ExactRail's Evans 5277 Single Door Box Car (Early) Undecorated Instructions

Thank you for purchasing an ExactRail Evans 5277 Single Door Box Car (Early) Undecorated Kit. We value your business and hope that these instructions help make the assembly of your model enjoyable. For more ExactRail Products, please visit us at **www.exactrail.com**.

Vocabulary:

For your convenience, we have identified the following terms with picture reference:

- A-End: Photo F
- B-End: Photo G
- Crossover Walk: Photo F&G
- Crossover Walk Railing: Photo F&G
- Door Track: Photo I
- Stirrups: Photo J
- Tack Board: Photo F&G

Contents:

The undecorated Evans 5277 Single Door Box Car (Early) kit consists of the following:

- Body Shell
- Roof
- Under Frame
- Weight
- Four small packages of detail parts
    1. One with ExactRail's Barber 70 Ton S-2 Trucks & CNC-Machined 33"Wheels.
    2. A second package contains various detail parts, including: stirrups, door details, crossover platforms, draft box lids and other injection molded parts.
    3. A third package includes all grab irons, wire parts, screws and Kadee® No. 5 Couplers.
    4. The fourth package includes two etched metal panels.

All parts are located within the body shell of the Evans 5277 Single Door Box Car (Early) kit. The roof should be removed gently to remove the parts.

Step 1: Underbody Detail

Weight:

The first item that is recommended to be added to the body shell is the weight. Having the weight in early will help minimize any damage to the separately added fine parts by handling the body shell.

a) Add a liberal amount of Gap Filling CA (Cyanoacrylate) glue to the inside floor of the body shell. Flexible cement, such as contact cement or Walther's GOO will work as well.
b) Very carefully insert the weight into the body shell, it should fit snugly between the two posts. Keep it as centered as possible between the two sides.
c) Set aside to allow the glue or cement ample time to cure.

Roof:

Once the glue that is holding the weight has cured, move forward and mount the roof into place.

d) Clean off any flash if needed.
e) Starting at one end of the body shell, insert the roof into the shell. Once it is in, work your way down the side until you reach the opposing end.
f) If needed, add a little plastic cement to fix the roof into place. Tamyia Extra Thin Cement and Ambroid Pro Weld are both recommended.

Under Frame:

The under frame of the box car needs to be placed in the proper direction. Two small posts have been molded into the under frame that will be received by two corresponding holes on the body shell.

g) In the center of the underbody, remove the body mold injection point. **(See Photo B)**
h) On the under frame, you will notice toward one end an L bend on the frame. Orient the under frame on the bottom of the body shell so the L is closer to the A-End of the body shell **(See Photo C)**
i) Clean off any flash with a hobby knife of file if needed.
j) With the frame properly oriented, insert the two posts into the corresponding holes. Fix it into place by adding plastic cement to the joints of the body frame and under frame.

At this point, it would be recommended to add the trucks to the car, this will make it so you can set the car down and not risk damaging the under frame details. Drop the trucks onto the collar at each end of the under frame. Add the two pan head screws with a small Phillips head screwdriver to fix the trucks into place.

Step 2: End Details

Multiple small details will be added to both ends. The ends have the same details applied to each other, the exception is the brake wheel and brake housing on the B-end.

A-End:

In one of the small packages are many small sprues with detail parts for the ends. Locate the sprues with the end ladders, crossover walk, crossover grab iron and tack board. **(See Photo F for placement of all items)**

End Ladders:

The body shell will require some minor modification to properly receive the included ladders. Some of the holes will need to be filled on the body and other holes will need to be drilled. **(See Photo F&G for location of all modifications)**

a) Fill in the inside upper holes with Squadron Green Putty or what item you prefer.
b) Carefully file down the sleeves that are molded around the two lower holes for each ladder.
c) Fill in the filed down holes with putty.
d) Clean off any excess putty and make sure surfaces are clean and smooth.
e) Remove the ladders from their sprue with and hobby knife. Clean off any flash if necessary.
f) There are three posts on the underside of the ladders. Using a hobby knife, carefully remove the bottom two posts. Do not remove the post on the end of the longer style.
g) Insert the remaining post into the single hole; the long style should be on the outside. **(See Photo F&G for placement)**
h) Ensure that the ladders styles are parallel to the car sides and then apply plastic cement to fix ladders into place.

Crossover Railing:

i) Prior to installing the crossover railing, a hole will need to be drilled to accept a loop eye that supports the railing.
j) Drill a hole with a #76 bit centered between the two tall styles on the ladders. Be sure to have the hole aligned with the holes on the tall styles that will receive the wire crossover railing.
k) Remove a loop eye from the sprue that also includes the brake wheel. There are four included on the sprue but only two will be used.
l) Insert a loop eye into the drilled hole and cement into place. Allow cement to cure before moving onto the next step.
m) Locate the long .012" wire in the bag of wire parts and couplers.
n) Feed one end through the loop eye and insert each end into the holes on the ladders. Glue into place with CA glue.

Tack Board & Platforms:

o) Locate the sprue with the tack boards and remove one.
p) Insert into the two holes that are near the right ladder, apply cement to fix in place.
q) In the package, there are two crossover walks included, one for each end, however one has an opening. Acquire the crossover walk without the opening and insert it into the four paral lel holes at the bottom of the A end.
r) Apply plastic cement to fix it into place.

B-End:

For the B-end, you will need to repeat all of the A-end steps; however you will need to add the brake housing and the brake wheel. **(See Photo G for placement of all items)**

s) Repeat steps a - p on the B-end of the car.
t) Locate the brake housing and remove it from the sprue. Remove any flash if needed.
u) Insert it into the remaining hole on the B-end of the car. Apply cement to secure the piece in place.
v) On the same sprue as the brake housing is the brake wheel. Remove it from the sprue and clean off any flash.
w) Insert it into the hole on the brake housing and apply cement.
x) Insert the crossover walk with the opening into the four parallel holes.
y) Apply plastic cement to fix it into place.

Step 3: Door Detail

Doors:

The doors of the car have a separately applied door track and depending on the prototype being modeled, an etched brass plate to be applied to the door.

Extra care must be taken when handling the door tracks because they can be very fragile. Also the door tracks can be warped on the sprue slightly; this will not be visible when glued in place. Do not try to bend them back into shape as they will break. Also there are extra parts on the sprue that will not be used on this model. **(See Photo I for part placement)**

Door Tracks:

a) Locate the sprue with the two door tracks and remove all pieces. Clean off any flash if needed, use care as not to damage part.
b) On the back of the tracks are four posts that are inserted into holes on the sill of the car. Apply cement and add some pressure if door track is slightly warped.
c) Add a door track to the opposite side of the car in the same manner.

Grab Irons and Stirrups:

A sprue is located in the package of various parts has the four stirrups that will be needed for this stage. There are sixteen grab irons located in the package of irons. Four will be placed at each end of the cars side. **(See Photo K)**

a) Remove the four stirrups from their sprue. Clean off any flash if needed.
b) Apply a small amount of cement to the two holes on the sill. Insert the two posts on the stirrups into the holes. Ensure that the stirrups are vertical and not bent in or out.
c) At each end of the car, insert four grab irons into the holes. Add a small amount of CA glue to each end of the grab irons to secure them into place.
d) Repeat on the other three sides to complete all grab irons.

Step 4: Couplers and Final Details

Couplers:

The couplers used on this car are Kadee No. 5's. They are located in the package that contained the wire parts. In this package you will need the couplers, bronze centering springs and screws. In the package that contained the miscellaneous parts will be the draft gear lids.

a) Insert the bronze centering spring into the draft gear box.
b) Drop in the Kadee #5 coupler into the draft gear box. Add the lid and then secure everything into place with the included screws.

This Completes your ExactRail Evans 5277 Single Door Box Car (Early) Undecorated Kit. Thank you again for having purchased from us. We hope that the assembly of this model was a pleasure. Please look forward to all the latest ExactRail products and announcements by visiting us online at **www.ExactRail.com**.

For any questions or concerns, please contact us at info@exactrail.com or by calling at **1-866-945-1701**.

Photo A: Under Frame

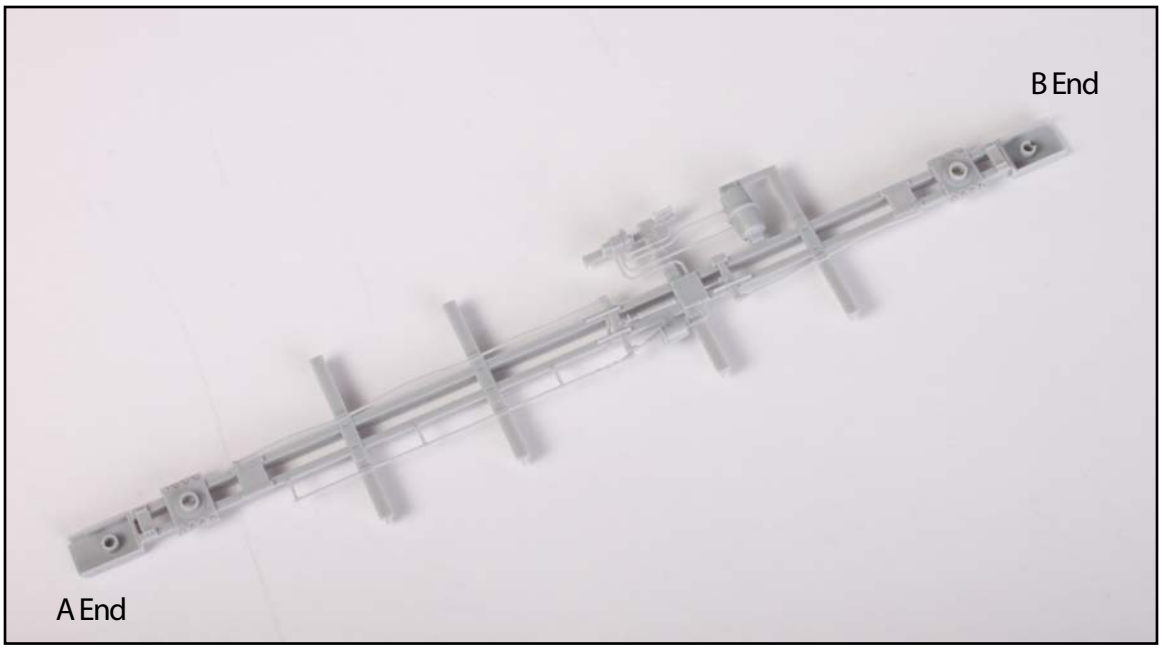


Photo B: Under Body Without Details

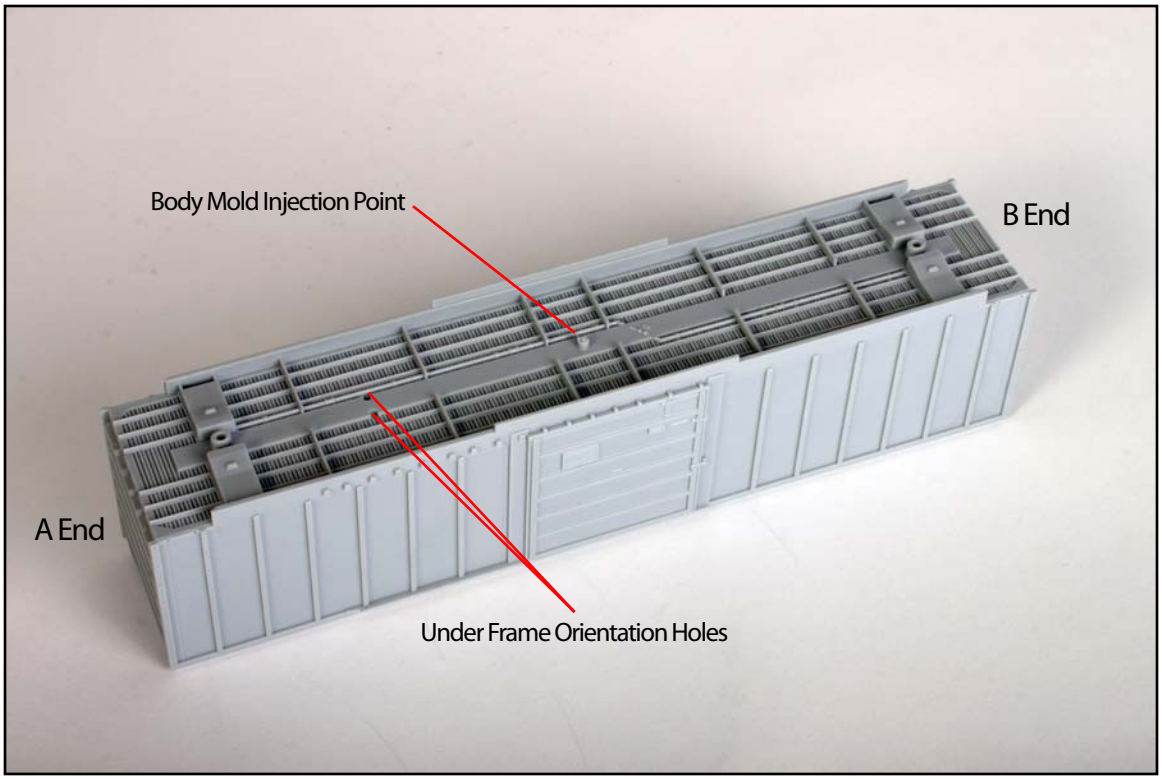


Photo C: Under Body With Details

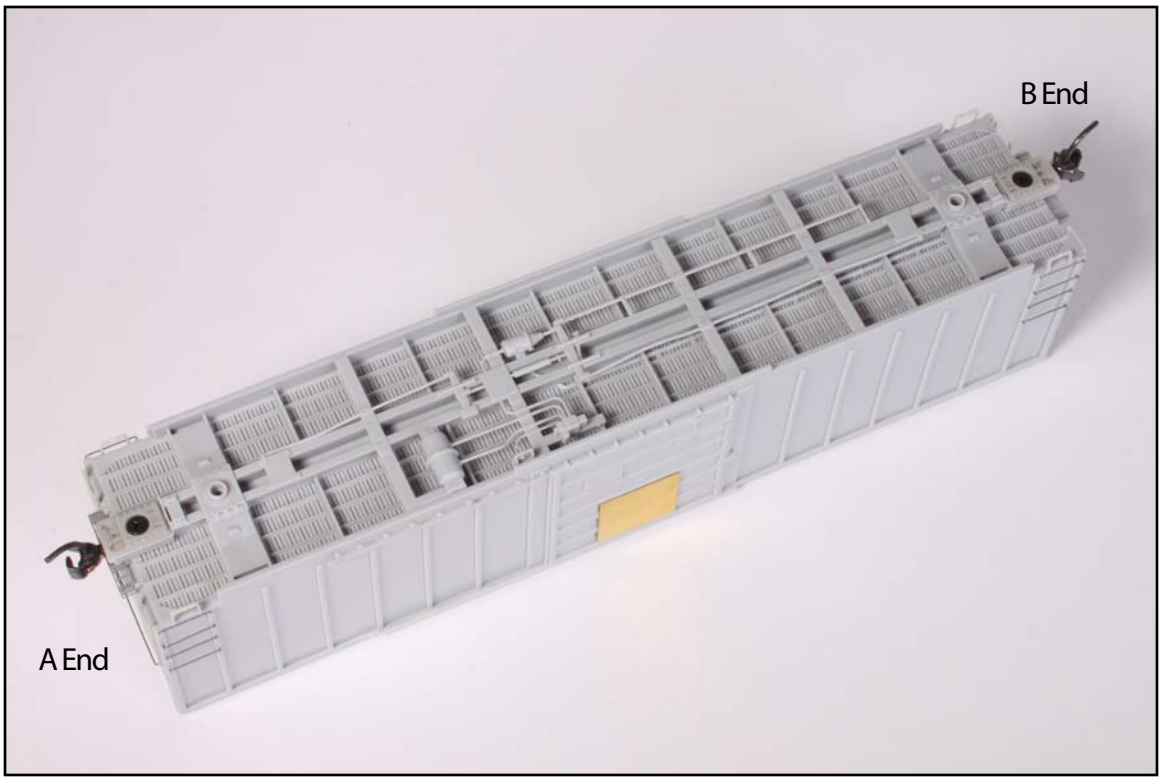


Photo D: End Ladder Sprue

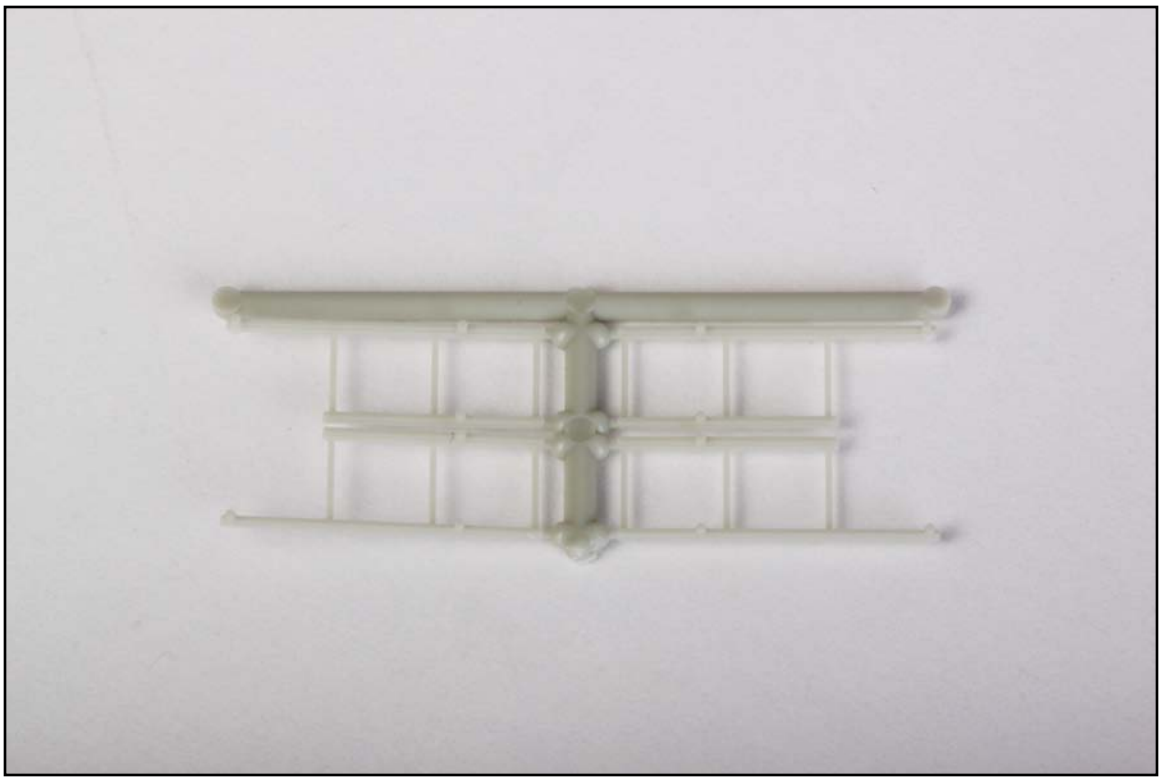


Photo E: Brake Rigging Sprue

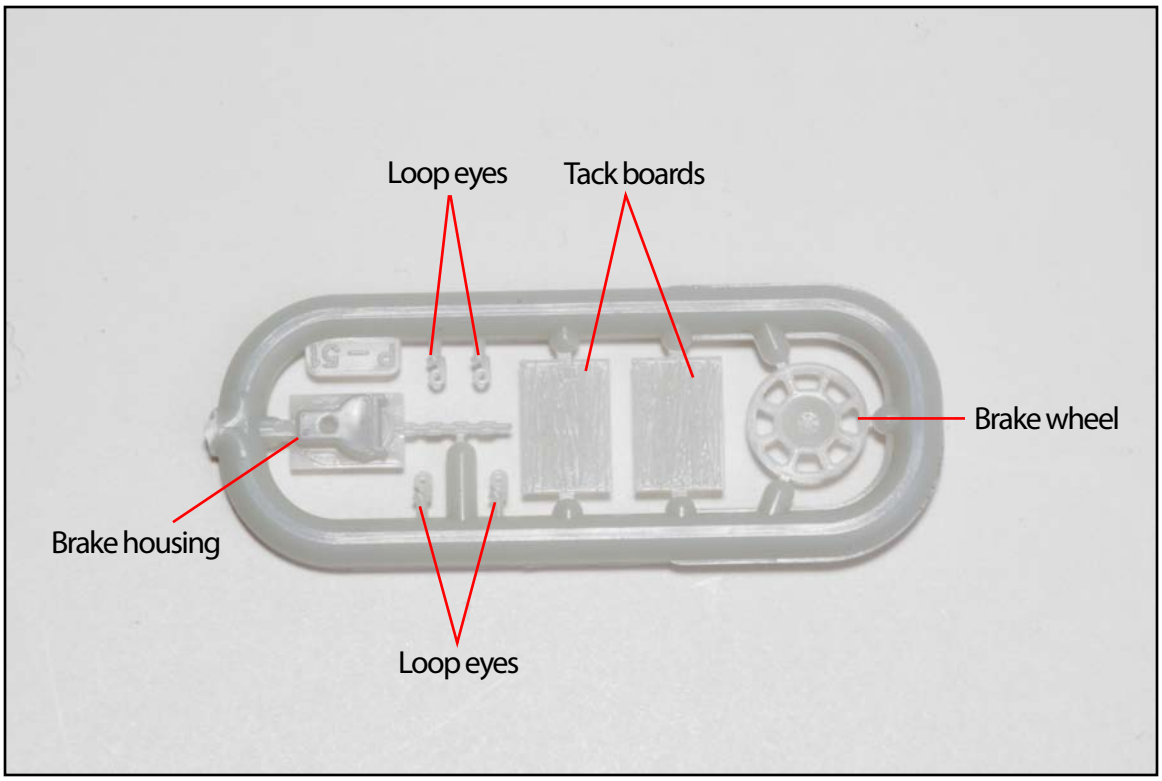
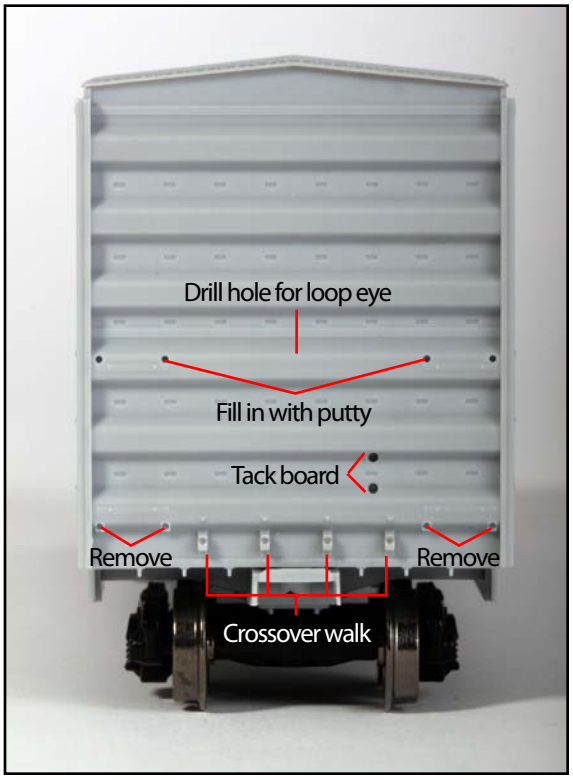


Photo F: A Ends



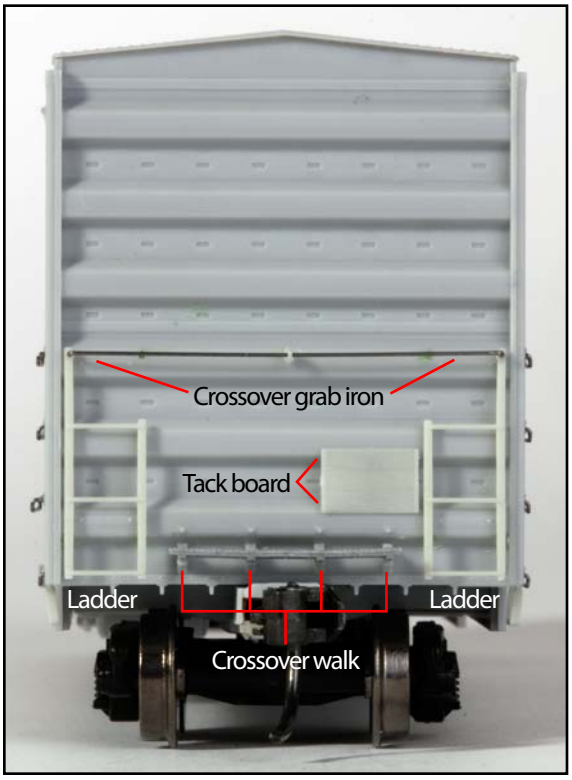
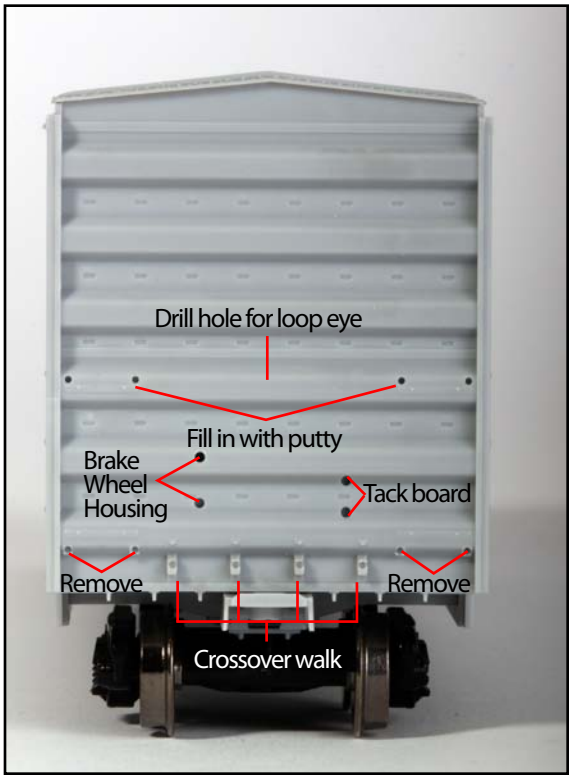


Photo G: B Ends



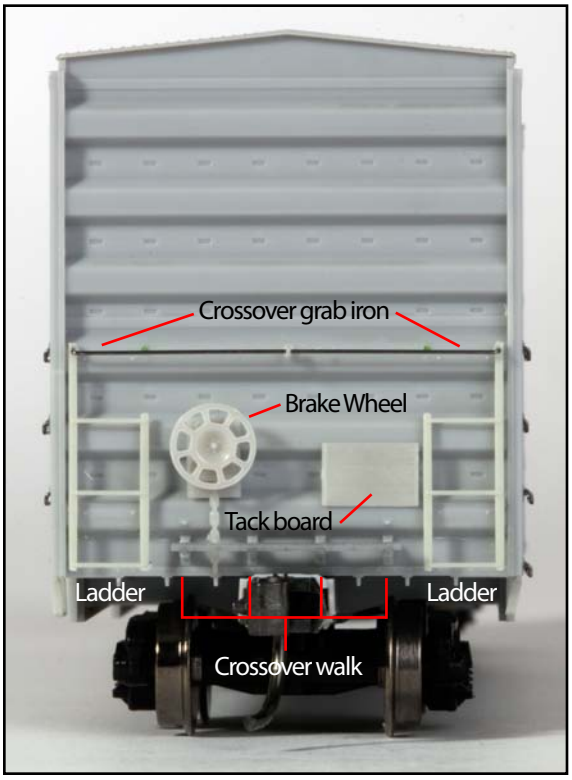


Photo H: Door Track Sprue

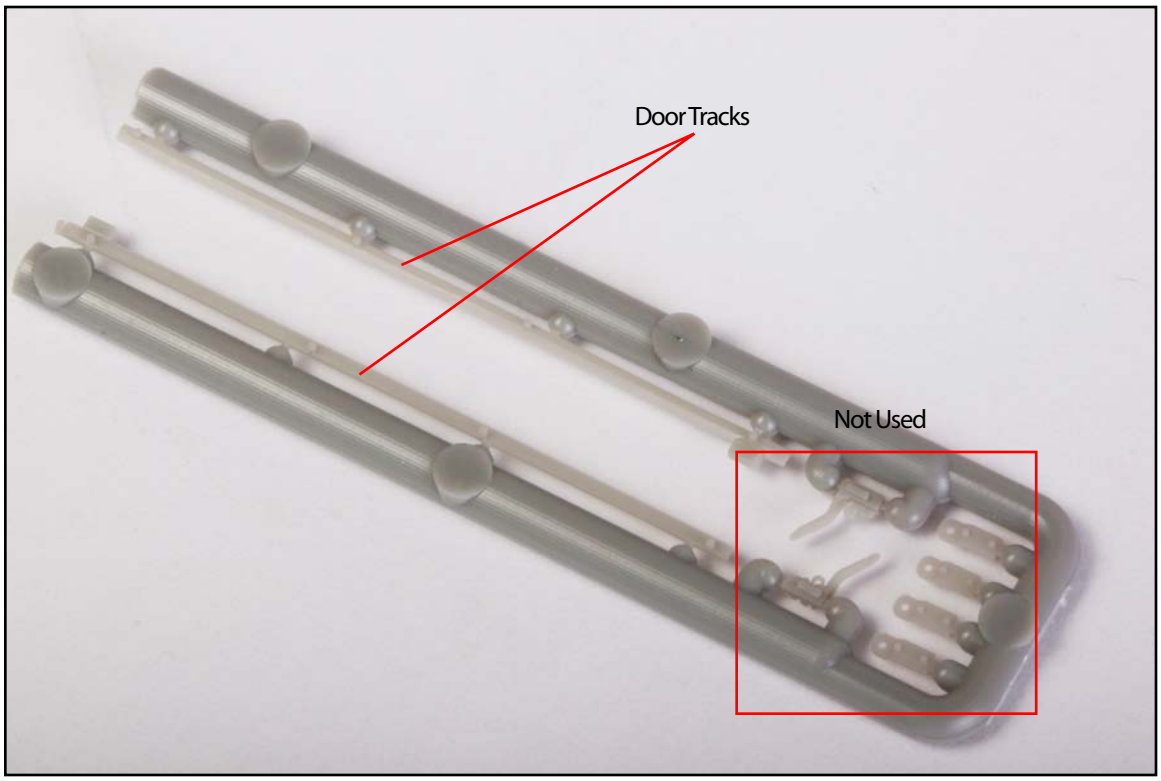


Photo I: Door Bar Sprue

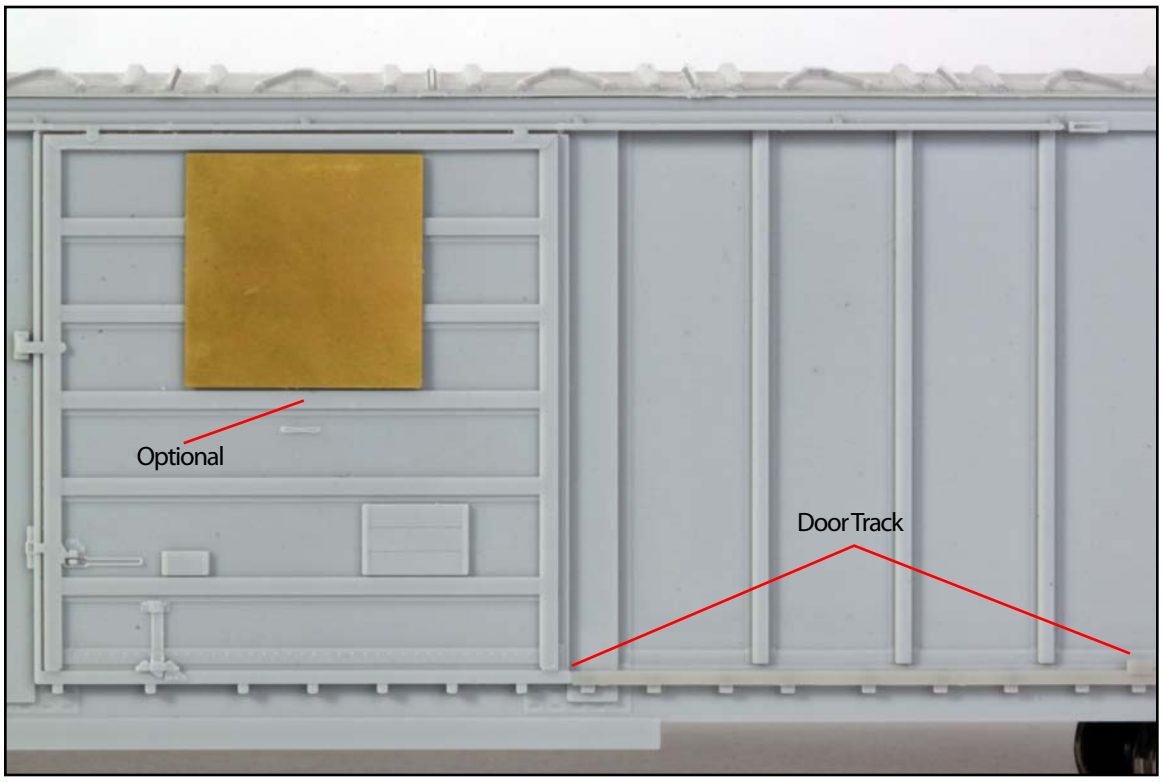


Photo J: Stirrup Sprue

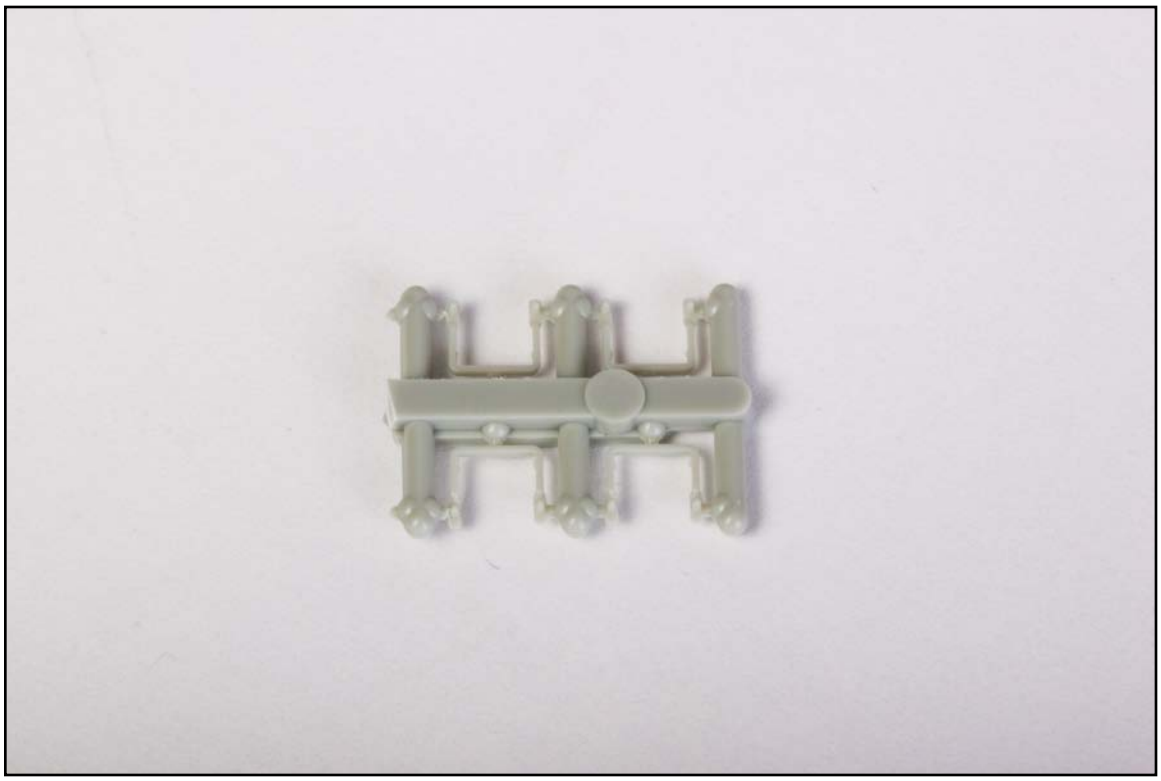


Photo K: Grab Irons & Stirrups

Completed Evans-USRE 5277 Box Car (Early)