

Steps to making a rotary coupler on a Walthers flat bottom coal car that has had the coupler and wheel support dremeled off in anticipation of installing Glatzl couplers.

Kadee #5 couplers

K&S Stock # 1144 3/32 x 0.014 RD. BR. brass tube

K&S Stock # 1145 1/8 x x 0.014 RD. BR. brass tube

#17 x 1" small nails that fit inside the small tube and the head is larger than the large tube - select the round headed ones as the oblong heads make for non-rotary

J-B WELD epoxy, gloves, mixing sticks, coated paper to mix on

cut off excess and glue wheel support to car, using the screw to maintain correct position

Dremel a slot next to the wheel support to allow the nail head to turn.

cut off 'fake' hose, coupler ring, Dremel down stem edges to fit inside brass tube

cut off nail to 3/8" length and when coupler assembly is dry fitted - maybe cut it more. file if necessary to fit in tube

cut small brass tube to 1/2" length - actually make marks every 1/2" and cut there and the length becomes a little less than 1/2"

cut larger brass tube 3/8" length, ditto on result or not - make them 3/8" or Absolute the inner tube must extend past the outer tube more than 1/16" to allow room for the glue to be messed up during application.

file everything and clean out the insides of tubes -test all fitting and redo filing where required

glue nail into small brass tube and set on nail head to dry

fit small tube into large tube and then glue the coupler into-onto the small tube - Make sure the coupler turns in tube before it all gets really hard. - But not too soon that it moves and messes everything up.

glue large tube onto car with nail head in slot, ditto on coupler turning. Another cars coupler is used to support - position the rotational coupler while glue dries. First glueing is a layer to hold coupler, and then after it dries and the coupler is tested to turn, a second layer is applied across the top of the coupler tube and ditto on coupler turning again. This allows oopso factor correction and the final glue can be glommed onto the sides of things to make the coupler mounting as sturdy as possible.

test fit with other cars couplers - nothing to do if fit fails. smile success.