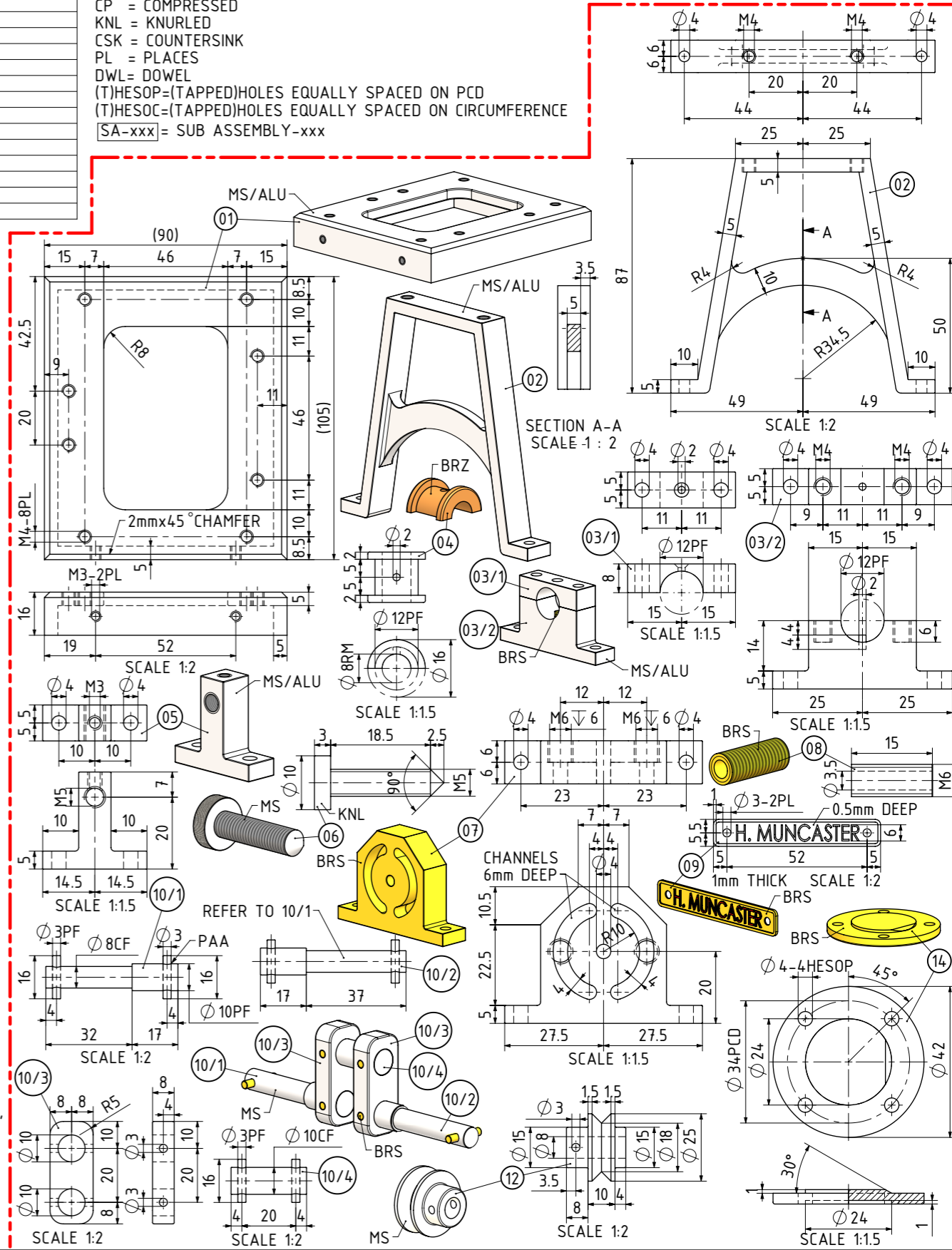


QTY.	PART NUMBER
1	MUNCASTER2-01-BASE PLATE
2	MUNCASTER2-02-UPRIGHT MAIN FRAME
2	MUNCASTER2-03-MAIN BEARING BLOCK
4	MUNCASTER2-04-MAIN BEARING
4	MUNCASTER2-M4x14 PAN HEAD SCREW
12	MUNCASTER2-M4x10 PAN HEAD SCREW
1	MUNCASTER2-05-CYLINDER PIVOT SPINDLE PEDESTAL
1	MUNCASTER2-06-CYLINDER PIVOT SPINDLE
1	MUNCASTER2-07-PORTBLOCK PEDESTAL
2	MUNCASTER2-08-PORTBLOCK NIPPLE
1	MUNCASTER2-09-NAME PLATE
1	MUNCASTER2-19-COMPRESION SPRING
3	MUNCASTER2-M3x6 PAN HEAD SCREW
1	MUNCASTER2-10-CRANKSHAFT
1	MUNCASTER2-11-FLYWHEEL
1	MUNCASTER2-12-PULLEY
1	MUNCASTER2-13-CYLINDER
1	MUNCASTER2-14-CYLINDER BOTTOM COVER
1	MUNCASTER2-15-CYLINDER TOP COVER
1	MUNCASTER2-16-PISTON ROD GLAND
8	MUNCASTER2-M4x8 PAN HEAD SCREW
1	MUNCASTER2-18-PISTON ROD BIG END
1	MUNCASTER2-17-PISTON-ROD
2	MUNCASTER2-M4x20 PAN HEAD SCREW

OTHER ABBREVIATIONS
 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 = HEXAGON, 6SIDED
 CP = COMPRESSED
 KNL = KNURLED
 CSK = COUNTERSINK
 PL = PLACES
 DWL= DOWEL
 (T)HESOP=(TAPPED)HOLES EQUALLY SPACED ON PCD
 (T)HESOC=(TAPPED)HOLES EQUALLY SPACED ON CIRCUMFERENCE
 [SA-xxx]= SUB ASSEMBLY-xxx

MATERIAL ABBREVIATIONS:
 ALU = ALUMINIUM
 BRS = BRASS
 BRZ = BRONZE OR GUNMETAL (BRZ/GM)
 MS = MILD STEEL/BRIGHT MILD STEEL
 S/S = SILVER STEEL OR STAINLESS STEEL
 SPS = SPRING STEEL
 SYN = SYNTHETIC MATERIAL SUCH AS RUBBER, TEFLON, NYLON, VETON etc
 nnn/nnn MEANS THAT EITHER MATERIAL CAN BE USED



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. WASHER 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.