MJT
scale components

Ref. 2900. BR Standard 63' 6" Coach Underframe.

INSTRUCTIONS

Manufactured by
Dart Castings, 17 Hurst Close, Staplehurst, Tonbridge, Kent, TN12 0BX

Made in England
Scale Models for Adult Collectors.

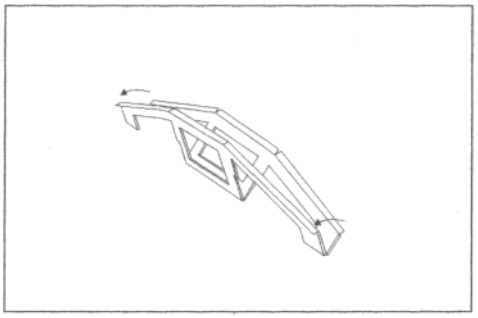
Stage 3. Fitting the Detailing Parts (if used)

- Position brake cylinder 'V' hanger behind solebar in line with inner bracket (on the floorpan main trussing). Open out the hole in the cast crank to 0.45mm
- Cut a length of 0.45mm brass wire to suit the brake cylinder brackets, thread through the brake crank and solder to the inner brackets. The remaining rodding can be added from more wire if desired.
- If you are using our coach compensation units***,** the mounting plates from the CCU fret can be soldered onto the floorpan using the half etched parallel lines as a source of location. If using our rigid bogies***** the cast mounting plate can be similarly positioned.

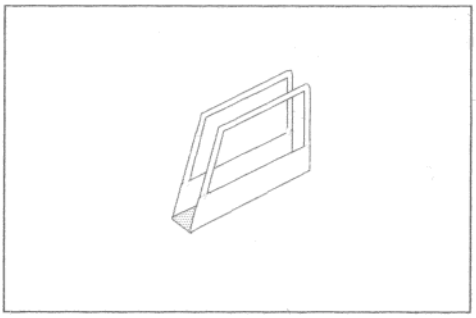
Stage 4. Attaching Ends

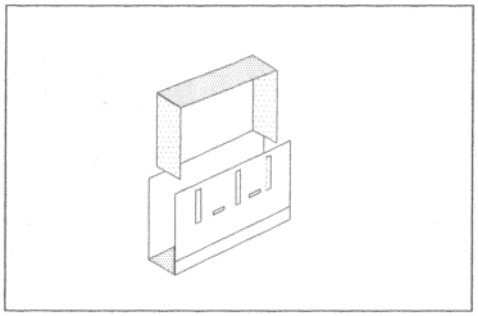
- Etched locating plates to allow the attachment of cast ends are supplied. These should be bent through 90 degrees. They fit behind the buffer beams and can be soldered or glued behind the end casting. A brass nut can be soldered on the upper face of the mounting plate.
- Once fitted there should be sufficient clearance between the mounting plate and the floor pan to take a false floor of 20thou plasticard.

Cross Struts

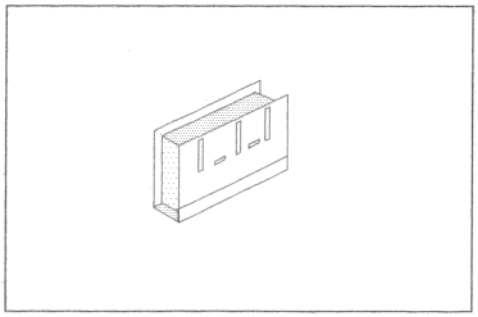


Regulator box bracket





Battery box and sides



Battery box completed

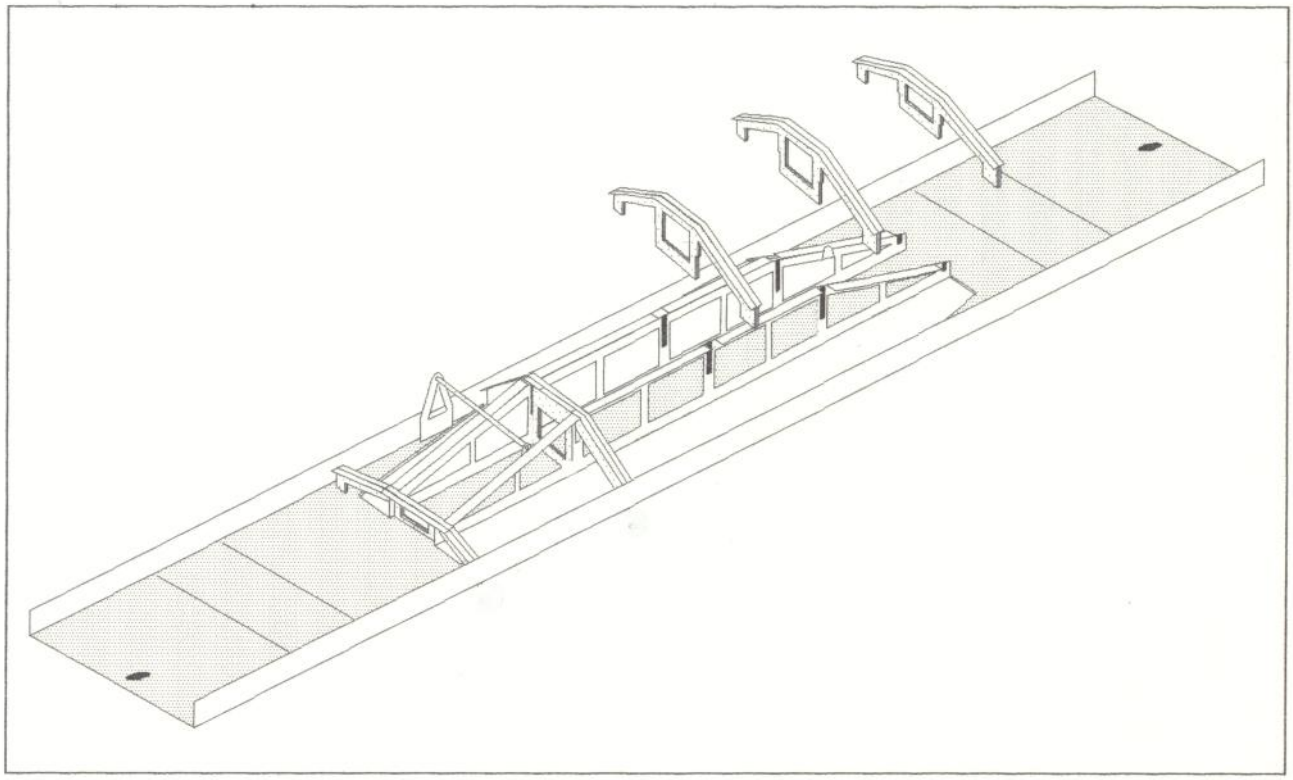
***** MJT coach suspension systems are ideal for use with this underframe kit. Choose from a wide range of wheelbases. Ref. 2221 (10'), 2222 (9') 2223 (8' 6") 2224 (8') and 2225 (7'). There is a wide range of cosmetic sideframes are available to suit the above. MJT also supply 'rigid' cast bogies.
Cast ends for many BR (SR) units are available such as 4CIG/BIG/VEP/TC or 2-4EPB, 4HAP/MLV, 4CEP (refurbished) and 3H DEMU's. Etched brass sides are available for all of the above. Check out our web-site at *www.dartcastings.com* and *.co.uk.*

BR Mk1 Underframe - Assembly instructions

Note:
This kit will produce an accurate model of a BR standard 63' 6" coach underframe. It is intended for modellers who wish to improve the underframe detail of proprietary 'modern image stock such as coaches produced by Hornby, Bachmann etc. It is also suitable as a base for scratchbuilding or for use with our own (and other's) etched sides, roofs, ends and bogies.
This product includes etched battery boxes, brake 'V' hangers and regulator box bracket as used by BR Mk 1 coaches. It also contains detailing parts. Not all of these fittings were used on all vehicles , e.g. BR (SR) EMU/DMUs. Check your prototype.
All 90 degree bends are made with the half etched fold line on the inside of the bend, 180 degree bends are made with the half etched fold line on the outside.

Contents
Etched sheet comprising floorpan, trussing, battery boxes, V hangers, regulator box bracket and coach end locating plates.
Castings for vacuum cylinders (2) cranks (2), dynamo, and regulator box.

Stage 1. The Floorpan.
- Remove the main floor fret from the etch and carefully clean up any half etched tabs.
- Drill all brake cylinder bracket holes (if used) to suit 0.45mm brass wire.
- Fold the edges of the main truss bars through 90 degrees. This is best done first as the trussing is rather fragile. We recommend clamping the fret along the fold line between the smooth jaws of a vice. (Strips of aluminium angle make good smooth jaws).
- Bend up the solebars through 90 degrees. This is best achieved by holding the main floor pan and pressing the solebars against a hard flat surface.
- Bend up the main trussing through 90 degrees to complete the basic unit.
- Bend inner mounting bracket for the brake cylinder through 180 degrees.



Stage 2. Preparing the Cross Struts
- Remove the five cross strut components from the fret and clean up any residue tabs.
- Bend angle iron lips through 90 degrees.
- Bend main unit back on itself through 180 degrees.
- Solder/glue cross struts into slots of main trussing as shown on the diagram