



STEPHEN JOHNSON MODELS
PO Box 31
RED ROCK 2450

ACM COMPOSITE SITTING AND SLEEPING COACH

Assembly instructions

The ACM consisted of three sleeping, one first and two second class sitting compartments. They were divided internally into three separate sections each with access through a door on each side of the car. These vehicles were used on branch lines where there was insufficient patronage to justify the use of larger cars.

The ACMs were built using the underframe and some of the body framing of redundant BX dogbox carriages. Ten ACM cars entered service between 1932 and 1936. They were given the same road number as the BX they were derived from; namely 655, 666, 730, 799, 1723, 1725, 1838, 1945, 2045 and 2047. This model represents the ACM as built with crown lights, timber panelling, side buffers and 2AF type 'Dean' bogies. Later in life there were a number of external changes to their appearance.

Recommended adhesives:

Superglue for polyurethane parts eg. Green Zap a gap. Some brands of superglue will not stick the plastic used in this kit. Unless you know a particular glue will work, testing the glue on some scrap is recommended.

Acrylic contact adhesive eg. Selley's Kwik Grip for clear window material.

Recommended bogies:

'Dean' type bogies which are available from either Stephen Johnson Models or Ian Lindsay Models.

1. Remove any flash from the window openings with a sharp knife. Take care to avoid damaging the window frames and crown light dividers. A knife with a narrow pointed blade is recommended for the flash in the curved crown lights.
2. Cut the clear glazing material into pieces which will fit in the cast window openings. Put these aside until the car has been painted. Don't remove the protective plastic coating until you are ready to glue the windows in place.
3. Glue a piece of 8mm angle to the inside of each end to provide a flat surface level with the bottom of the end.
4. Assemble sides and ends. It is best to trial fit each joint to ensure the parts fit neatly together before applying any glue. Use the gutter line as a guide to locate the ends at the correct height. Make sure the resulting assembly is square and is not twisted.
5. Fit the roof into this assembly and glue in place. Note that the roof is directional and the vents should line up with the compartments. Fill the remaining joint with body filler and remove any excess with wet and dry sandpaper wrapped over a small flat block. Glue additional vents in the holes provided.
6. Drill # 69 holes in the stocks on the buffer beams then glue the brass buffers in these holes. Glue the buffer beams to the body assembly.
7. Glue the battery boxes and generator to the appropriate pads on the floor casting.
8. With the floor in position (2nd class end is marked), determine the correct location of the couplers in relation to the heads of the buffers (#16 Kadee couplers to mount directly on the pad at each end). Mark the centre of the mounting hole of the coupler. The coupler mounting screws (either 8BA

or 2-56) attach both coupler and floor to the angle glued at the bottom of each end. Drill a suitable diameter clearance hole and tap a thread in the angle glued to each end (Diagram 1).

9. Locate the bogie centres in relation to the bogie pivot holes on the solebar. Drill and tap suitable holes for mounting screws (suggest 8BA). Glue the bogie pivot blocks to the floor, lining up these holes. The bearing strip on these pivot blocks should be at right angles to each other.
10. Fit bogies and check coupler height. Adjust height of bogies or couplers as required.
11. Bend the V shaped truss rods. The single queen post on each side protrudes 5½ mm below the solebar. Solder the truss rod to the top of the queen post.
12. Bend pieces of 20 thou wire to right angles to form the attachments for the bogies and glue into holes in the solebars. Cut these to length so they don't foul the bogies, but from the side they appear to be connected to the bogie.
13. Fit steps under doors (Diagram 2). Bend and fit handrails from 15 thou brass wire.
14. Paint
15. Fit window material

References:

General assembly techniques: Branchline Modeller No. 1

AMRM Issue 93. November / December 1978. Pages 30 – 31, 43.

Coaching Stock of the NSW Railways (Eveleigh Press) Page 153

Diagram 1.

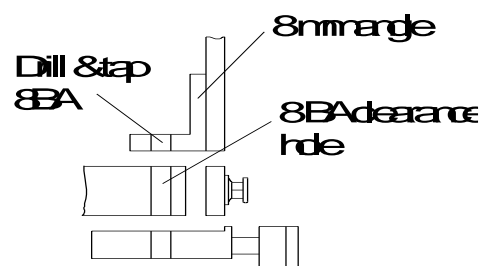


Diagram 2.

