

## EM4 Pair of LMS Steel Brake Coach Ends

### Assembly instructions

1. Remove the parts from the fret only when required and file off any holding tabs. The etched steps should be left attached to their strip which acts as an alignment aid.
2. Bend up the underframe fixing bracket to 90° and solder an M2 nut (supplied if this pack is bought as a component in a complete coach kit) over the hole. When soldering the bracket in place rest it on a piece of 18 thou scrap from the underframe. This will ensure that when the bodyshell is later assembled to the underframe it will sit down correctly so that the edges of the top surface of the underframe are not visible.
3. Tack solder the bracket to the end, ensuring that it is vertical and central and that the slots for the steps are correctly handed. When satisfied with the alignment complete the solder joint.
4. Tack solder the sides to the ends, keeping a close watch on the alignment. Note that the sides fit **outside** the ends. When satisfied complete the joint.
5. Check that the step strips are the correct way round and fold out the step treads as shown. Push the step assembly through the ends and solder in place.
6. Cut the aluminium roof section to length. The roof should slightly overhang the ends. Remove a small section of the rebate at all four corners to achieve a close fit over the ends.

