



## Instructions: Greenville 6,000CuFt 60' Double Plug Door Box Car Phase 3 Alternate Instructions

04/2024



These instructions are to be used in conjunction with the instructions for Phase I body, Keystone cushioning kit #33002-001 to allow you to build the Phase 3 body with Keystone cushioning, kit #33004-001. There are several steps where you will be performing the same task so having access to both versions is recommended. These steps will be indicated as such in the text. The text for this version will also not be as detailed so referring to the photos will be more useful to assist in the assembly.

### Underframe Construction:

1. Install the weights into the carbody using the four panhead screws (same as PH I)
2. As with the Phase I body, install the underframe if it is not already installed. It is keyed by pins on the bolsters so it can only be installed one way (same as PH I)
3. Install the Keystone cushioning components (same as PH I)
4. Install the cross member at the B end of the underframe (same as PH I)\*

\*this is easier to do before any of the other brake components are added

5. There are 6 cross member braces instead of 4 on the PH I version. These parts differ slightly in that the outer edges are tapered, and the outer two do not

have the small gussets at the lower edge. They are installed in a similar fashion as the PH I version in that the holes for the brake lines all line up on one side (same side as the AB and reservoir) and the gussets face toward each other on the middle pairs. (see photo)



6. The brake line consists of two pieces of brown plastic (see photo), and the long straight wire in the wire parts bag. Install the plastic components per the photo but do not install the wire part yet as other components need to be put in place to allow proper orientation.

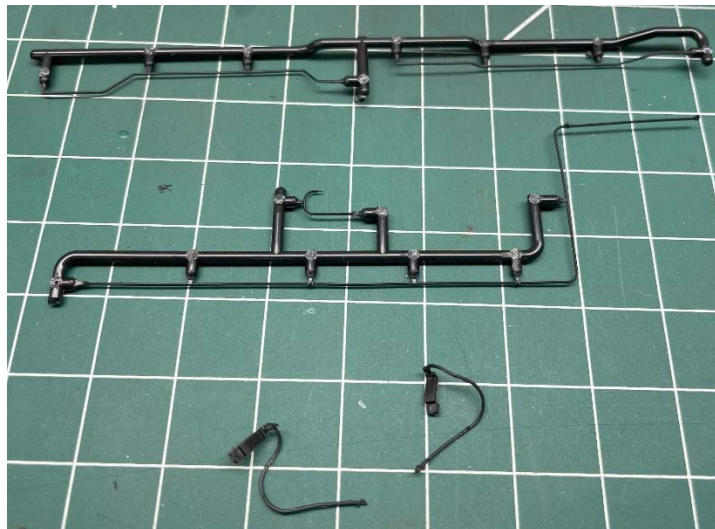




7. The AB valve for this version is part #13. When installed the holes in the part face outward (toward the side sill). It fits between the floor cross members and in a mounting hole in the floor. Using the photo as a guide, locate the version of reservoir shown and install next to the AB valve, again with the holes facing outward.



8. Locate the air line components using the photo to assist. There are two of the sprue at the top of the photo included in the kit-you will need both as you will need two of the part that is on the left of the sprue in the photo.



You will need to lift up the bolster in order to fit these parts in position (one at either end of the car). They fit in slots in the floor and bolster, and attach at the second cross member behind the bolster (see photo)



9. The angle cock/air hose is a rubber part. It has a tab that fits into a slot next to the coupler pocket. Use CA to set in the hole, and attach the end of the air line installed in the previous step to the bottom of the bracket behind the angle cock, again using CA. (see photo).





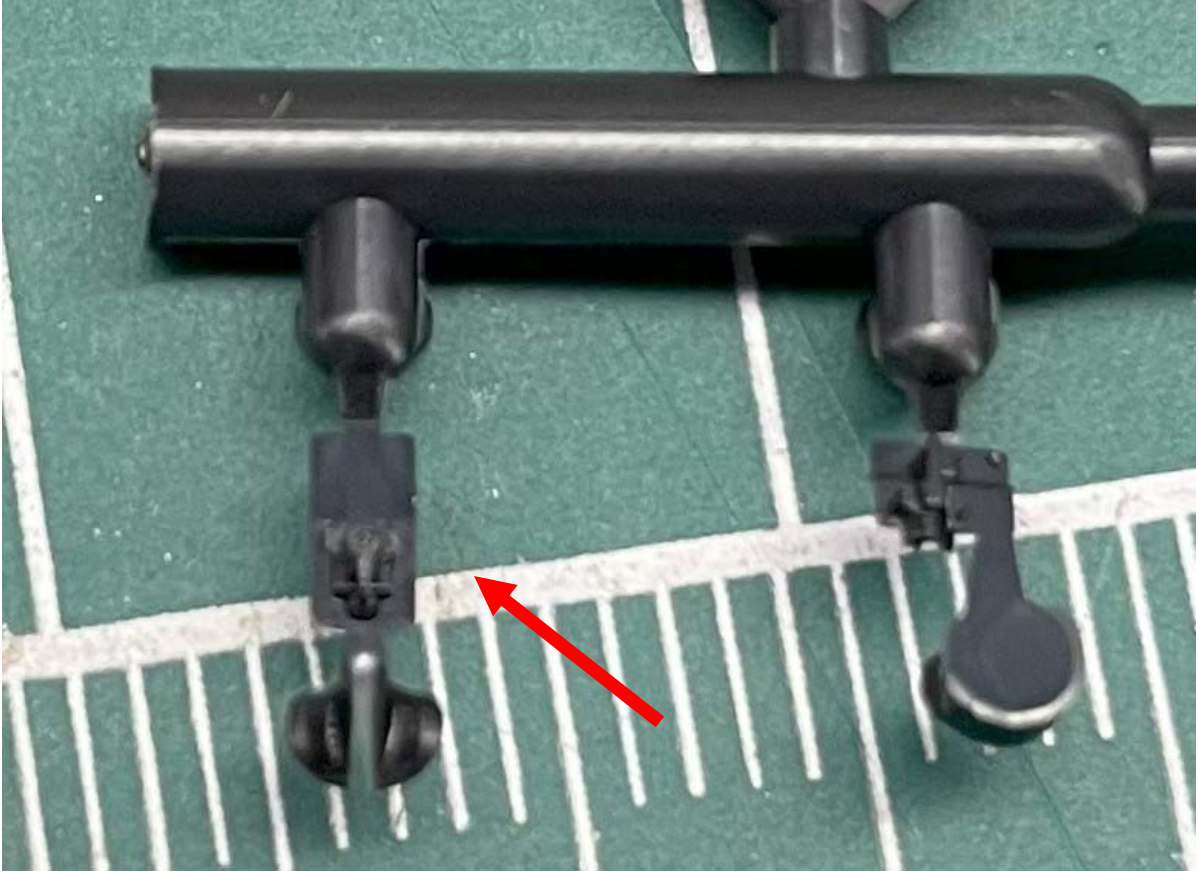
Install the final section of the air line using the holes in the underframe to guide positioning. After the air line is in place you can install the wire section of the brake line by threading it through the holes in the cross member braces. Set in place and secure with CA. (see photo of completed brake/air lines)



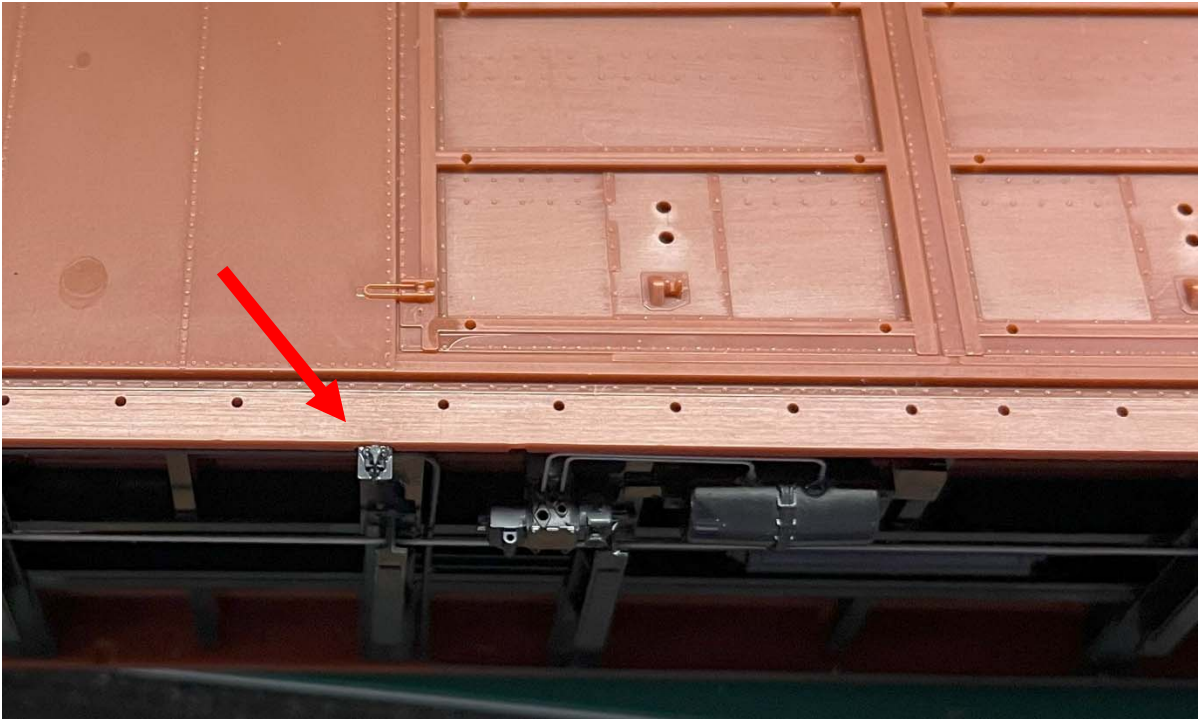
10. Locate the two reservoir wires from the wire parts bag. They are oriented so that the shorter leg goes in the reservoir, and the longer legs go into the lower two holes in the AB. Attach with CA at the reservoir but not the AB to make sure no other holes get blocked. (see photo)



11. Using the photo for reference locate the appropriate retainer valve for this body style.



It fits in a slot in the side sill next to the AB valve (see photo).

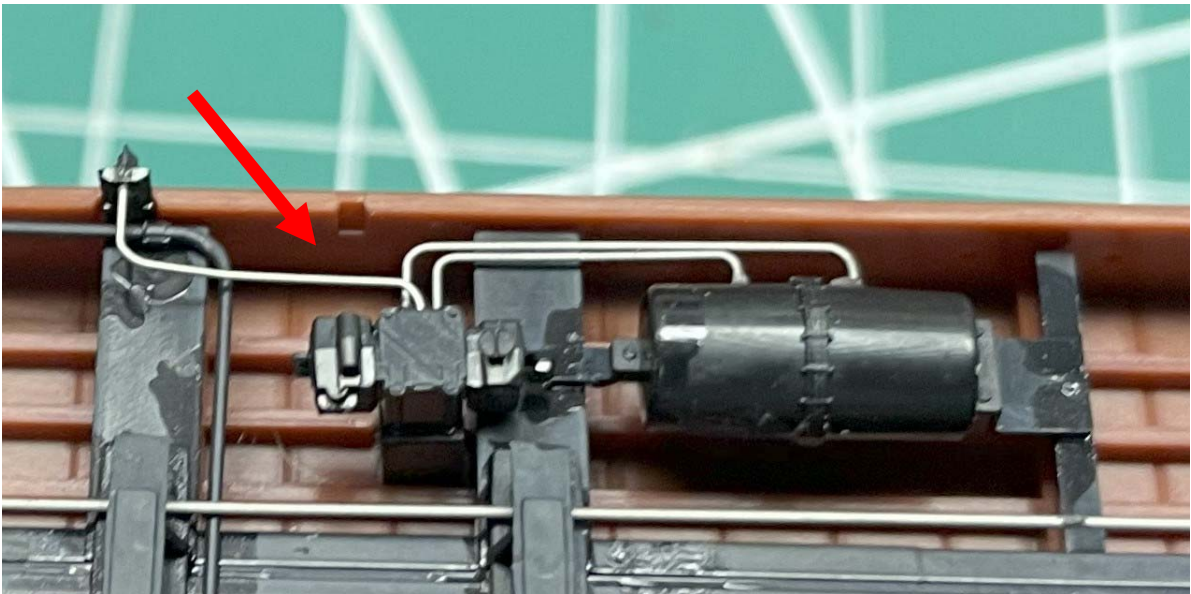




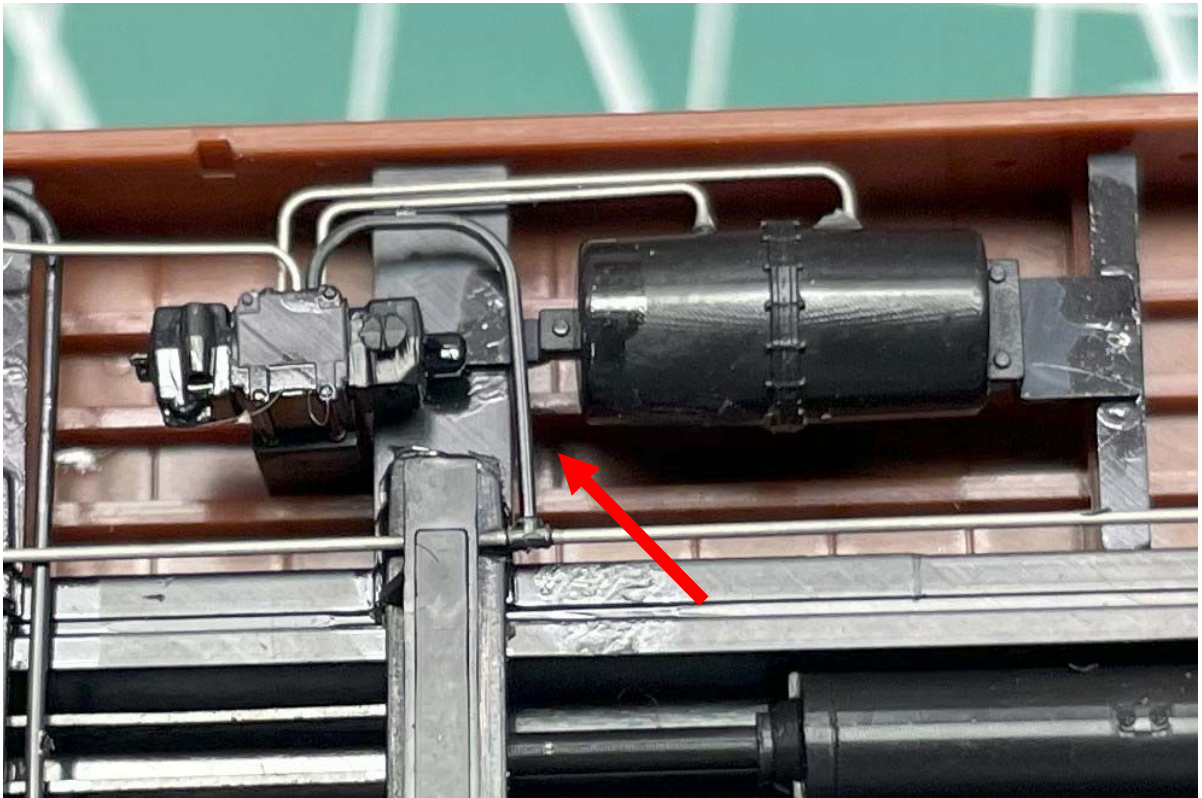
Returning to the wire parts bag, locate the small Z shaped wire for the retainer line.



The longer leg with the slight offset fits into a hole in the back of the retainer valve and the other end goes into the center hole of the AB. Secure with CA at the retainer. (see photo)

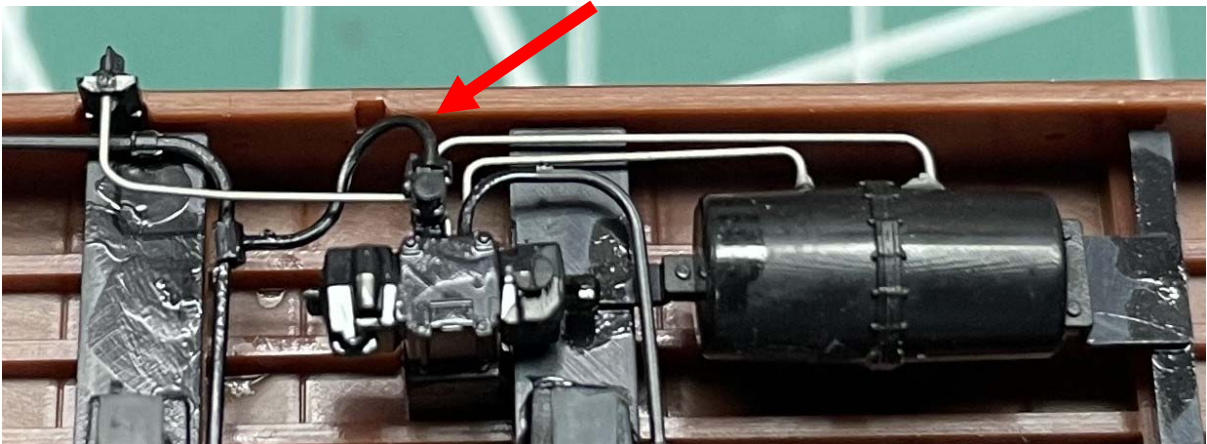


12. The brake line coupler (U shaped part) goes into the top left hole in the AB and attaches to the brake line. (see photo)

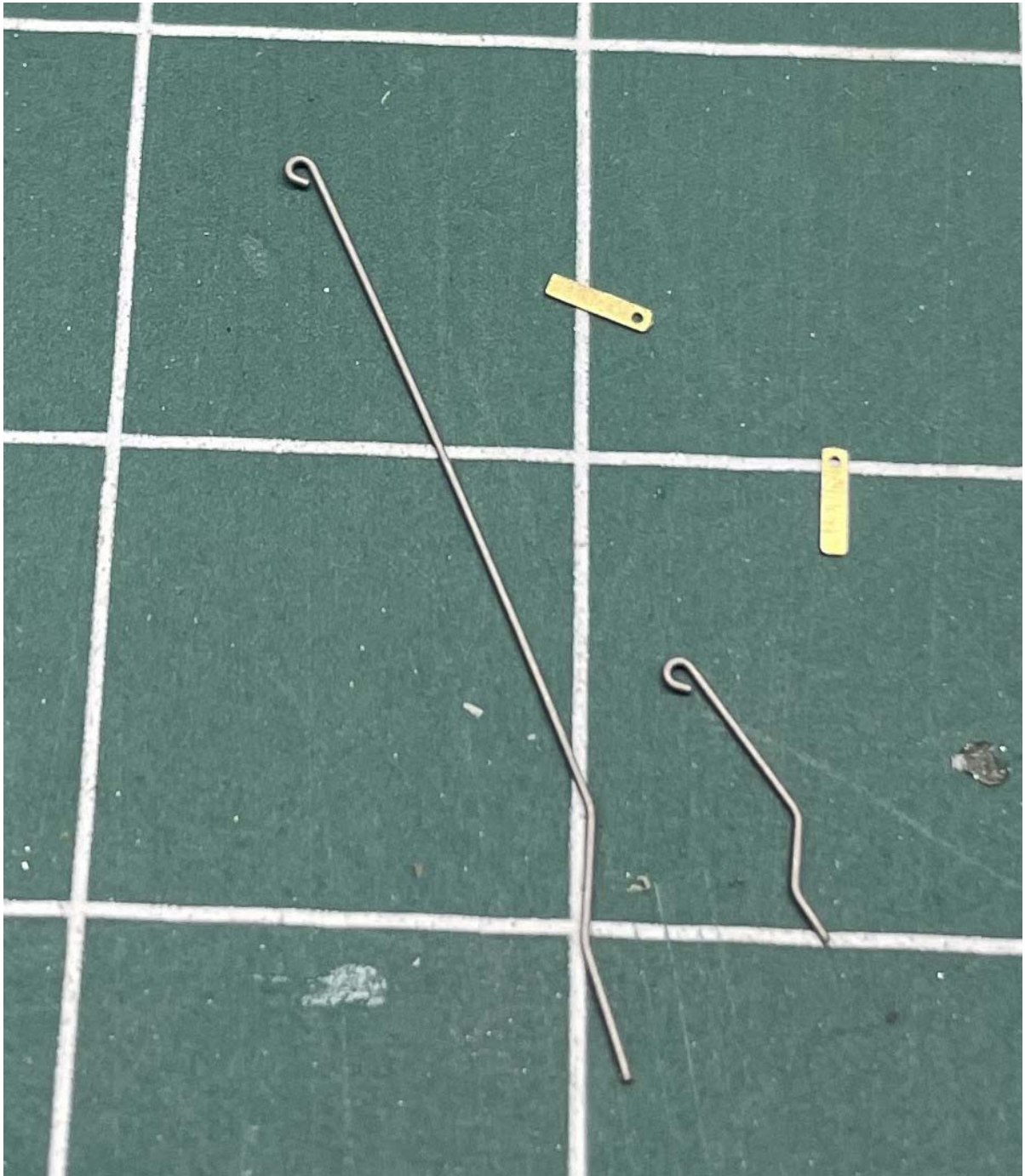




13. The dirt collector fits into the last hole in the AB valve and connects to the air line. It needs to be maneuvered under the retainer line and connected to the air line. When installed you can secure all parts in the AB valve. (see photo)

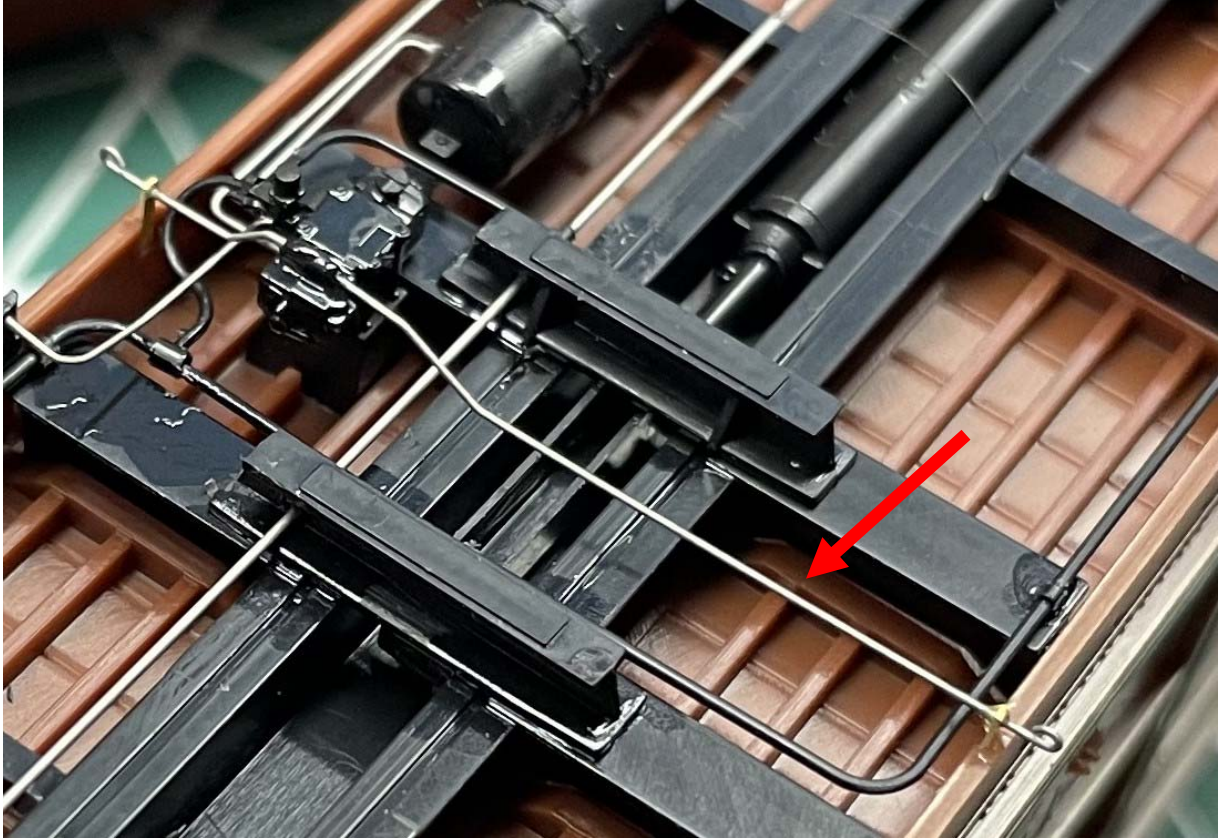


14. There are 4 components that make up the bleed rod (see photo).

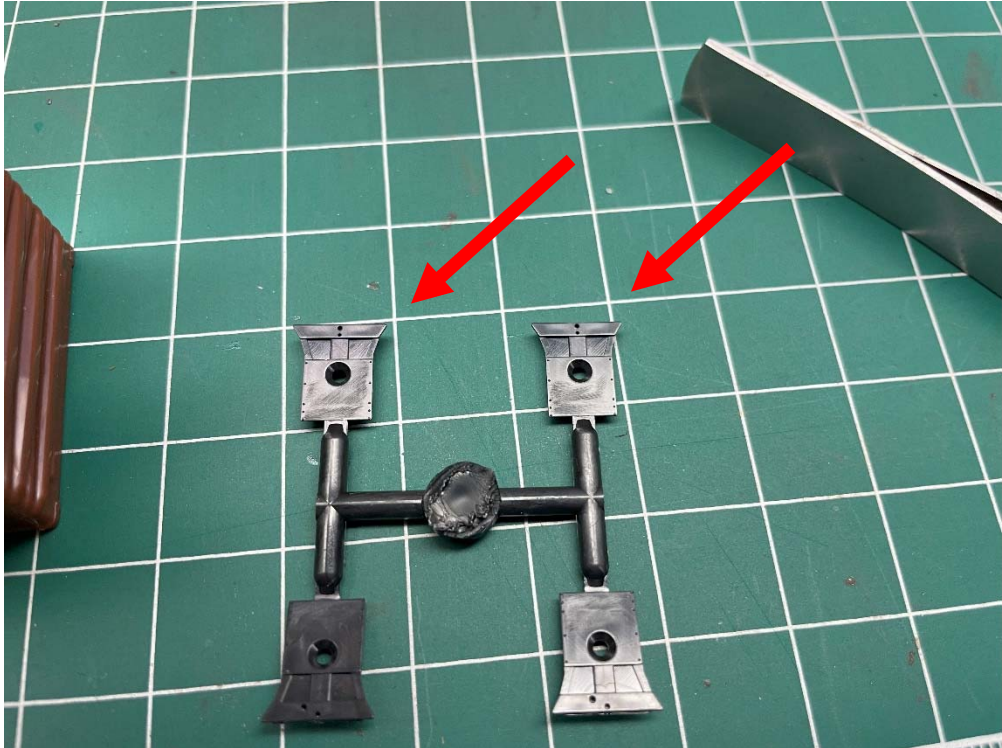


The two brass brackets fit in slots in the side sill. Using the photo as a guide install the two wire components of the bleed rod and set in place with CA. (see photo)





15. The coupler box covers for this version have the two aligned holes at the front of the cover.

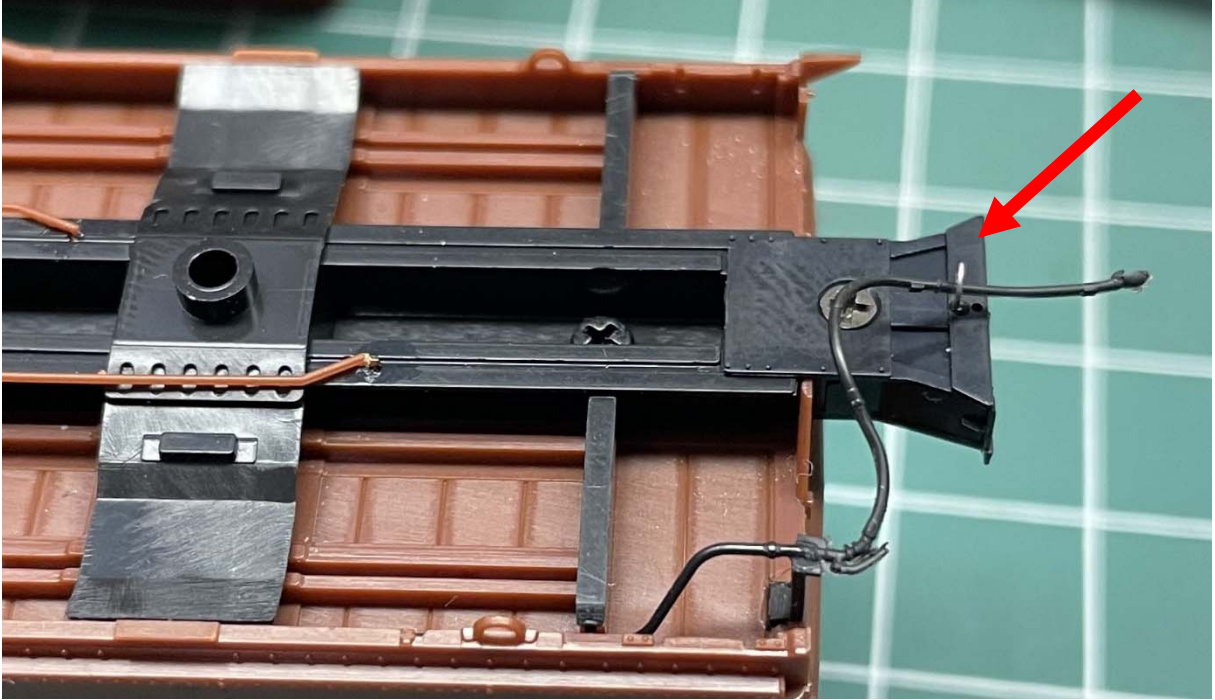


There is a small casting pin at the back of the coupler box that needs to be removed in order for the cover to fit properly. Attach with the two small flathead screws. From the wire parts bag, retrieve the two large eyelets. These will be installed in the rear hole of the cover with CA.



After they are in place you can fish the air hose through the eyelet but do not glue to allow the cover to be removed to install couplers (see photo)





16. Install the coupler cut levers and brackets per the PH I instructions.
17. Install the small round head screws to secure the underframe to the floor as per the PH I instructions.
18. Install the fulcrum per the PH I instructions.

### **B-End Detailing Instructions:**

19. Locate crossover platform #04 from the parts sprue and install in the mounting holes along the bottom edge of the car end.
20. Locate brake housing #04. Feed the brake staff through the opening in the crossover platform and over the fulcrum, and into the mounting holes in the car end. (see photo)



21. Install the tack board and long crossover rail (from the wire parts bag).



22. For the end ladders, locate ladder part #11 for the right side ladder, and part #06 for the left hand ladder. (see photo)



## A-End Detailing Instructions:

23. For the A end of the car, the crossover platform is part #02. All other parts are the same. (see photo)



24. For the side ladders the left hand is part #12, and the right hand is part #10. (see photo)



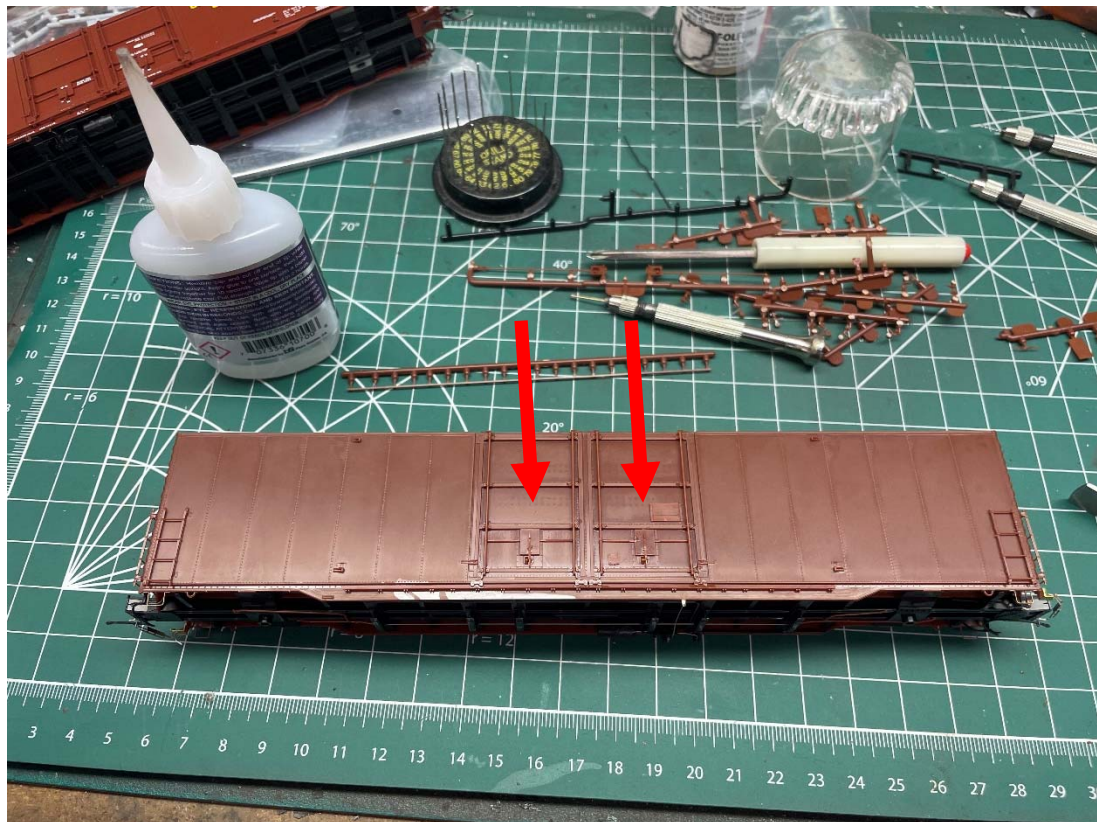
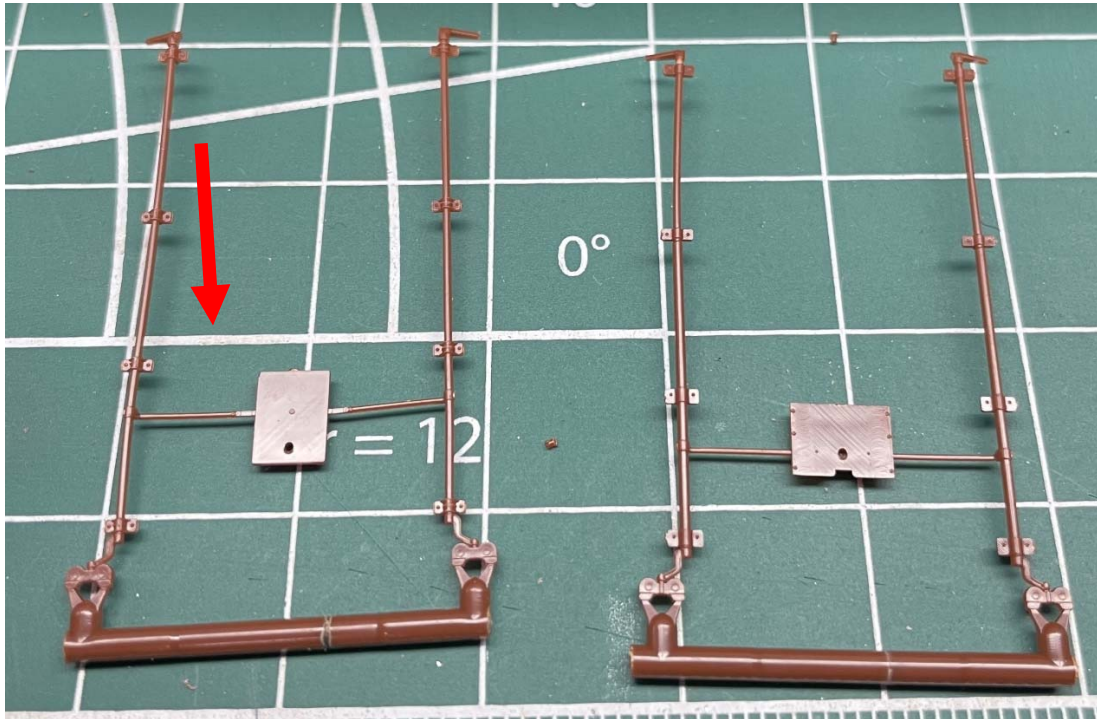


25. There are two lower tracks included but only one will align with the mounting holes. Install per the photo.





26. There are two different versions of door rods. The version you need for this carbody is the one that has the mounting plate that is longer vertically. Install on all four doors.





27. The tack boards and door openers are the same as PH I.
28. Install the roof and the build is complete.









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