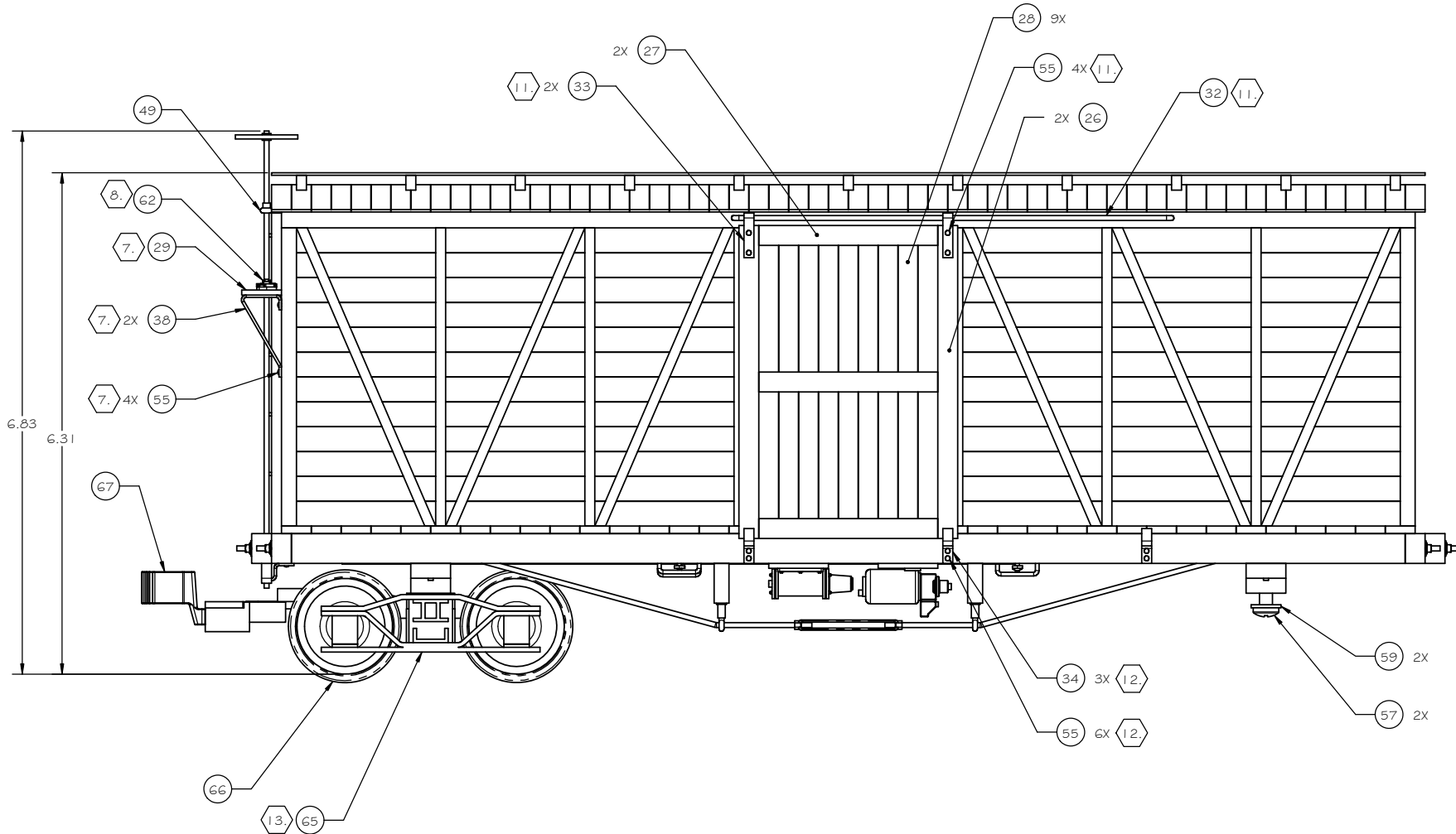
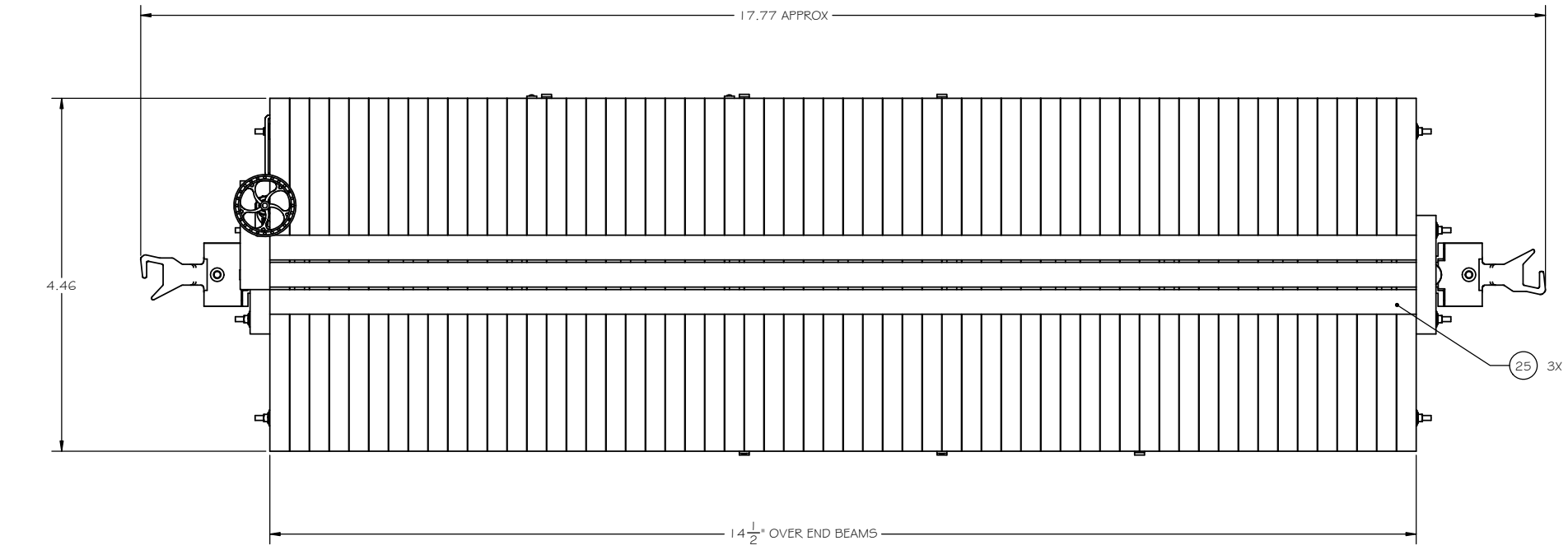
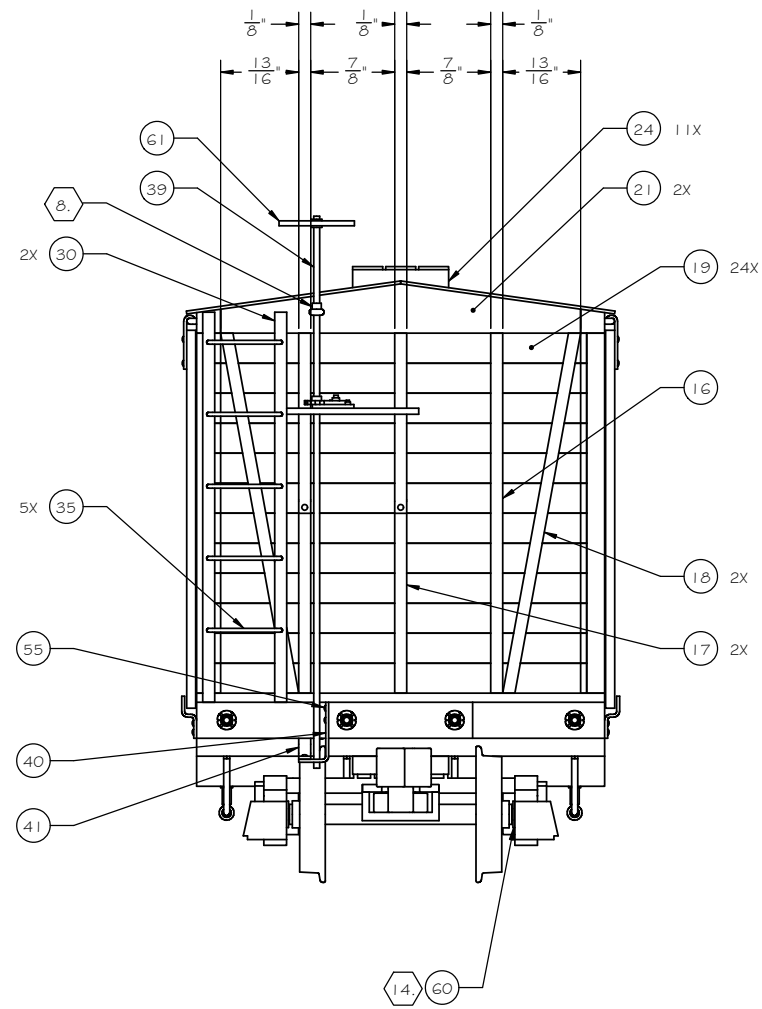




# SUGGESTED ASSEMBLY INSTRUCTIONS

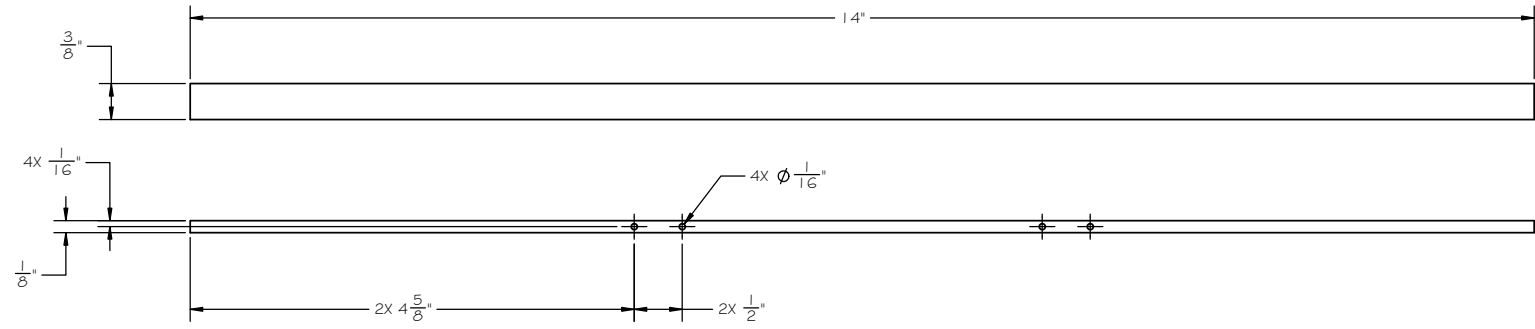
1. FIND NUMBERS 42 THRU 47 (BRAKE ROD TRUCK, BRAKE LINK ROD, BRAKE WHEEL ROD, BRAKE RIGGING SHORT LEVER, BRAKE RIGGING LONG LEVER, AND BRAKE RIGGING SUPPORT), FIND NO 63 (K VALVE MASTER) AND FIND NO 62 (K VALVE SLAVE) MAY BE ELIMINATED IF BRAKE RIGGING DETAIL IS NOT DESIRED.
2. ASSEMBLE MAIN FRAME COMPONENTS FIND NUMBERS 1 (SIDE SILL), 2 (INTERMEDIATE SILL), 3 (CENTER SILL LEFT), 4 (CENTER SILL RIGHT), 5 (END BEAM), AND 6 (BUFFER BLOCK) USING A GOOD QUALITY WOOD GLUE.
3. ASSEMBLE FIND NUMBERS 7 (BODY BOLSTER) AND 8 (KING PIN BLOCK) SEPARATELY. AFTER GLUE HAS COMPLETELY DRIED, DRILL 1/4" HOLE AS SHOWN. INSTALL FIND NUMBER 56 (TAPPING INSERT FOR WOOD) IN 1/4" HOLE WITH SCREW DRIVER SLOT LOCATED ON FIND NUMBER 7 SIDE OF ASSEMBLY. COATING THE HOLE WITH THICK CA PRIOR TO INSTALLING THE TAPPING INSERT WILL SECURE IT IN PLACE PERMANENTLY. LOCATE AND INSTALL ASSEMBLY ON FRAME.
4. ASSEMBLE FIND NUMBERS 48 (QUEEN POST TUBE), 49 (COTTER PIN, NEEDLE BEAM) AND 58 ( WASHER, FLAT) AND SOLDER TO MAKE A QUEEN POST (8 REQUIRED).
5. SLIP ONE EACH QUEEN POST ASSEMBLY AND FIND NUMBER 50 (COTTER PIN, BOLSTER) ON TO EACH FIND NUMBER 36 (TRUSS ROD OUTER) AND 37 (TRUSS ROD INNER). SLIP TRUSS RODS THROUGH HOLES IN END BEAMS AND BUFFER BLOCKS. INSTALL COTTER PINS IN MATING HOLES IN BOLSTER AND NEEDLE BEAM SECURING WITH THICK CA.
6. ASSEMBLE FIND NUMBERS 40 AND 41 (BRAKE STAFF SUPPORT) USING FIND NUMBER 55 (CARRIAGE BOLT) AND CA CEMENT. LOCATE ASSEMBLY IN CORNER OF END BEAM AND BUFFER BLOCK, MATCH DRILL .031 (#68) HOLES FOR FIND NUMBER 55 (CARRIAGE BOLT) AND SECURE USING THICK CA.
7. INSTALL FIND NUMBER 38 (BRAKE PLATFORM SUPPORT) TO FIND NUMBER 17 (BRAKE) PLATFORM POST) USING FIND NUMBER 55 (CARRIAGE BOLT) AND THICK CA. SECURE FIND NUMBER 29 (BRAKE PLATFORM) TO BRAKE PLATFORM SUPPORTS USING THICK CA.

FOR CONTINUATION SEE SHEET 3

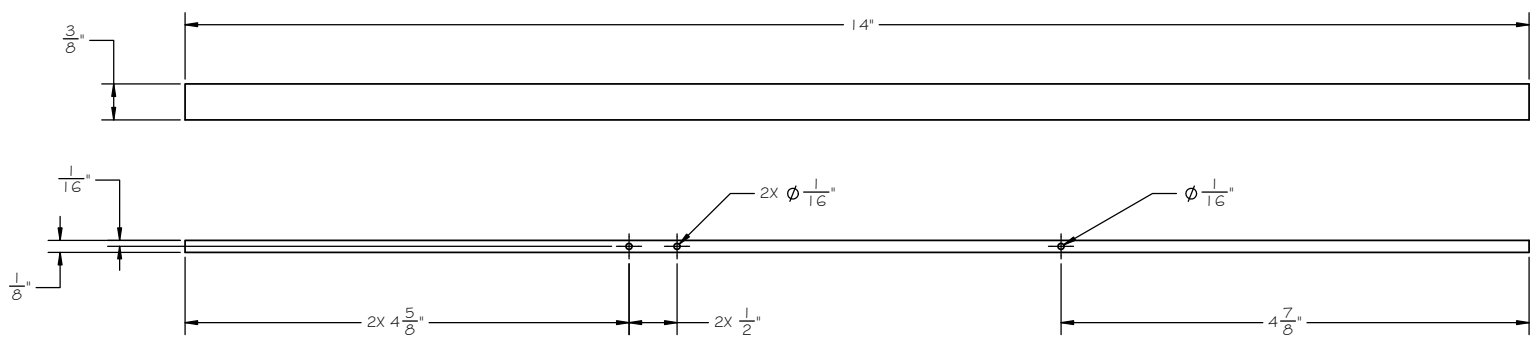


TITLE			
OUTSIDE BRACED BOX CAR			
SIZE	CAGE CODE	DWG NO.	REV
D	-	GR Plan Set 44	-
SCALE	NONE	UNIT WT.	SHEET 2 OF 7

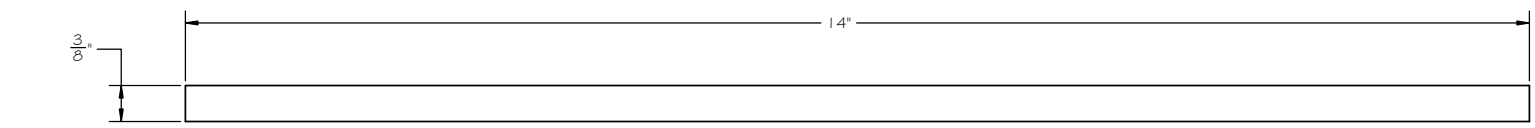




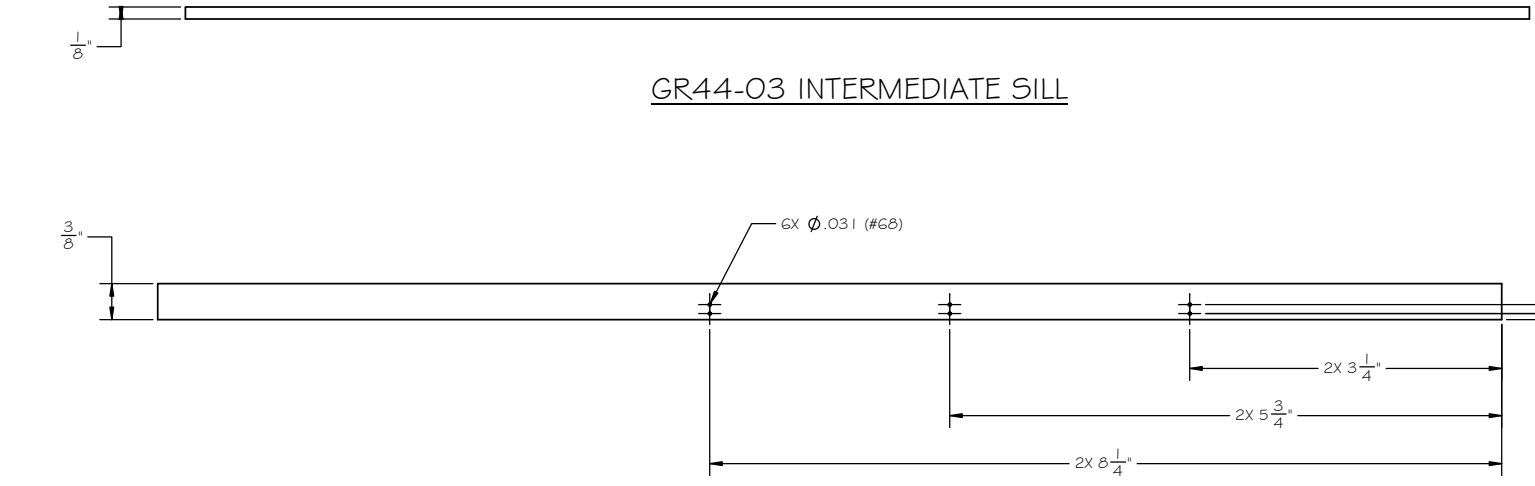
GR44-01 CENTER SILL, LEFT



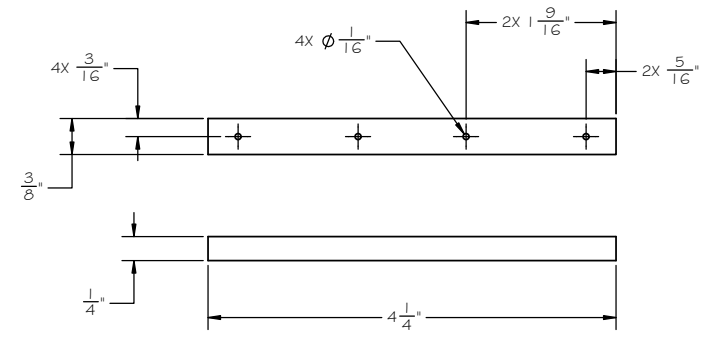
GR44-02 CENTER SILL, RIGHT



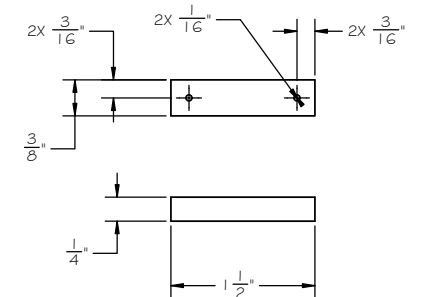
GR44-03 INTERMEDIATE SILL



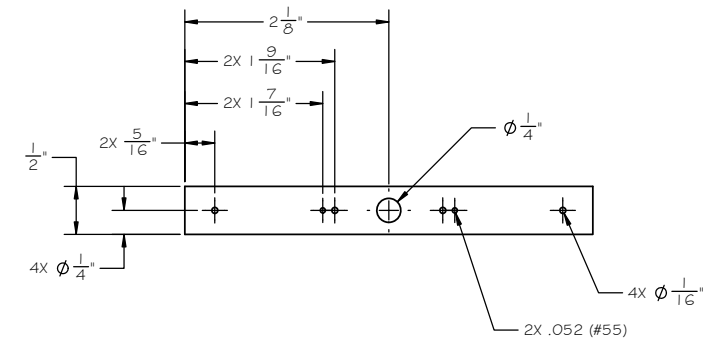
GR44-04 SIDE SILL



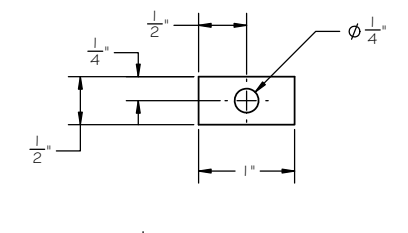
GR44-05 END BEAM



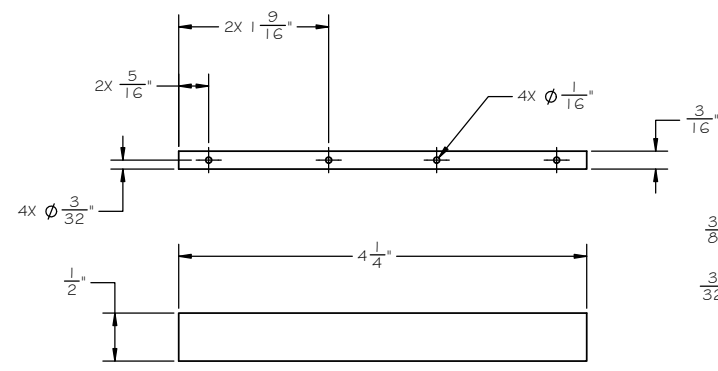
GR44-06 BUFFER BLOCK



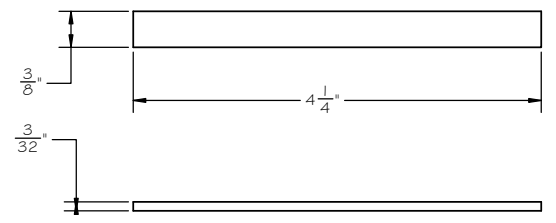
GR44-07 BODY BOLSTER



GR44-08 KING PIN BLOCK

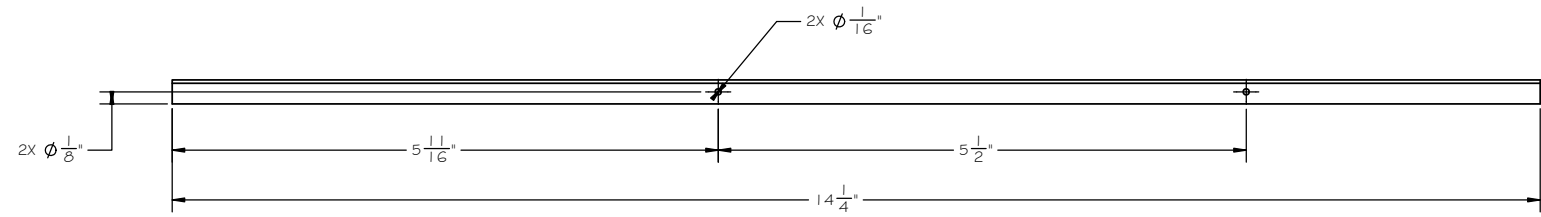


GR44-09 NEEDLE BEAM

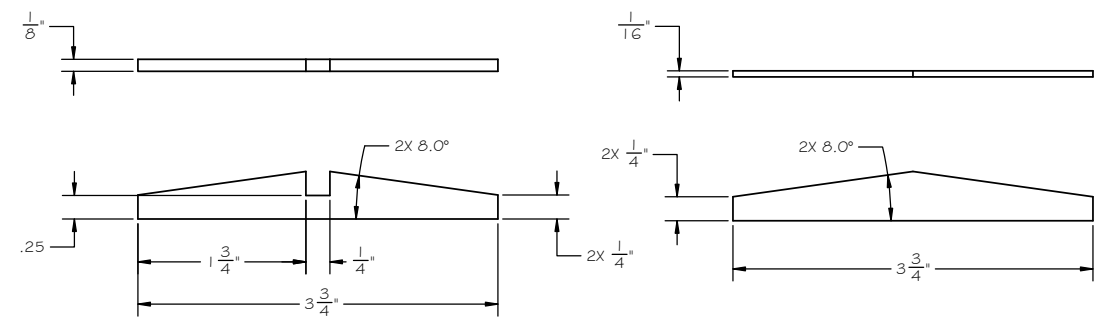


GR44-10 DECK PLANK

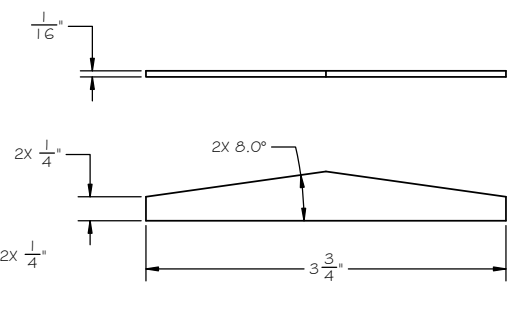
TITLE			
OUTSIDE BRACED BOX CAR			
SIZE	CAGE CODE	DWG NO.	REV
D	-	GR Plan Set 44	-
SCALE	NONE	UNIT WT.	SHEET 4 OF 7



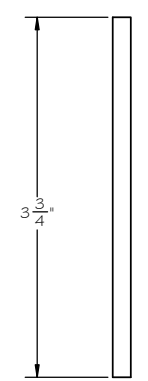
GR44-11 SIDE HEADER BEAM



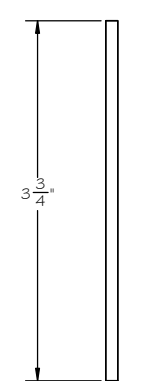
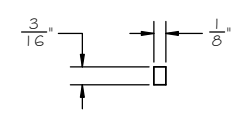
GR44-20 RAFTER



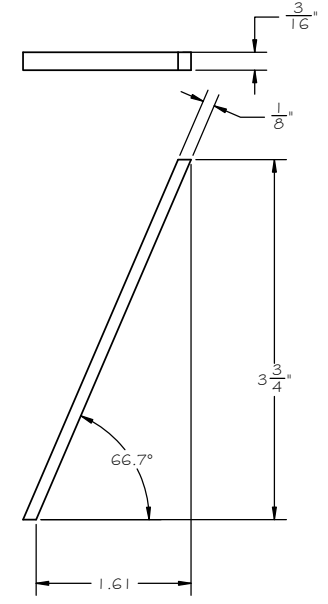
GR44-21 FACIA



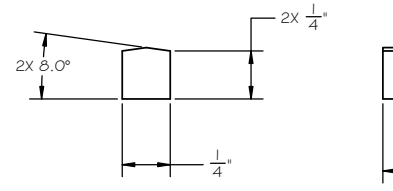
GR44-12 CORNER POST



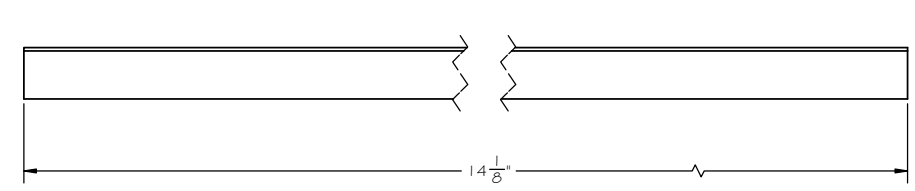
GR44-13 INTERMEDIATE POST



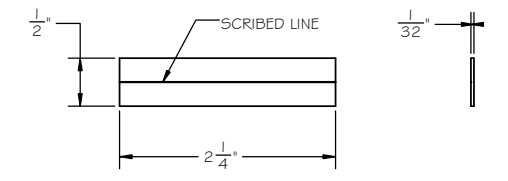
GR44-14 SIDE DIAGONAL



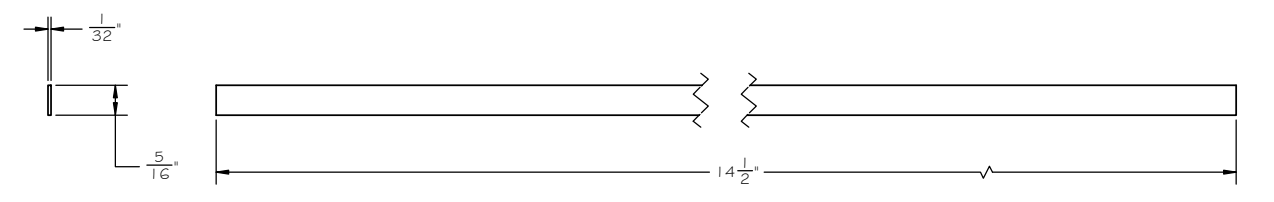
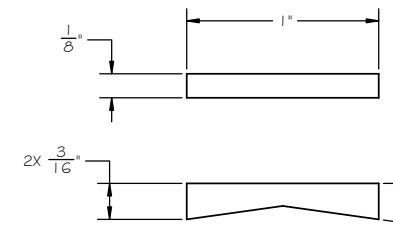
GR44-24 ROOF WALK SUPPORT



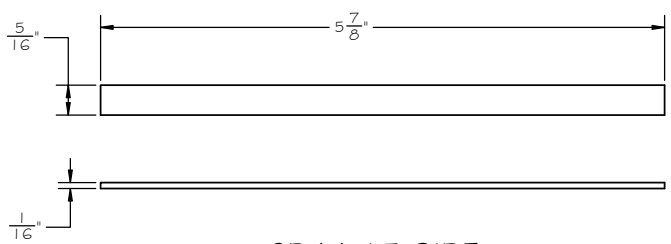
GR44-22 RIDGE BEAM



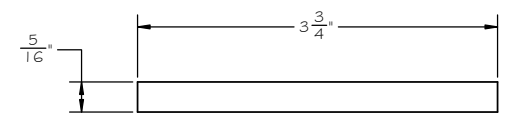
GR44-23 ROOF PLANK



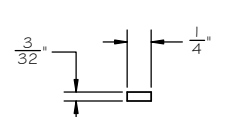
GR44-25 ROOF WALK



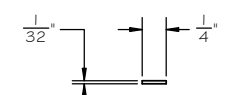
GR44-15 SIDE SHEET PLANK



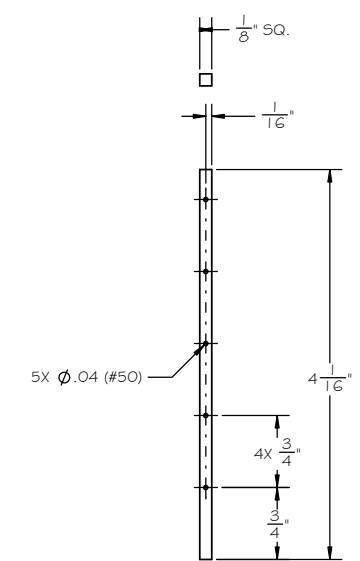
GR44-19 END SHEET PLANK



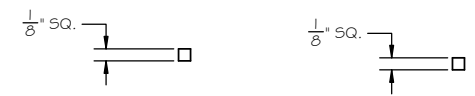
GR44-27 DOOR STILE



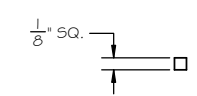
GR44-28 DOOR PLANK



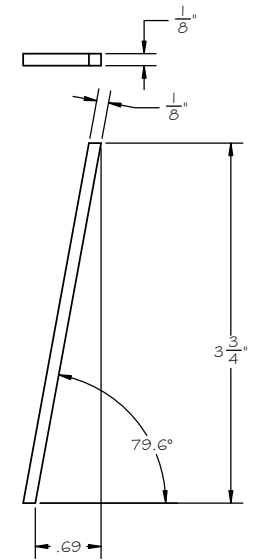
GR44-30 LADDER RAIL



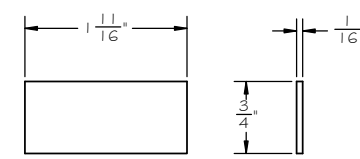
GR44-16 END POST



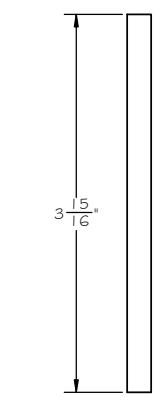
GR44-17 BRAKE PLATFORM POST



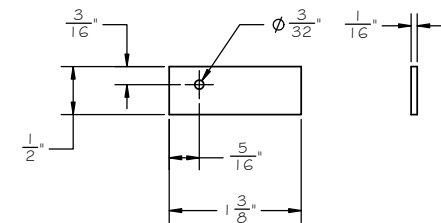
GR44-18 END DIAGONAL



GR44-31 K-VALVE MOUNTING PLANK

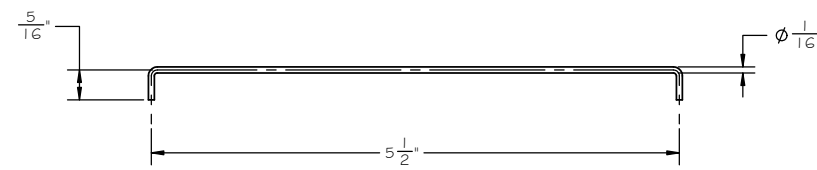


GR44-26 DOOR RAIL

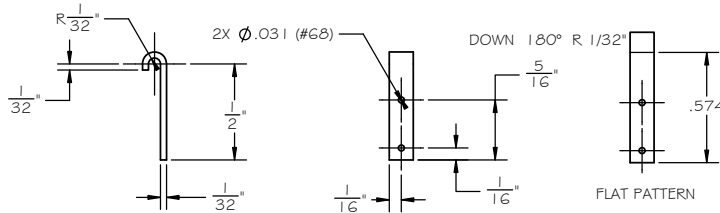


GR44-29 BRAKE PLATFORM

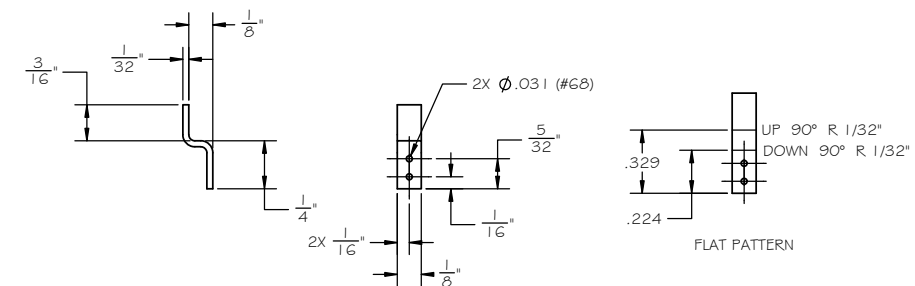
TITLE			
OUTSIDE BRACED BOX CAR			
SIZE	CAGE CODE	DWG. NO.	REV
D	-	GR Plan Set 44	-
SCALE	NONE	UNIT WT.	SHEET 5 OF 7



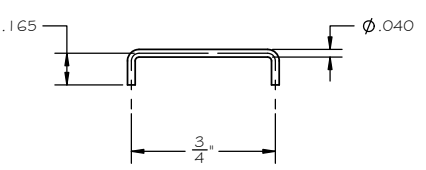
GR44-32 DOOR TRACK



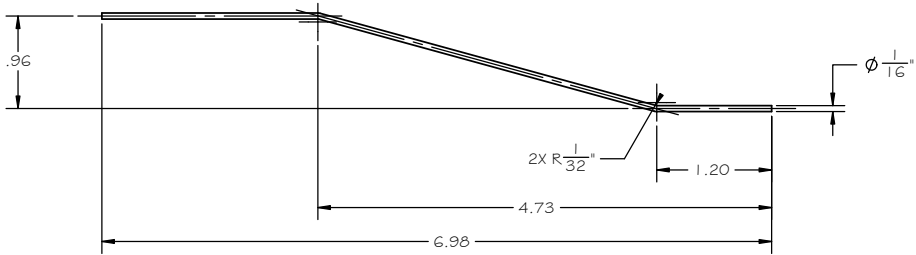
GR44-33 DOOR HANGER  
SCALE: 2:1



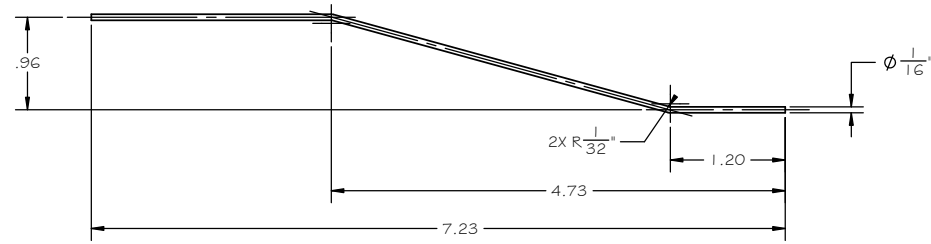
GR44-34 DOOR GUIDE  
SCALE: 2:1



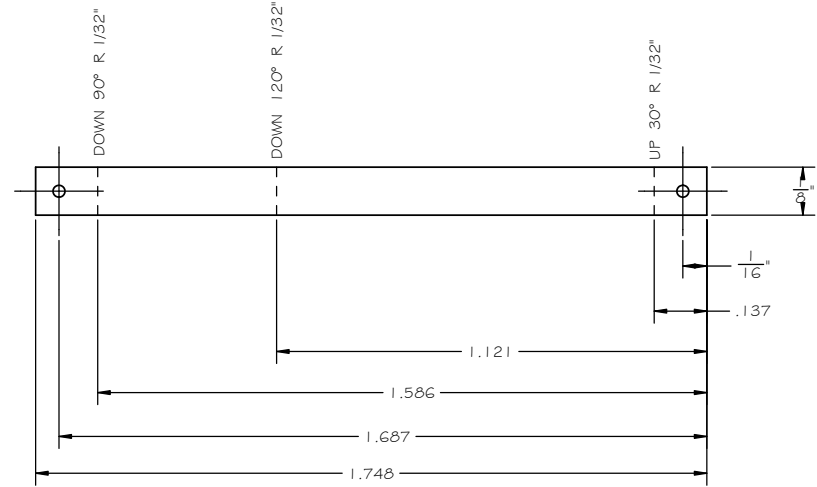
GR44-35 LADDER RUNG  
SCALE: 2:1



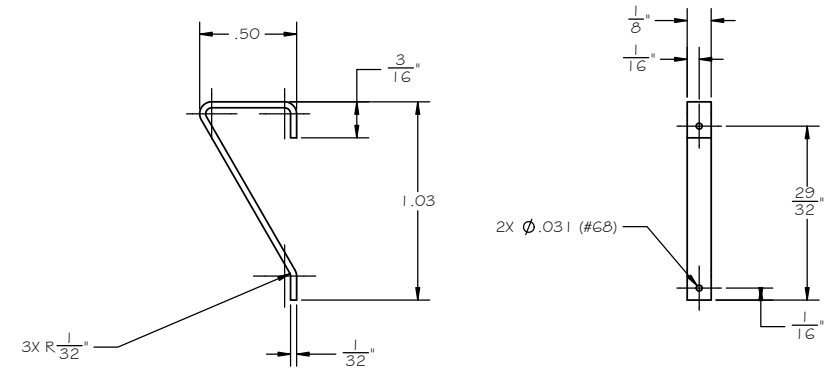
GR44-36 TRUSS ROD, OUTER



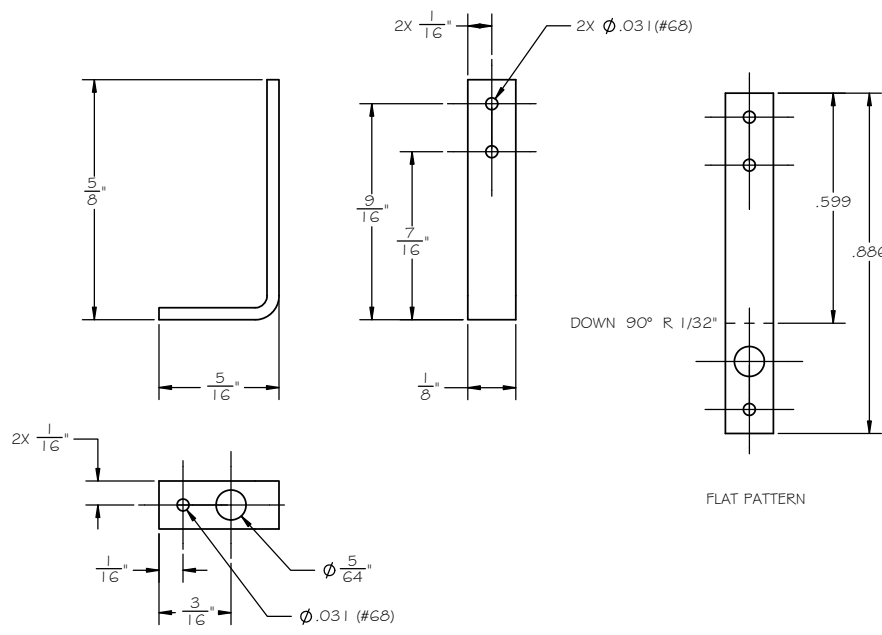
GR44-37 TRUSS ROD, INNER



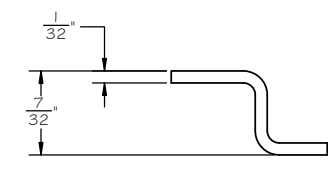
GR44-38 BRAKE PLATFORM SUPPORT  
SCALE: 4:1



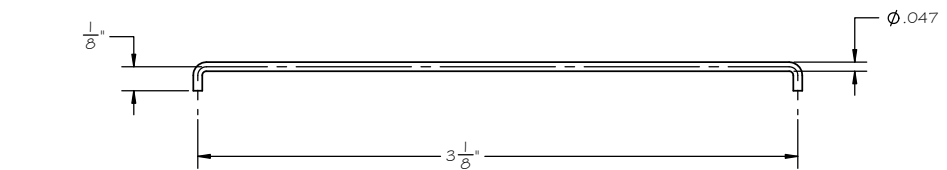
GR44-40A BRAKE STAFF SUPPORT  
SCALE: 4:1



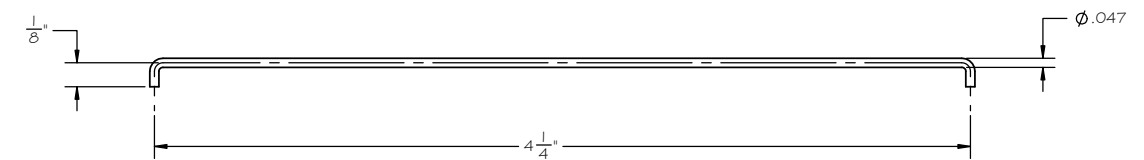
GR44-40B BRAKE STAFF SUPPORT  
SCALE: 4:1



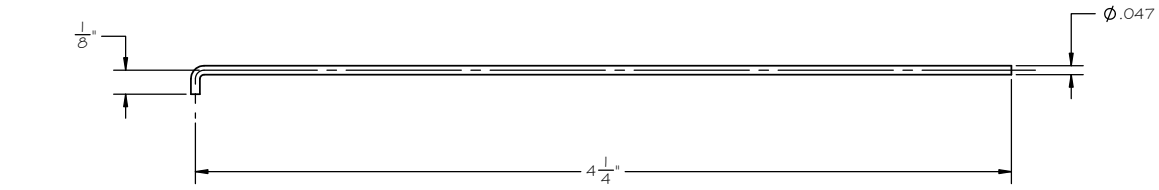
GR44-41 BRAKE ROD, TRUCK  
SCALE: 2:1



GR44-42 BRAKE LINK ROD  
SCALE: 2:1



GR44-43 BRAKE WHEEL ROD  
SCALE: 2:1



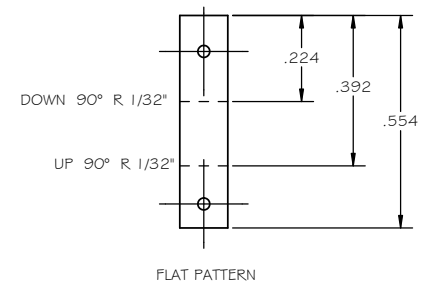
GR44-44 BRAKE WHEEL ROD  
SCALE: 2:1



GR44-45 BRAKE WHEEL ROD  
SCALE: 2:1

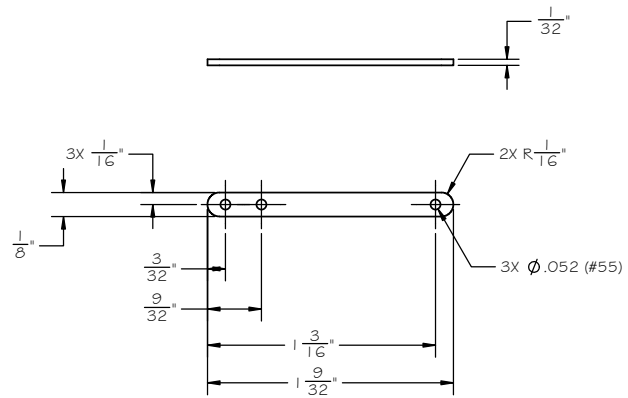


GR44-46 BRAKE WHEEL ROD  
SCALE: 2:1

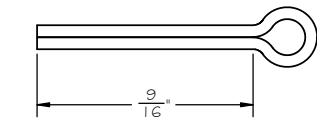


FLAT PATTERN

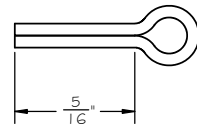
TITLE			
OUTSIDE BRACED BOX CAR			
SIZE	CAGE CODE	DWG NO.	REV
D	-	GR Plan Set 44	-
SCALE	NONE	UNIT WT.	SHEET 6 OF 7



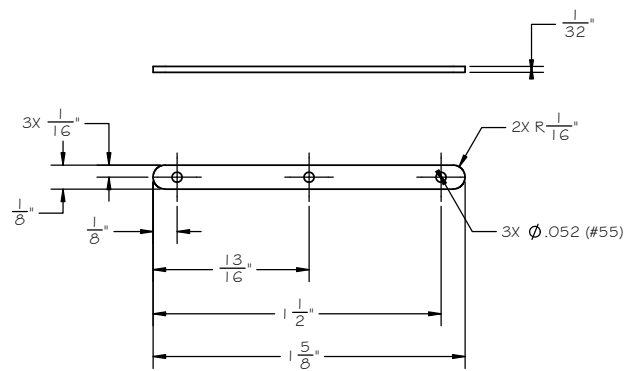
GR67-15 BRAKE RIGGING  
SHORT LEVER  
SCALE: 2:1



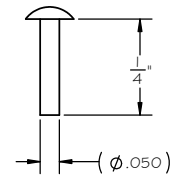
GR67-25 COTTER PIN  
NEEDLE BEAM  
SCALE: 4:1



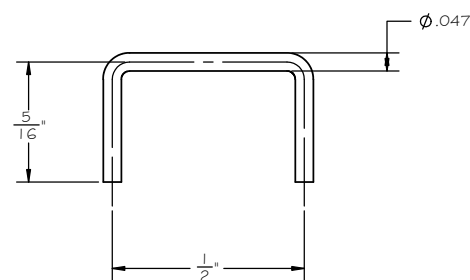
GR67-26 COTTER PIN  
BOLSTER  
SCALE: 4:1



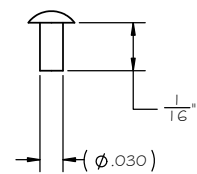
GR67-16 BRAKE RIGGING  
LONG LEVER  
SCALE: 2:1



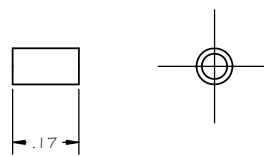
GR67-27 ESCUTCHEON PIN  
SCALE: 4:1



GR67-20 BRAKE RIGGING  
SUPPORT  
SCALE: 4:1



GR67-39 CARRIAGE BOLT  
SCALE: 8:1



GR67-24 QUEEN POST  
TUBE  
SCALE: 4:1

TITLE			
OUTSIDE BRACED BOX CAR			
SIZE	CAGE CODE	DWG NO.	REV
D	-	GR Plan Set 44	-
SCALE	NONE	UNIT WT.	SHEET 7 OF 7