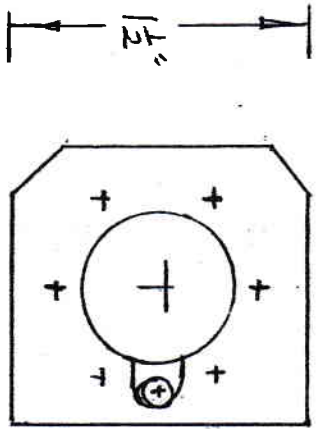
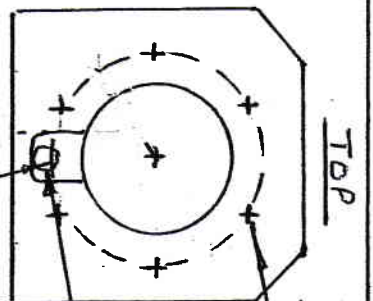




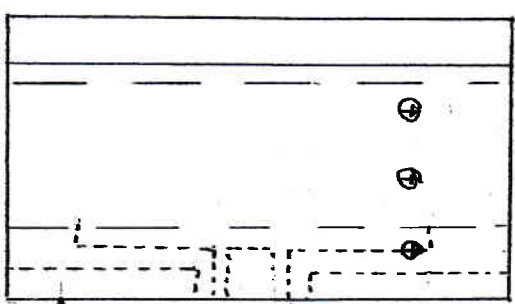
8 HOLES DRILLED AND TAPPED 6BA $\times \frac{1}{4}$ " DEEP FOR STEAM CHEST STUDS



THE INLET PASSAGE IS LOCATED ON THE $1\frac{1}{8}$ " PCD

DRILL & TAP 6 HOLES 5BA $\times \frac{3}{8}$ " DEEP ON $1\frac{1}{8}$ " PCD.

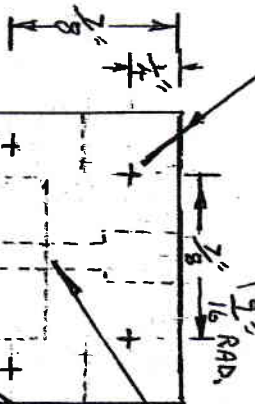
DRILL & TAP 3 HOLES ON EACH SIDE 5BA $\times \frac{1}{2}$ " DEEP



INLET & EXHAUST PORTS MILLED $\frac{1}{4}$ " DEEP

LOCATION OF STEAM CHEST

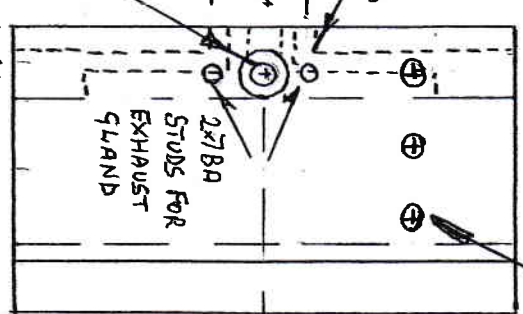
INLET RECESSES MILLED $\frac{1}{4}$ " WIDE $\frac{3}{8}$ " DEEP



INLET STEAM PASSAGES DRILLED $\frac{5}{8}$ " INTO INLET PORTS - TOP & BOTTOM

DRILL & TAP 7BA $\times \frac{1}{4}$ " DEEP

DRILL $\frac{5}{8}$ " INTO EXHAUST PORT - COUNTERBORE $\frac{1}{4}$ " $\times \frac{1}{4}$ " DEEP



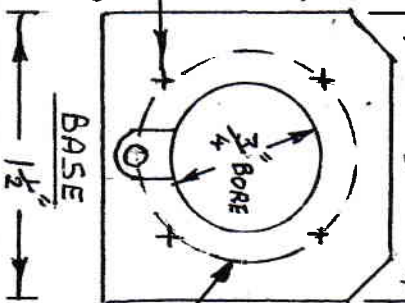
STUDS FOR EXHAUST GLAND

DRILL $\frac{5}{8}$ " INTO EXHAUST PORT - COUNTERBORE $\frac{1}{4}$ " $\times \frac{1}{4}$ " DEEP

LEFT SIDE CYLINDER BLOCK

DRILL & TAP

4 HOLES 5BA $\times \frac{3}{8}$ " DEEP ON $1\frac{1}{8}$ " PCD



BASE

DOUBLE SIDE BEAM ENGINE

DWG. NO 5

RM