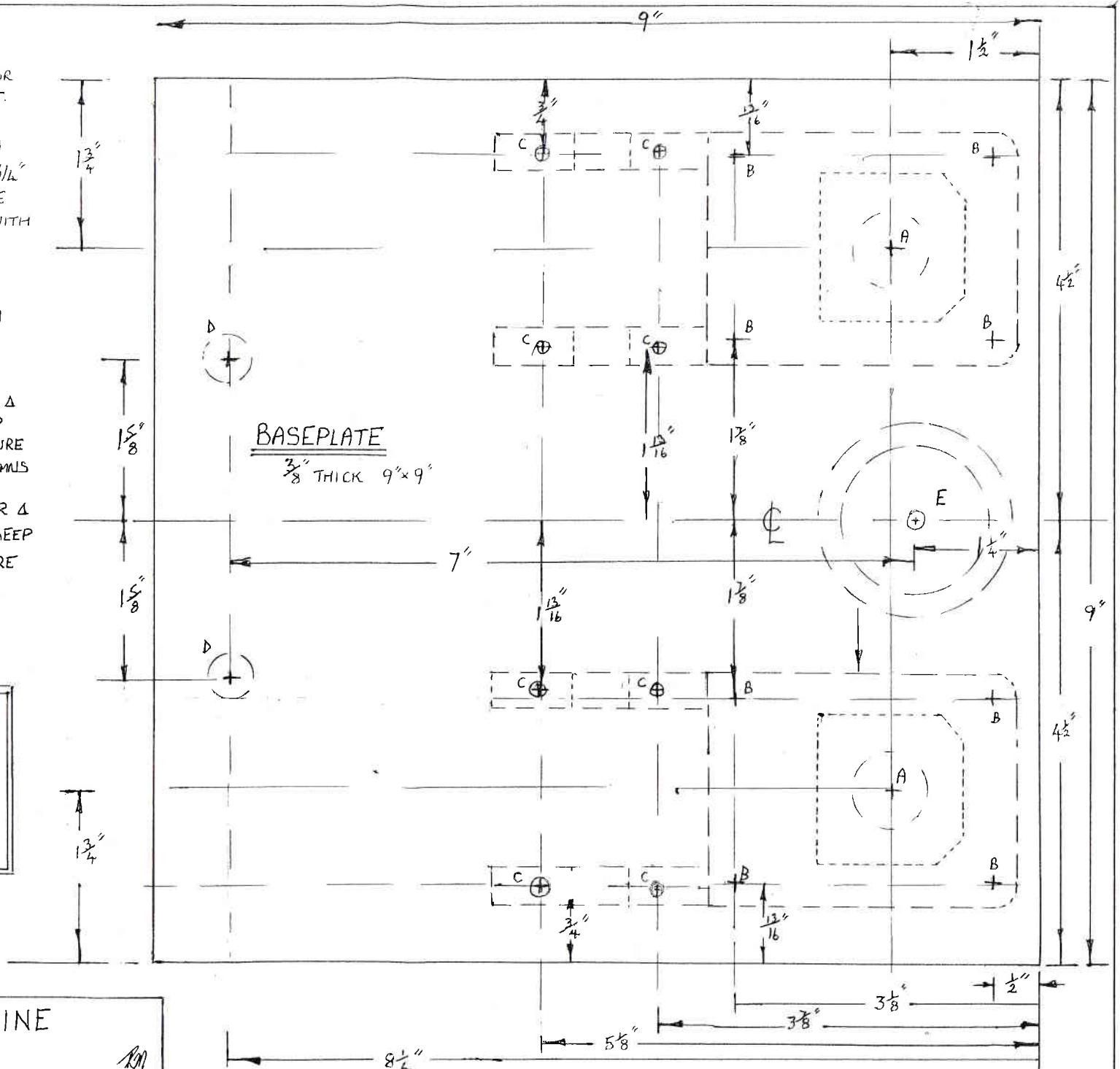
A. DRILL 2 HOLES 2BA CLEAR & COUNTER BORE APPX. ¼" DEEP FOR NUT TO SECURE BASE SPIGOT.

B. DRILL & TAP 8 HOLES 2BA INSERT 2BA STUDS APPX 3/4" IN LENGTH TO SECURE THE CYLINDER MOUNTING PLATE WITH 2BA DOME NUTS

C. DRILL AND TAP 8 HOLES 5BA TO SECURE THE BEAM SHAFT SUPPORTS WITH 5BA SET SCREWS

D. DRILL 2 HOLES 2BA CLEAR & COUNTER BORE APPX. ¼" DEEP FOR SET SCREWS TO SECURE THE BEARING SUPPORT COLUMNS

E. DRILL 1 HOLE 2BA CLEAR & COUNTER BORE APPX ¼" DEEP FOR SET SCREW TO SECURE THE MAIN COLUMN



NOTES
This drawing shows a baseplate made from 3/8" steel or aluminium plate. An alternative would be a thin (1/8") steel plate secured to a solid hard wood base. There would have to be a series of holes cut into the wood to enable access to the securing bolts.

DOUBLE SIDE BEAM ENGINE
DWG N° 4