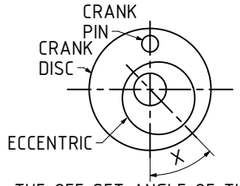
QTY.	PART NUMBER
1	09B-23-00-1-01-BRICK BASE
1	09B-23-00-1-02-ENGINE BEDPLATE
1	09B-23-00-1-03-BED PLATE BEARING
1	09B-23-00-1-04-OUTER CRANKSHAFT BEARING
1	09B-23-00-1-05-CROSSHEAD GUIDE STAND
1	09B-23-00-1-06-WATERPUMP BRACKET
1	09B-23-00-1-07-GOVERNOR PULLEY BRACKET
1	09B-23-00-1-08-CYLINDER + VALVE CHEST
1	09B-23-00-1-09-EXHAUST PIPE
1	09B-23-00-1-10-CYLINDER FRONT COVER
1	09B-23-00-1-11-CYLINDER REAR COVER
2	09B-23-00-1-12-CROSSHEAD GUIDE BAR
2	09B-23-00-1-12-CROSSHEAD GUIDE BAR
1	09B-23-00-1-13-GOVERNOR MAIN FRAME
1	09B-23-00-1-14-CYLINDER BRACKET
1	09B-23-00-1-15-STEAM SUPPLY CONTROL VALVE
1	09B-23-00-1-16-WATER PUMP
1	09B-23-00-2-01-CRANKSHAFT+FLWHEEL
1	09B-23-00-2-02-PISTON+CROSSHEAD
1	09B-23-00-2-03-CON-ROD
1	09B-23-00-2-04-SLIDE VALVE+ROD
1	09B-23-00-2-05-ECCENTRC SHEAVE
1	09B-23-00-2-06-WATER PUMP ECCENTRC SHEAVE
1	09B-23-00-2-07-ECCENTRIC STRAP
1	09B-23-00-2-08-WATER PUMP ECCENTRIC STRAP
1	09B-23-00-2-09-WATER PUMP RAM
1	09B-23-00-2-10-V-BELT PULLEY-1
1	09B-23-00-2-11-V-BELT PULLEY-2
1	09B-23-00-2-12-V-BELT
1	09B-23-00-2-13-GOVERNOR VERTICAL SPINDLE
1	09B-23-00-2-14-GOVERNOR SLIDE COLLAR
2	09B-23-00-2-15-GOVERNOR FLYWEIGHT
2	09B-23-00-2-16-GOVERNOR LINK
1	09B-23-00-2-17-GOVERNOR CONTROL ARM
1	09B-23-00-2-18-REGULATOR FLAP+SPINDLE
2	09B-23-00-2-19-SPEED FINE TUNING LINK
1	09B-23-00-2-20-STEAM SUPPLY VALVE
3	09B-23-00-M2 NUT
2	09B-23-00-M2.5x12 A-K CYL HEAD SCREW
3	09B-23-00-M2.5x6 A-K CYL HEAD SCREW
10	09B-23-00-M2.5x8 A-K CYL HEAD SCREW
4	09B-23-00-M2x3 A-K GRUB SCREW
1	09B-23-00-M2x5 A-K CYL HEAD SCREW
18	09B-23-00-M3 DOME NUT
5	09B-23-00-M3 NUT
6	09B-23-00-M3 WASHER
8	09B-23-00-M3x14 A-K CYL HEAD SCREW
4	09B-23-00-M3x18 A-K CYL HEAD SCREW
12	09B-23-00-M3x38 STUD
10	09B-23-00-M3x5 A-K CYL HEAD SCREW
5	09B-23-00-M3x5 A-K GRUB SCREW
4	09B-23-00-M3x8 A-K C-SINK SCREW
8	09B-23-00-M3x8 A-K CYL HEAD SCREW
4	09B-23-00-M4 DOME NUT
1	09B-23-00-M4 NUT
2	09B-23-00-M4x14 A-K CYL HEAD SCREW
2	09B-23-00-M4x24 A-K CYL HEAD SCREW
2	09B-23-00-M4x6 A-K GRUB SCREW
18	09B-23-00-M5x12 A-K CYL HEAD SCREW
4	09B-23-00-M5x20 A-K CYL HEAD SCREW
2	09B-23-00-M5x38 A-K CYL HEAD SCREW
2	09B-23-00-M6 NUT
2	09B-23-00-M6x20 A-K CYL HEAD SCREW
2	09B-23-00-M6x30 A-K CYL HEAD SCREW
6	09B-23-00-M6x40 A-K CYL HEAD SCREW

NOTES:
0. ALL DRAWINGS ARE IN METRIC MEASUREMENTS
1. ALL ENGINEERING PRACTICES SHALL BE APPLIED WITH REGARDS TO HOLE AND SHAFT TOLERANCES.
2. WHERE SCREWS OR BOLTS ARE USED THE CLEARANCE HOLES SHALL BE APPROXIMATELY 5% TO 8% LARGER THAN THE MATCHING TAPPED HOLE.
3. PREFERABLY ALL TAPPED HOLES AND MATCHING SCREWS AND/OR BOLTS TO BE METRIC FINE (MF)
4. MATERIALS SPECIFIED ON THE DRAWINGS ARE INDICATIVE ONLY. THE BUILDER CAN MAKE HIS/HER OWN MATERIAL CHOICE.
5. ALL CONNECTIONS/JOINTS WHICH HAVE STEAM PRESSURE APPLIED TO IT SHALL BE SILVER/HARD SOLDERED.
6. COMPRESSION SPRINGS ARE DRAWN IN COMPRESSED STATE (CP), UNCOMPRESSED STATE IS APPROX 40% TO 60% LONGER THEN COMPRESSED STATE.
7. WHERE PREFERRED SCREW OR RIVETED CONNECTIONS CAN BE OMITTED AND PARTS CAN BE BONDED TOGETHER BY USING EITHER HIGH STRENGTH GLUE, EPOXY RESIN, OR SOLDER.
8. PARTS WHICH ARE DIRECTLY EXPOSED TO STEAM AND/OR WATER SHOULD BE CONSTRUCTED USING NON-FERROUS OR NON CORROSIVE MATERIAL SUCH AS BRASS, BRONZE, GUNMETAL, STAINLESS STEEL, COPPER OR MONEL.
9. THE ORDER IN WHICH THE PARTS/COMPONENTS ARE MANUFACTURED AND THE MODEL IS ASSEMBLED IS ENTIRELY LEFT TO THE BUILDER/MODEL MAKER.
10. A COLOUR SCHEME FOR THIS PROJECT IS ENTIRELY LEFT UP TO THE MODEL MAKER.
11. THE MANNER IN WHICH THE PARTS/COMPONENTS ARE MANUFACTURED IS ENTIRELY LEFT UP TO THE BUILDER.
12. USE LOCTITE, ON SCREW OR PRESS FIT CONNECTIONS OR SURFACES, WERE DEEMED NECESSARY TO PREVENT PARTS FROM LOOSENING.
13. WASHERS AND/OR SPRINGWASHERS SHALL BE USED WHERE DEEMED NECESSARY.
XX. ERRORS AND/OR OMISSIONS MAY OCCUR IN THE DRAWINGS, DO NOT HESITATE TO CONTACT ME SO THAT THE ERRORS/OMISSIONS CAN BE RECTIFIED.

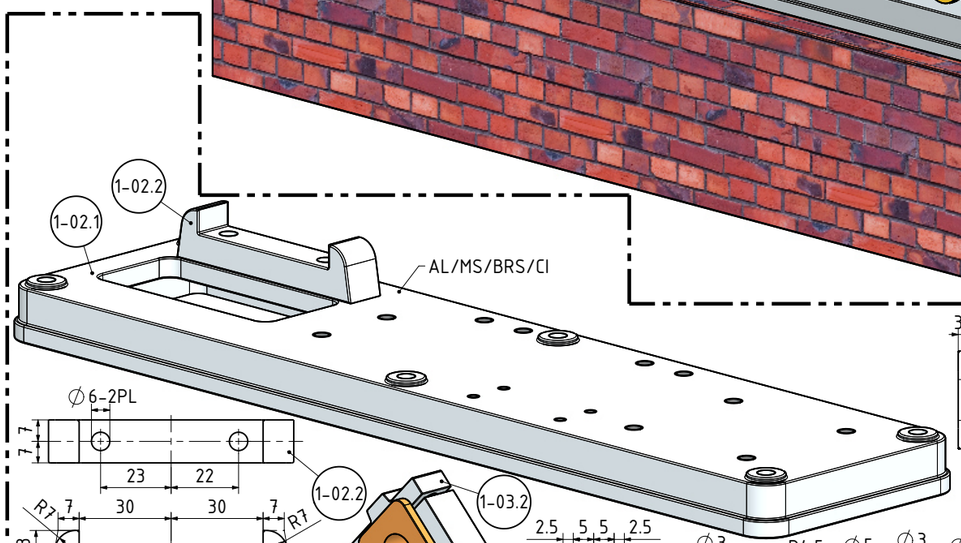
OTHER ABBREVIATIONS
AS = AS SHOWN
DP = DEEP
DAA= DRILL AFTER ASSEMBLY
D&TAA= DRILL AND TAP AFTER ASSEMBLY
CF = CLOSE FIT (SIZE FOR SIZE)
PF = PRESS FIT
PFAA= PRESS FIT AFTER ASSEMBLY
PCD = PITCH CIRCLE DIAMETER
RM = REAM
HEX = HEXACON, 6SIDED
CP = COMPRESSED
KNL = KNURLED
CSK = COUNTERSINK
PL = PLACES
DWL= DOWEL
SPF= SPOTFACE
(T)HESOP=(TAPPED)HOLES EQUALLY SPACED ON PCD
(T)HESOC=(TAPPED)HOLES EQUALLY SPACED ON CIRCUMFERENCE
OD = OUTSIDE DIAMETER
ID = INSIDE DIAMETER
SA-xxx = SUB ASSEMBLY-xxx

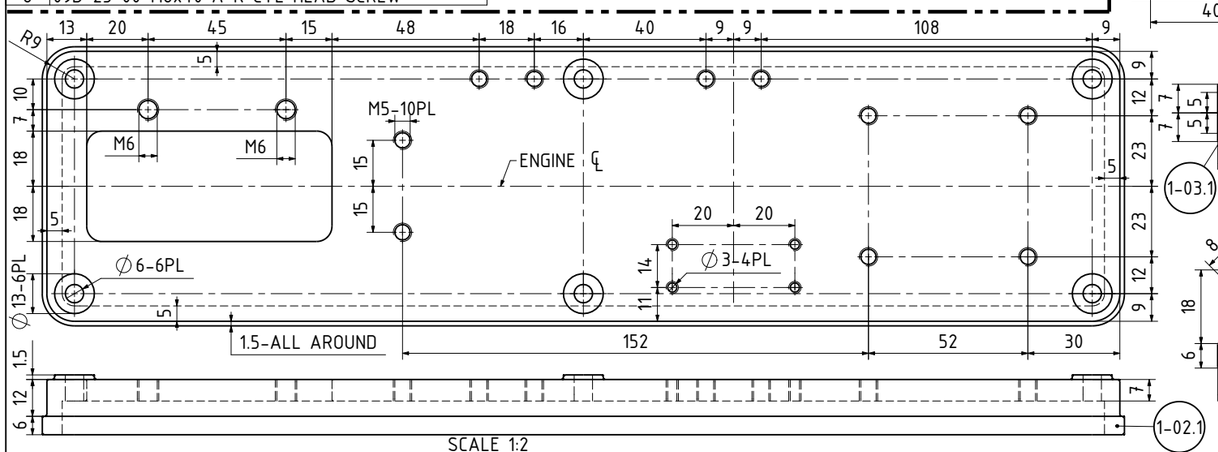
MATERIAL ABBREVIATIONS:
ALU = ALUMINIUM
HALU= HARD ALUMINIUM
BRS = BRASS
BRZ = BRONZE OR GUNMETAL (BRZ/GM)
CI = CAST IRON
CU = COPPER
GRA = GRAPHITE
MS = MILD STEEL/BRIGHT MILD STEEL
SS = SILVER STEEL OR STAINLESS STEEL
SPS = SPRING STEEL
PEEK= POLYETHER ETHER KETONE
SYN = SYNTHETIC MATERIAL SUCH AS VETON, NYLON, TEFLON OR RUBBER
IN GENERAL SYNTHETIC MATERIALS SOULD BE ABLE TO WITHSTAND THE HEAT AND PRESSURE(S) APPLIED TO THEM.
nnn/nnn MEANS THAT EITHER MATERIAL CAN BE USED

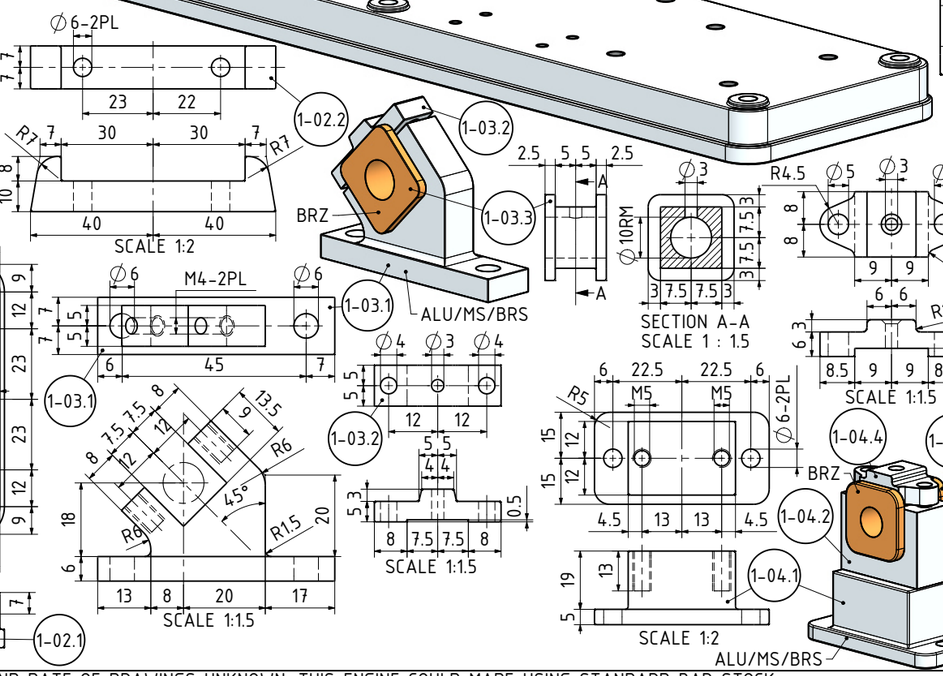
NOTE 1:THE CONICAL (45deg) GEAR WHEELS EITHER TO MADE BY THE BUILDER TO HIS/HER OWN SPECIFICATIONS OR BEING RESOURCED FROM A RETAILER



THE OFF SET ANGLE OF THE ECCENTRIC IN RELATION TO THE CRANK AXIS TO BE EXPERIMENTALLY DETERMINED FOR THE SMOOTH RUNNING OF THE ENGINE AND SATISFACTION OF THE BUILDER







NOTES: FOUND ORIGINAL DRAWINGS ON THE INTERNET. THE ORIGINAL DRAWINGS HAD LIMITED DIMENSIONS. ORIGINATOR/AUTHOR AND DATE OF DRAWINGS UNKNOWN. THIS ENGINE COULD MADE USING STANDARD BAR STOCK

TITLE
RAMSOME & MAY HORIZONTAL MILL ENGINE CIRCA 1850

DRAWING CONTENTS
ISOMETRIC VIEW, NOTES, BILL OF MATERIALS, PARTS AND ASSEMBLIES

PROJECT No 09B-23-00
JDW DRAUGHTING SERVICES
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PROJECTION | JDWDS | MODEL SCALE: 1:1
DWG SCALE: 1:1 @A3 OR AS SHOWN
DATE: FEBRUARY 2020

SHEET: 02 OF 06 | A3 | No: 09B-23-00-SHT02