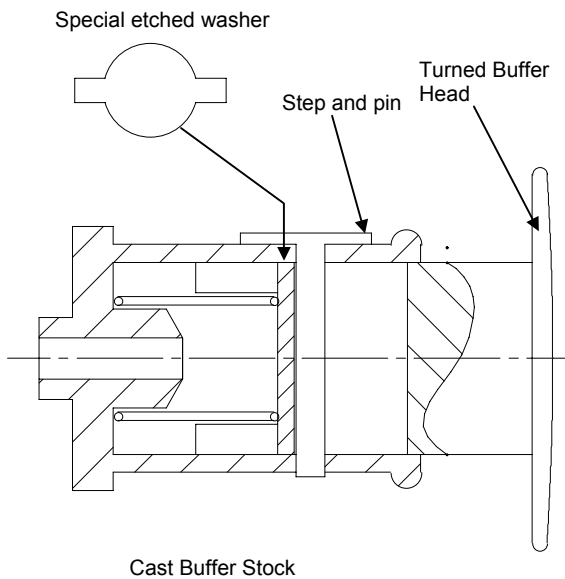
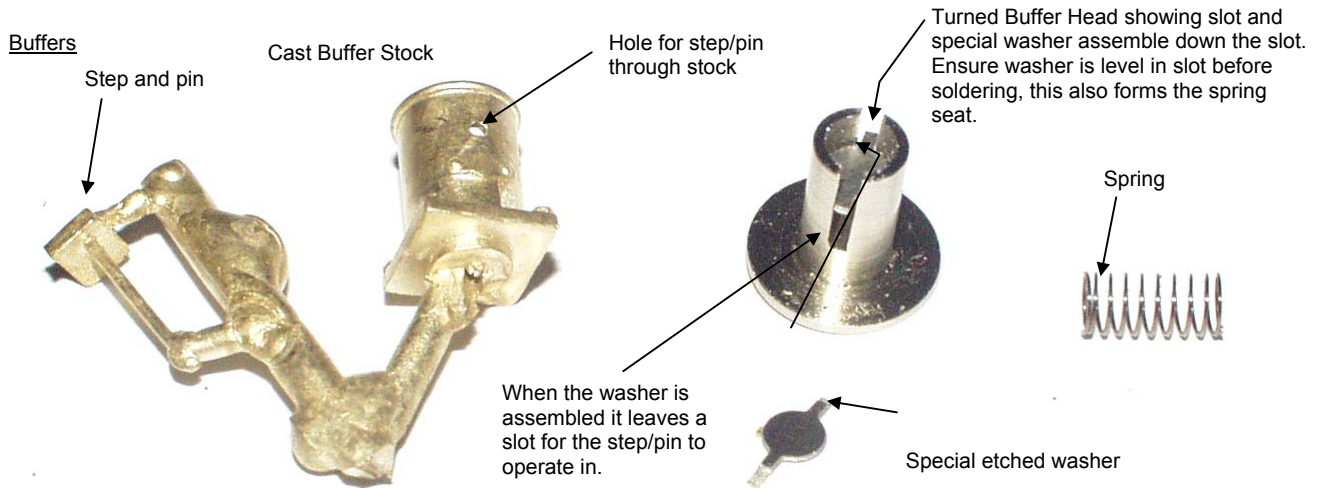




16" BR/LMS Buffer Construction
For use with Ivatt 4F Loco and 3500 Gall Tender

10/30/13



The buffers are designed as closed back allowing you to fit them without concern for nuts or other fastening devices at the rear of the buffer plank. Although described now it is recommended that only the stocks are soldered in place at this time.

Locate the various parts. The hole through the rear of the stock is for ventilation only.

Assemble the special washer to the slit in the buffer head. Ensure the washer is pushed to its stop at the bottom of the slot. Solder only the ears of the washer to the stem. Ensure the stem runs freely in the stock and ease if necessary.

Clear the hole from the top to the underside through the stock for the wire cast to the step. Ensure the step seats properly on the top of the stock. Assemble all the components to the stock and ensure free movement.

The wire on the step is secured with a tiny blob of glue to the underside of the stock to allow removal if necessary.

At this stage solder only the stocks to the buffer plank; all the remainder of the parts to be assembled after painting.

