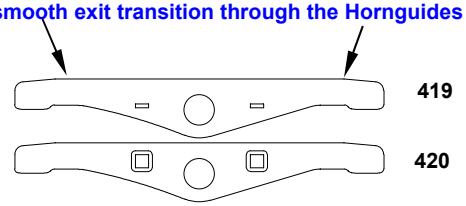
Rear Balance Beam

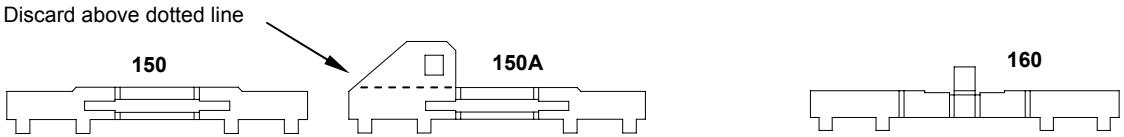
Locate the Rear balance beams from Loco Chassis sheet 2 and assemble together. Fold out the two internal tabs on **420** and assemble **419** to it. Twist tabs to retain and solder around the edges. Ensure both parts are registered and tight together prior to soldering. Clean of excess solder and tabs. Test assemble to the bearing previously soldered to the frames. Open out hole carefully to ensure rotating fit.

After assembly chamfer the top edges to ensure smooth exit transition through the Hornguides



Hornguides.

Remove the projection from **150A** hornguide to make the same as **150.** This projection was for a different drive option that was not developed.
Note: - Design space limitation does not allow the balance beams to be removed from the model once constructed.

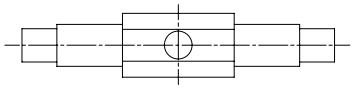


Locate Hornguides, 7 off **150** and 1 off **150A** if driving from Rear Intermediate axle (See drive options) and centre Hornguides 2 off **160.**
Test assemble a balance beam to the slot in the hornguide and ensure that it moves easily; also ensure that the beam can exit the hornguide smoothly as it moves through its angle of action after the hornguide is formed. Fold up 150 and 150A to form the hornguide.
Note: - Excessive twist on the hornguide tabs can distort the running faces. All guides are assembled to the inside faces of the frames in the etched slots provided. Flux the front but solder from the rear to limit the quantity of solder reaching the corners of the guides. Remove any excess to obtain a smooth running hornblock bearing.
Rear and Intermediate Rear positions. First assemble a folded hornguide to the **REAR** axle location and twist tabs to retain. **IMPORTANT the RHS frame uses part 150 and the LHS frame use part 150A in this location**.
Assemble the rear intermediate hornguide together with the rear balance beam. Twist tabs to retain. Ensure that the hornblock and beam will move easily in the hornguide.

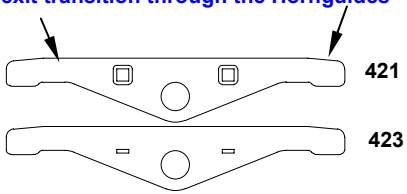
Front Balance Beam

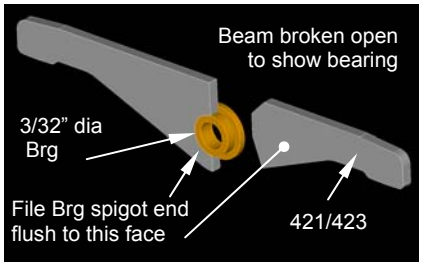
Locate the Front balance beams **421 and 423** from Loco Chassis sheet 2 and assemble together in a similar fashion as the rear described above.
Clean off excess tabs and solder.

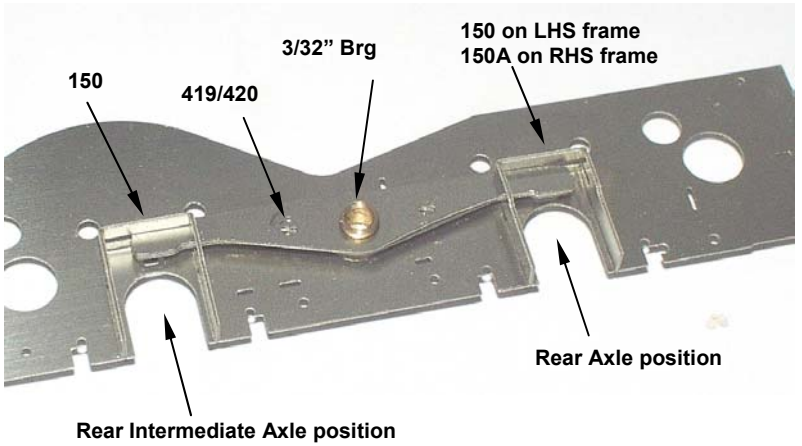
Assemble and solder a 3/32” Bearing to the hole.
Ensure seated fully against the flange before soldering.
File away the exposed part of the bearing spigot flush with face of the beam assembly.
The front balance beams assemble later to the Lateral Balance Beam illustrated below.



After assembly chamfer the top edges to ensure smooth exit transition through the Hornguides







RHS Frame Illustrated