



# WEST SIDE HEAVY DUTY ARCH BAR TRUCK

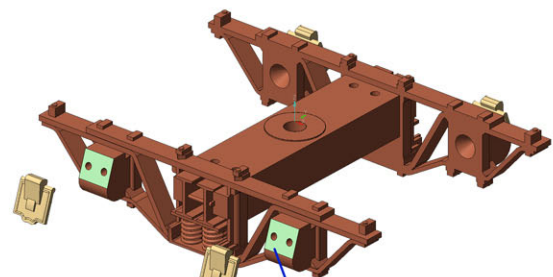
Sideframe & Bolster Assembly

Side Bearer

Tie Strap

Ream All Side Bearer Holes using #69 or 1/32" Drill

Check size of hole for fitment of your truck screw and ream if necessary...



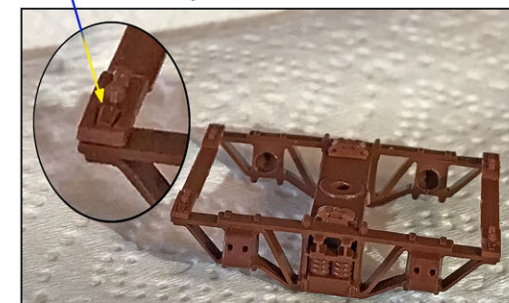
Apply ACC Here One at a time... (Small amounts please...)

Apply "Kicker" Here (ACC Accelerator)

Assemble together and hold for 10-15 seconds... Done!

"Keystone" shaped lug on end of truck...

Strap has hole to match... Should just snap in place... Use a tiny drop of ACC to hold it forever...



Journal Lids / Covers

Ream All Journal Lid Holes using a #72 drill. (0.65mm) (8 Holes)

Note that these holes are perpendicular to the side frames, NOT the journal faces...

### ASSEMBLY HINTS

1. Examine the major parts for casting flash and carefully remove any that you see, especially around the Spring Plank & Brake Shoes... Follow the illustrations on this page for the best results... Carefully desprue small parts only as you need them to avoid losing them...
2. Fit Side Bearers in place and ACC from inside bolster...
3. Fit Wheelsets into trucks with insulated wheels on same side, splaying of side frames is OK for this step... Ok... Go for it! You can test roll it now!
4. Snap end straps over "keystone" shaped lugs...
5. Fit journal lids in place...
6. Insert and test your truck screw...
7. Install spring plank and test roll again... It should roll like the wind... If not, make sure spring plank is seated in bolster correctly and brake shoes are level as vewed from the side... Fix in place with ACC...

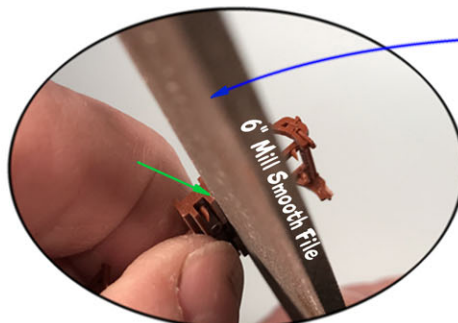
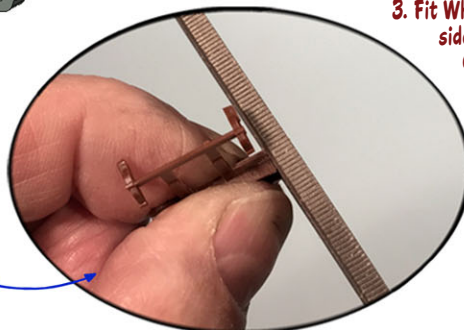
Spring Plank / Brake Shot

Flat File Ends and Bevel Slightly... Make sure to take the same amount off each end... In our case about three passes were sufficient...

Flat File / Chamfer Ends of Spring Plank as Shown...

Spring Plank / Brake Shot

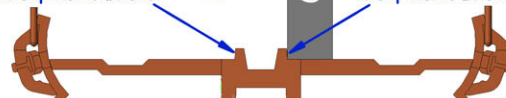
Spring plank needs to fit snugly between truck's side frames, but not so tight as to cause side frames to splay outwards. You will be gluing this shot in place later anyway...



File in this direction

Remove enough material here to allow spring plank to slip inside bolster

Remove enough material here to allow spring plank to slip inside bolster



LH

Diagonal Cut

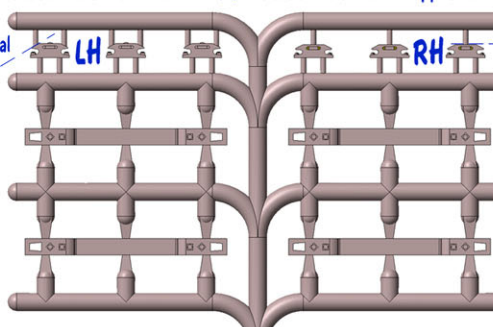
NOTE: LH & RH side bearers are NOT the same...

These are fitted to one truck These are fitted to opposite truck



RH

Straight Cut



WSLco HD Archbar

Truck - Detail Shot

Note: We included one extra of each style of side bearer "just in case" ... (Just in case you lose one!)

