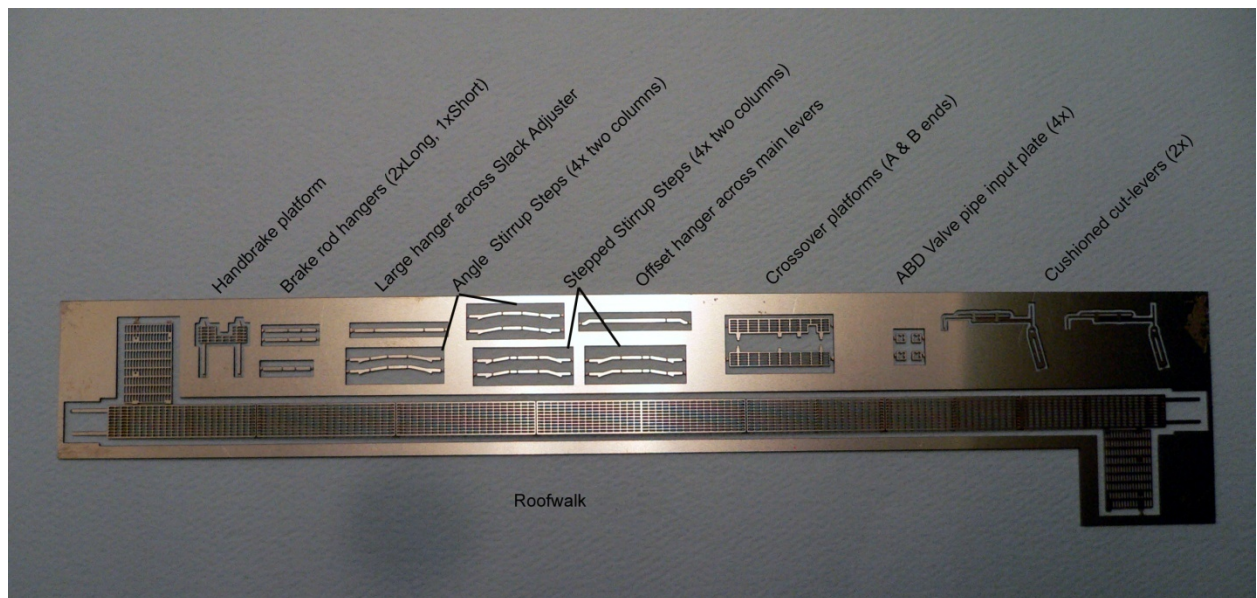
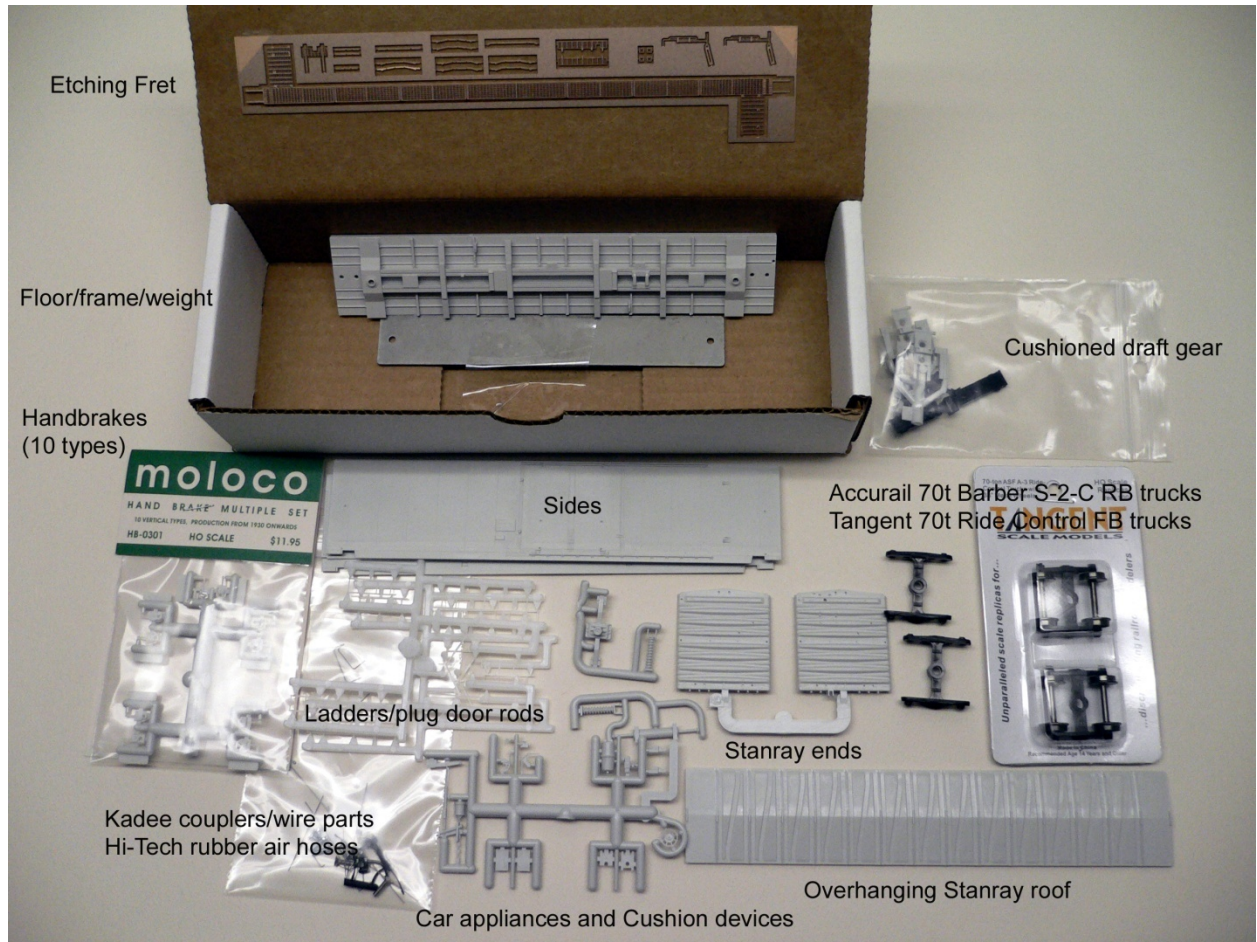
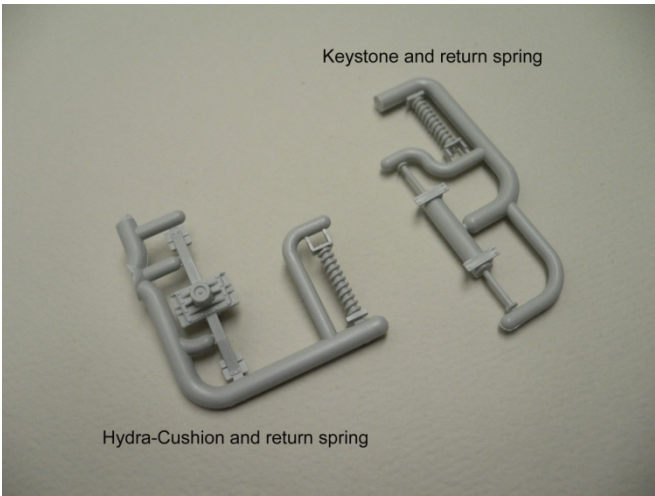
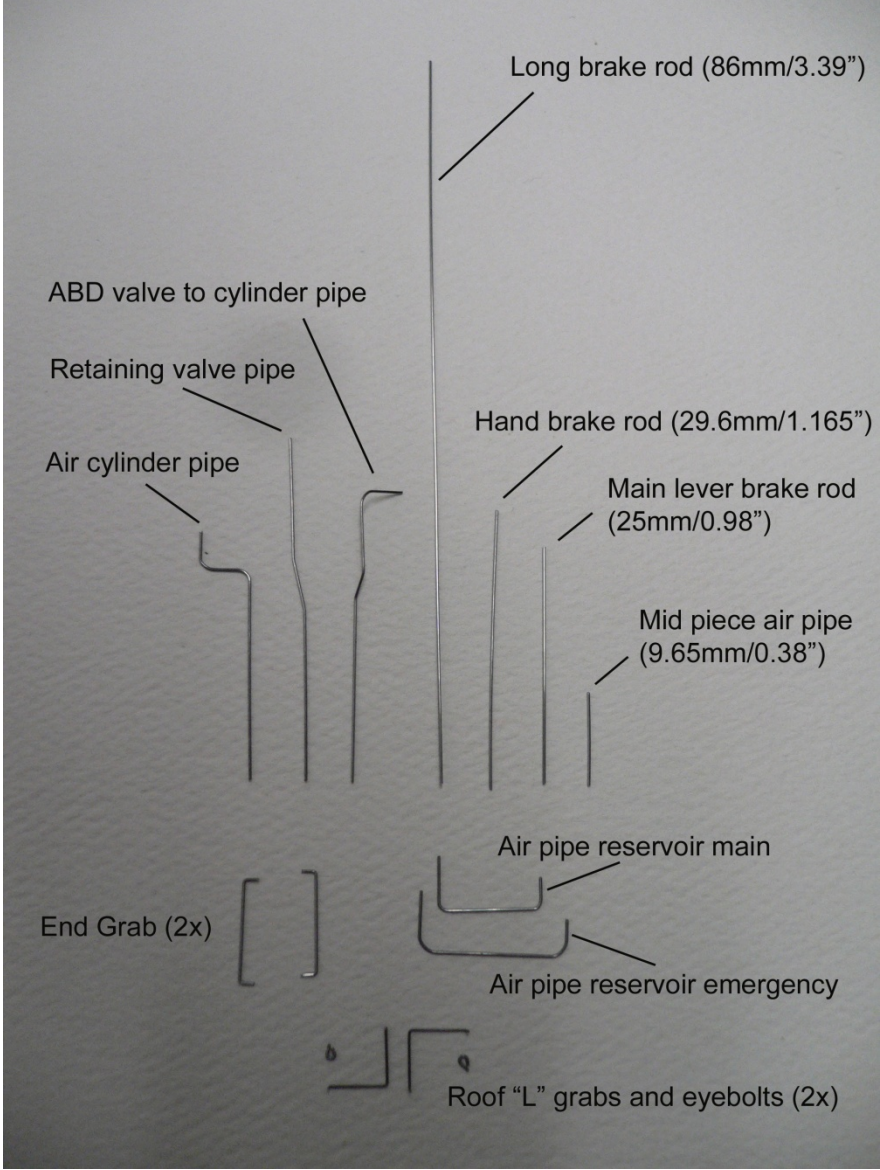


# MOLOCO - General American 50' RBL Kit Instructions

## Kit part identification





## Railroad specifications and option selections

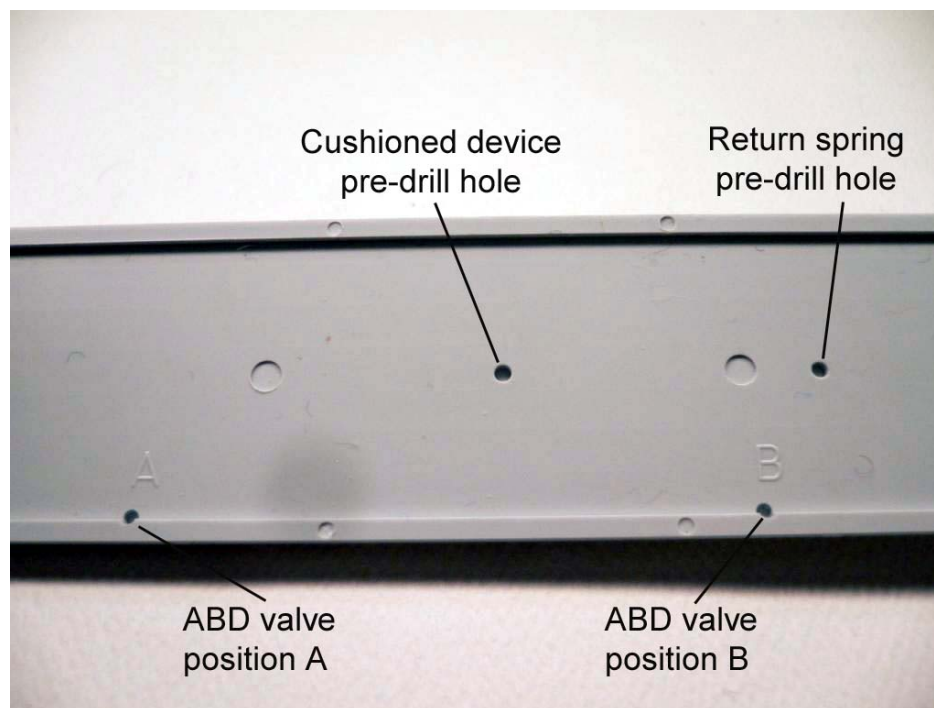
### *Sill 1 10-6 Offset wide door rods*

- EL (CR and D&H)-Keystone cushioning, Ajax handbrakes, Stepped stirrups, friction bearing trucks (Tangent)
- KCS-Keystone cushioning, unknown handbrakes, Angled stirrups, roller bearing trucks (Accurail)
- MILW-Keystone (first 50 cars) and Hydra-cushion cushioning, Ajax handbrakes, Angled stirrups, roller bearing trucks (Accurail)
- MP-Keystone cushioning, Equipco 3750 handbrakes, Angled stirrups, roller bearing trucks (Accurail)
- RI (ROCK)-Keystone cushioning, Ajax handbrakes, Angled stirrups, roller bearing trucks (Accurail)
- WAB (NW)-Keystone cushioning, Equipco 3750 handbrakes, Stepped stirrups, friction bearing trucks (Tangent)

### *Sill 2 10-0 Centered door*

- CGW-Keystone cushioning, Ajax handbrakes, Stepped stirrups, roller bearing trucks (Accurail)
- DRGW- Keystone (first 70 cars) and Hydra-cushion cushioning, Klasing 1150 handbrakes, Stepped stirrups, roller bearing trucks (Accurail)
- GM&O (ICG)- Keystone cushioning, Ajax handbrakes, Stepped stirrups, friction bearing trucks (Tangent)
- SOO- Keystone cushioning, Ajax handbrakes, Stepped stirrups, roller bearing trucks (Accurail)
- SLSF (XL version)-Hydra-cushion cushioning, Miner D3270XL handbrakes, Stepped stirrups, roller bearing trucks (Accurail)

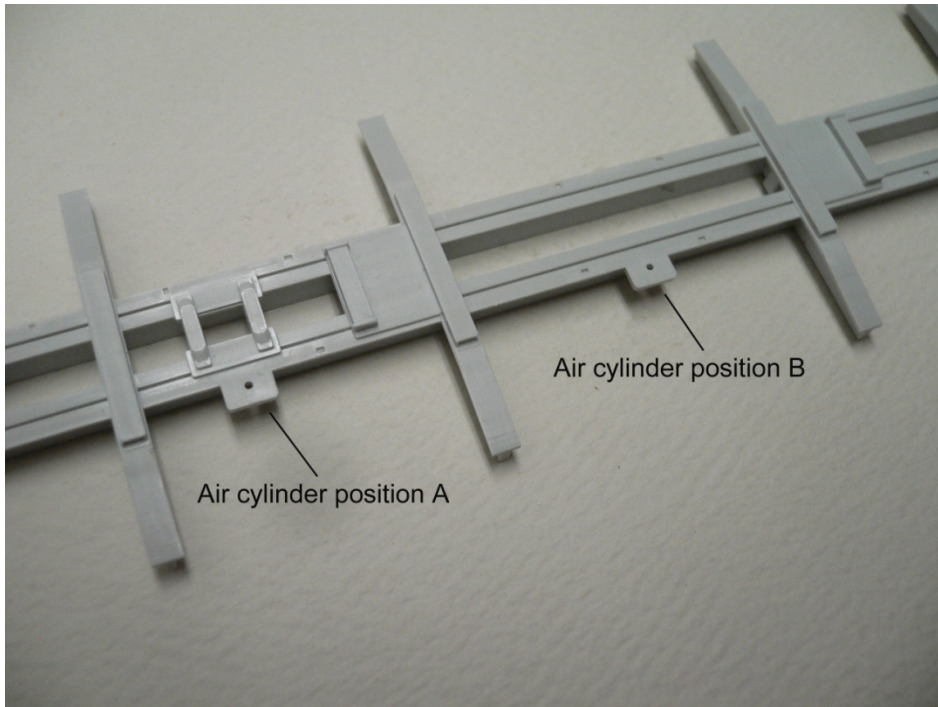
## Assembly



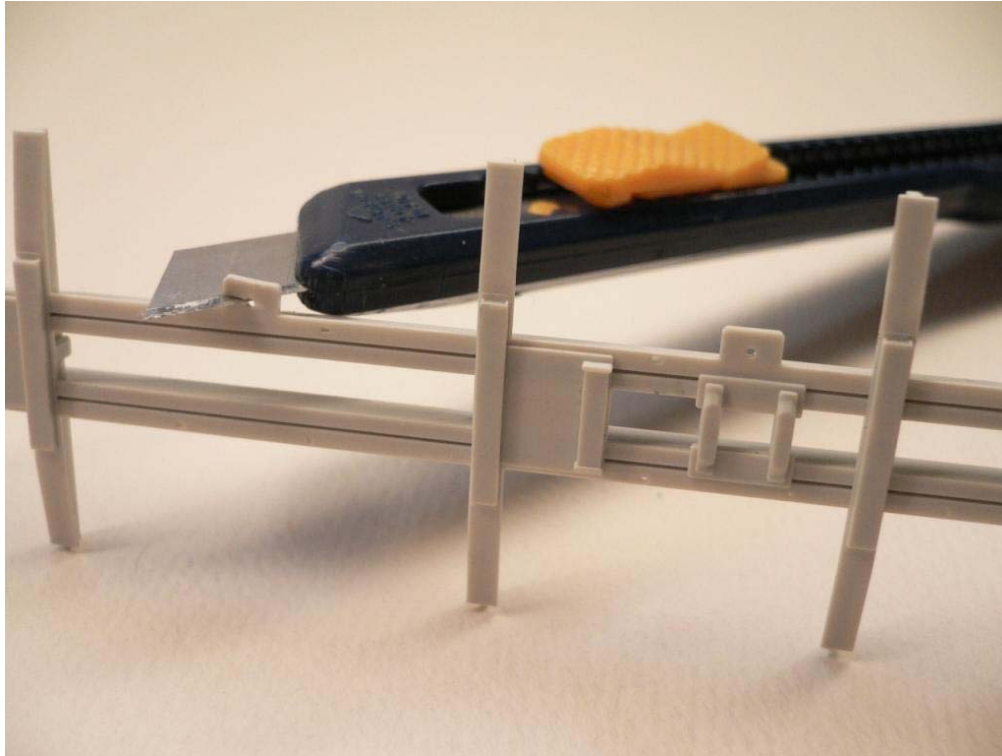
Sill 1 and 2 use ABD valve position A



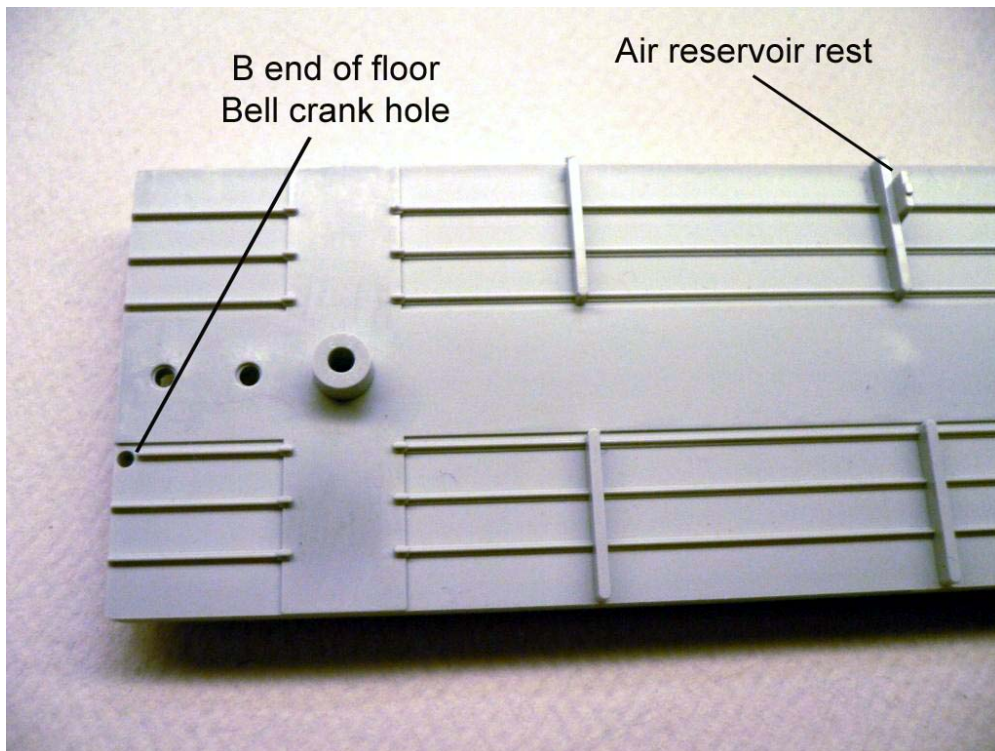
Starter dimples on rear side

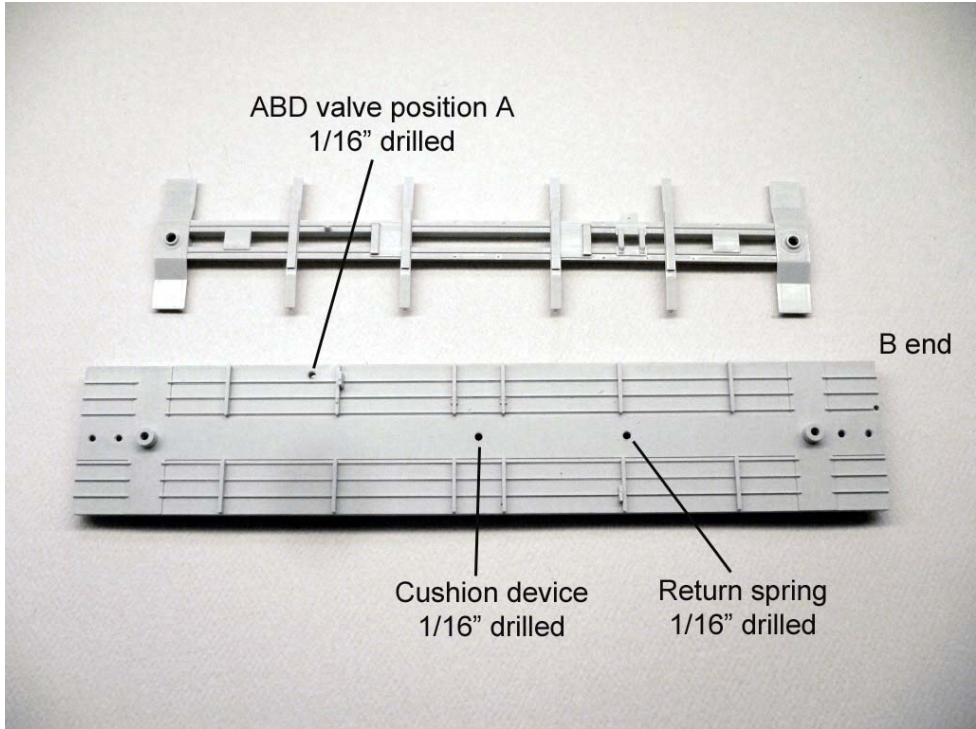


Sill1 and 2 use Air cylinder position A

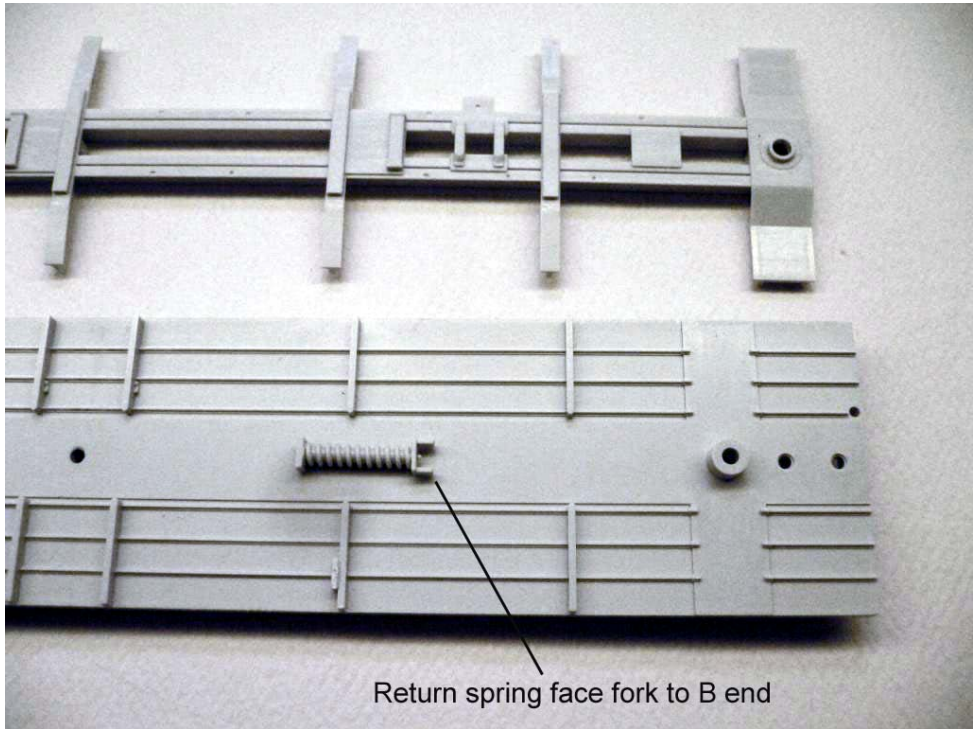


Shave off Air cylinder position B level to fixed frame





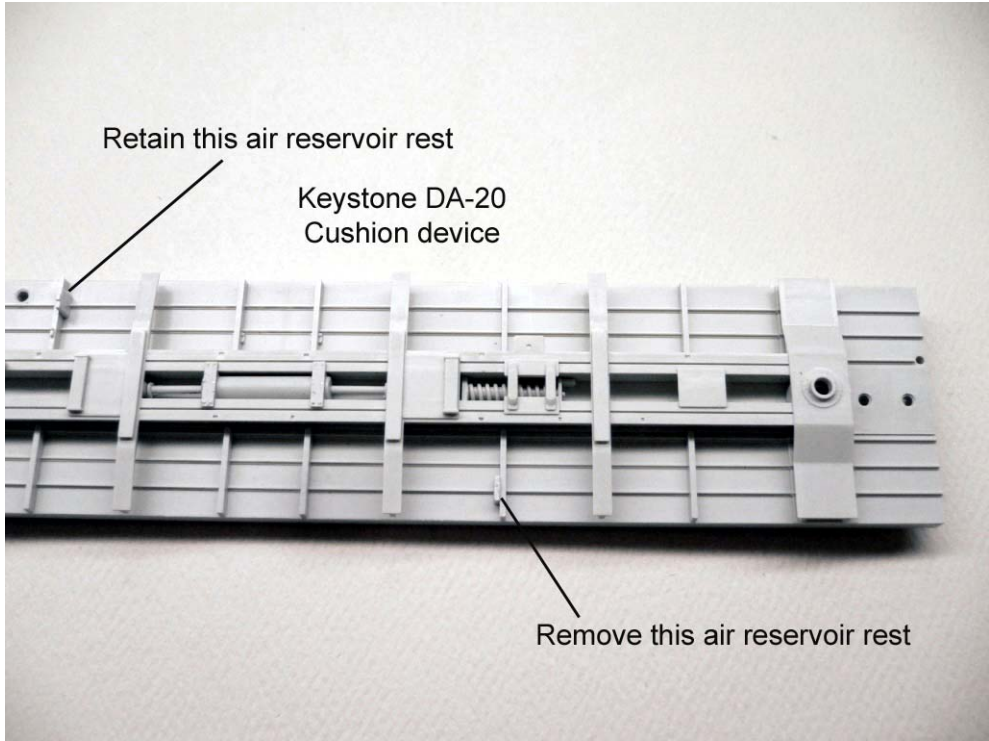
Floor and frame after the drilled holes and cutting



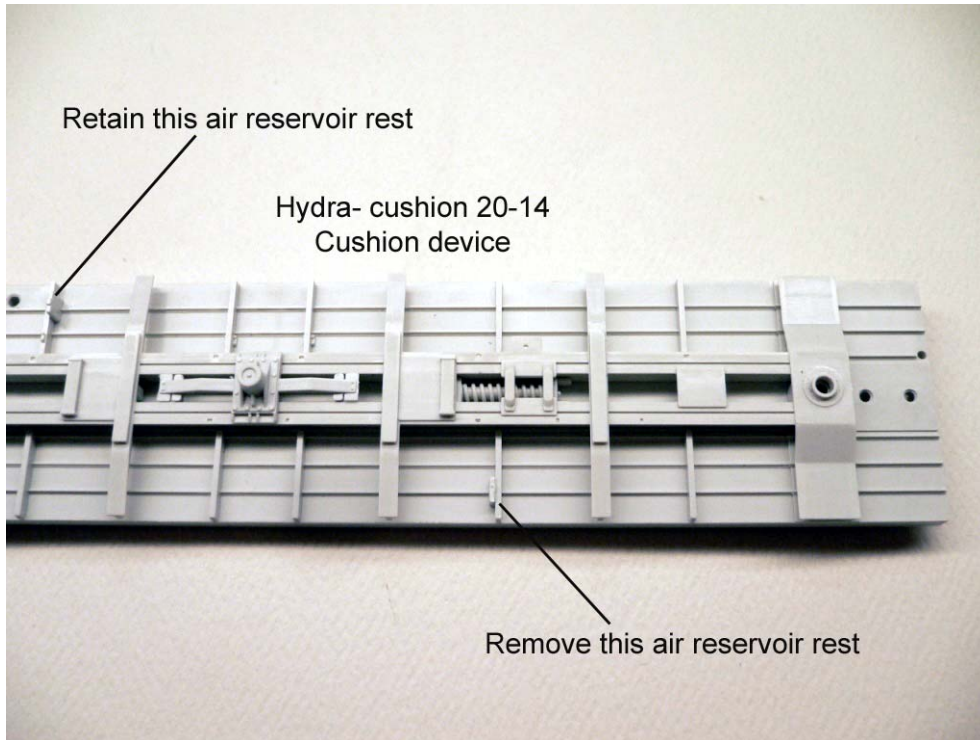
Glue return spring to floor



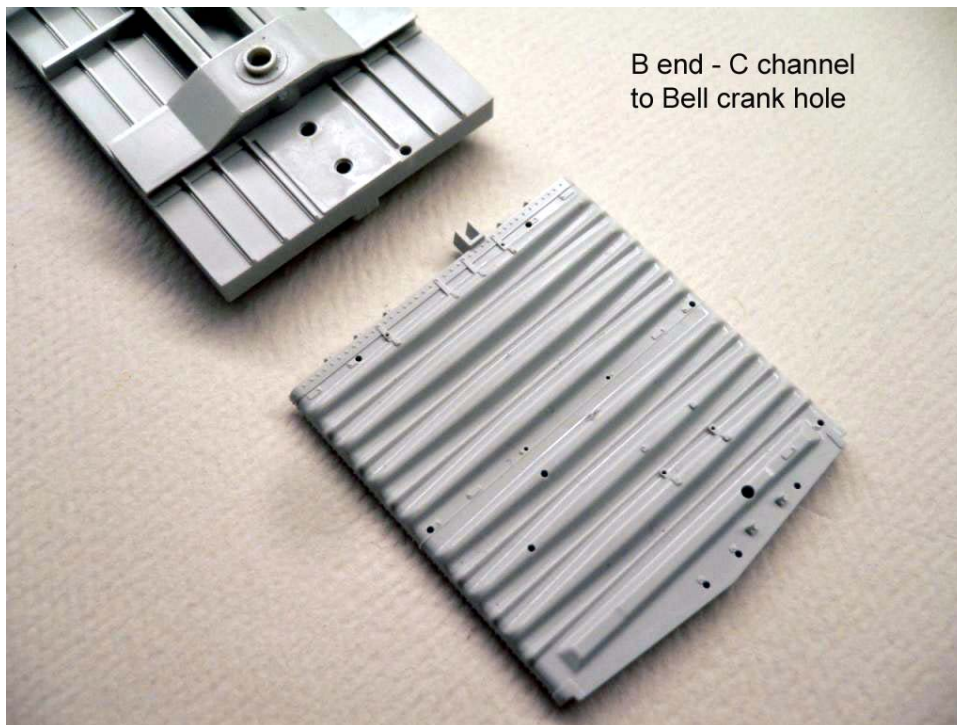
Glue first wire part before glueing frame



Cut-off (position B) air reservoir rest and retain other (position A), glue Keystone device to lock floor

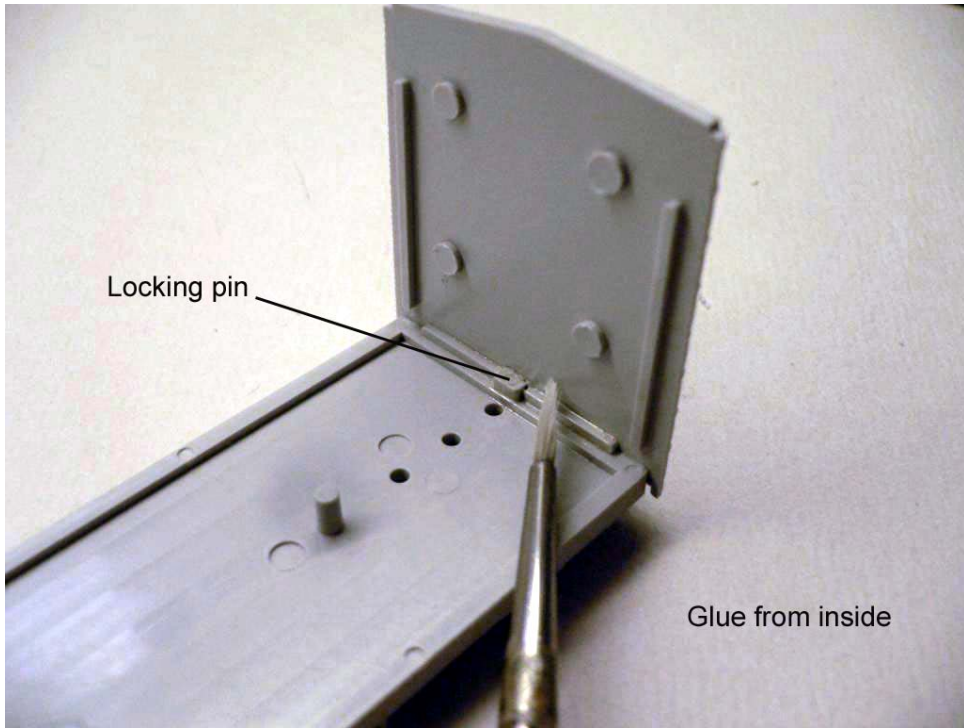


Cut-off (position B) air reservoir rest and retain other (position A), glue Hydra-cushion device to lock floor

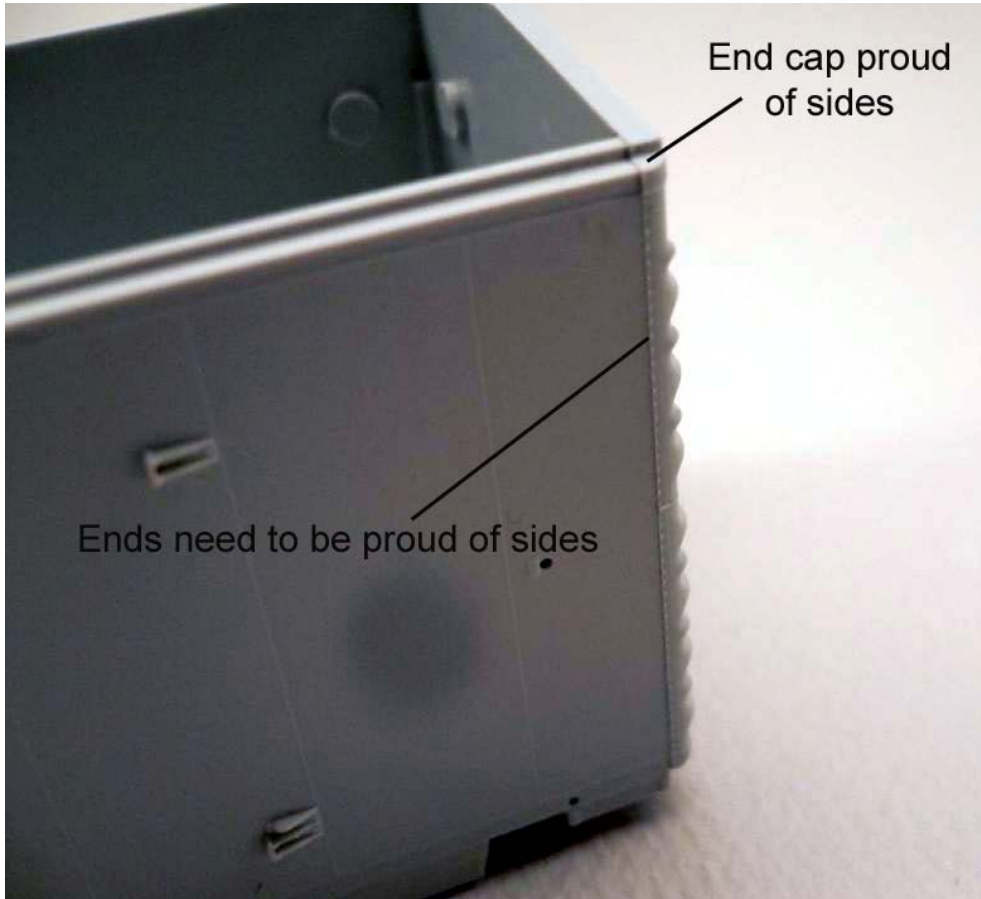


Take note of matching B end on floor to B end panel

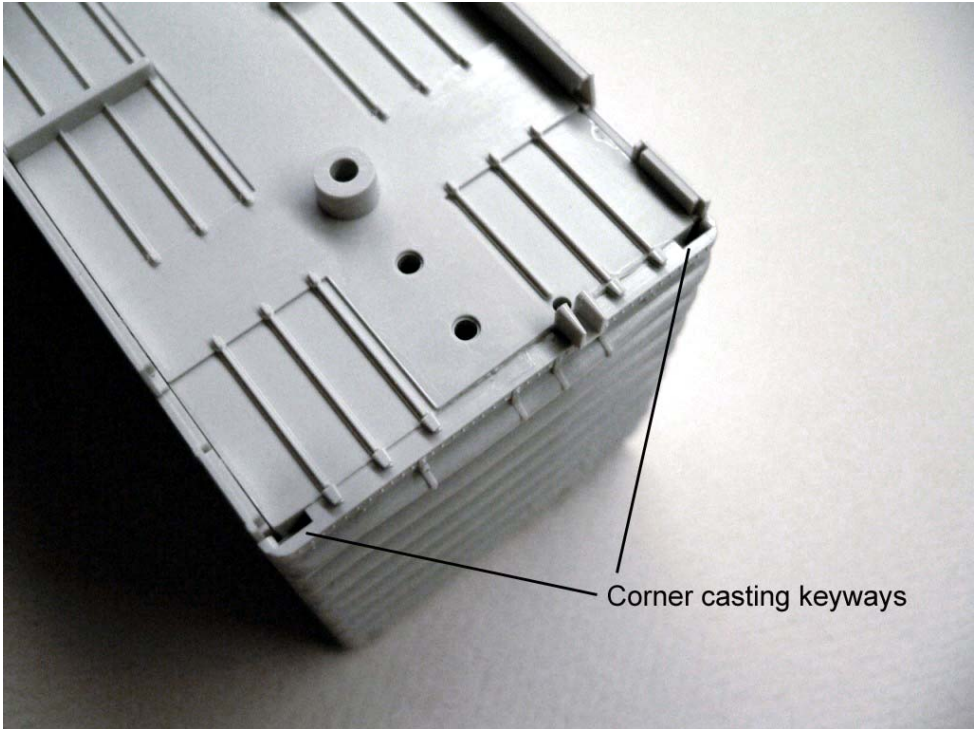




Glue from inside of ends first by help of the locking pins, at the same time glue the sides



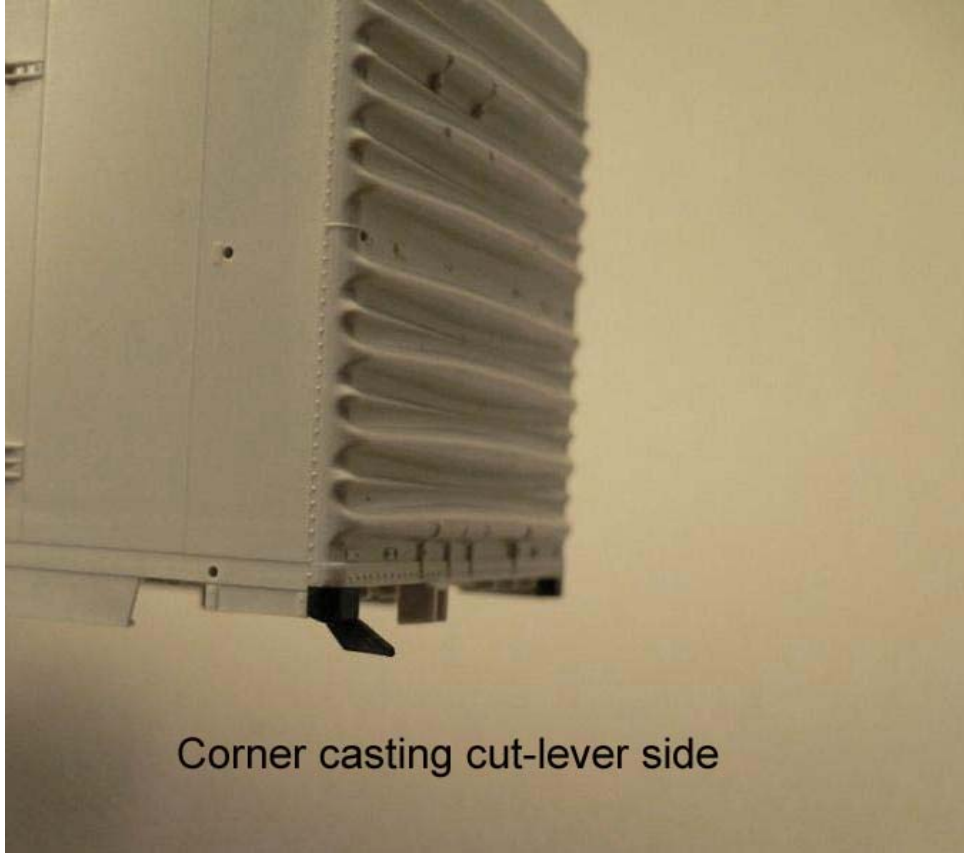
Make sure that the finished positions and push down and in against stops, so the ends are proud of the side panels



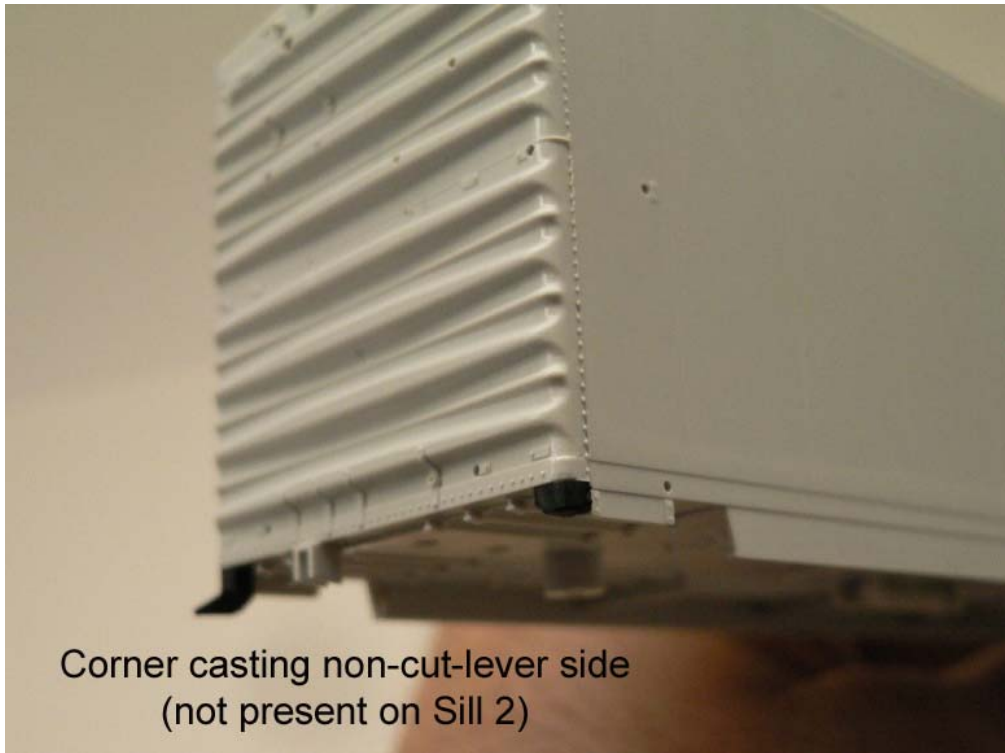
Sill 2 Corner cut-lever base (left-side only)

Sill 1 Corner casting and cut-lever base

Select Corner casting parts dependent to Sill type



Corner casting cut-lever side

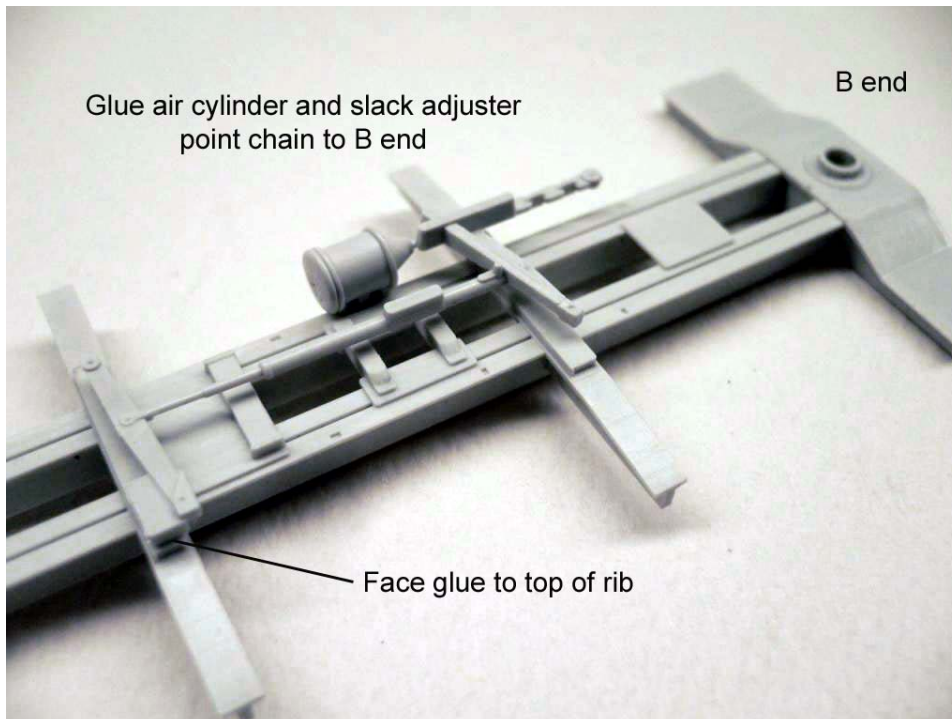


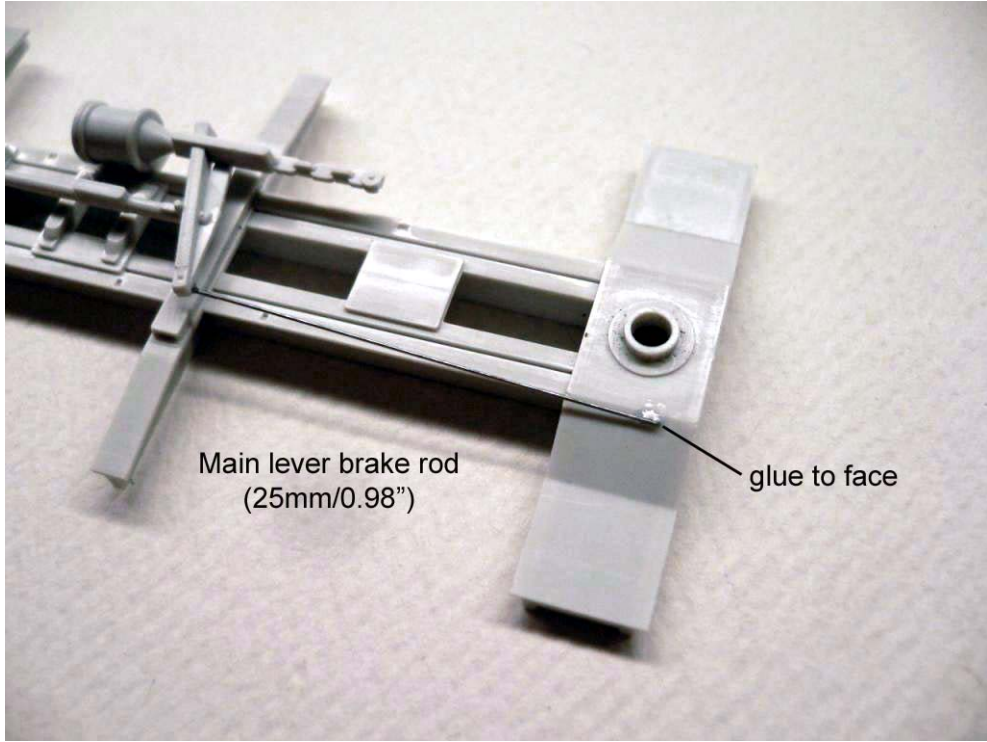
Corner casting non-cut-lever side  
(not present on Sill 2)

Drill 0.35mm (#80 drill) 3 locations

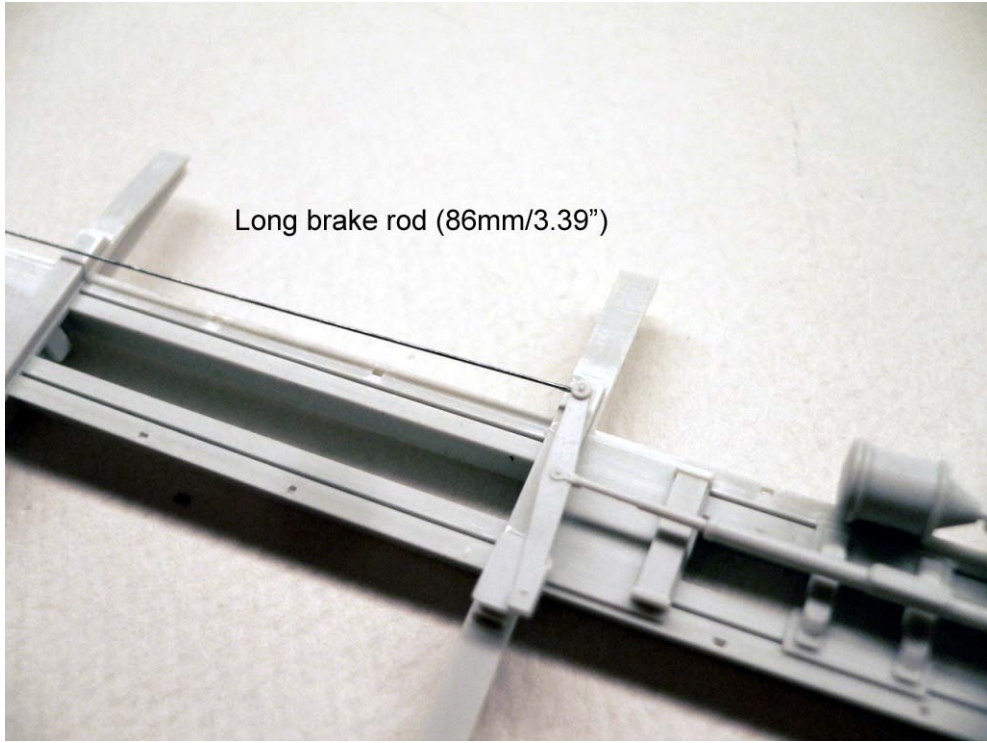


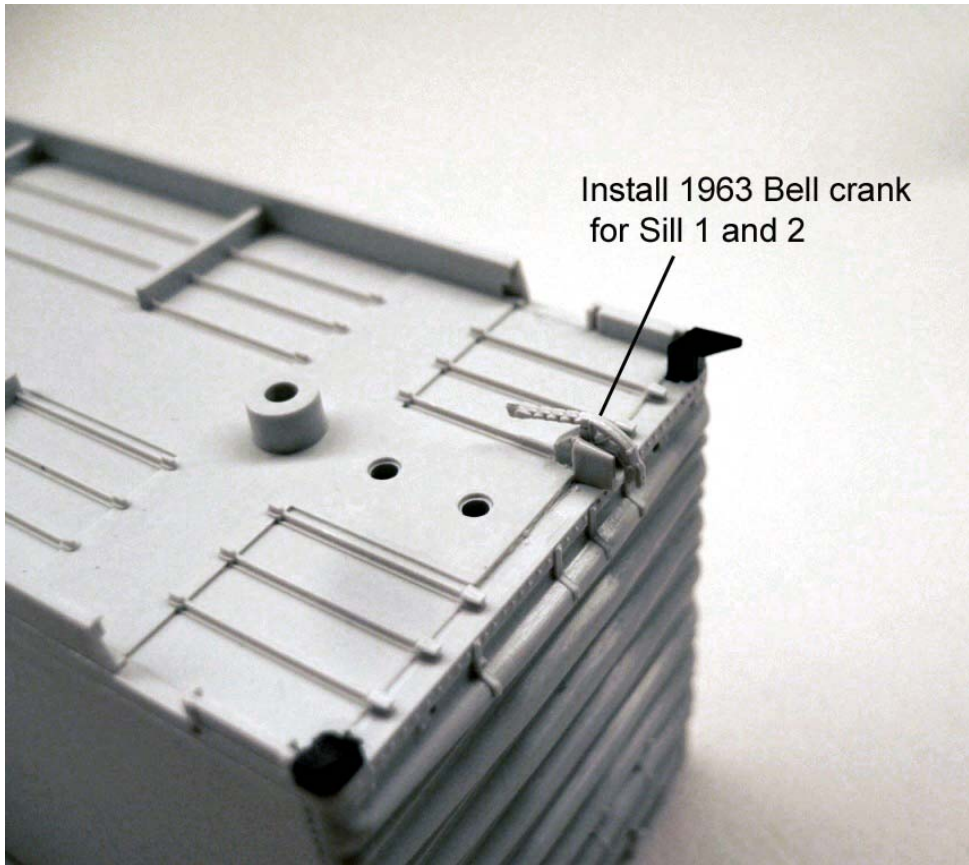
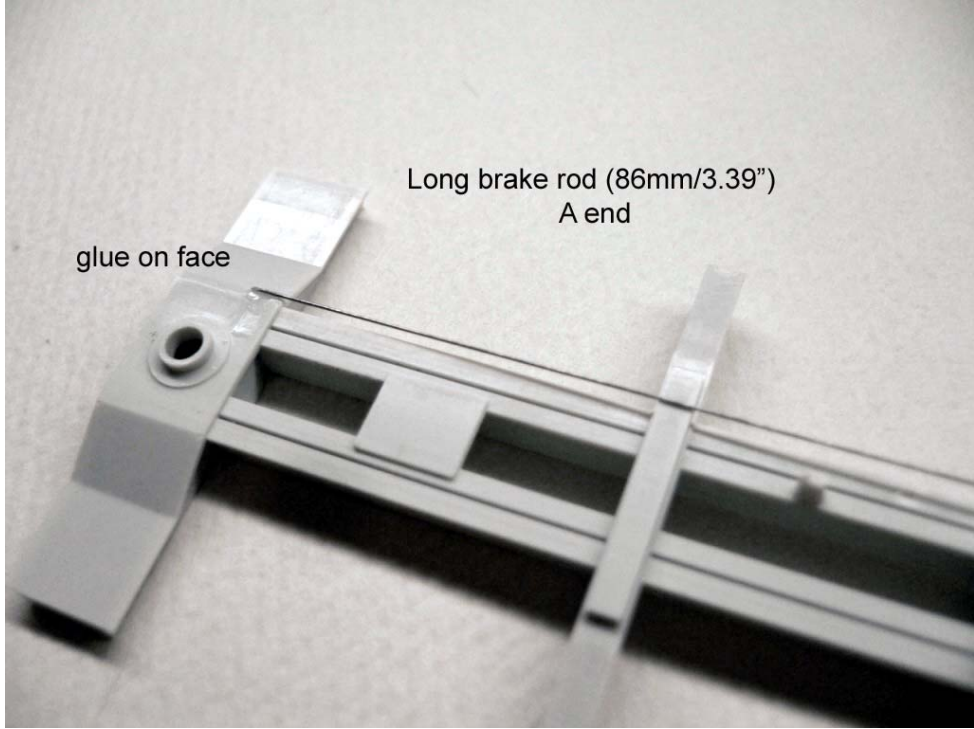
Pre-drill the Air cylinder and Air reservoir





Wire parts can be glued before or after the frame is glued to the floor

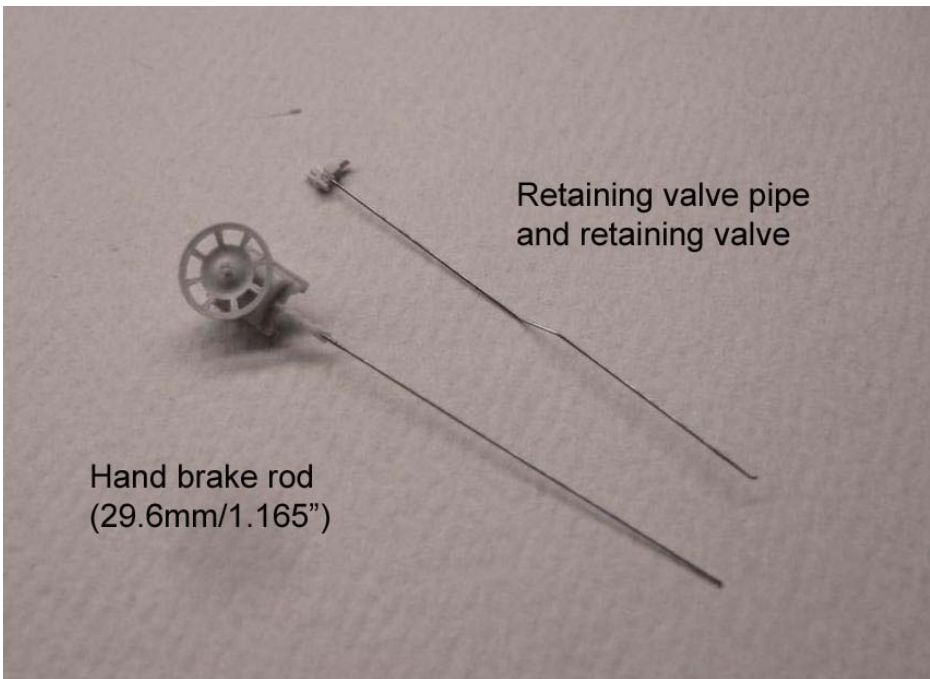




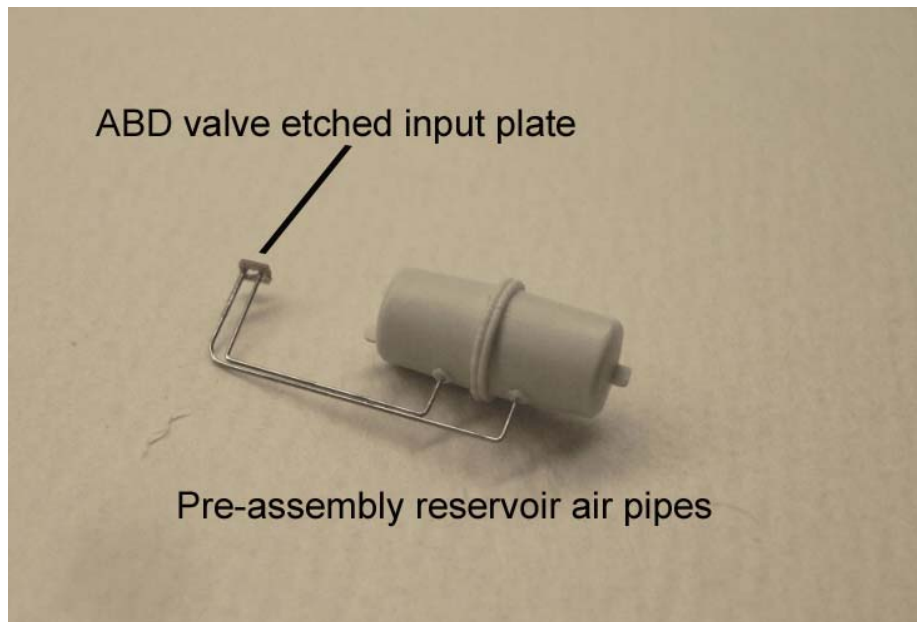
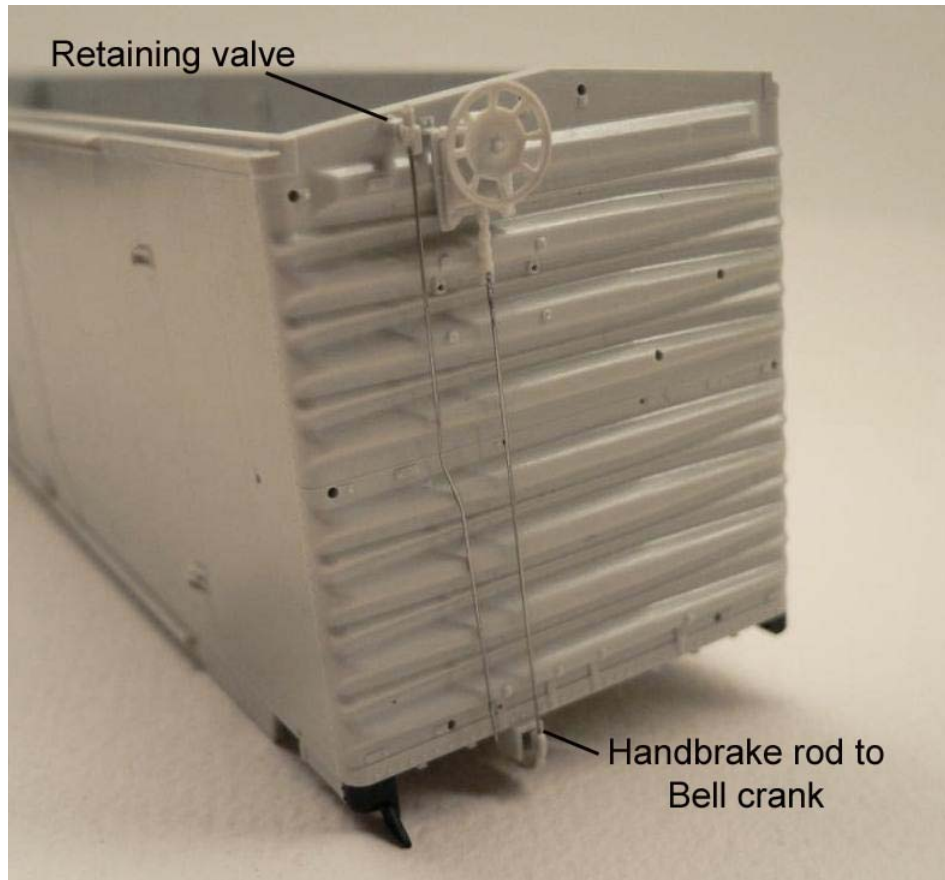
## High-mount brake plate to handbrake sub-assembly



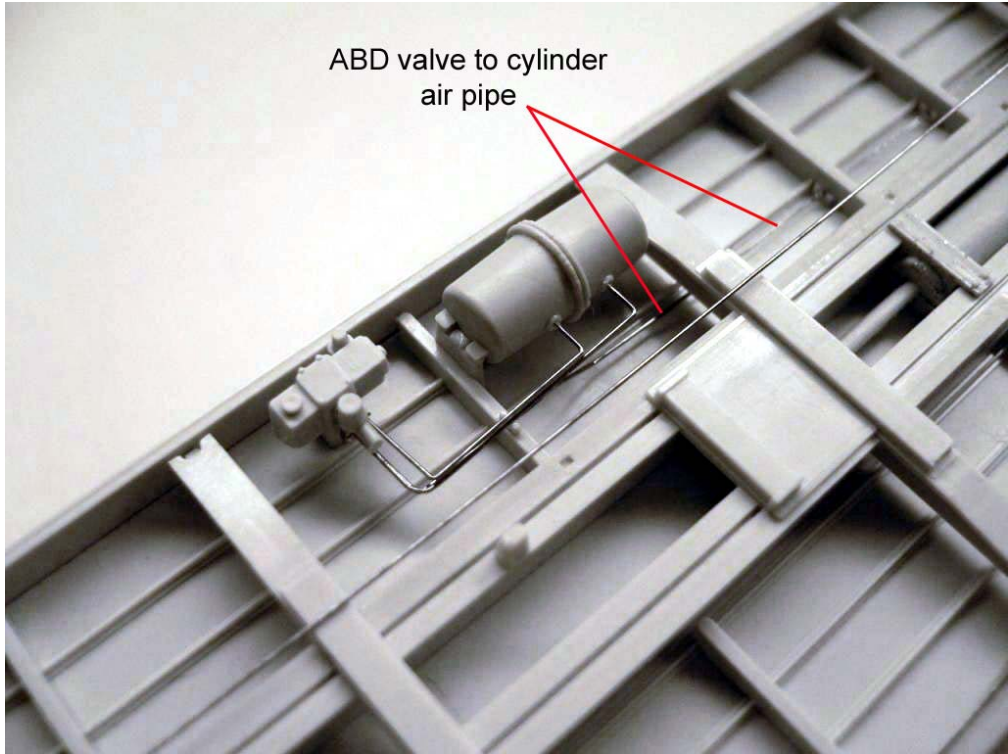
Pre-assemble wheel to handbrake, then to high-mount plate



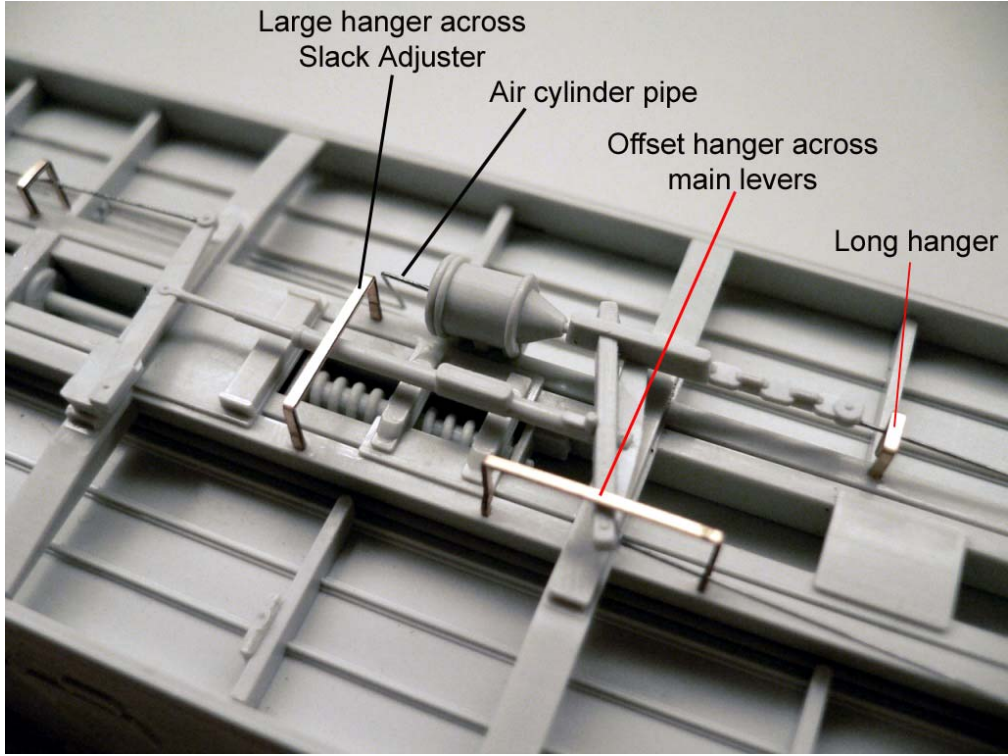
Pre-assemble wires to assemblies and parts



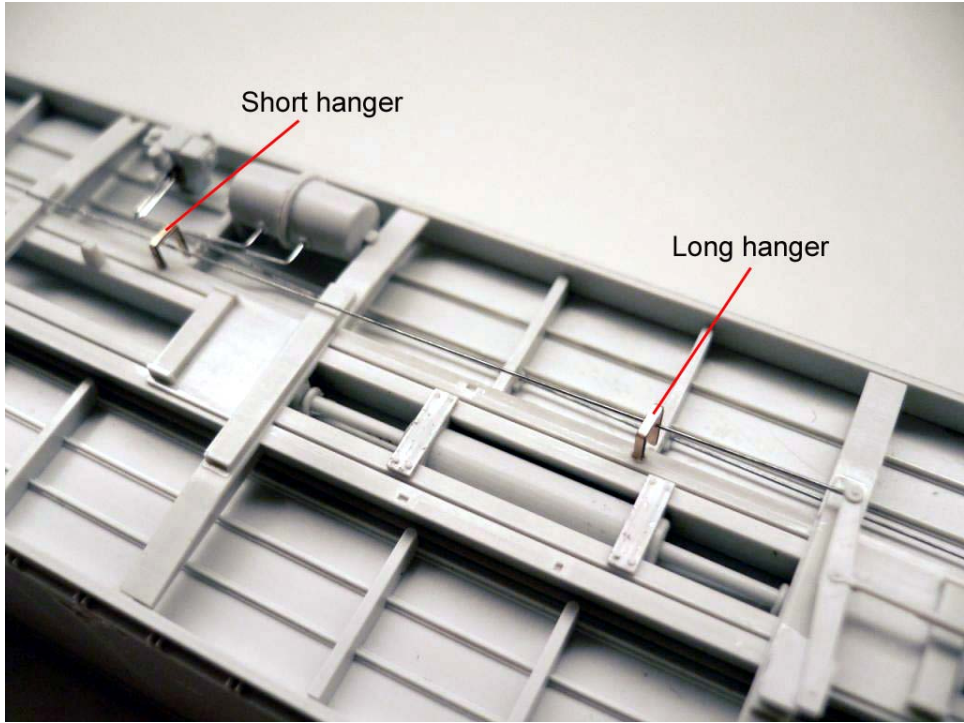




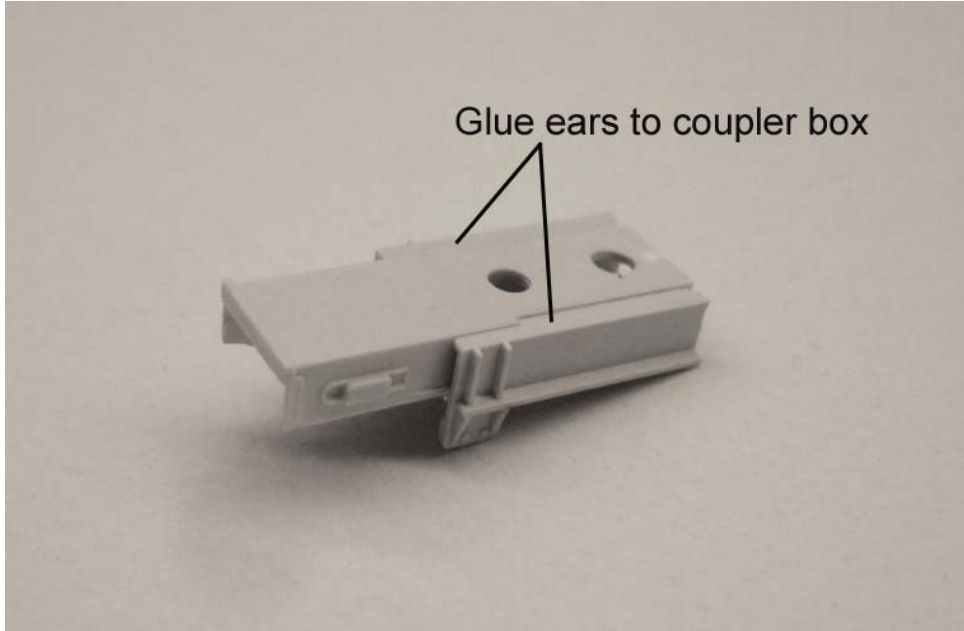
Glue ABD valve and Air reservoir



Bend and glue etched hangers

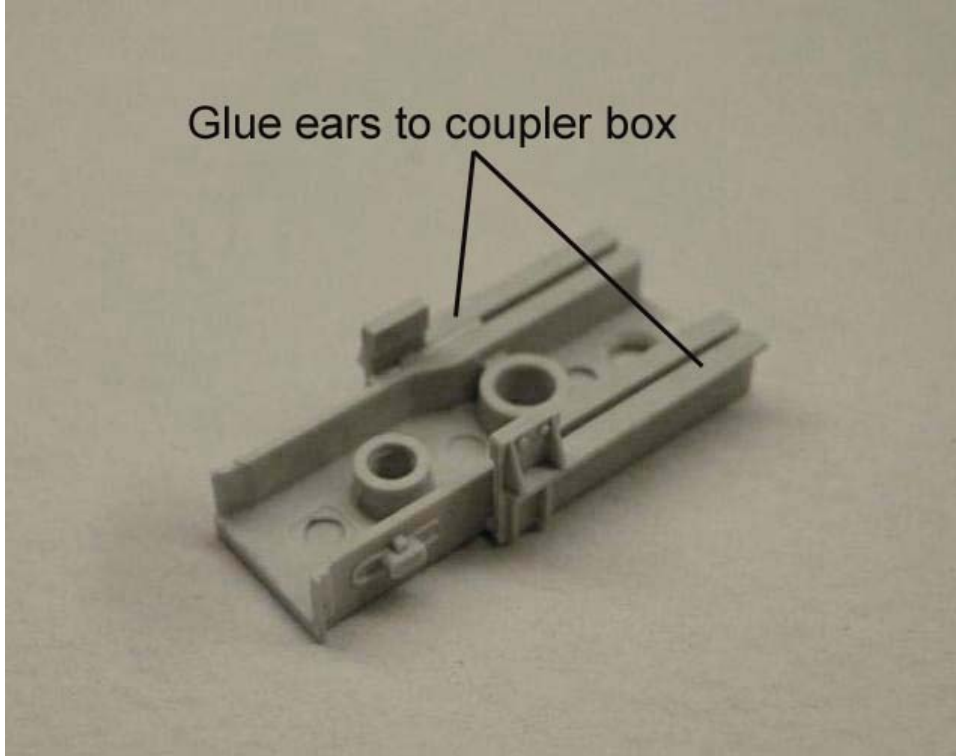


Bend and glue etched hangers

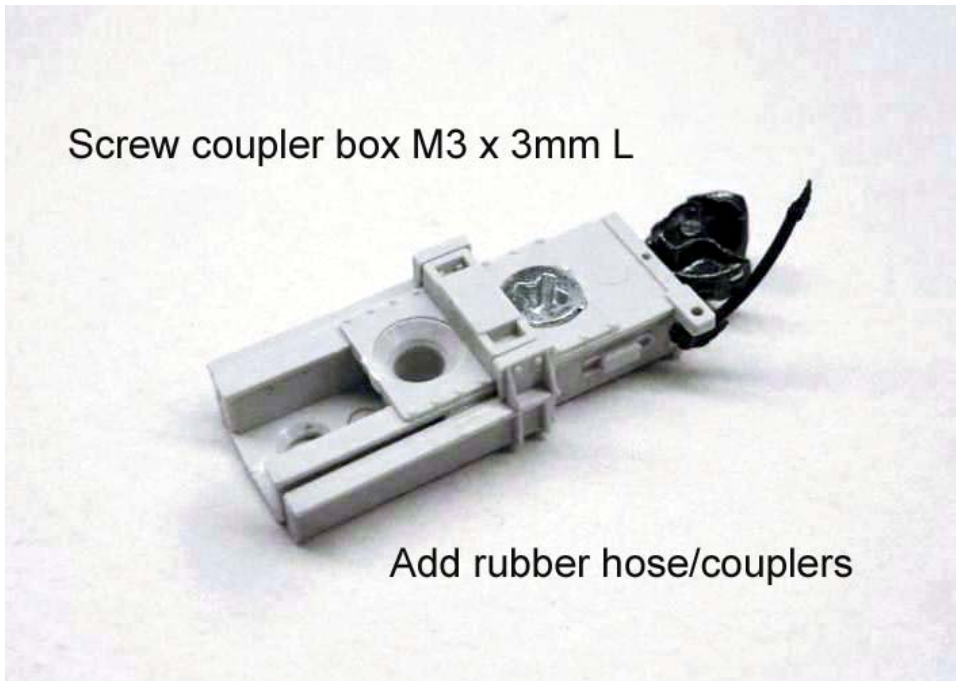


Pre-assemble "ears" (fixed sill) to main coupler box

Glue ears to coupler box

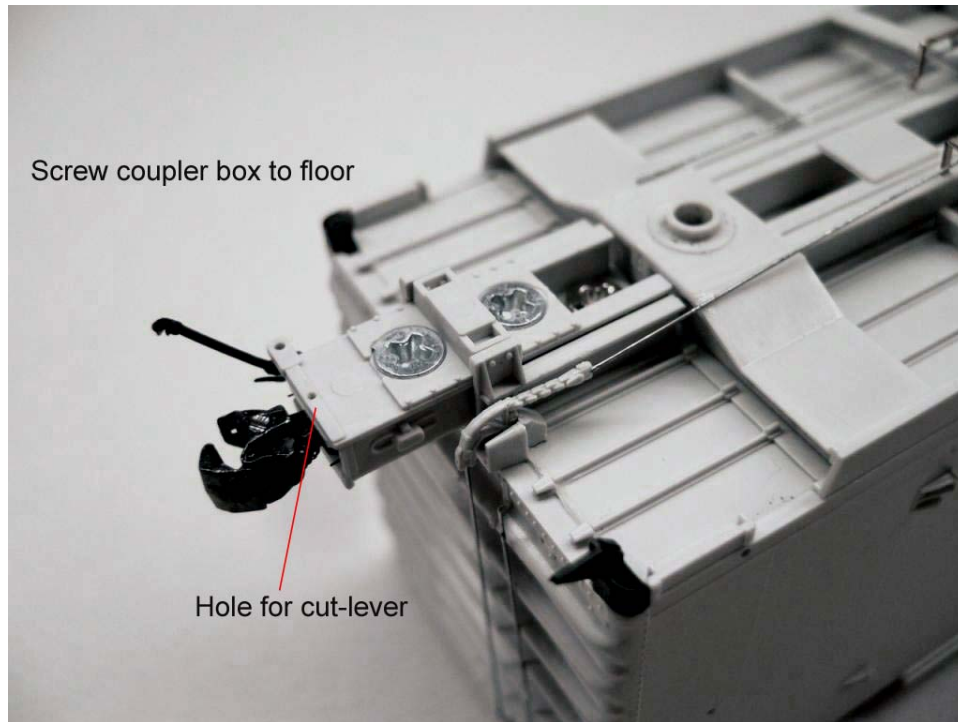


Screw coupler box M3 x 3mm L



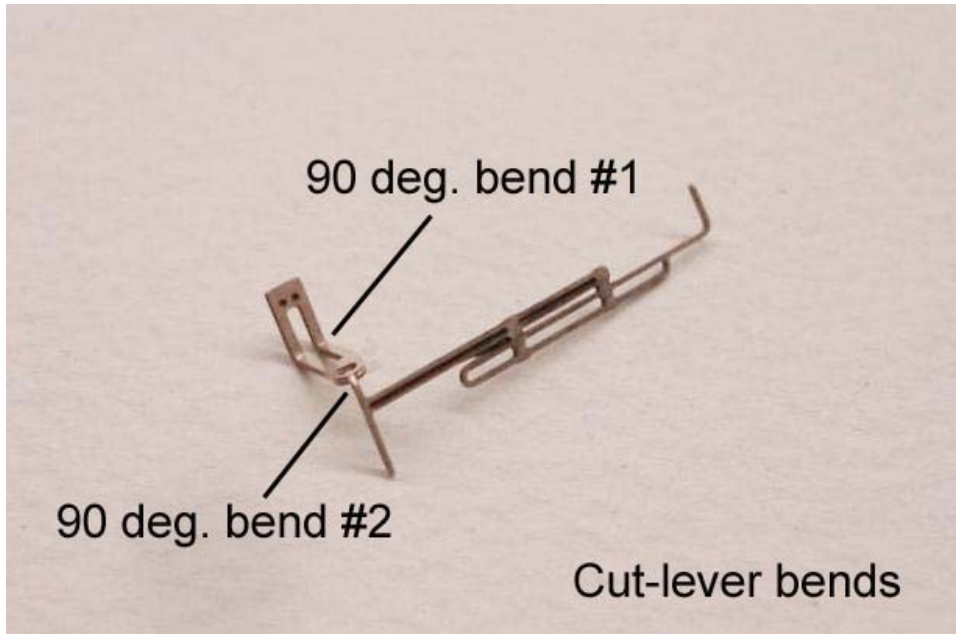
Add rubber hose/couplers

Pre-assemble coupler into coupler box, and the coupler can be removed for painting

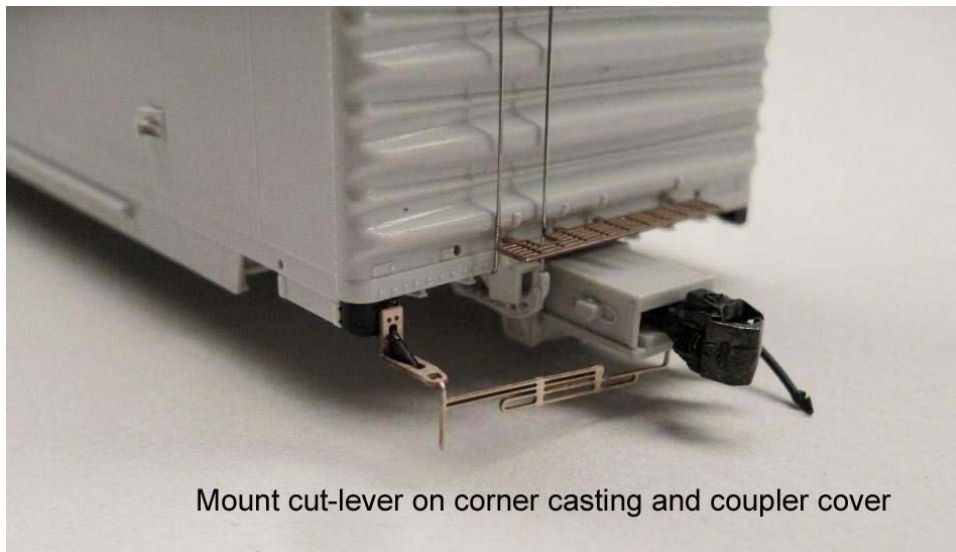


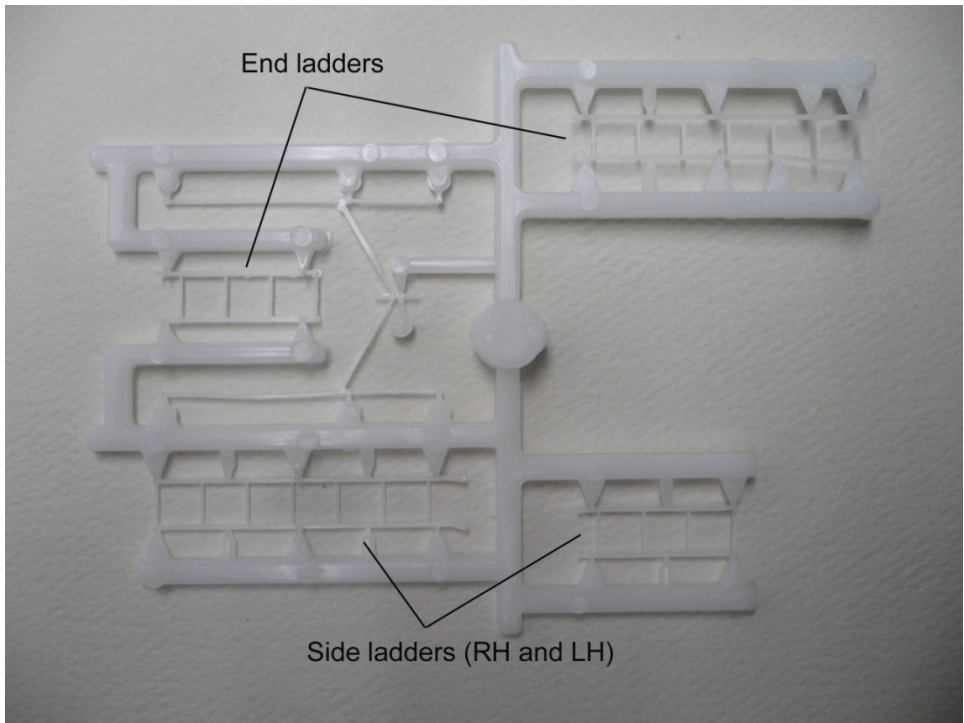
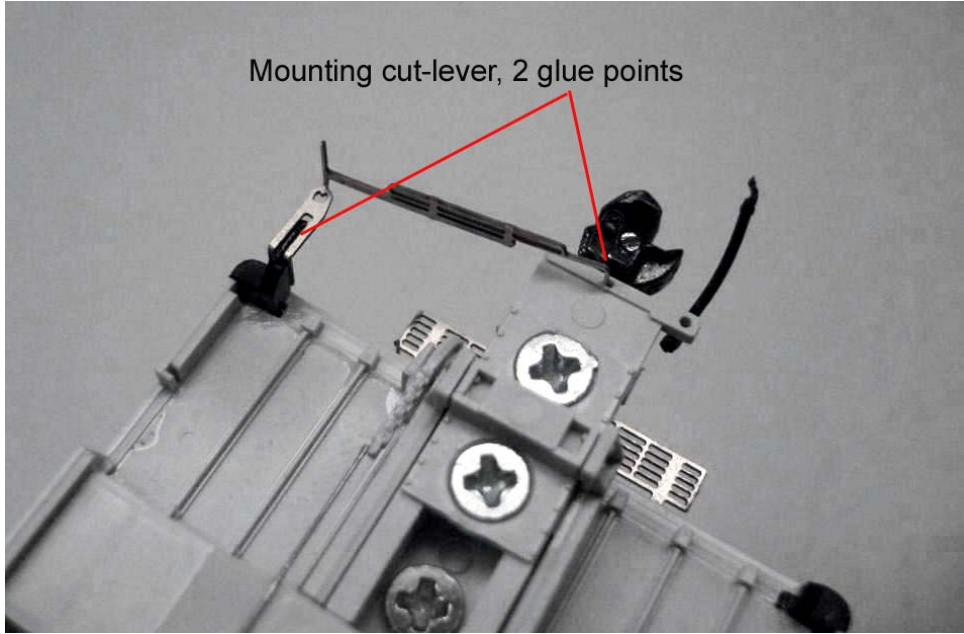
Drill end of coupler cover to accept cut-lever ends



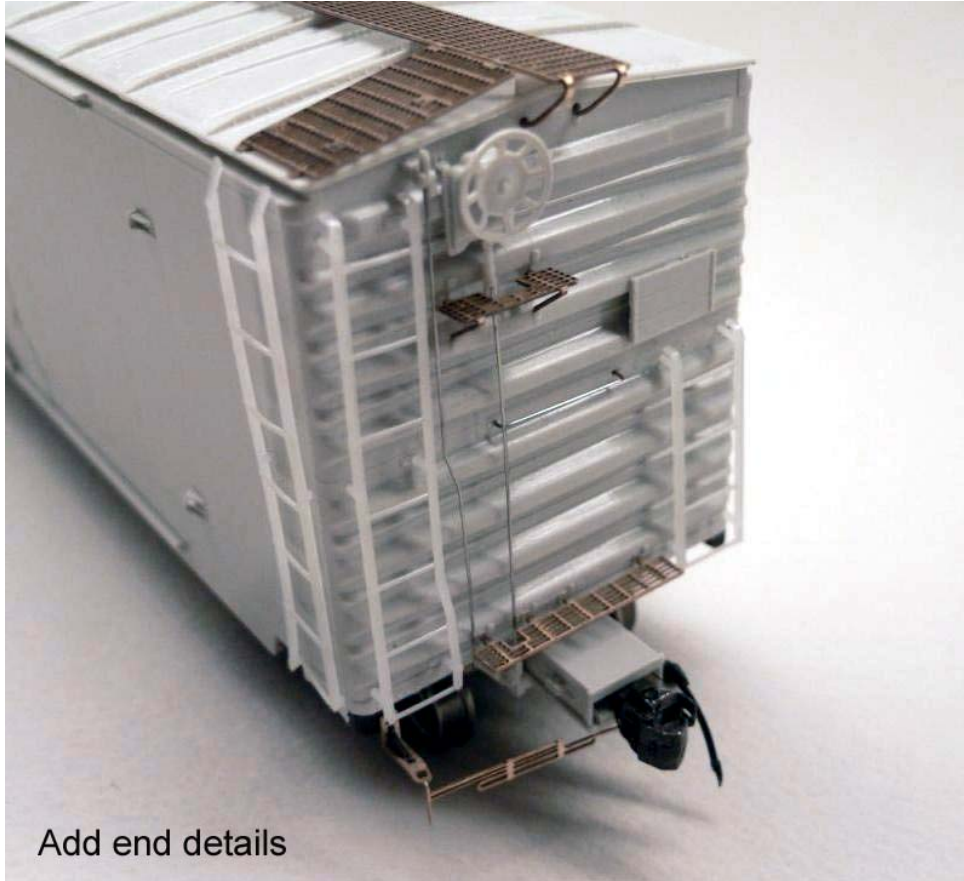


Pre-bend two locations at 90 degrees

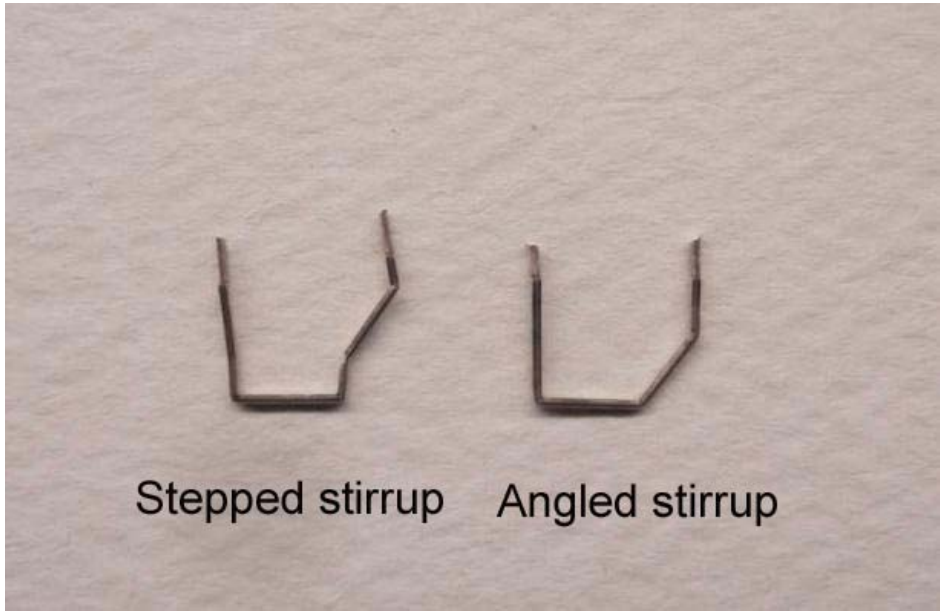




Identify ladder types, see photos for positions



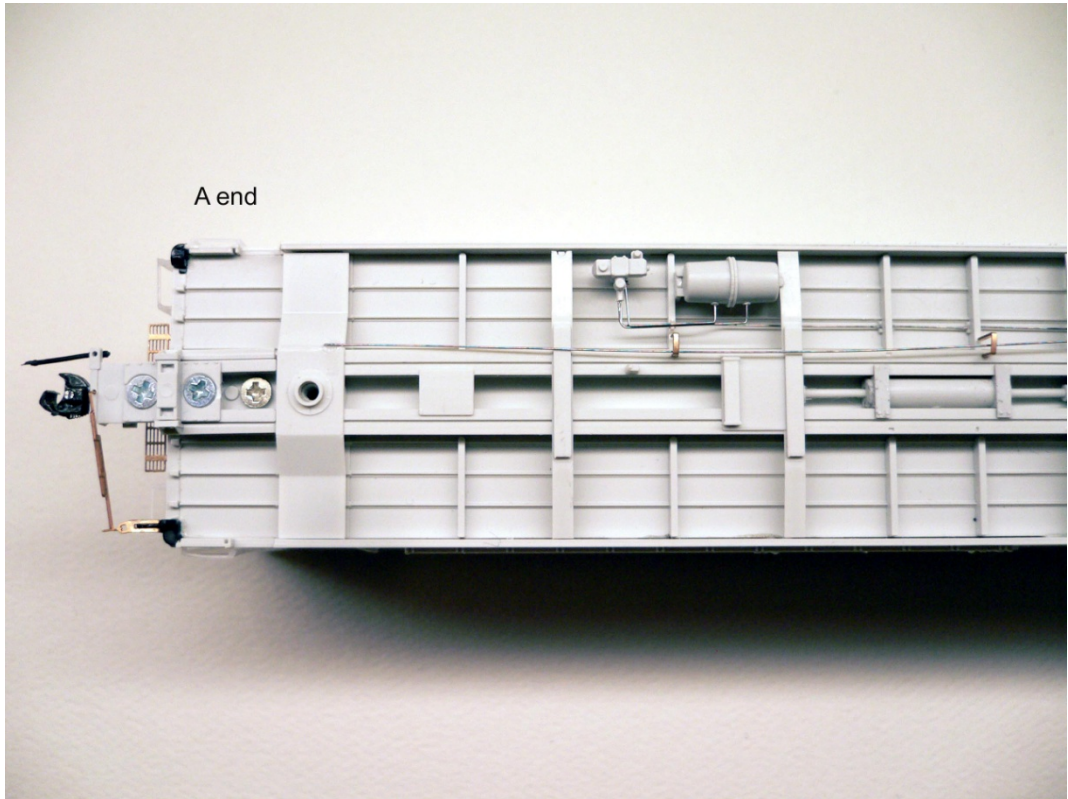
Add end details



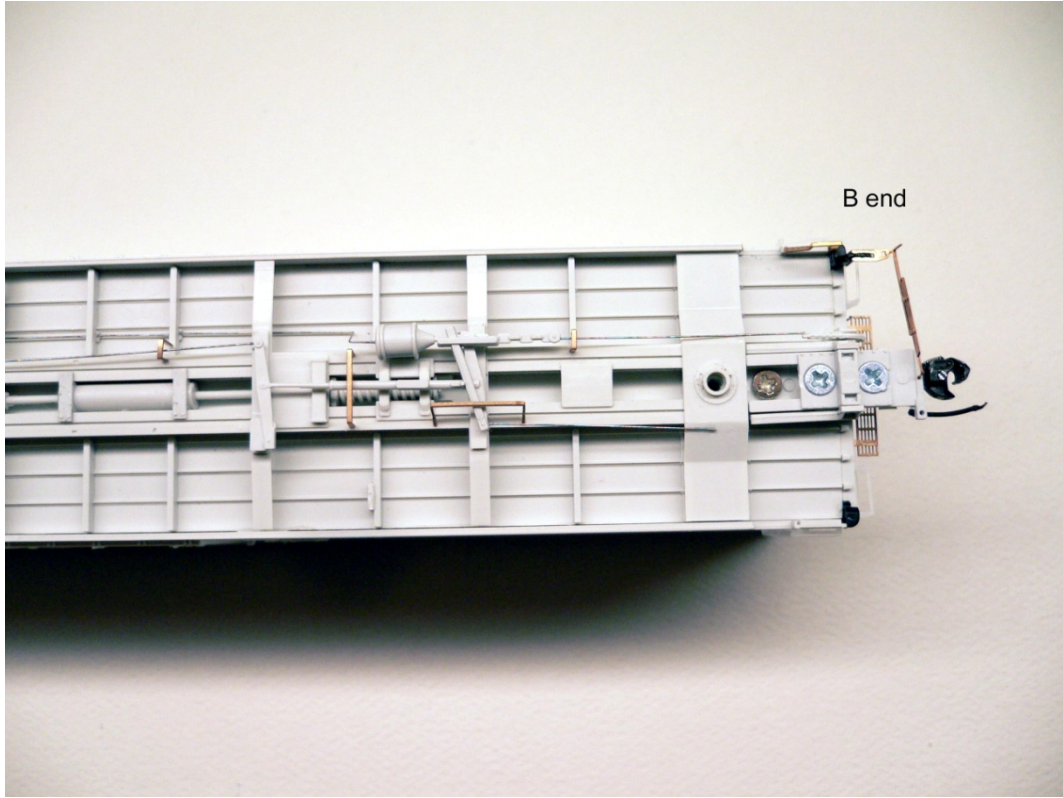
See railroad specifications for selection of the type of stirrups



Stirrups kink inward to fit Plate B clearance, there are RH and LH versions (RH shown)







Overview of all underbody details A and B ends

