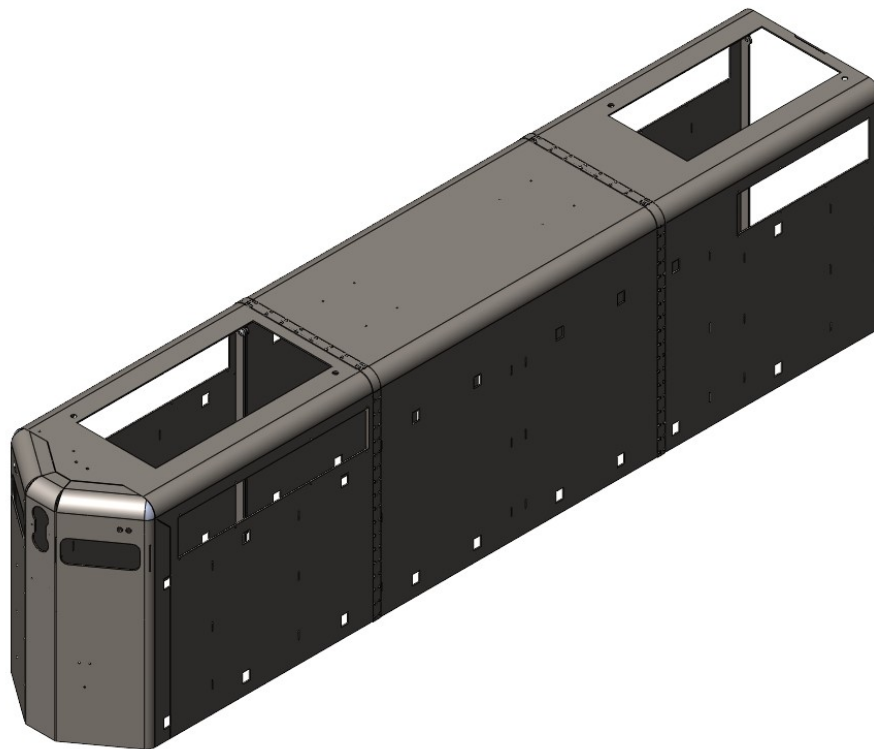


GP9 BODY LONG SECTION
FOR 1:8 SCALE



INSTRUCTION MANUAL

KIT OVERVIEW

THE INFORMATION CONTAINED IN THIS INSTRUCTION MANUAL IS THE SOLE PROPERTY OF PACIFIC DESIGN SHOPS. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF PACIFIC DESIGN SHOPS IS PROHIBITED.

Tools you may need to assemble the kit:

- Welder
- Grinder
- Clamps
- Square
- Cordless Drill
- 1-72 Tap and #42 Drill Bit
- 10-32 Tap and #18 Drill Bit
- #9 Drill Bit

Extra materials you may need:

- Frame & Trucks
- Detail Parts
- Paint
- Decals
- Common acronyms:
- BOM - Bill of Material
- PDS - Pacific Design Shops
- PSC - Precision Steel Car
- MMC - McMaster Carr

Helpful Tips

- Assemble kit together before welding to see how the parts go together.
- Tack weld the pieces together. It is easier to undo a tack than a bead.
- When applying the finishing welds, use skip welds instead of a continuous welding to avoid extreme warping and twisting.
- Weld from one end to the other to avoid warping.
- Use clamps to keep joints tight together when welding.
- Note locations of holes and mating parts, avoid welding in those areas to reduce need to come back and grind out.

See the FAQ page for more helpful tips and answers to common questions.

We want your feedback! If you see an area to improve either on the kit or the instructions, please let us know. Send your feedback to info@pacificdesignshops.com.

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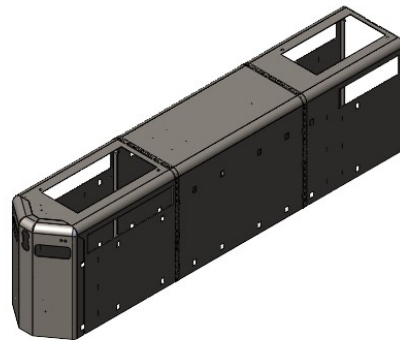
BOM OVERVIEW

Use the BOM's below for pages 4-11.

*Use the BOM for pages 2-3.

Cab Roof Parts*

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GP9B75_ST14G_K1	Cab Roof	1
2	GP9B75_ST11G_B3	Cab Roof Arches	3
3	GP9B75_ST11G_C2	Cab Roof Support	2
4	GP9B75_ST11G_D3	Cab Roof Cross	3



Long Body Weldment Parts

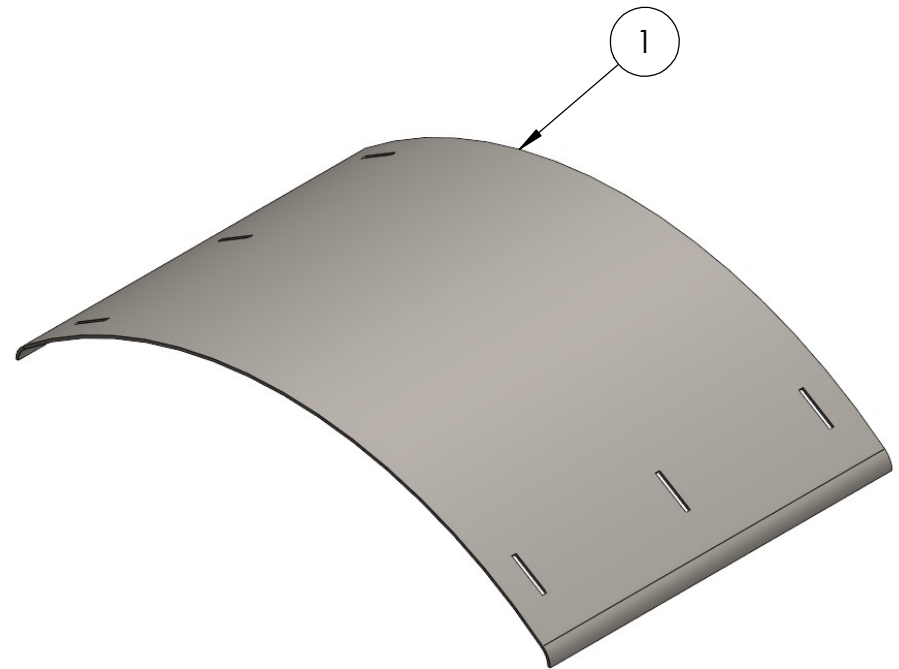
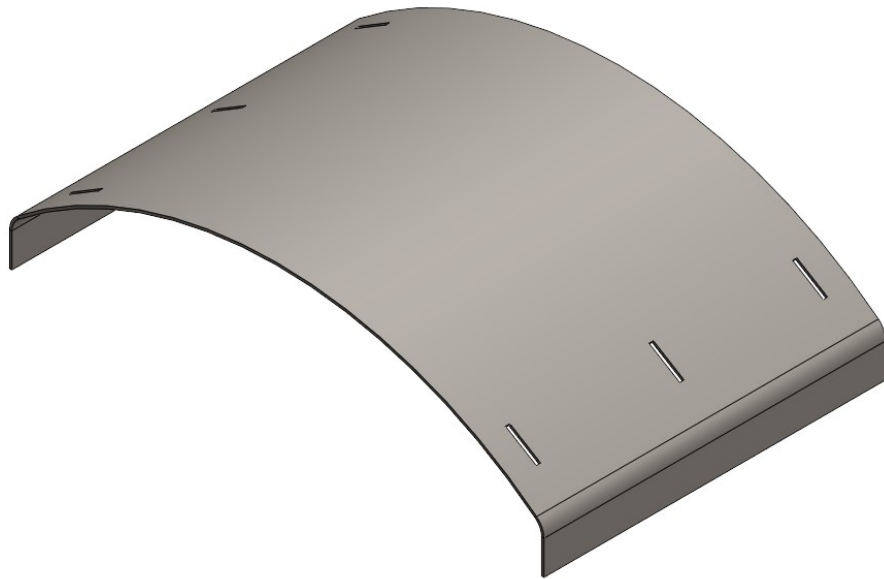
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	GP9B75_ST14G_B1	Body Rear End Nose	1
2	GP9B75_ST14G_D1	Body Rear End	1
3	GP9B75_ST14G_E1	Body Mid A	1
4	GP9B75_ST14G_F1	Body Mid B	1
5	GP9B75_ST11G_A6	Body Supports	5
6	GP9B75_ST16G_A4	Nose Filler Piece	2
7	GP9B75_ST20G_A2	Body Band	2

Hardware

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
8	MMC_91772A063	1-72 X 1/8" PHPS	176
9	MMC_92949A261	10-32 x 1/4" BHCS	8

STEP 1A: CAB ROOF

Locate laser etch lines on cab roof in location shown below. Using grinder with a cutoff disc, cut along line. Repeat on both sides.

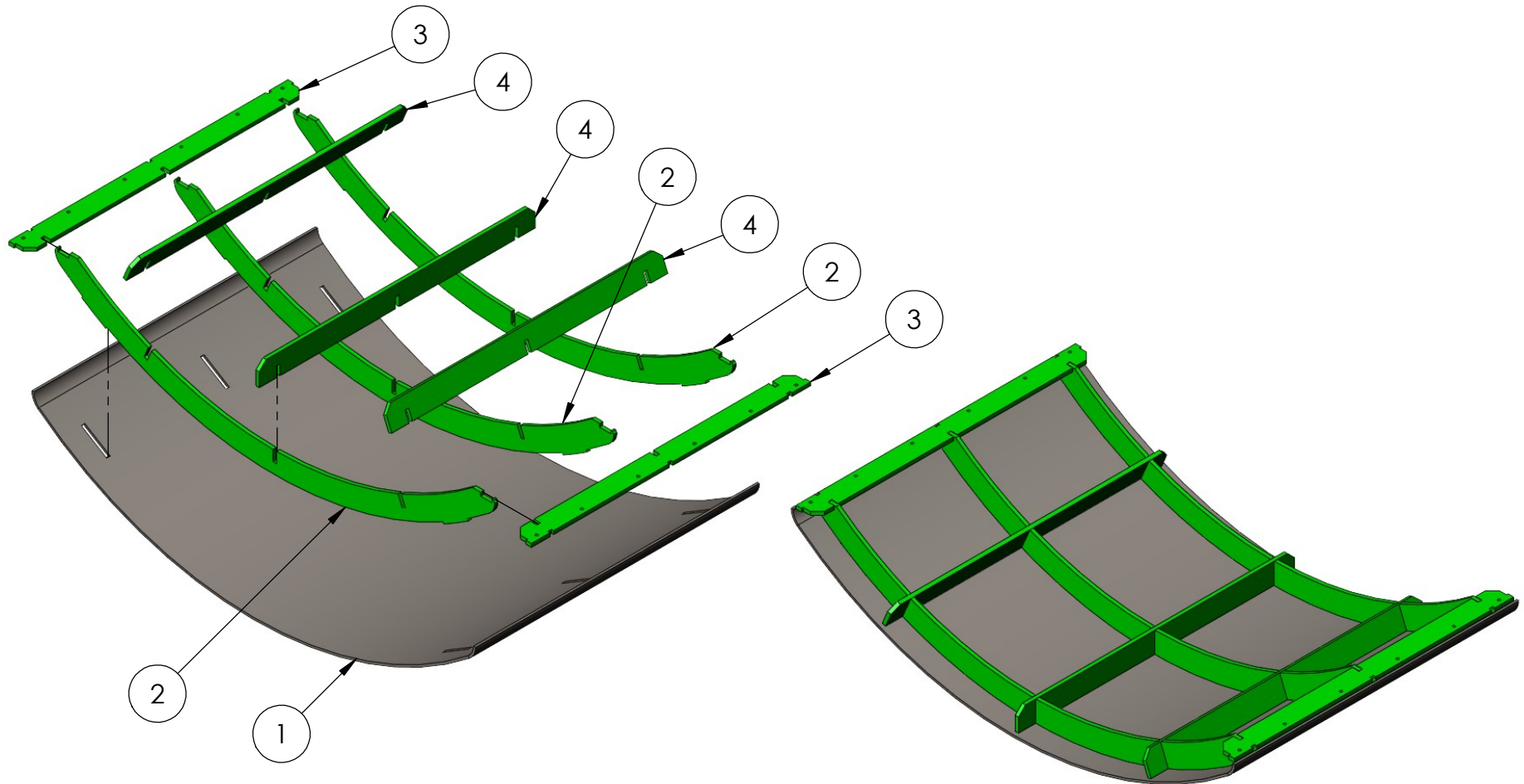


STEP 1B: CAB ROOF

*****TACK WELD ONLY*****

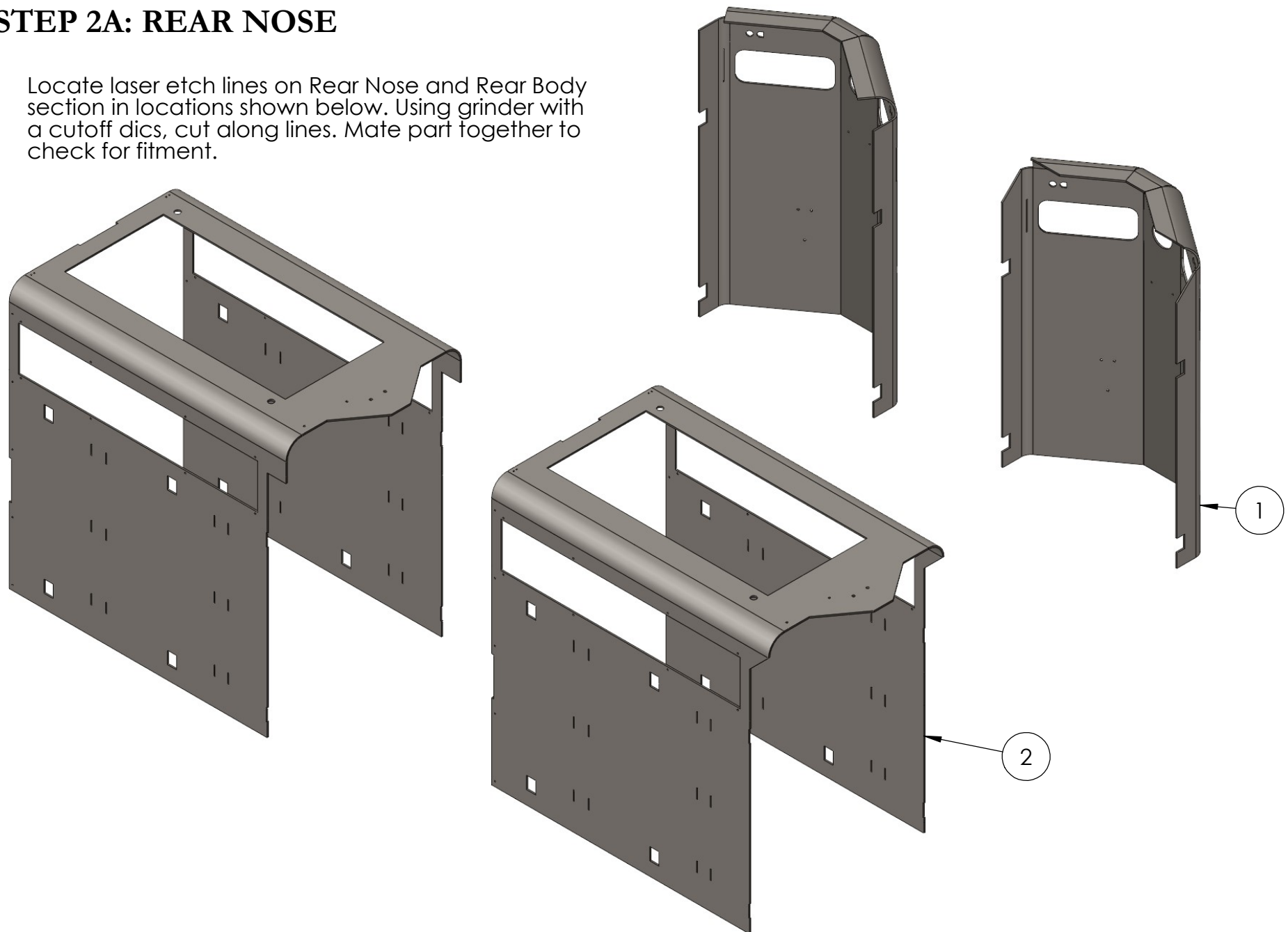
Assemble cab roof as shown below.

Recommend to only tack weld assembly together.
Stitch welding not necessary.



STEP 2A: REAR NOSE

Locate laser etch lines on Rear Nose and Rear Body section in locations shown below. Using grinder with a cutoff discs, cut along lines. Mate part together to check for fitment.

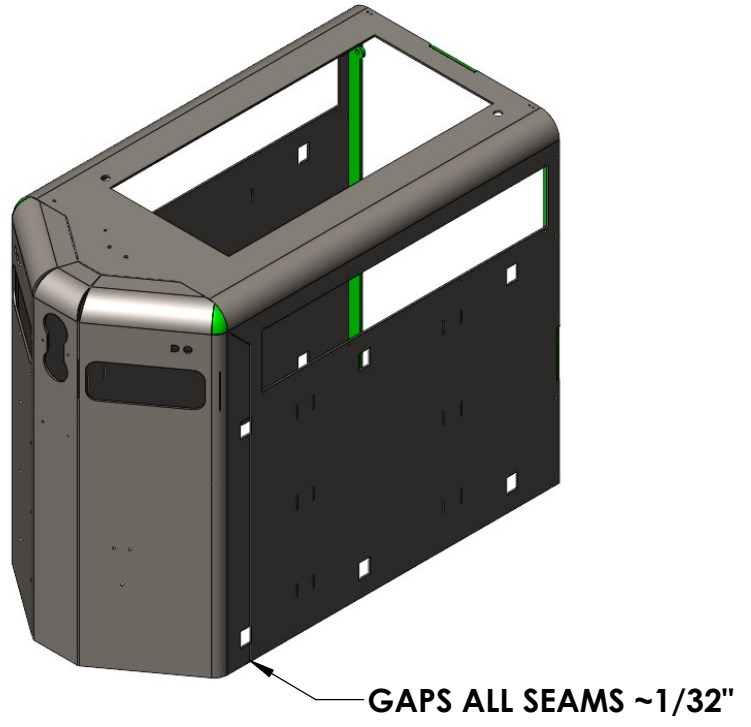
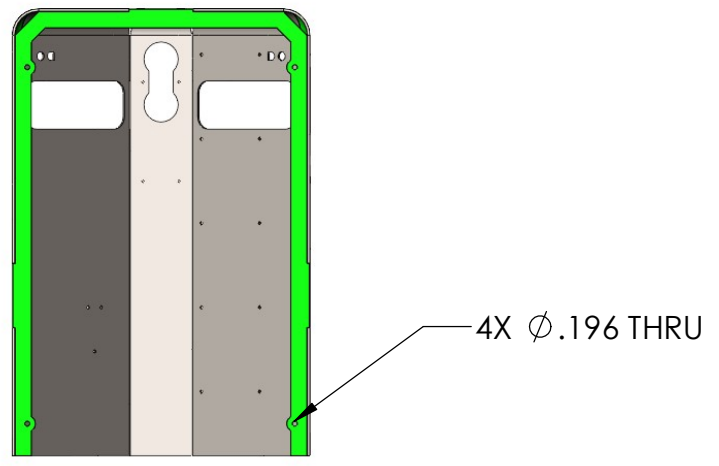
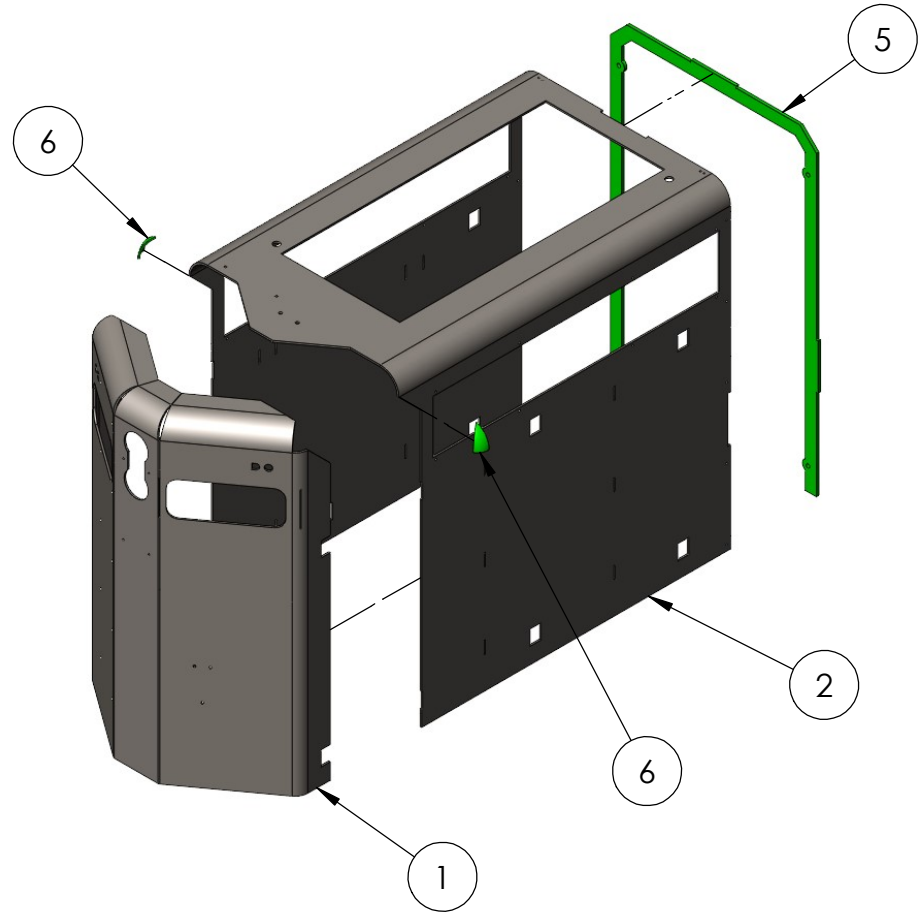


*****TACK WELD ONLY*****

STEP 2B: REAR NOSE

Assemble rear nose as shown below keeping a ~1/32" gap between all seams.

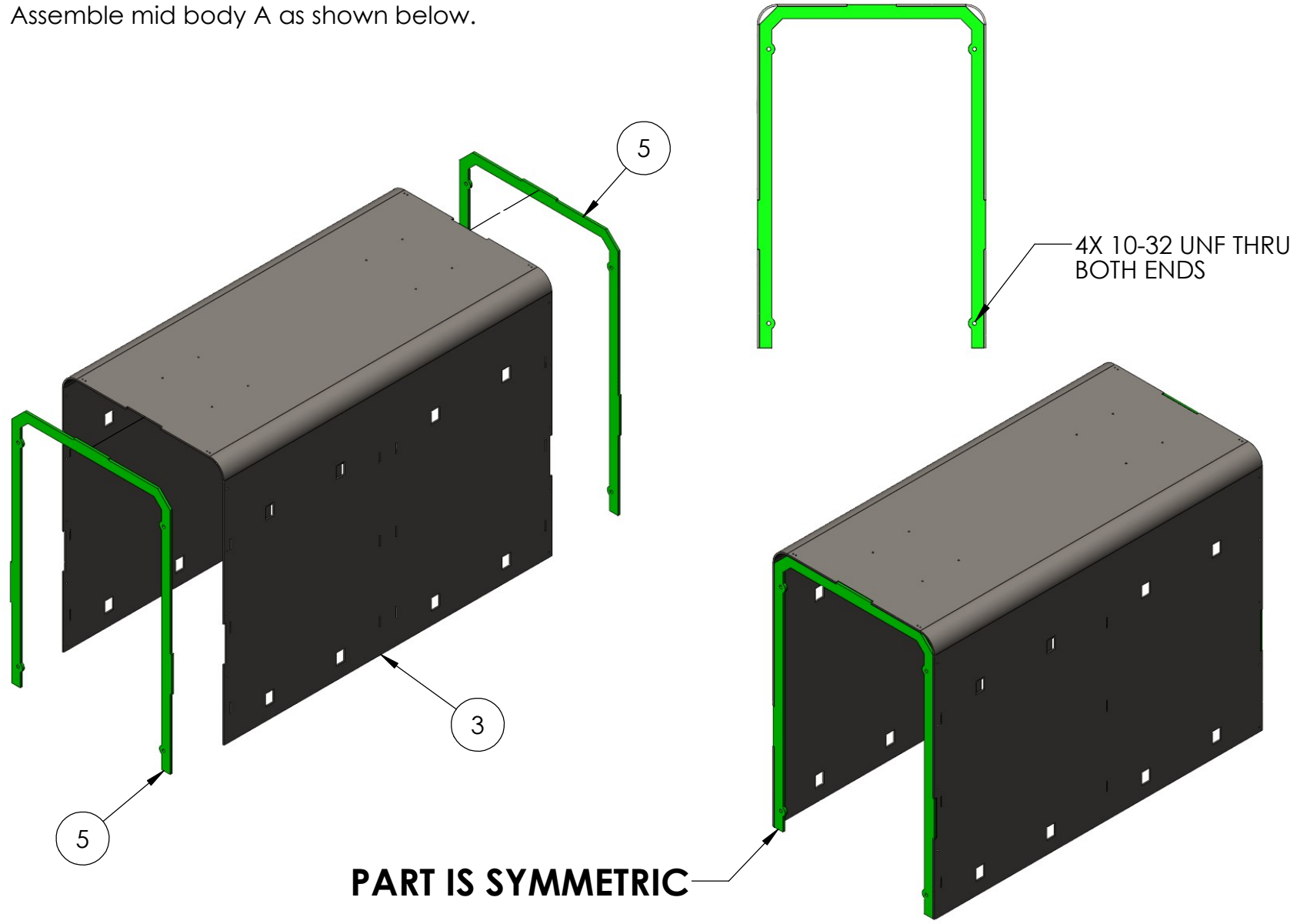
Recommended to tack weld seams every 3-4" and avoid stitch welding seams. Apply tack welds on inside of body to reduce grinding.



*****TACK WELD ONLY*****

STEP 3: MID BODY A

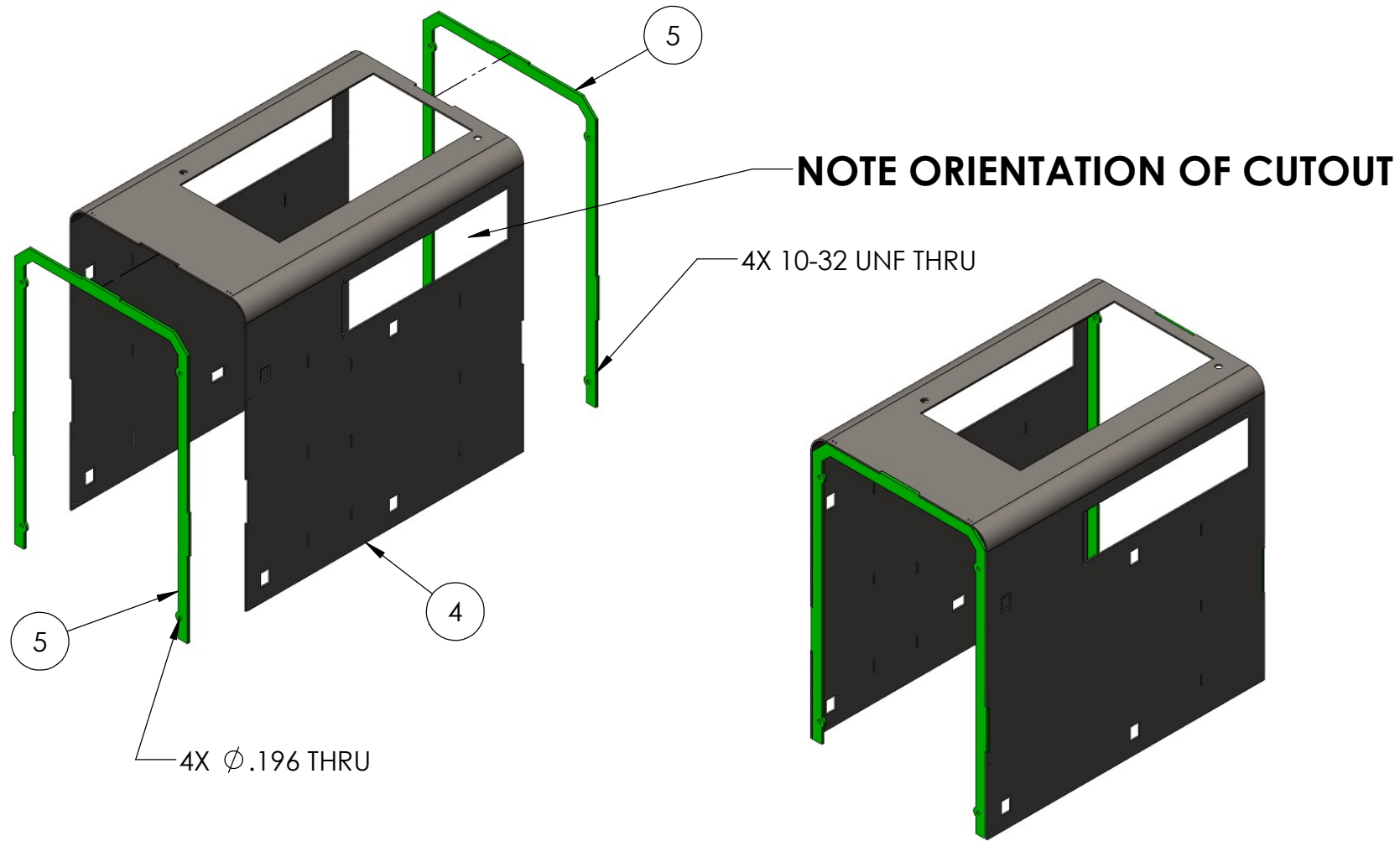
Assemble mid body A as shown below.



*****TACK WELD ONLY*****

STEP 4: MID BODY B

Assemble mid body B as shown below.
Note ends to tap 10-32 vs #9 drill bit.

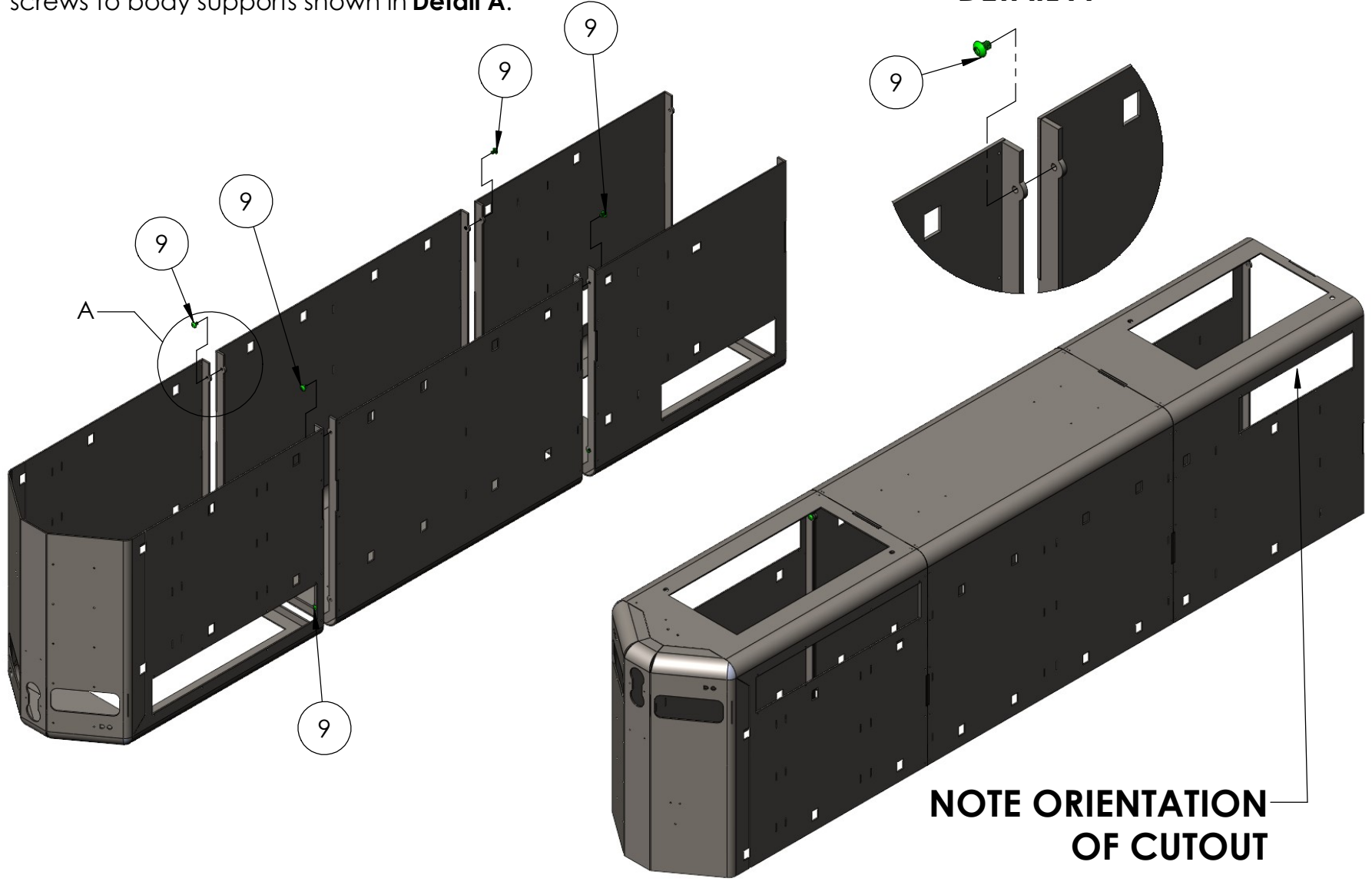


*****TACK WELD ONLY*****

STEP 5: LONG BODY ASSY

Assemble body as shown below. Note direction of screws to body supports shown in **Detail A**.

DETAIL A



NOTE ORIENTATION OF CUTOUT

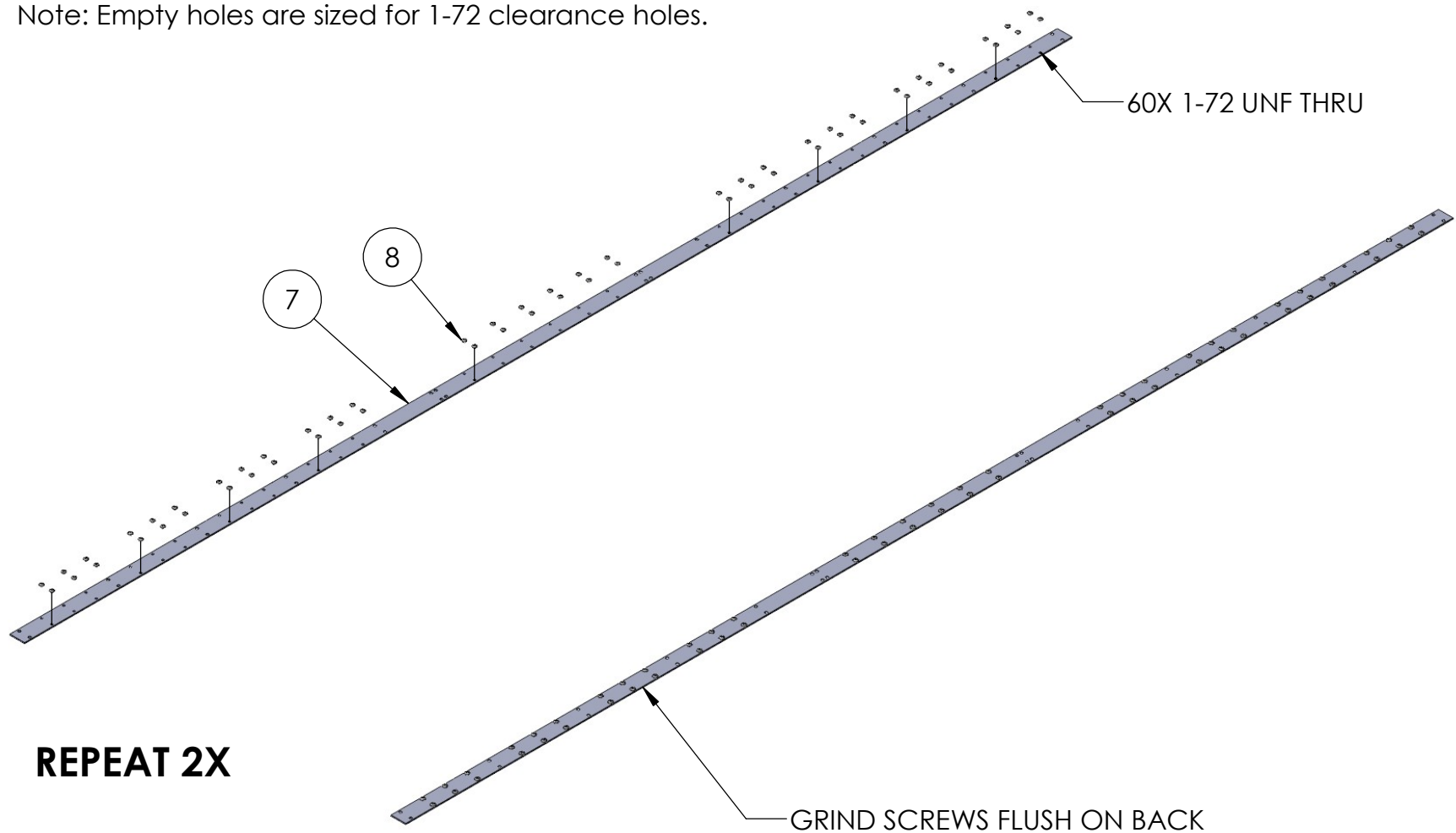
STEP 6A: BODY BANDS

*****TACK WELD ONLY*****

Drill and tap holes in body bands as shown.

Assemble screws to body band as shown below.

Note: Empty holes are sized for 1-72 clearance holes.

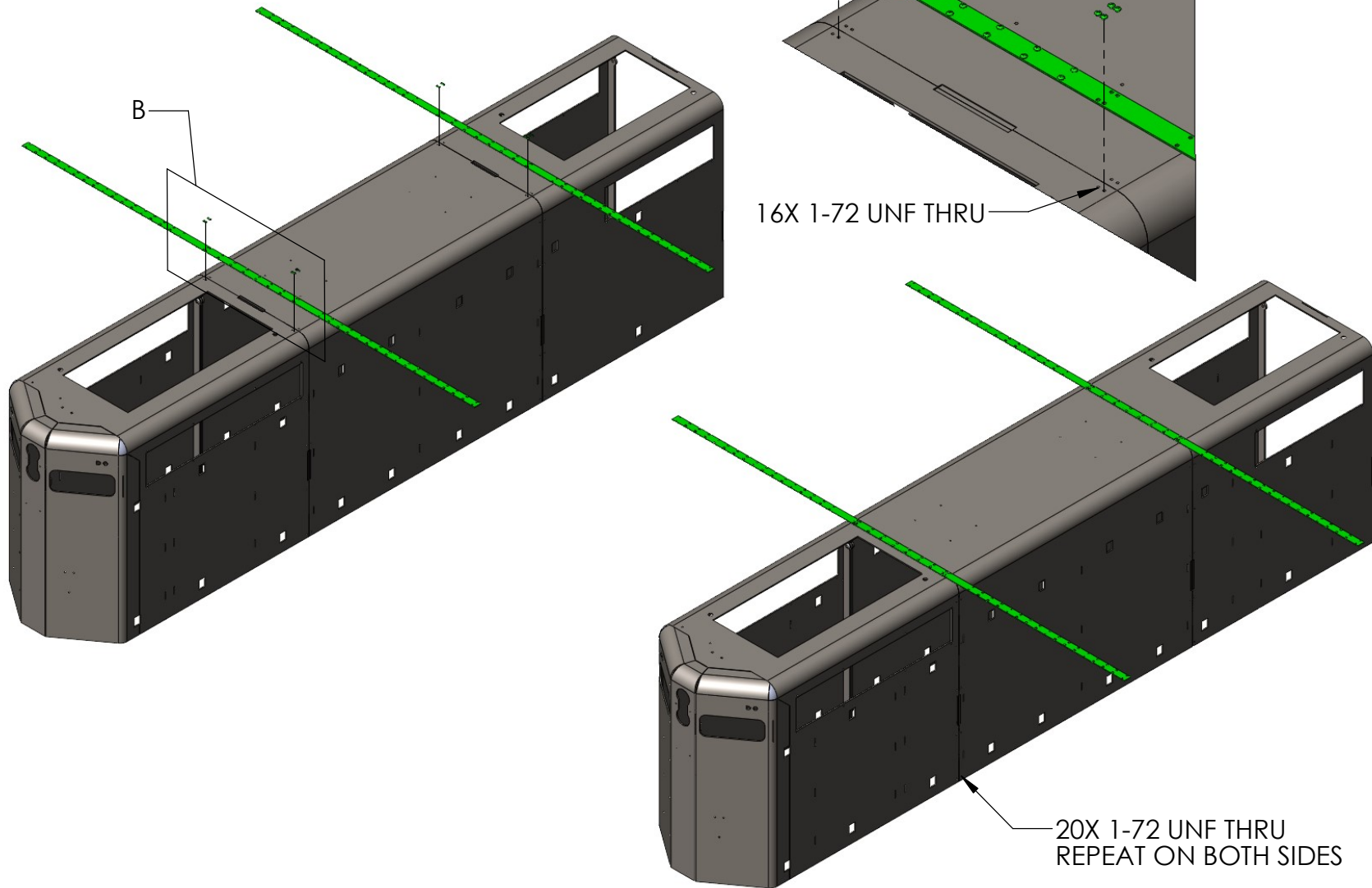


REPEAT 2X

STEP 6B: BODY BANDS

Drill and tap holes in body as shown below.

Assemble screws to body as shown below and in **Detail B**.

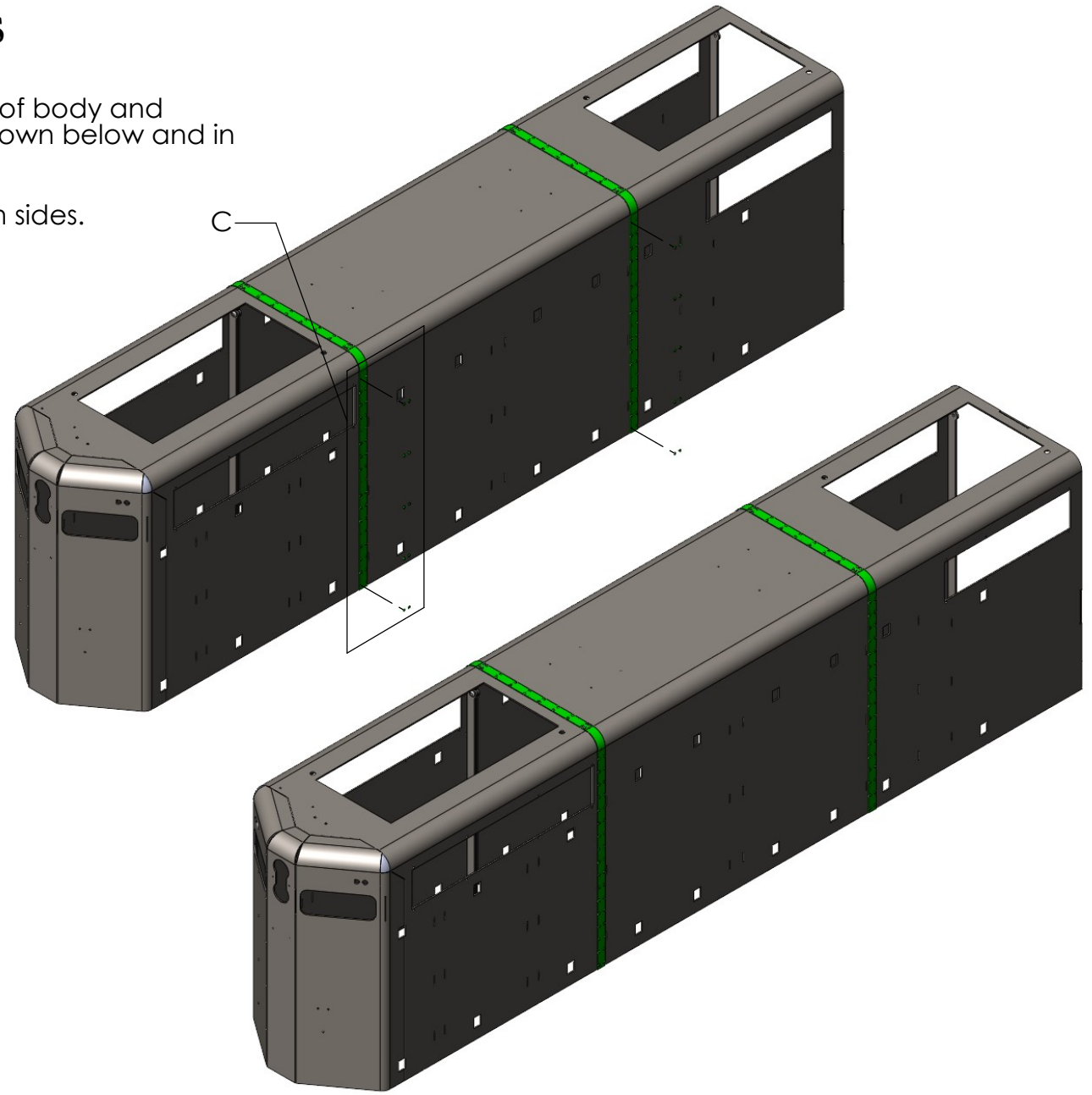
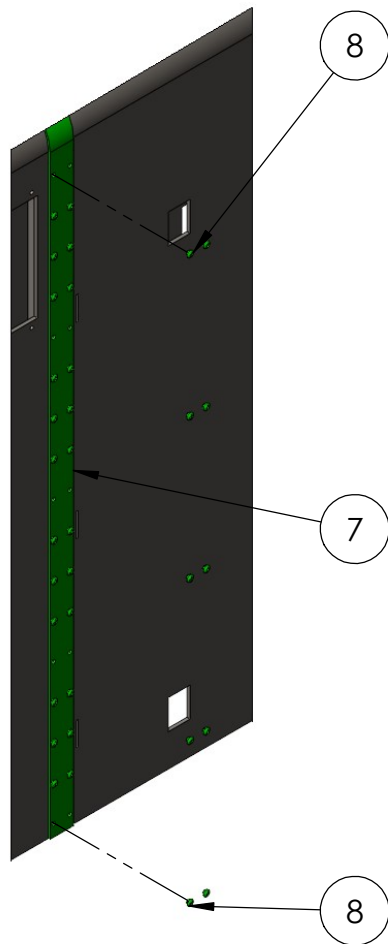


STEP 6C: BODY BANDS

Bend body bands over corner of body and assemble screws to body as shown below and in **Detail C**.

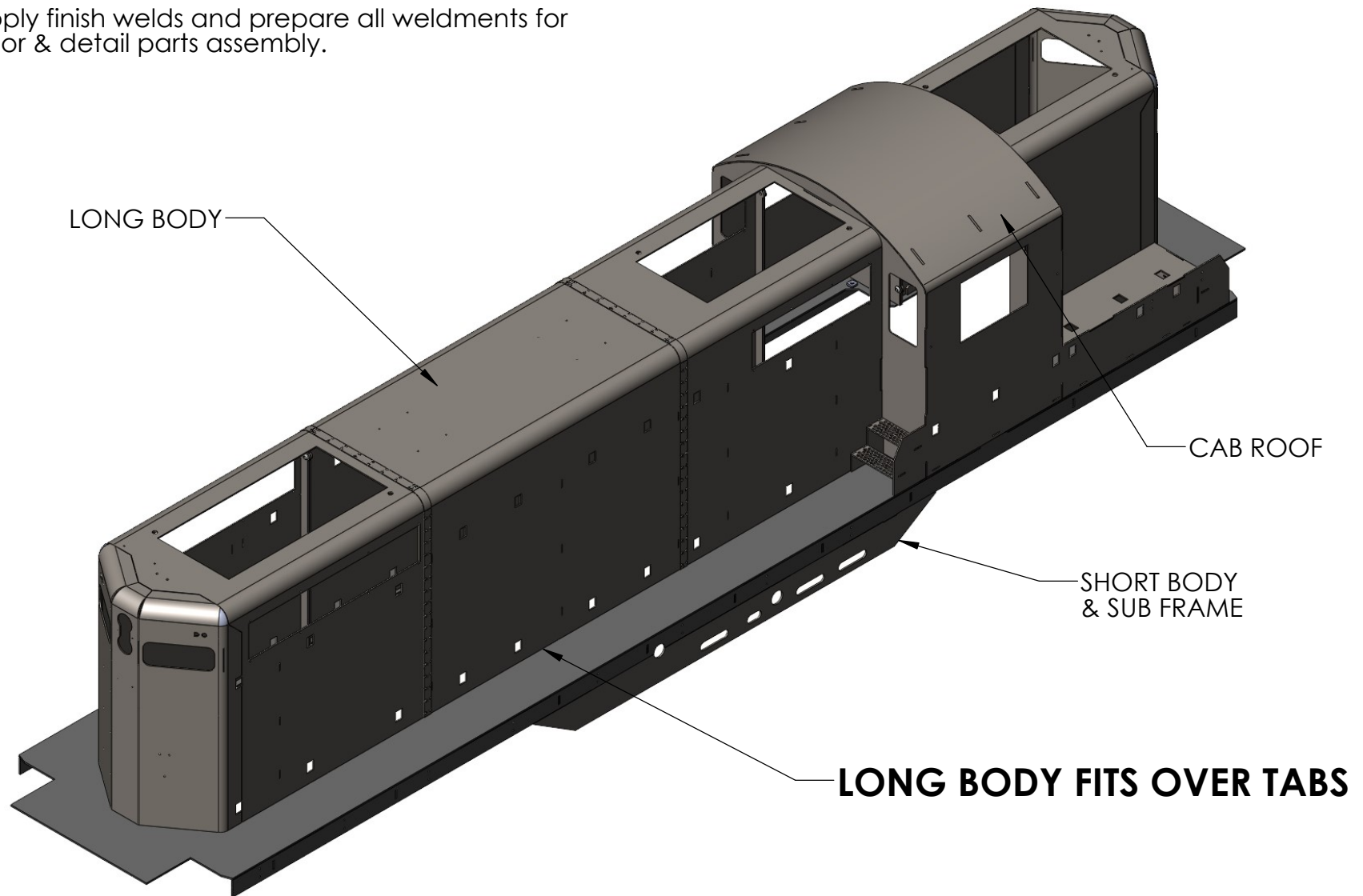
Repeat for both bands on both sides.

DETAIL C



STEP 7: BODY COMPLETE

Apply finish welds and prepare all weldments for door & detail parts assembly.



FREQUENTLY ASKED QUESTIONS

Q: My body isn't fitting together and there are gaps, what is going on?

A: Care was taken in the design to incorporate tab and slot construction to avoid having to use jigs or special clamps to hold items in the correct positions for welding but that also increases the locations for interferences to occur. Wiping down all the parts prior to welding is a good first step to remove grit from mating surfaces that may have accumulated from storage or the manufacturing process. Because of the laser cutting process used to cut out the parts, there may be some burrs on the corners. Use a file or grinder to remove them. Making sure to fit all the parts together before welding will help you locate where a problem is before items are welded together. During welding, weld BB's may get stuck to faces and should be grinded off as the steps are followed.