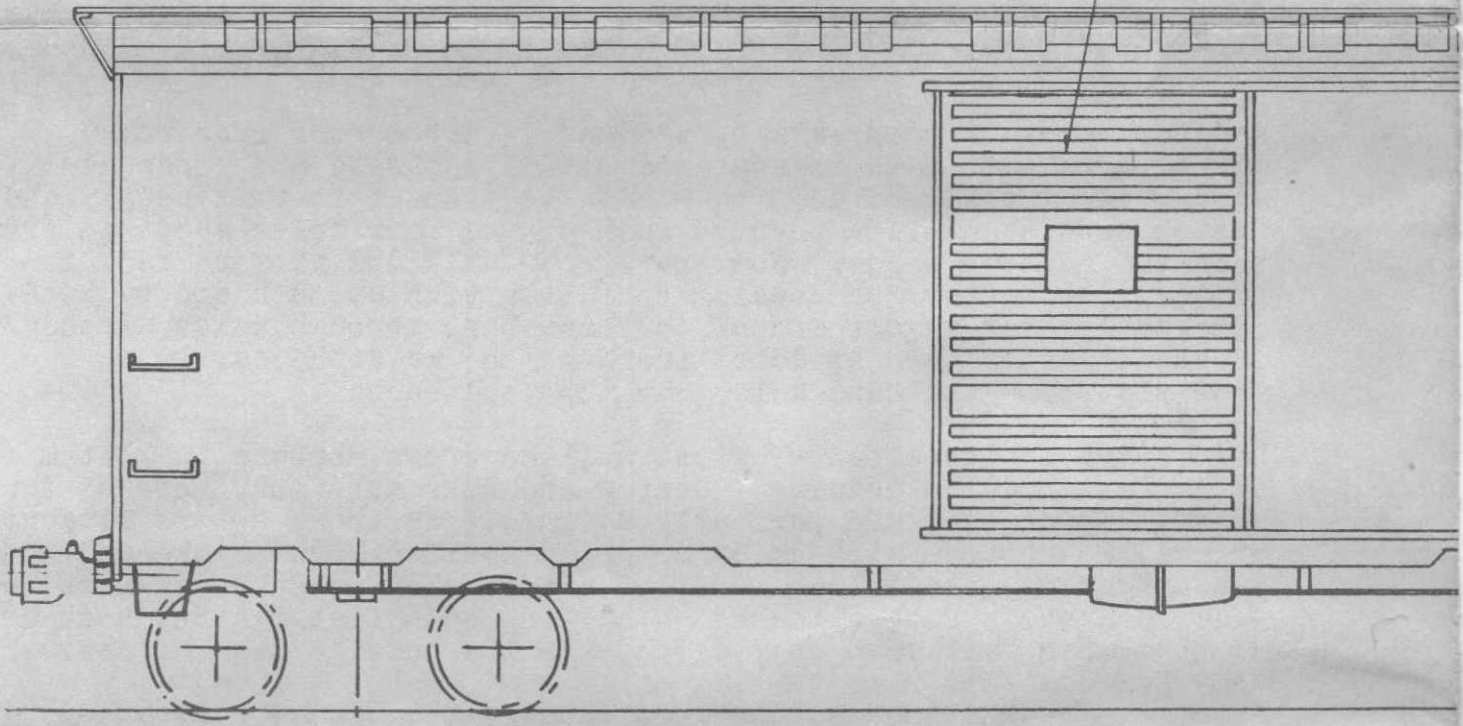
1. Nail wooden roof, bottom and ends together, seeing that the edges of the ends are flush with the sides of the bottom and rabbited portion of the roof. Then nail texboard sides to wooden framework, using a small square to hold the ends at right angles to the roof and bottom. Should the sides have a slight taper, a small amount of filing will square the edges. In removing the door opening, use a pen knife to complete the cutting operation so that the side will not be damaged in pushing out the door blank.
2. Use a 68 drill for laying out the holes in the ends necessary to attach hardware. Fasten to wood body being certain that ends are centered so that sides will slide under each edge. Make sure that the top of end is flush with roof and that metal roof will fit down over ends. Pins used in attaching hardware are usually sufficient to hold ends in place. Both ends are the same with the exception that only one has brake wheel, platform and piping.
3. Lay out holes in roof walk by placing inverted roof over walk, making sure that walk is centered both lengthwise and crosswise. Then press metal roof down on wooden body until it fits snugly and fasten down by nailing through each of the four holes about $\frac{1}{4}$ " from each end on both sides. Now, nail roof walk and ribs to roof in center, thereafter, proceeding to fasten ribs at each end by bending gently over edges of roof and attaching through holes already punched. After this is done, install roof walk braces. Roof platforms and hand holds can now be attached.
4. Underframe is installed by first nailing cross members to bottom of car as shown in drawing. Center and make sure that notches for underframe channel are perfectly aligned. AB brake set is attached by drilling bottom with holes slightly smaller than shanks and then pressing same into holes. Coupler and coupler pockets can next be added. Steps can be attached by nailing ends flat against bottom so that when bent down they align with the outside edge of car.
5. After piping has been soldered on end and all hardware attached to both ends and roof, our practice is to paint car. When this has been done fasten sides, door guides and miscellaneous hardware to sides of body. Prepainting of doors, guides and ladders will eliminate danger of smearing sides. Use a small brush to touch heads of escutcheon pins and car is then ready for trucks.

NOTE: In assembly of Great Northern Kits

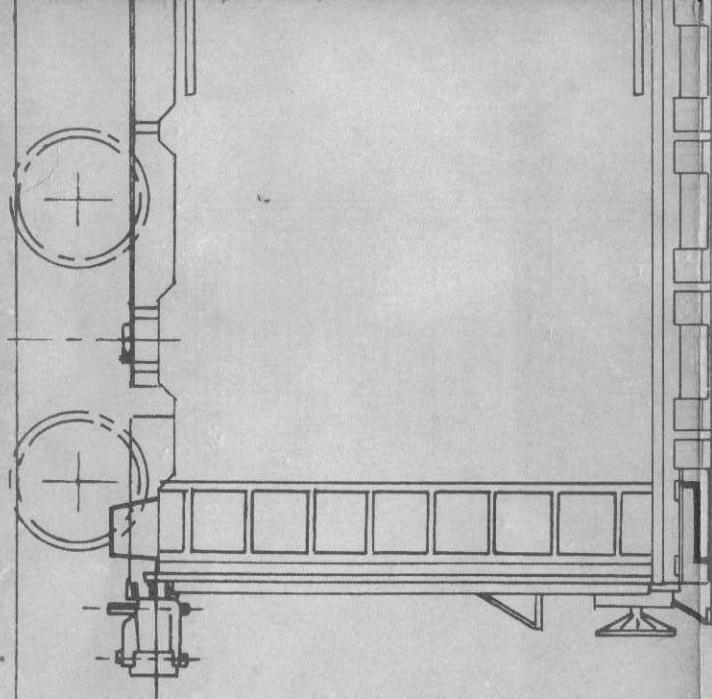
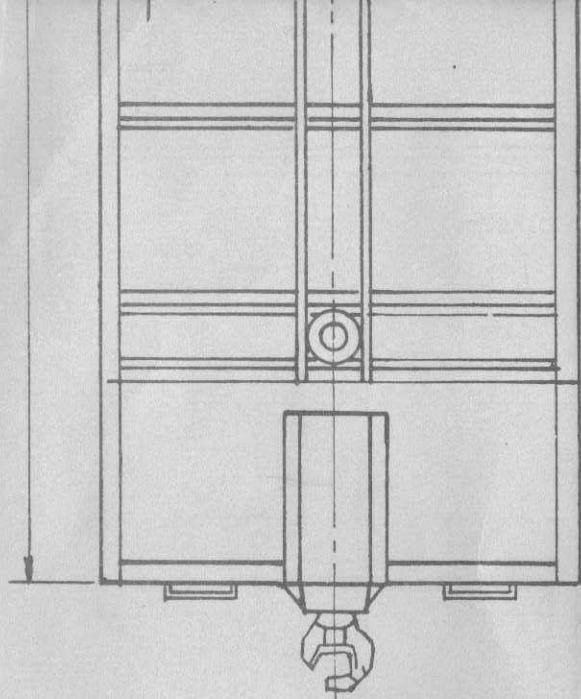
Since these kits have wooden sides, the sides are used as part of the body kit. Procedure in assembling is same, except that sides are put on at time body is assembled and in painting it is well to mask the entire area of both sides to avoid smearing.



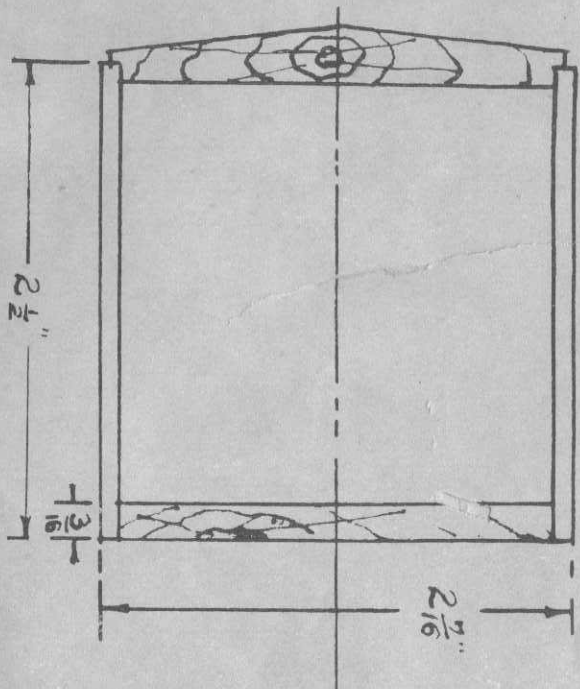
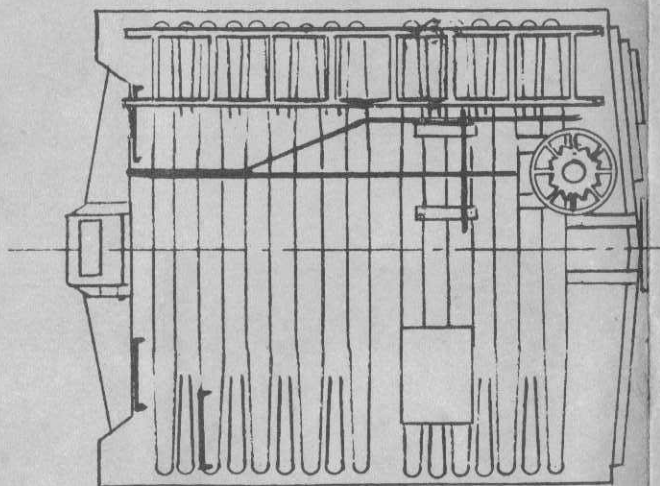
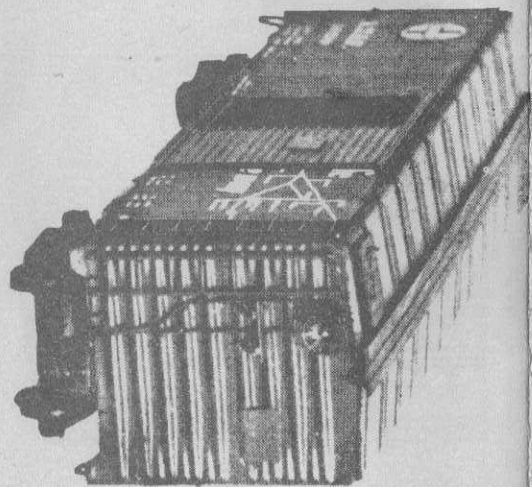
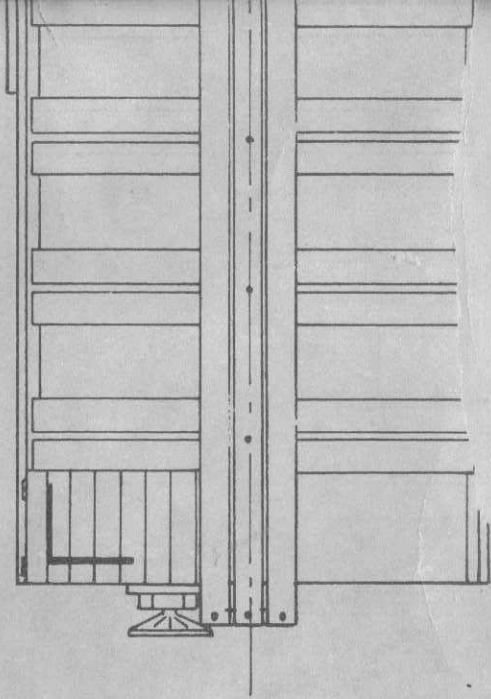
METAL ROOF
METAL DOORS AND



$10 \frac{1}{8}$ OVER ENDS



TRIMMINGS



IRVIN R. ATHEARN.
11129 VAN BUREN AVE.
LOS ANGELES 44, CALIF.
A.A.R.
BOX CAR
SCALE 1/4 INCH = ONE FOOT

