

9F Loco Chassis

BUILD INSTRUCTIONS BR Std 9F 2-10-0

Jan 2017

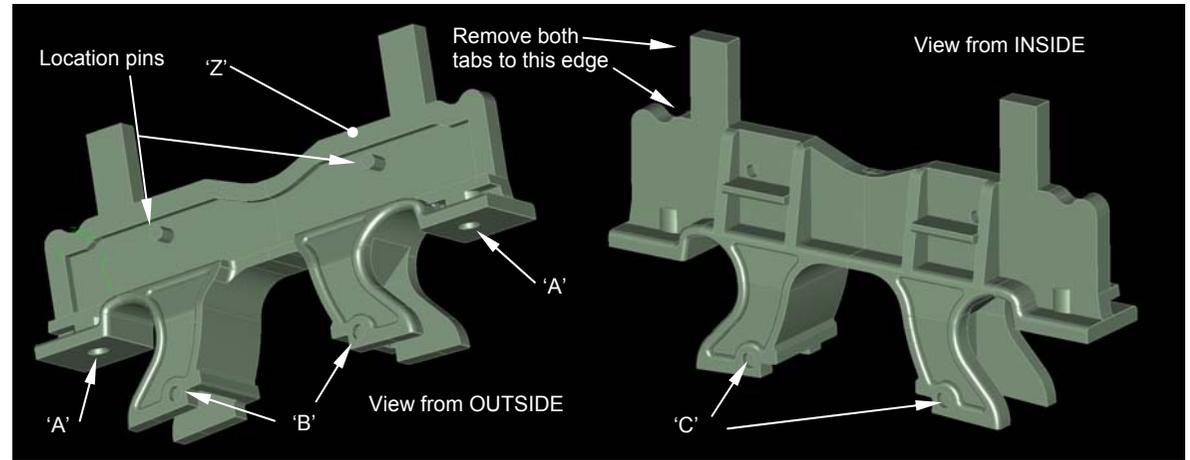
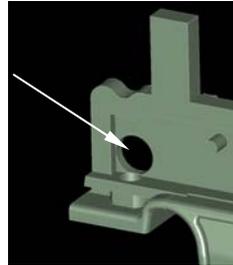
Spring Hanger casting preparation

Locate 8 off Intermediate Spring Hanger castings **Pkt 3/004** and remove from their sprues. Cut off the tabs and file back to the top edges. Clean off any flash to make tidy, make the joint face 'Z' free from any surface protrusion so that it will assemble tight to the frame side when needed later.

From the illustrations to the right take careful note of which is considered the outside and inside face of the casting.

Drill and tap holes as listed below.

- A Drill and Tap 12BA (2 places). To relieve the tip of the tap and avoid breakage, a 2mm dia hole may be drilled on the corner prior to tapping as shown.
- B Drill and Tap 14BA through **OUTSIDE** flange **ONLY**
- C Drill 14BA clear through **INSIDE** flange **ONLY**. Chamfer hole carefully to accept 14BA Csk screw

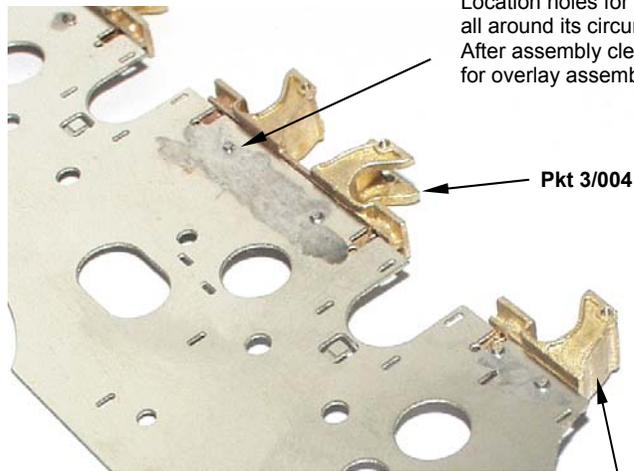


Likewise locate the end Spring Hanger Castings **Pkt 3/001** and **Pkt 3/003**. Treat the same as for the intermediate.

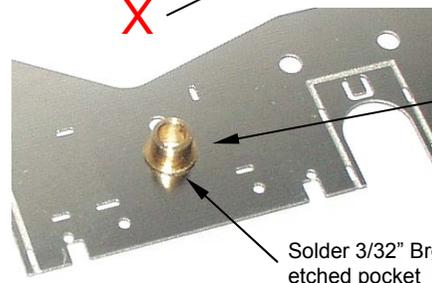
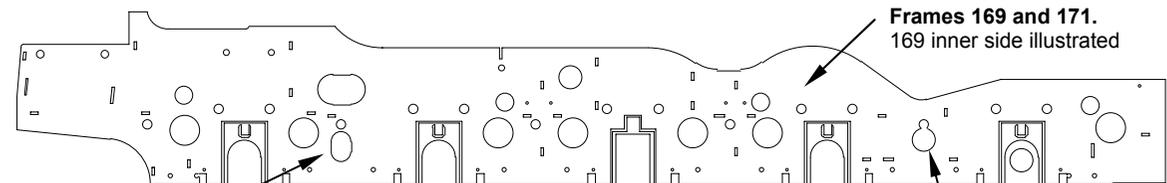
Solder ALL spring Hangers in place to the **INSIDE** face of the Chassis Frames as shown below left.

Location holes for the pins on the castings may need to be opened to suit. Ensure the brackets are tight to the frame all around its circumference before soldering.

After assembly clean off all projecting pins and excess solder from the outside frame surface to make smooth ready for overlay assembly later.



Pkt 3/001 LHS Front & RHS Rear
Pkt 3/003 RHS Front & LHS Rear



Locate 2 off 3/32 brass Brg and solder one each to the etched pocket toward the rear of each of the frames as shown. Do-Not confuse with the oval shaped pocket toward the front of the chassis. Ensure outside bearing surface is free from solder and that the brg flange is seated fully into the pocket.

Note the Brg flange slightly obscures the hole above it. After soldering, clear the flange from the hole with a 2mm drill or small round file.