

## KASGRO 400 TON, 16 AXLE, 40' DEPRESSED CENTER FLAT CAR KIT ASSEMBLY INSTRUCTIONS



### Unpacking

1. The kit is shipped in 2 boxes. Remove the bags and parts from the boxes. Do not discard the thin foam wrap used on the main body – you will use it for storage later.
2. Do not open all of the bags of parts at once in order to minimize the chance any of the small parts getting lost. The bags are marked alphabetically in the order the parts will be used.

### Preparation

1. You will need a clean flat work area 3 to 4 square feet in size.
2. Tools required are a #1 Phillips screw driver, small file, small angled needle nose pliers, hobby knife, toothpicks, small container to hold water for decals, "setting" solution for decals, and optionally a magnifier and 400 grit wet/dry sand paper.
3. Spray booth or well ventilated and clean area to paint.
4. Area where parts can be set aside without getting dirty or damaged.

### Assembly Notes

1. Please note that many parts in this kit have many small, fine details which are delicate. **Hold parts by the edge as much as possible to minimize the chance that any of those features get damaged.**
2. Use medium viscosity CA glue only. No other glue will hold the parts together. Only a small amount of glue is necessary. Place a small amount of glue on the part and spread the CA with a toothpick so all the joint surface is covered. Error on the side of less glue, as you do not want glue to ooze out the joints.
3. Railfan Models uses and recommends Tru-Color paints, but you can use any brand of paint you are comfortable with. Tru-Color paint numbers used are: TCP-005 WHITE, TCP-007 PRIMER, TCP-010 BLACK, TCP-012 CHINESE RED, TCP-018 GLOSS, TCP-069 REEFER YELLOW, and TCP-077 SILVER. While we use custom blends of rust colors, but TCP-405 MATT ORANGE RUST and TCP-407 MATT BROWN RUST are close to what we use.
4. *Please note that the parts in your kit may be a different color or show slightly different features that the pictures shown in these instructions. The assembly process will remain the same though.*

## Trucks

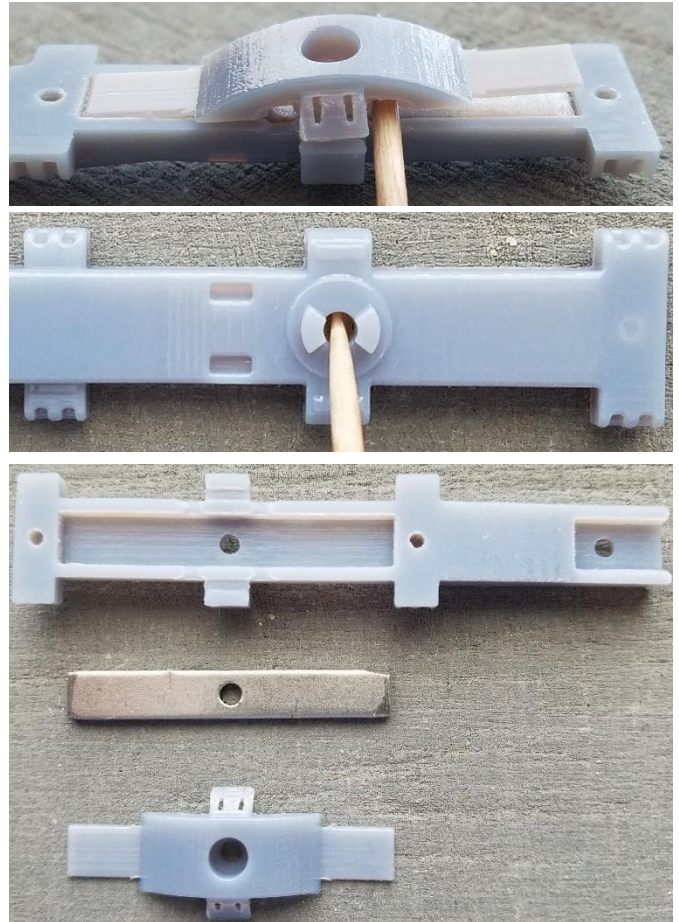
1. Remove the trucks from the packaging. For the best looking car, the wheelsets should be painted.
  2. Remove the wheelsets from the trucks.
  3. We highly recommend washing the wheelsets in soapy water to remove any residue from the manufacturing process prior to painting. Thoroughly dry the wheelsets.
  4. Prime and paint the wheelsets. While brush painting is acceptable here, airbrushing works and looks much better. For a newer look, use a rust color with more orange hue. If you want an older look, use a darker rust color. There is no absolute right or wrong rust color.
  5. Pull the decal sheet from Bag H and select 1 out of the 5 road numbers provided.
  6. Carefully cut out 16 of the 24 small road numbers. Soak the decal 10-15 seconds and apply in the position as shown.
  7. Repeat for both sides of all 8 trucks.
  8. Apply a setting solution and let dry.
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9. Seal the decals with a clear gloss coat.
  10. With the side frames and wheelsets dry, install the wheelsets back into the truck frames.
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11. Use a small brush to paint the bearing caps blue.
  12. Set aside for later use.



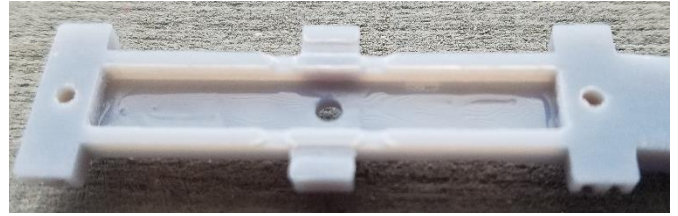
*The decals are made by Microscale for Railfan Models, and go on just like any of their other decals. Cut the decal out with enough extra paper on one side so that it can be held with small needle nose pliers and not interfere with the decal sliding off. Dip the decal in warm water for at least 10 seconds and remove. Let set for another 10 seconds, then slide the decal off the paper into position with a toothpick. Blot any excess water with a small dry paint brush. Allow the decals to dry then brush a "setting" solution over the decals and let dry. A magnifier will come in very handy viewing, cutting, and placing the decals.*

## Small Span Bolster Assembly

1. Remove the Span Bolsters from Bag A. The top, bottom and steel insert are put together for shipping, but are not glued. Separate the top and bottom by inserting a toothpick as shown here.
2. If the steel insert does not fall out, then use the toothpick to poke the insert out as shown here.
3. When you are finished separating the parts, you will have 4 identical bottoms, 4 steel inserts, 2 short bolster tops, and 2 long bolster tops with coupler pockets. Assembly will be identical for each span bolster.



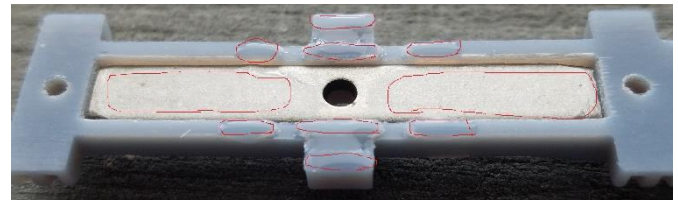
4. Apply a small amount of CA to the flat part of the cavity of the top span bolster. DO NOT get CA near the hole though.



5. Lay the steel insert into the cavity and press firmly in place.



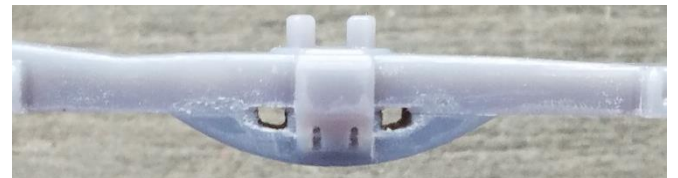
6. Apply a small amount of CA on the steel but stay away from the hole. Using a toothpick, apply CA to the areas shown here circled in red.



7. Press the span bolster bottom into position as shown.



8. Use a small file to smooth the joints between the top and bottom.

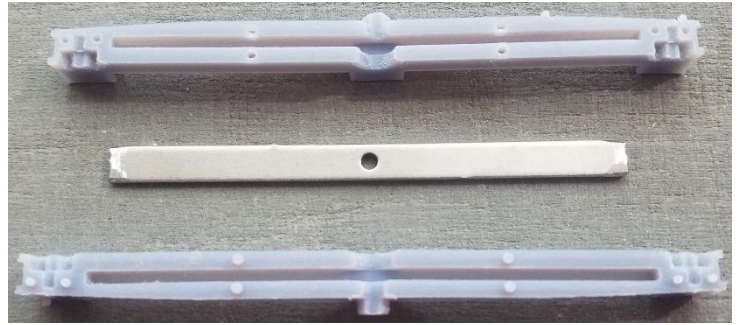


9. Repeat steps 4-8 for the remaining 3 span bolsters.

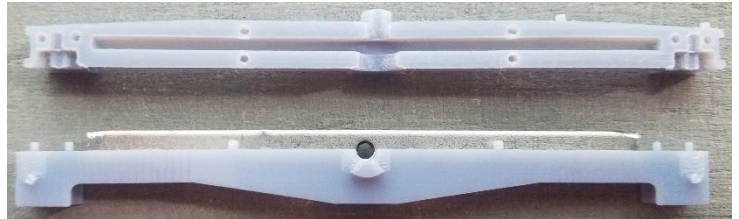
10. The holes are pre-threaded so you do not need to do anything with the holes.

## Large Span Bolster Assembly

1. Remove the Span Bolsters from Bag B. The left, right and steel insert are put together for shipping, but are not glued.
2. Pull the left and right apart and remove the steel insert.



3. Place the steel insert into the side with the pins as shown here. Use a tooth pick to make sure the hole of the insert matches the hole in the side piece.



4. Using medium viscosity CA , apply a *liberal* bead along a flat mating surface of the span bolster without the steel insert. Use a toothpick if needed to spread the CA along to entire mating surface. **DO NOT GET GLUE IN THE RECESSED AREAS AT THE ENDS.** This is the ONLY time that you will use this amount of glue.



5. Place both halves together and apply pressure evenly the length of the span bolster for about 10 seconds. Use a toothpick to smooth out any excess glue along the seam. Set aside to cure for an hour.



6. Repeat steps 2 and 5 for the second span bolster.
7. After the Span Bolsters have cured, use a small file to smooth out the seams and any excess glue. You can wet sand the bottom with 400 grit paper.

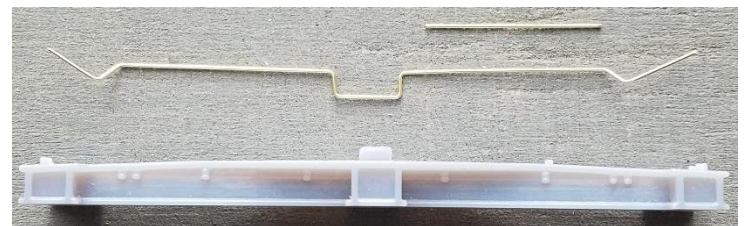
8. Check the fit of the small span bolsters in the large span bolster. The small span bolster should freely twist back and forth. If it does not, use a hobby knife to trim the outside circumference of the socket.



9. Verify there is no glue in the center hole. If the hole is not clean, use a 1/16 drill bit twisting back and forth to clean the hole out. Don't make the hole deeper, just clean the hole out.
10. This is a good time to pre-thread the mounting holes for the coupler and end trucks. Pull one of the black 3/8" #4 screws from bag G. The locations of the screws are shown below.
11. Start the threading process by turning the screw until it starts to bite into the plastic. At this point, turn the screw about a 1/8 of a turn then back out about 1/16 of a turn. Rotate the screw back and forth, advancing the screw about a 1/8 turn each time. Keep advancing until you feel notable resistance. Note the depth of the fully seated screws below.



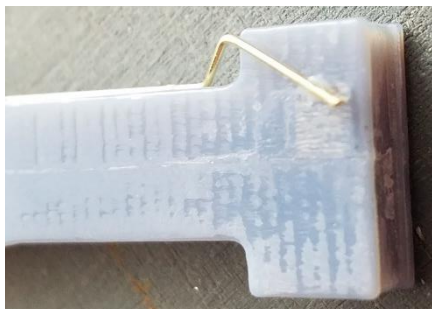
11. Repeat for each end of both span bolsters.
12. Remove the screws and file away any material pushed out of the mounting holes. Place the screws back into bag G until they are needed later.
13. Remove the formed brass wires from the cardboard backing, and the short brass wires from Bag B.



14. Use a toothpick to apply CA to the mounting brackets on the side of the span bolster. Place the formed brass wire in the sockets as shown here.

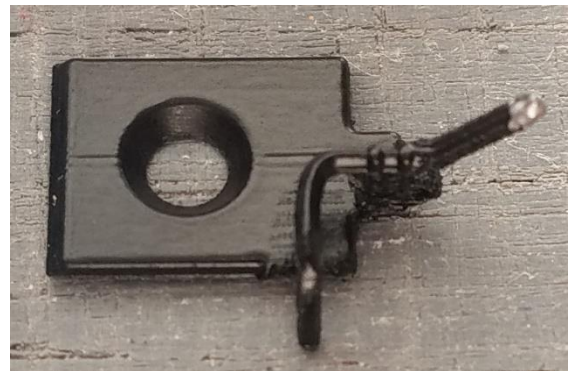


15. After allowing the glue to cure for a minute or two, use a toothpick to apply CA to the end brackets and press the wire into place. Glue the short wire into place using the same process.



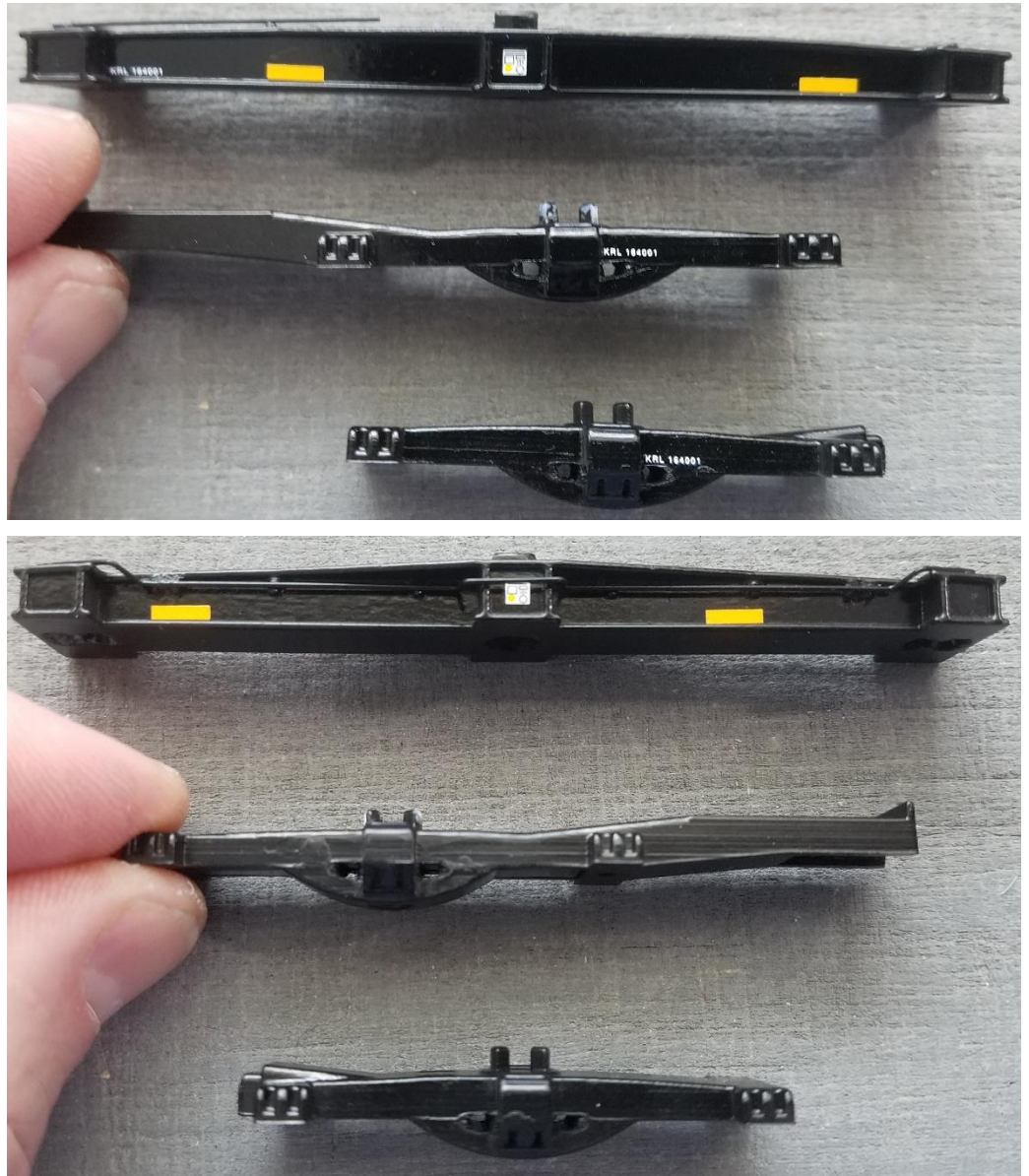
## Paint Span Bolsters

1. Remove the coupler covers from the cardboard protector.
2. Prime all of the parts with an airbrush for best results.
3. All six span bolsters and the two coupler covers should be painted black for KRL 164001-164004. *If modeling 164000, the two long span bolsters should be painted a light to medium blue. Paint these later with the main body. See photos at the end of these instructions.*
4. Painting the Trucks and Span Bolsters should be done with an airbrush only.
5. Any shade of black will work. If you want a new look, use gloss black. Grimy black is a good choice if you want a faded or heavily used look.
6. For best results and quicker painting, use a quick drying solvent based paint. We use and recommend Tru-Color paints. Paint colors are listed on Page 1.
7. A small rod placed through the center of the Trucks and Span Bolsters makes handling easy when painting. Wrap some tape on the rod to get a snug fit.
8. After the paint has dried on the coupler covers, paint the tips of the angled air line silver. Set the Coupler Covers aside in a protected place until needed at the end of the assembly process.
9. OPTIONAL: Apply any weathering to the Span Bolsters at this time.



## Decorate Span Bolsters

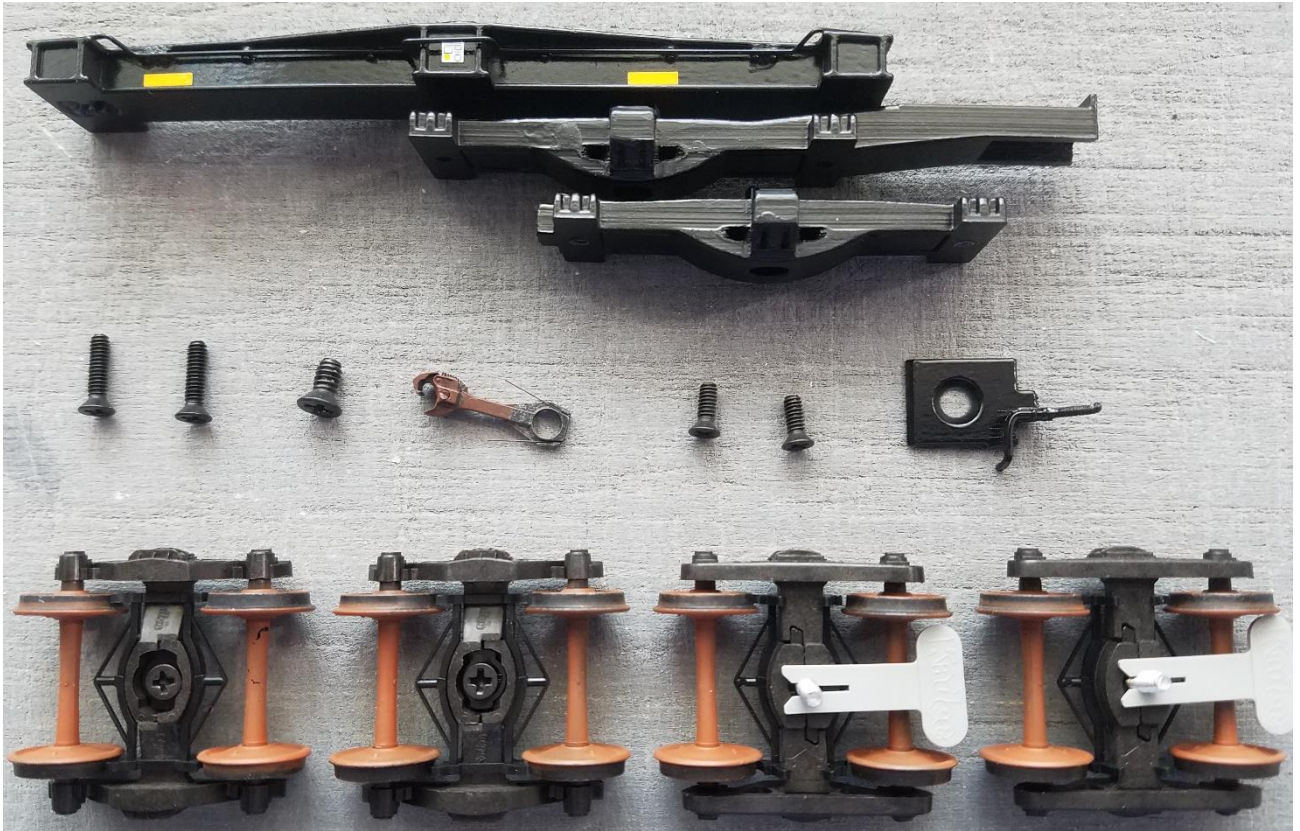
1. Remove the reflective striping and decal sheet from Bag H.
2. Use a hobby knife to remove the size of striping and place on the Large Span Bolsters as shown in the pictures below.
3. Locate and carefully cut out the decals shown below. There are 4 of the square brake system diagrams, and 6 small road numbers used here. Please note there are 5 different road numbers on the decal sheet. Make sure you use the same road number on the trucks, span bolsters, platforms, and main body.
4. Wet the decals for 10-15 seconds and place in the locations as shown here. Please note the road numbers are only placed on one side of each span bolster as shown in the top picture.
5. Let the decals dry, then apply a setting solution. After the setting solution has dried, these parts are ready for a clear gloss coat to seal the decals.



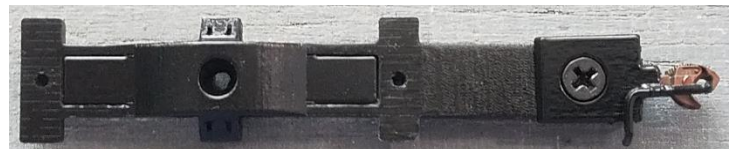


## Assembling Span Bolsters

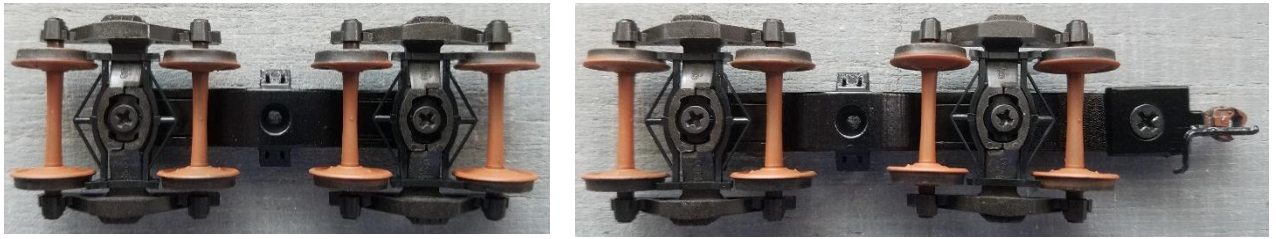
1. Carefully remove all of the screws and couplers from Bag G. Leave the other items in the bag until they are required later.
2. Gather the trucks previously completed with the span bolsters and coupler covers.



3. Turn the truck upside down with the tab on the bottom. Pull the tab off and discard. While pressing the truck side frames together, push the factory silver screw up and out of the truck. Be sure that the small insert the screw passes through does not come out with the screw.
4. Take one of the 1/4" long black screws removed from Bag G back into the truck. You can see the two trucks on the left in the picture above have the black screws installed. Repeat for all of the trucks.
5. Place the coupler and coupler cover in position and secure with the #4 screw as shown here.



6. Install the trucks to the span bolsters as shown here. Be careful to not over-tighten the screws. The trucks should turn side to side freely.

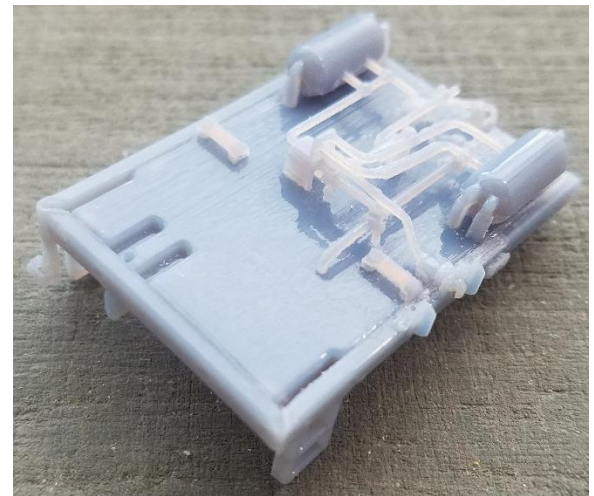
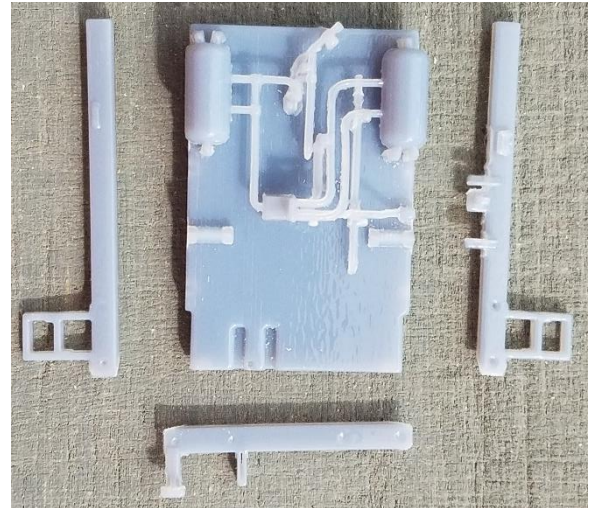


7. Mount the smaller span bolsters to the large span bolster as shown below. Ensure the small span bolsters turn side to side freely. Use the 3/8" #2 screws to secure the parts together. **DO NOT OVER TIGHEN THE SCREWS!**
8. Repeat for the other span bolsters.
9. This is a great time to test run the Span Bolsters to ensure they run correctly. You should not need pressure to force any of the axles on the track.

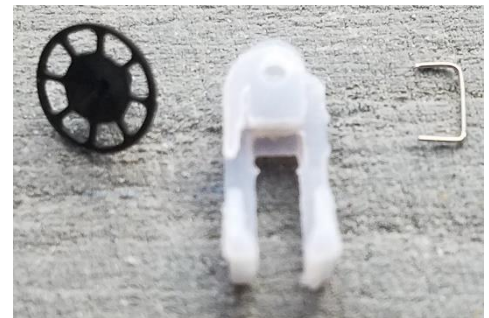
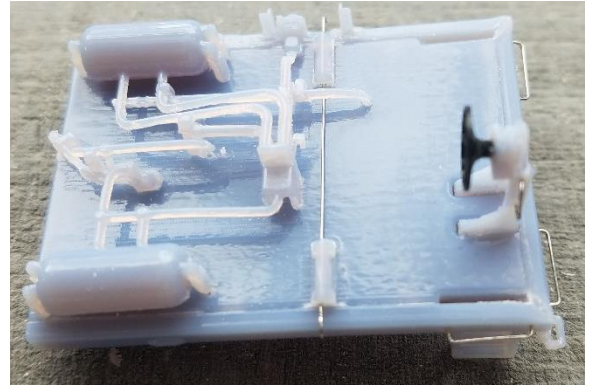


## End Platform Assembly and Painting

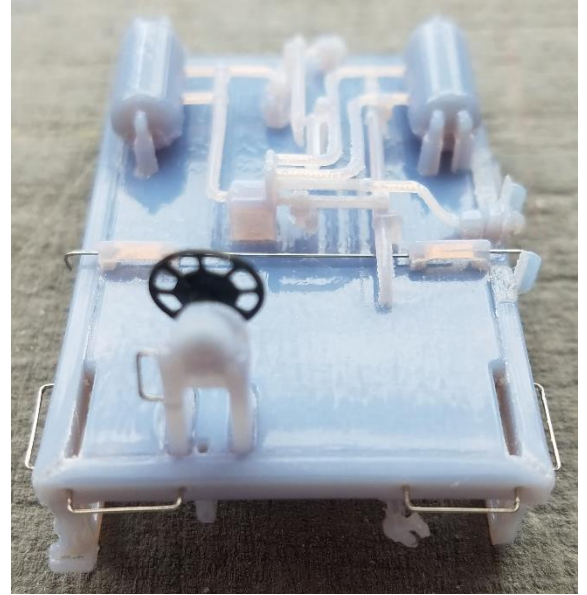
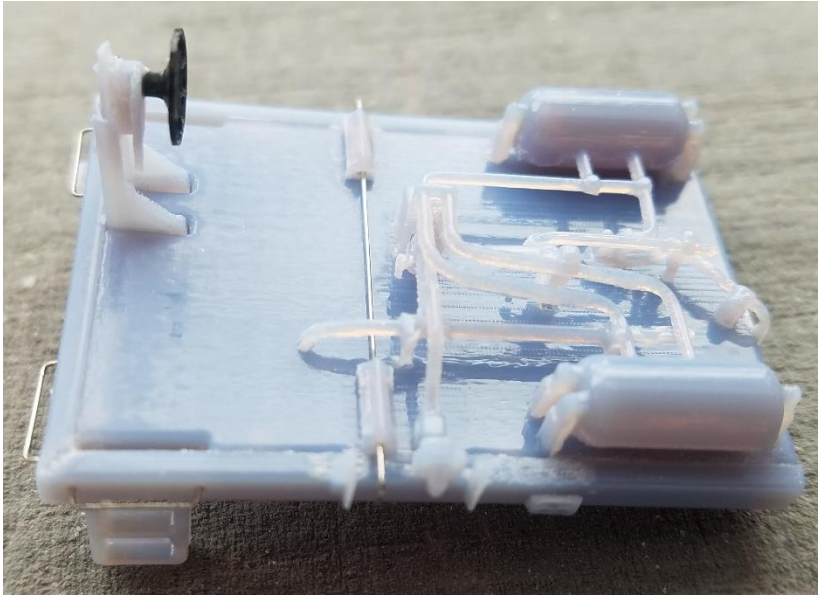
1. Remove the contents of Bag E.
2. Dry fit the Sides and Ends to the Platform Cores.  
The top of the Side should be flush with the top of the Core. The joints should be tight without any gaps. If a gap does exist, use a small file to remove material from the side of the Core only.
3. Apply CA to the end of the Core. Use a toothpick to evenly spread the glue over the entire surface.
4. Press the End piece on the Core and hold for 8 seconds.
5. Glue both Side pieces in position using the same processes as the end piece.
6. Repeat for the other End Platform.



7. Carefully remove the Grab Irons and Brake Wheels from Bag E.
8. Test fit the Long Grab Irons on the Platform Sides and Ends of the Platforms. Bend to fit if necessary. While the holes are pre-drilled, use a #80 drill bit in a pin vice to deepen the hole if necessary.
9. Apply CA to the ends of the Grab Irons and insert into the four locations.
10. Starting from the bottom in the picture to the right, thread the Long Pull Rod through the brackets as shown to where the end enters the inside bracket on the opposite side.
11. Apply CA to the Rod and bracket joints using a toothpick and push the Rod in slightly.
12. With needle nose pliers, grab the bent end of the Short Rod and apply a small amount to the straight end. Then insert into the bracket on the opposite side of the Long Rod. Hold the Short Rod in position for 6-8 seconds then release.
13. Dry fit the Brake Stand to the top of the Platform. The hole for the Brake Wheel should face the away from the end of the Platform towards the tanks and piping. It should fit into the slots. If not, use a small file to remove material from the feet of the Brake Stand. Do not glue the Brake Stand to the Platform yet, as it is easier to add the grab irons and brake wheel before gluing to the Platform.
14. Remove the flashing from the back of the Brake Wheels. Test fit the Short Grab Irons and Brake Wheel on both Brake Stands.
15. Apply CA to the back of the Grab Irons and Brake wheel and insert on the Brake Stand.



16. Apply CA to the bottoms of the Brake Stands and insert into the slots on the Platforms.

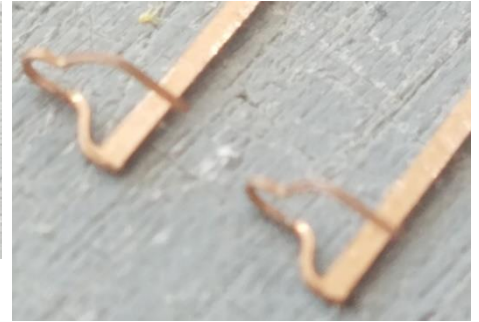


17. Remove one of the Lower Brake Pipes from the cardboard enclosure.
18. Dry fit the Brake Pipe into the opening on the bottom of the Core. You will need small needle nose or tweezers to do this.
19. Remove the Brake Pipe, apply CA to the Core, then press the Brake Pipe into the core with the same tool.



20. Repeat for the other Platform End.

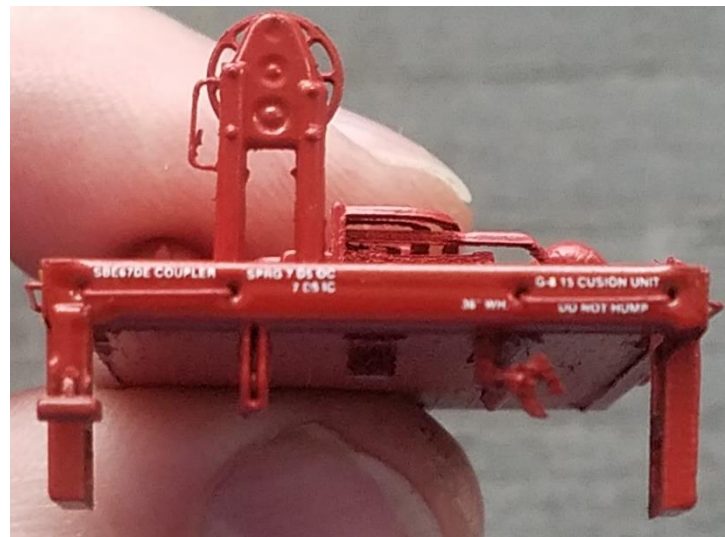
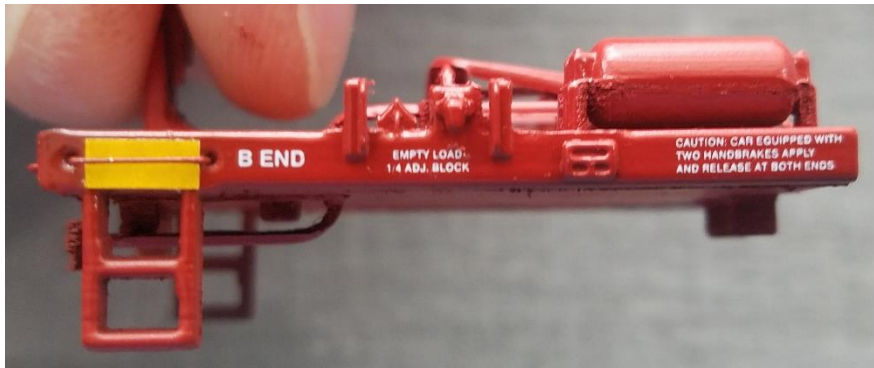
21. We recommend priming the End Platforms before painting.
22. After the primer is dry, airbrush the same color red as the Center Body.
23. Pull the Coupler Cut Levers from Bag G.
24. Bend the end of the lever as shown using small needle nose pliers or similar tool.



25. Prime these parts and paint per the picture here.  
Most of the part is Yellow with about an 1/8" at the end being Red for 164001-164004 and Blue for 164000.

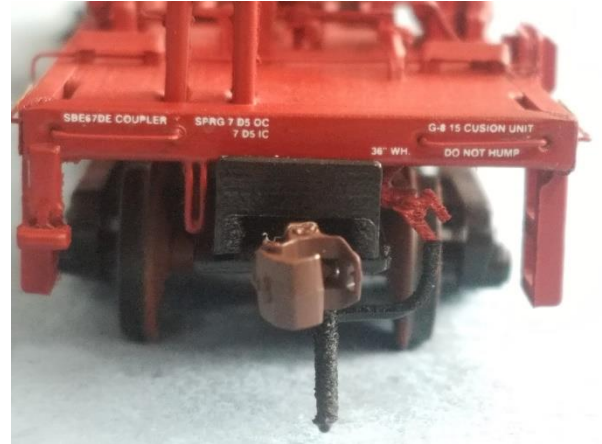


26. Regardless of the body color, the reflectors and markings are the same for each road number as shown in this section. A map of the Decals is at the end of this document.
27. It is easier to place the yellow Reflectors from Bag H before placing the decals.
28. Place the reflectors on one side. Use a hobby knife to lift a reflector from the backing and apply to the car body. Place into position and burnish the reflectors with a toothpick. For more detailed instructions, go to [smokeboxgraphics.com](http://smokeboxgraphics.com).



## Final Span Bolster Assembly

1. Once you are satisfied how the Span Bolsters run on your track, you can proceed to add the End Platforms and other parts.
2. Test fit the End Platforms on the Span Bolsters. They should look like these pictures.

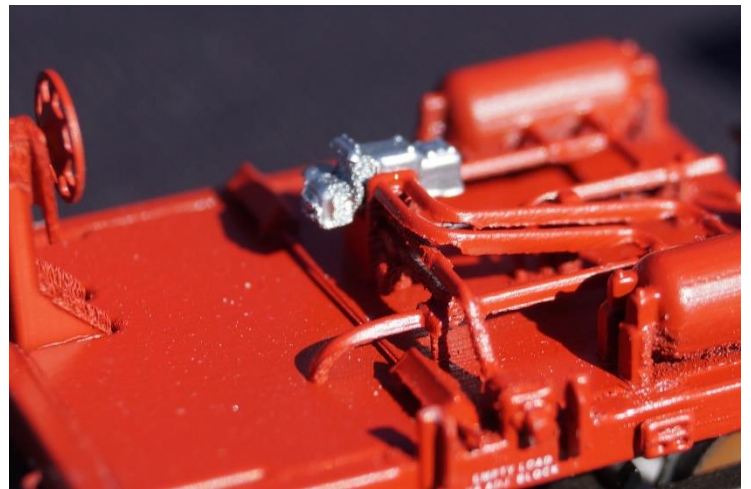
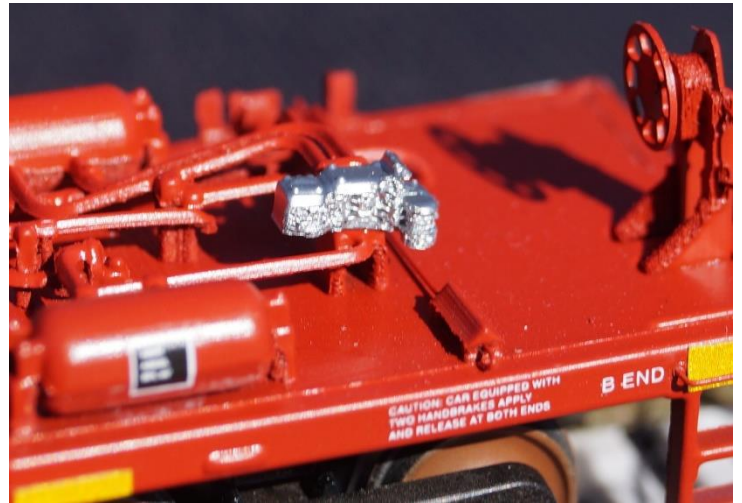


3. Apply CA to the mating surfaces as shown in this picture, and place into position on the Span Bolster. Hold in position for 8-10 seconds.

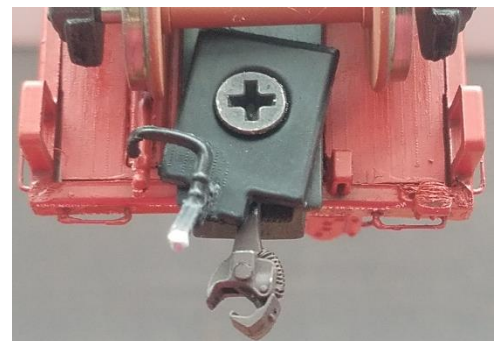




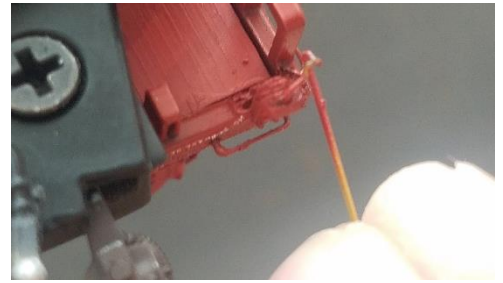
4. Remove the Control Valves and Coupler Cut Levers from Bag G.
5. Test fit the Control Valve as shown to verify the fit.
6. Apply a small amount of CA to the base of the bracket and manifold on the Platform.
7. Position the Control Valve in place and let set for 30 seconds before moving the Platform.



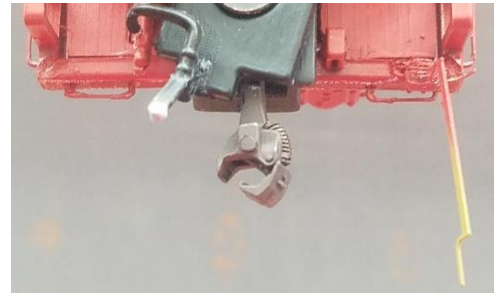
8. Remove the 1" thick top piece of foam from one of the boxes the kit came in and place in front of you.
9. Flip the entire Span Bolster/End Platform Assembly upside down and carefully place on the foam with the Brake Wheel and Stand hanging off the edge of the foam.
10. Loosen the screw holding the Coupler Cover enough so that you can angle the Coupler Cover to the left slightly as shown in this picture. *Please note that the following several pictures are of the 12 Axle cars, but the process is exactly the same to install the Coupler Cut Bar.*



11. Place the Coupler Cut lever as shown on to the bracket of the Platform End.

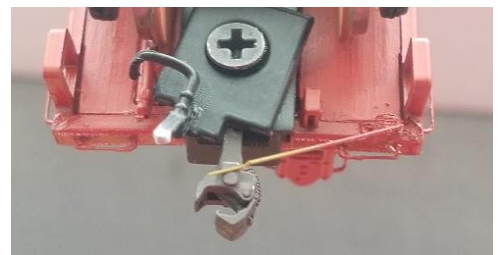


12. The Cut Lever should fall through the hole in the bracket of the Platform. Do not force it through as the bracket might break.



13. Carefully twist the Cut Lever 180 degrees along the long axis of the car. The portion of the Cut Lever through the hole will twist to your right.

14. Move the long part of the Cut Lever to your left.



15. Line up the end of the Cut Lever with the hole on the Coupler Cover, and move the Coupler Cover to the right so that it is in line with the Span Bolster.

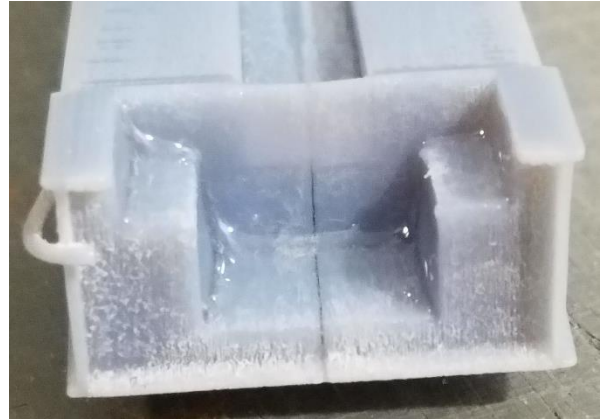
16. Tighten the Screw just enough that the Coupler Cover will not move. **DO NOT OVER TIGHTEN THE SCREW!**

17. Place a small amount of CA on the end of a toothpick and dab on both sides where the Coupler Cut Lever passed through the Coupler Cover.



## Center Body Pre-Assembly

18. Un-wrap the Center and remove the pieces from Bag C.



19. Test fit the end block, then remove.

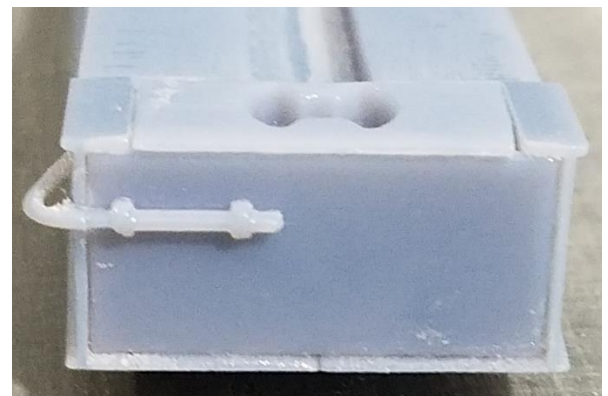
20. Apply CA to the mating surfaces on the main body.

21. Fit the end block into position and press in place for 10-15 seconds. Repeat on the other end.



22. Test fit the end pieces. File the edges if necessary to fit properly.

23. Remove the end piece, apply CA to the mating surface, then install the end piece and press in place for 10-15 seconds.



24. Partially test fit the Body Recess Covers on the underside of the body near the ends.



25. Use a small file on the edges if necessary so the cover fits easily.



26. Apply CA to the recessed face and install the Cover. Use a small flat object to press firmly in place.



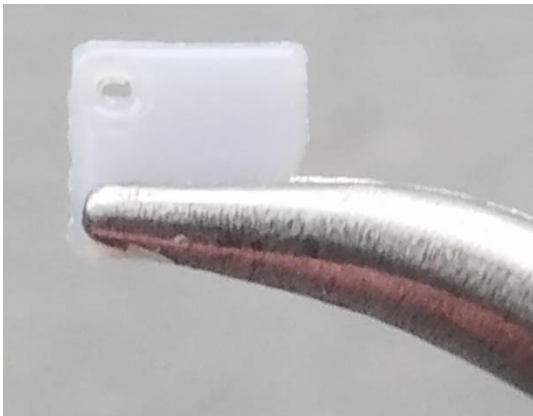
27. The main body is comprised of 4 pieces that sandwich magnets and steel plates. The seams have already been wet sanded, however, you may want to finish this further to your satisfaction before proceeding. HINT: Spraying a coat of primer on the body will make any imperfections more visible. HINT: CA makes a great filler with the material used on our models. Apply the CA, then use a clean toothpick to smooth the area and let dry. Traditional plastic filler material probably WON'T WORK. HINT: If you add any filler or primer, wet sand with 400 grit sandpaper or finer grit. **Do not use anything coarser than 400 grit paper.**

## Paint Center Body

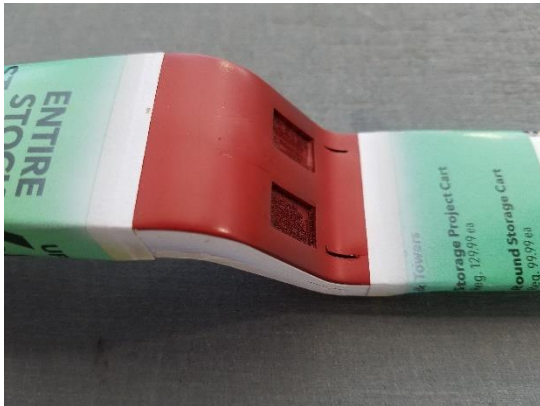
1. Remove the small parts from Bag D. There are 4 Shear Plates (thick rectangles) and 4 Weld Plates.
2. Because the body and separate parts are somewhat translucent, we **highly recommend priming it before painting**. Any light color primer will work.
3. Paint the Body, Shear Plates, and Weld Plates. For road numbers 164001-164004, we recommend Tru-Color Chinese Red, part number TCP-012. But any darker red color will be fine, especially if you plan to weather the car. Use the models on our website as reference or other photos online of these cars. Using a gloss paint will allow the decals to go on easier without having to apply a separate clear gloss coat. For 164000, use a medium blue.



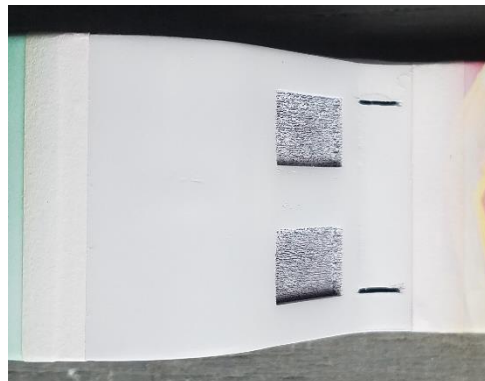
4. For 164001-164004, the Shear Plates and Weld Plates are also painted the same Red color. For 164000, they should be painted a light Grey. HINT: The bottom of the sheer plates has the matte finish and the tops are smooth. Place the sheer plates on double sided tape to hold in place while painting. HINT: Use small tweezers or needle nose to grab the corner opposite the holes on the flat Weld Plates. This area will be hidden during final assembly, so does not have to be 100% covered.



5. When the red has dried and cured, it is time to paint the large white areas. To make this easier for you, there are two masking tools inside Bag C.
6. Place the masking tools into the sides opposite each other. Use the picture as a guide to tape the masks into place. Use a light adhesion tape designed for masking paint.
7. The tape on the top deck should be placed where the taper of the deck plating meets the thin section of plating. Wrap the tape around under the body to hold the masks firmly in place.
8. On the lower deck, place tape 1/16" away from the edge of the recessed pockets for the Weld Plates. Wrap the tape under the body to hold the masks in place. Use paper to shield the body from paint.

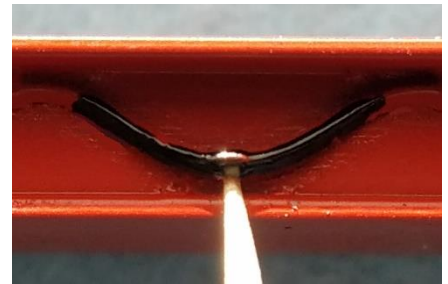
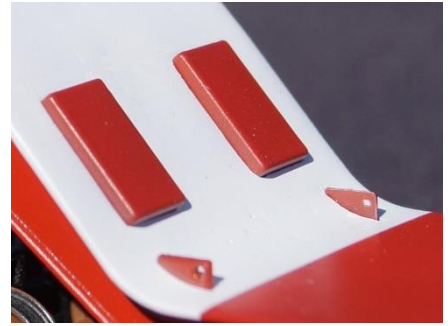


9. Paint the exposed area gloss white. This includes the edges of the deck in the transition areas.
10. Remove the masking shortly after spraying and is dry to the touch. Don't let set overnight though.
11. Mask the other side and paint. Remove the masking as before.
12. Let the paint cure.

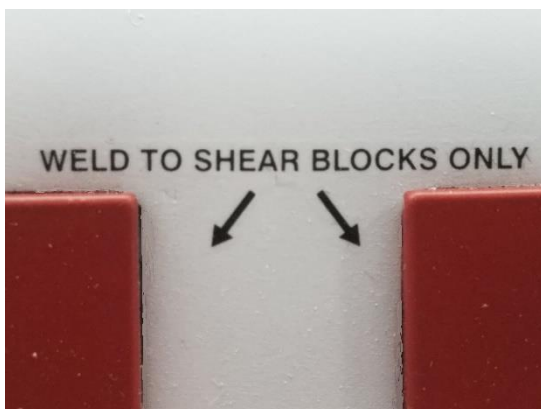


### Center Body Final Assembly and Decoration

1. Apply a little CA to the inside of the Sheer Plate cavities on the Body.
2. Insert the bottom side of the Sheer Plates into the cavities.
3. The thin Weld Plates can be pushed into the appropriate slots on the body. No glue is needed for these parts. Be sure the tops of the Weld Plates are parallel to the lower deck body.
4. Carefully slide a toothpick under the air hose as show here.
5. Paint the areas shown Black and let dry.
6. Move the toothpick as shown and paint Silver.



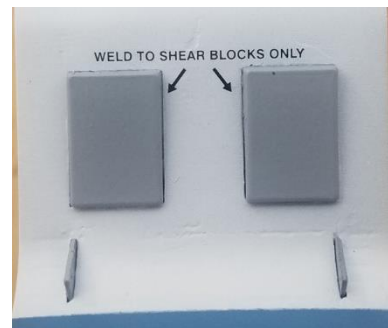
7. It is easier to place the Reflectors as shown before placing the decals.
8. Apply setting solution to the decals and let dry.
9. Both sides are exactly the same with one exception. On the side without the air line, there is an additional reflector cut in half placed in the center where the air hoses would be.
10. Apply a clear gloss coat to the sides, ends, and transition areas of the car body and let dry.





**164000 Photos**

There are a few differences between 164000 and the other road numbers. Use the photos below to choose and place the correct decals. There are no reflectors on the long span bolsters.

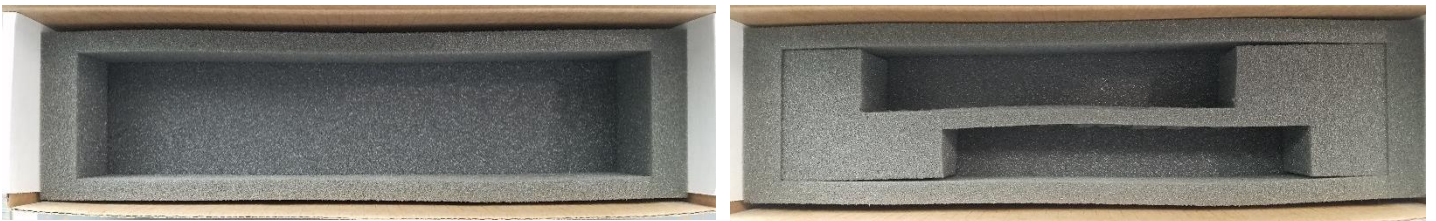


## Final Model Assembly

1. Note which side of the Body has the Air Line running end to end. The End pieces are exactly the same, except one is marked "A END" and the other "B END" on the platform sides. If looking at the Body side with the Air Line, the "A END" should be placed at the LEFT and "B END" to the RIGHT.
2. Place the Center Body upside down on a padded surface with the Air Line away from you. That way the "A End" will be on the Left and "B End" on the Right. The thin foam sheet the body was originally wrapped in will work great here.
3. Remove the remaining two 3/8" #2 screws from Bag G.
4. Take one of the car ends, turn it upside down and line up the center of the span bolster with the receptacle and hole on the appropriate body end.
5. Place one of the screws through the center of the span bolster and tighten the screw until you feel some resistance. The Span Bolster should turn side to side freely. If it doesn't, back the screw out 1 full turn so that it turns freely.
6. Repeat for the other side. The car is now complete and ready to be placed on the track.

## Congratulations, you have finished! Now go enjoy your car on the track.

To store your car long term, just reverse the steps above. Wrap the body in the foam sheet, place in the box with the foam cutout for the body, add the top layer of foam and close the box. Unfortunately a foam insert for the Span Bolsters/End Platforms would not fit in the box with the parts. You can cut up other foam you may have like that shown below to create pockets that the end pieces of the car will fit in.





LIFT HERE JACK HERE LIFT HERE JACK HERE LIFT HERE JACK HERE LIFT HERE JACK HERE LIFT HERE JACK HERE

2 INCH HF COMP SHOES 2 INCH HF COMP SHOES 2 INCH HF COMP SHOES 2 INCH HF COMP SHOES 2 INCH HF COMP SHOES

CAUTION: CAR EQUIPPED WITH TWO HANDBRAKES APPLY AND RELEASE AT BOTH ENDS CAUTION: CAR EQUIPPED WITH TWO HANDBRAKES APPLY AND RELEASE AT BOTH ENDS CAUTION: CAR EQUIPPED WITH TWO HANDBRAKES APPLY AND RELEASE AT BOTH ENDS CAUTION: CAR EQUIPPED WITH TWO HANDBRAKES APPLY AND RELEASE AT BOTH ENDS CAUTION: CAR EQUIPPED WITH TWO HANDBRAKES APPLY AND RELEASE AT BOTH ENDS

EMPTY LOAD 1/4 ADJ. BLOCK EMPTY LOAD 1/4 ADJ. BLOCK EMPTY LOAD 1/4 ADJ. BLOCK SPRG 7 DS OC 7 DS IC SPRG 7 DS OC 7 DS IC SPRG 7 DS OC 7 DS IC L- 148" - 82" L- DECK 40" - 00" L- 148" - 82" L- DECK 40" - 00" L- 148" - 82" L- DECK 40" - 00"

SBS27DE COUPLER SBS27DE COUPLER SBS27DE COUPLER G-8 15 CUSION UNIT G-8 15 CUSION UNIT G-8 15 CUSION UNIT 36" WH. 36" WH. 36" WH.

DECK LENGTH 48" 9" DECK LENGTH 48" 9" DECK LENGTH 48" 9" CAR LENGTH 148" 9" CAR LENGTH 148" 9" CAR LENGTH 148" 9" CAR WIDTH 9" 9" CAR WIDTH 9" 9" CAR WIDTH 9" 9"

WELD TO SHEAR BLOCKS ONLY

WELD TO SHEAR BLOCKS ONLY

A END B END FD DO NOT HUMP

A END B END FD DO NOT HUMP

A END B END FD DO NOT HUMP

LD LMT 802900 LD LMT 800900

LT WT 341100 LT WT 339100

LD LMT 802900 LD LMT 800900

LT WT 341100 LT WT 339100

LD LMT 802900 LD LMT 800900

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Red 'n Ready Red 'n Ready Red 'n Ready



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