

ELEMENT "D"

DRILL 8 HOLES 4 BA CLEAR
ON P.C.D 2 1/4"

PLAN VIEW
(TOP)

ENGINE Φ

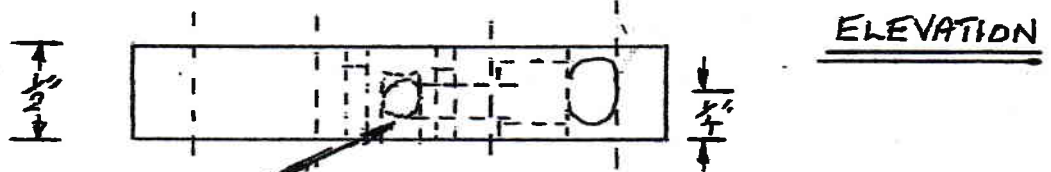
DRILL $\frac{3}{32}$ "
THROUGH
INTO STEAM INLET PORTS

STEAM EXHAUST
GLAND FITTED HERE

DRILL $\frac{3}{16}$ " Φ
TO BREAK INTO EXHAUST PORT -
PLUG THE OUTER END OF PASSAGE

THE
"TRUNCH
TROJAN"

DWG N°7



NOTE

STEAM EXHAUST PORT
IS CUT $\frac{3}{8}$ " DEEP
USING A $\frac{3}{16}$ " SLOT DRILL

UNDERSIDE (BOTTOM)
VIEW

NOTE

THE STEAM INLET PORTS
ARE MILLED $\frac{3}{8}$ " DEEP ONLY

A LONG SERIES $\frac{3}{32}$ " SLOT DRILL
MAY BE USED TO FINISH THESE SLOTS

DRILL $\frac{3}{16}$ " Φ TO BREAK
INTO CROSS EXHAUST
PASSAGE WHICH HAS
BEEN DRILLED FIRST.

OPEN OUT AND TAP
 $\frac{3}{8}$ " x 32 TPI FOR A DEPTH
OF $\frac{1}{2}$ " TO FIT EXHAUST
GLAND [SEE DWG N°]