



Australian Railway Kits

ABN: 27 416 246 418

Incorporating Main West Models
Manufacturers, Wholesalers and Retailers of Quality Australian Model Railways
PO Box 252 Warwick, Queensland, 4370 Australia
Phone/Fax: 617 4667 1351 Website: www.arkits.com Email: info@arkits.com

NSWGR D50 2-8-0 LOCOMOTIVE AND TENDER KIT

E152 Manufactured Exclusively for AR Kits by DJH Engineering from Patterns owned by AR Kits

PLEASE READ INSTRUCTIONS THOROUGHLY BEFORE COMMENCING ASSEMBLY

CONSTRUCTION

It is important to ensure that all parts are clean, free of "flash" (excess metal on castings) and fit properly. The "flash line" is easily removed from most areas by scraping gently with a sharp hobby knife - a round blade is more effective than a straight pointed type. Pull the blade along the "flash line" - several light strokes are better than a single one. Some areas are better cleaned up with a 6" jewellers' file. Take care not to flatten round parts by filing too heavily. All locating holes for detail fittings should be pre-drilled to the size specified in the instructions. Sometimes it is necessary to clean out these holes with a "rat tail" file; take care not to snap off the tip of the file. Gently wash the castings in warm soapy water to remove mould release residue.

Etched brass items are best removed from the fret by placing the fret on a scrap piece of hard timber (e.g. Pine board) and cutting the tabs with a large Stanley knife - cut the tab at the point furthest away from the part, then trim the tab off close to the part with a small pair of quality side cutters. Hold small parts with a pair of flat nosed pliers (not serrated jaws) while cleaning up with jeweler's files. Be careful not to distort the etchings; they are difficult to straighten if bent or twisted. Drill all required holes before assembly, noting the spigot sizes of the fittings, because some holes will be difficult to drill after parts are assembled.

This kit contains sufficient parts to make either the Saturated or Superheated version of the D50. Both Saturated and Superheated parts are shown on the drawings, therefore during assembly refer to parts listing where alternate parts are marked *. As with all classes of NSWGR locomotives, individual DSOs varied in minor details from time to time in their life. Modellers are therefore advised to check photographs of the particular locomotive they have chosen to model.

A detailed history of the D50 locomotive is covered in Ron Preston's book "**Standards in Steam, the D50 Class**", and an excellent **D50 Class Data Sheet is available from Data Sheets**.

Modellers are advised to check photographs of the particular locomotive they have chosen to model, also keeping in mind the era they are modelling. For assistance in general detailing, modellers are referred to the Data Sheet plan and the many photos which appear in Australian railway books and journals.

These kits are designed to give many years of operating pleasure. A little extra time taken during construction will ensure that your kit will do this. It cannot be emphasized too strongly that the basis of a smoothly operating model is care when constructing the chassis and valve gear, i.e. you must double check every step. Check that the axles turn freely in their bearings, check again with the coupling rods on, then again with the connecting rods on, etc, etc.

Assembly methods

The two main construction methods are:

(a) Low melt solder - Low melt solder is an excellent medium for use with white metal kits. It is quick and easy providing a stronger joint than can be achieved with glue. It has the added advantage of easily repairing minor

casting flaws, and because of the relatively low temperature, many parts can be held in the fingers while soldering. Brass to white metal joints can also be made by "tinning" the brass first with normal solder. Low melt soldering requires the correct type of soldering iron (e.g. Dick Smith T2200). These irons have temperature control, as low melt solder requires temperature between 70 degrees and 200 degrees Celcius. You must use special low melting point solder, such as that available from AR Kits.

IT IS ADVISABLE NOT TO ATTEMPT TO SOLDER ANY CASTINGS WITH A STANDARD SOLDERING IRON

(b) Glue - Superglue and Plastibond are two types of glues suitable for use with this kit. Some modellers prefer to superglue major joints first then "fillet" the joint with Plastibond. Small detail parts are best glued with Superglue. Glue is not recommended for those parts need good electrical contact, such as the tender bogies.

It does not matter which method you choose but dry fitting parts will ensure a good fit.

Electrical pickup.

The electrical system used on these kits is called "half live". Looking from the top facing forward the locomotive chassis collects current from the live wheels on the right-hand side, shown as LS (live side) on the drawings. The tender is insulated from the locomotive chassis by plastic bush and current is collected from the wheels on the left-hand side of the tender.

Cleaning up and Painting.

On completion, any areas which were soldered should be washed using a soft brush and methylated spirits. Alternatively an excellent pressure pack flux remover is also available from Dick Smith stores. Then wash thoroughly in warm soapy water. Rinse with clean water and allow to dry thoroughly before applying a suitable self-etch primer.

Spare Parts.

Spare parts are available on a replacement basis. Should any part be missing or damaged contact AR Kits for replacement. Should you have any problems with the Mashima motor please do not attempt to repair it yourself - return the motor to us. Mashima will not replace motors which have been tampered with.

Should you have any queries or problems with construction please drop us a note and we will do our best to advise you. Likewise we would be pleased to hear any suggestions you may have for improving the kits or instructions.

General.

The following drill sizes are required: 0.5mm, 0.6mm, 0.7mm, 0.8mm, 0.9mm, 1mm, 1.2mm, 1.5mm, 1.6mm, 1.9mm, 2mm, 2.1mm and 3.7mm.

During construction refer to the drawings at all times. A number of parts are quite similar, so double check if in doubt. Note that attached to the instructions is a photocopy of the lost wax brass castings sprues with each part numbered for easy identification. In the general instructions the part numbers are shown in brackets.

The instructions sometimes refer to the right-hand (R/H) and left-hand (L/H) side. This is taken as viewing the model from above and looking forward.

To minimize the risk of losing parts, do not remove them from the etched fret or the plastic packing until you are ready to use them. We recommend that you start construction with the tender.

Safety First.

These models are not toys and are not suitable for young children. White metal castings contain lead and modellers are advised to wash their hands after working with unpainted white metal castings. When using superglue, solder or when spray painting ensure your work area is well ventilated

Tender Drawing T1 (Parts T1 to T20)

Take tender back and sides (T2) and fold to form 90 degree corners - note that fold lines are etched on the inside of the corners to assist in folding. At this point solder the bogie centre pivots (T10x2) to the underside of the tender floor. Now fix the back and sides onto the tender floor (T1). Bend the door shapes on the tender front (T3)

as shown in the small insert drawing 1, then fix to the floor and sides. Bend the coal trough (T4) and fix to the front (T3) noting that the fold on the rear coal trough helps to locate this part. Now fix in place the rake irons support (T20). Fit buffer beam (T32 from drawing 2) onto the underneath of the floor, noting that the two vertical spigots form the lamp irons.

Fit the side valances (T6x2) followed by front valance (T5). Check that the assembly is "square" before adding the front steps (T7x2). Fold up edges of front step treads (T8x2) before adding to front steps. Fit the brake cylinder (T17) to the tender floor. Prior to fixing the tender top (T18) into the tender body, some modellers may prefer to fit parts T21, T22, T29, T30 and the grab rail from drawing 2 before fitting the tender top in place. Fit the hungry boards (T19x2) to the tender top

Fix the turned brass side frame mounts (T14x4) to the bogie side frames (T12x4). For good electrical pickup low melt solder is recommended here. The bogie stretchers (T11x2) are on the etched nickel silver valve gear fret - remove them and check that the holes either side fit over the brass side frame mounts (T14), you may need to enlarge the hole slightly. Check also that the holes for screws (T16bx4) are large enough. Fold the stretchers as per drawing 1, using a pair of flat nosed (non-serrated) pliers.

Push the brass wheel bearings (T13x8) in the bogie side frames using low melt solder if necessary, and attach the side frames to the stretcher with 4.0mm long brass screws (T16bx4) and washers (also from the nickel silver fret) (T16ax4).

Tighten the screws then gently ease the side frames apart to fit the wheel sets (T15x4) in place, making sure the insulated wheels are on the same side for each bogie - see drawing 1.

Trim the bogie mounting screws (T9ax2) to a length of 7.0mm and attach the assembled bogies to the tender using the springs (T9bx2) and washers (T9cx2).

Tender Drawing T2 (Parts T21 - T34).

If you have not already done so, fit water filler (T21) and tool box (T22). Fit drawbar pin (T23) using two M2 nuts (T24x2). Add fire irons (T25x3). Fit tender footplate (T26) followed by handbrake stand (T27) and handbrake handle (T28) - note, drill handbrake stand 0.8mm to accept the handbrake handle. Prior to fitting the ladder (T29) fold as per the insert drawing. Fit lamp bracket (T30), lamps (T31x2), buffers (T33x2) and brake pipe (T34).

Locomotive Drawing 1 (Parts 1 - 31).

As mentioned previously all holes shown on the drawing should be drilled prior to assembly.

Select either the Saturated smoke box (16) or Superheated smoke box (17) and fit to the boiler/firebox (15) making sure that the base of the smoke box and firebox are level (check the assembly on a flat surface). Check that there is no flash inside the firebox which may prevent the motor from fitting properly. Trim the M2 screw (18) to a length of 11mm and secure in place inside the smoke box. Cleanup the footplate (19) and remove the feed sprues from the centre cutout under the boiler. Fix the smoke box/boiler/firebox assembly to the footplate (19) securing in place with M2 nut (20) making sure that the footplate is kept straight.

Remove the cab (1) from the fret and fold up as shown. Solder the inside corners of the sides/front. Fix the screw (2) into the cab as shown at this stage as it is not possible to do this once the cab assembly is completed. Take the fall plate (3) and fold the tabs down 90 degrees, then glue the plasticard to the underside trimming so that it overlaps the three outside faces by 0.8mm to prevent it shorting out against the tender. Attach to the cab floor (4) using 0.4mm wire as shown. Fold the cab support floor (5) as shown and fix into the cab. Fix the cab floor (4) on top of the cab floor support (5). Fit R/H cab sandbox (11) and L/H sandbox (12) in place.

Fit the completed cab to the footplate using M2 nut (20). Detail the boiler by adding the safety valves (22), steam generator (23), dome (24), chimney (25) and smoke box door (26). Note: drill the smoke box door as shown before fitting. Fix saturated main frames (27) or superheated main frames (28) followed by the footplate sand boxes (29xpair).

The fitting of the gearbox (30), motor (31), back head detail (14) and regulator handle (13) is covered under Chassis Drawing 7.

Locomotive Drawing 2 (Parts 32 - 70).

In this drawing we have attempted to show both the saturated and superheated versions, note the difference in the electric lights and the handrails.

Note the saturated version does not need parts 34, 35, 45ax2, 57, 58x3, 59x2, 64 and 69. Note: the superheated version does not need parts 45bx2, 54, 55x2 and 56x3.

Note also that the left hand side of the boiler has two sets of handrail holes, so when using parts (56x3) drill out and use the lower holes and when using parts (58x2) and (64) drill out and use the upper holes.

Follow the drawing for the version you are building, noting that steps (61) should be folded before fitting, likewise rear step treads (62x2) and front beam step (49). When fitting the guard irons (40) note that they need bending out to the track centres (see the photograph on the label for clarity). Note also that the boiler handrails go right around the boiler and that they have been shown broken on the drawing for clarity.

Chassis Drawing 3 (Parts 71 - 96).

Take one R/H frame (71) and L/H frame (72). Carefully clean out the axle holes with a 3.7mm drill bit and push fit the axle bushes (73x8). The bushes should be a firm fit in the frames -any loose bushes should be soldered in place. Note there are a number of holes on the chassis that may require cleaning out to a specific size, check drawing for details. Fit the turned brass chassis spacers (74a & 74b) noting that the rear spacer (74b) has a M2 thread for fixing the motor (see drawing). The holes in both spacers must be aligned vertically. Fit front mounting plate (75) and rear mounting plate (76) and tighten the spacer screws (77x4). Temporarily fit axles and wheels to the front and rear axle holes and place the chassis on a section of level track to check that the chassis sits properly on the track. If necessary, loosen the spacer screws and adjust. Remove the wheels and axles and solder the chassis together.

Before fitting the driving wheels (86x2, 87x2, 91x2 and 92x2) note that the insulated wheels are on the L/H side as viewed from the top facing forward and that the two centre driving wheels are flangeless. Fit the driving wheels, axles (85x4) and axle washers (89x8) to the chassis with the axle nuts (88x8), placing the axle gear (90) on the second axle as shown on the drawing. If necessary clean out the hole in the axle gear with a 1/8" reamer or 1/8" drill bit. Move the gear to one side of the axle, place a small spot of super glue or Loctite 601 on the centre of the axle and push the gear to the centre of the axle. Make sure the gear is "square" with the axle. Be careful not to get any glue or Loctite in the axle bushes. The wheels are quartered so that the crankpin on the right hand wheel leads that of the left hand wheel by 90 degrees when the axle rotates forward. Make sure that all axles rotate freely in the axle bushes. Use a Romford axle nut driver to tighten the axle nuts. Remove the etched counterweights (95x4), (96x4) from the fret and glue to the wheels as shown. Using a Romford axle nut driver fit the crankpins (93x8). Axle covers (94x8) should be fitted after final assembly and painting.

Now fit drawbar/tender pickup placing insulator (80) on M2 screw (78) cut to 10mm, and pass this through the rear mounting plate (76). Now add spring plate (82), loco tender coupler (83) and spring (84) as shown, followed by M2 nut (81).

Chassis Drawing 4 (Parts 97 - 115).

Fit crankpin spacing washers (97x8) then add rear coupling rods (98xpair), leading coupling rods (99xpair) and centre coupling rods (110xpair). For easy removal of the coupling rods during testing, painting etc, strip a short length of insulation from some fine electrical wire and push this "tubing" onto the crankpins as a temporary retainer. The crankpin washers (101x8) should not be fitted until the chassis has been completed and painted. Check that the rods revolve freely; should binding occur, locate where this happening and gently ease out the offending hole in the coupling rod with a rat-tail file, remove the minimum amount to achieve free movement. Sometimes swapping the side rods around (i.e. left to right) can overcome binding.

Remove the wheels from the chassis and fold the rear brakes (104) as shown before fitting. Using 0.7mm wire, fit the leading brakes (102x2) and support bracket brakes (103x2) - note that the leading brakes (102) are etched with a "W", and the support bracket brakes (103x2) are etched with a "V". Using 0.7mm wire through the holes at the rear of the frames locate the R/H pull rod (106) and L/H pull rod (107) between the frames. Note that the 0.7mm wire extends 3.0mm on the L/H side for later fitting of the brake cylinder (121). Fit the brake stretchers (105x3) and leading brake stretchers (108x2).

Test fit slide bar support bracket (109) into the cutouts on top of the frame making sure it can be pushed down to the bottom of the cutout. Trim the outside locating lugs to clear the wheel flanges and put aside for later fitting. Make up cylinder assemblies using cylinders (110x2), rear cylinder covers (111x2) and front cylinder covers (112x2) - note that rear cylinder covers are drilled 1.2mm. For the saturated version only, drill the front cylinder covers 1.0mm and fit 1.0mm wire to represent piston balance rod.

Fold the slide bars (113x2) as shown, note these are left and right handed, the etched fold line goes to the inside of the fold. Test fit the crosshead into slide bar, you may need to clear out the keyways of the crossheads using a knife-edge file, or you may need to lightly file the inside edges of the slide bars to achieve a good fit.

Fix the slide bar assemblies to the rear of the cylinders and also attach underneath the cylinders - see drawing. Fix the completed cylinder assemblies to the frames.

Chassis Drawing 5 (Parts 116 - 130).

Fit brake cylinder (121) and pass 0.7mm wire through as shown. Assemble the front bogie using bogie body (126), bogie wheel (127) and bogie arm (128). Attach bogie wheel inserts (129x2) and fix bogie to chassis with M2 nut (130). Fit wheels, axles and side rods. Fit the connecting rods (117xpair) to crossheads (118xpair) using 14BA screw (116x2) and nut (119x2). Fit the crossheads into the slide bars and then fit the slide bar support bracket (109).

Assemble the gearbox as per the accompanying instructions and trim the shaft to 3.5mm as shown in drawing 3. Do not force the worm onto the shaft. Carefully ream the worm bore using a 2.0mm drill or hand reamer so that the worm fits the shaft without undue force. Use a spot of superglue or Loctite 601 to permanently fix in place. Clean the shaft of excess glue or Loctite. As the gearbox screws are self tapping, screw the bottom cover plate screws in and out a couple of times before fitting the gearbox to the chassis. Remove 0.75mm from the bottom of the gearbox as shown in drawing 7 and fit gearbox to the chassis.

Fit the locomotive body to the chassis securing with M2 nuts (124 and 125).

Take two 60mm lengths of pickup wire, solder to the motor terminals and mark the positive (+) lead for later identification. Trim the motor coupling sleeve to 12mm and fit half way onto the motor shaft. Pass the motor through the hole in the front of the cab ensuring the motor coupling sleeve (31) couples to the shaft on the gearbox. (Check from underneath). Note, for easier fitting/removal of the motor, temporarily screw an M2 x 16mm bolt into one of the threaded holes in the rear of the motor, finger-tight only. Pass the wires down through the footplate, see drawing 3. Fit M2 screw (74c) to the rear chassis spacer (74b) and gently tighten the M2 screw just enough to retain the motor. Take the positive lead and solder it to the motor tag (7) which locates under M2 body mounting nut (125) (see drawing 7). The other wire spot solders to loco tender coupling (83) (see drawing 5).

Lightly oil the mechanism and test run, checking for electrical "shorts" on sharp curves etc. Also check that the motor does not overheat due to chassis binding.

24 Feb 2009

(E152) - D50 - Parts List Page 1

Tender Drawing 1.

T1.	Floor	E
T2.	Sides and Back	E
T3.	Front	E
T4.	Coal Trough	E
T5.	Front Valance	E
T6.	Side Valances x 2	E
T7.	Front Steps x 2	E
T8.	Front Steps Treads x 2	E
T9a.	M2 Screws x 2	T
T9b.	Springs x 2	-
T9c.	Washers x 2	E
T10.	Bogie Centre Pivots x 2	T
T11.	Bogie Stretchers x 2	E
T12.	Bogie Sideframes x 4	W/M
T13.	Wheel Bearings x 8	T
T14.	Sideframe Mounts x 4	T
T15.	Bogie Wheels 10.5mm x 4	T
T16a.	Washers x 4	E
T16b.	Brass Screw (4mm long) x 4	T
T17.	Brake Cylinder	W/M
T18.	Tender Top	W/M
T19.	Hungry Boards x 2	E
T20.	Rake Irons Support	E

Tender Drawing 2.

T21.	Water Filler	W/M
T22.	Tool Box	W/M
T23.	Drawbar Pin	T
T24.	M2 Nut	T
T25.	Rake Irons x 3	E
T26.	Tender Floor	E
T27.	Handbrake Stand	W/M
T28.	Handbrake Handle	L/W
T29.	Ladder	E
T30.	Lamp Bracket	E
T31.	Lamps x 2	W/M
T32.	Buffer Beam	E
T33.	Buffers x 2	W/M
T34.	Brake Pipe	L/W

0.4mm dia. Wire

Drawing 1

1.	Cab	E
2.	M2 x 16mm C/H Screw	T
3.	Fallplate	E
4.	Cab Floor	E
5.	Cab Floor Support	E
6.	Motor	-
7.	Motor Tag	E
8.	Insulated Wire	-
9.	Motor Mounting Screws x 2	T
10.	Plasticard	P
11.	R/H Cab Sandbox	W/M
12.	L/H Cab Sandbox	W/M
13.	Regulator Handle	W/M
14.	Cab Backhead Detail	W/M
15.	Boiler/Firebox	W/M
16.*	Original Smokebox	W/M
17.*	Extended Smokebox	W/M
18.	M2 x 16mm C/H Screw	T
19.	Footplate	W/M
20.	M2 Nuts x 2	T

21.	Cab Roof	W/M
22.	Safety Valves	W/M
23.*	Steam Generator	W/M
24.	Dome	W/M
25.	Chimney	W/M
26.	Smokebox Door	W/M
27.*	Saturated Main Frames x 1 pr	W/M
28.*	Superheated Main Frames x 1 pr	W/M
29.	Footplate Sandboxes x 1 pr	W/M
30.	Gear Box	-
31.	Motor Coupling Shaft	P

0.4mm dia. Wire
Insulated Wire

Drawing 2

32.	Whistle	L/W
33.	Clack Valves x 2	L/W
34.*	Headlamp	W/M
35.*	Marker Lights x 2	W/M
36.	Smokebox Door Handle	L/W
37.	Single Lamp Irons x 2	E
38.	Buffer Beam	E
39.	Double Lamp Iron	E
40.	Guardirons x 1 pr	E
41.	Small Air Tank	W/M
42.	R/H Firebox Double Handrail Bracket	E
43.	Short Handrail Knob	T
44.	R/H Boiler Double Handrail Brackets x 2	E
45a.*	Medium Handrail Knobs x 2	T
45b.*	Short Handrail Knobs x 2	T
46.	Pump	W/M
47.	Pump Valve	W/M
48.	Handrail Post	L/W
49.	Front Beam Step	E
50.	Dummy Coupler	W/M
51.	Brake Pipe	L/W
52.	Buffers x 2	W/M
53.	Single Smokebox Door Lamp Iron	E
54.*	Bogie Pivot Cover	W/M
55.*	Short Handrail Knobs x 3	T
56.*	Medium Handrail Knobs x 3	T
57.*	Electrical Junction Box	W/M
58.*	Medium Handrail Knobs x 3	T
59.*	L/H Boiler Handrail Brackets x 2	E
60.*	Reversing Rod	E
61.	Rear Steps	E
62.	Rear Step Treads x 1 Pair	E
63.	Reversing Gear Cover	W/M
64.*	L/H Firebox Handrail Bracket	E
65.	Firebox Valves x 2	L/W
66.	Globe Valves x 2	L/W
67.	Cab Side Cowling	W/M
68.	Large Air Tanks x 2	W/M
69.*	Medium Handrail Knob	T
70.	Split Pins x 4	-

0.4mm dia. Wire
0.7mm dia. Wire

(E152) - D50 - Parts List Page 2

Drawing 3

71.	R/H Frame	E
72.	L/H Frame	E
73.	Bushes x 8	T
74a.	Spacers	T
74b.	Spacer Threaded	T
74c.	M2 Screw	T
75.	Front Mounting Plate	E
76.	Rear Mounting Plate	E
77.	Spacer Screws x 4	T
78.	M2 x 16mm C/H Screws	T
79.	No Part	-
80.	Insulator	P
81.	M2 Nuts x 2	T
82.	Spring Plate	E
83.	Loco Tender Coupler	E
84.	Spring	
85.	Axles x 4	T
86.	Insulated Driving Wheels x 2	T
87.	Insulated Flangeless Driving Wheels x 2	T
88.	Axle Nuts x 8	T
89.	Axle Spacing Washers x 8	E
90.	Axle Gear	T
91.	Flangeless Driving Wheels x 2	T
92.	Driving Wheels x 2	T
93.	Crankpins x 8	T
94.	Axle Covers x 8	E
95.	Small Balance Weights x 4	E
96.	Large Balance Weights x 4	E

Drawing 4

97.	Crankpin Spacing Washers x 8	E
98.	Rear Coupling Rods x 1 pr	E
99.	Leading Coupling Rods x 1 pr	E
100.	Centre Coupling Rods x 1 pr	E
101.	Crankpin Washers x 8	T
102.	Leading Brakes x 1 pr	E
103.	Support Bracket Brakes x 1 pr	E
104.	Rear Brakes x 1 pr	E
105.	Brake Stretchers x 3	E
106.	R/H Pull Rod	E
107.	L/H Pull Rod	E
108.	Leading Brake Stretchers x 2	E

109.	Slidebar Support Bracket	E
110.	Cylinder Bodies x 2	W/M
111.	Rear Cylinder Covers x 2	W/M
112.	Front Cylinder Covers x 2	W/M
113.	Slide Bars x 1 pr	E
114.	M2 x 16mm C/H Screw	T
115.	M2 Nut	T

0.7mm dia. Wire
1.0mm dia. Wire

Drawing 5

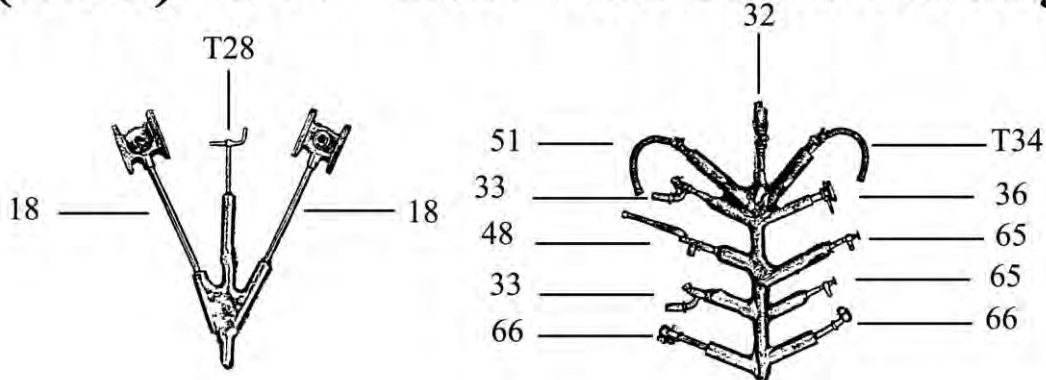
116.	14 B.A. x 1/8" C/H Screws x 2	T
117.	Connecting Rods x 1 pr	E
118.	Crossheads x 1 pr	L/W
119.	14 B.A. Nuts x 2	T
120.	Crankpin Fixers x 2	T
121.	Brake Cylinder	W/M
122.	Gearbox Base Plate	P
123.	Gearbox Base Plate Mounting Screws x 2	T
124.	M2 Nut	T
125.	M2 Nut	T
126.	Bogie Body	W/M
127.	Bogie Wheel	T
128.	Bogie Arm	W/M
129.	Bogie Wheel Inserts x 2	E
130.	M2 Nut	T

0.7mm dia. Wire

Drill Sizes - Key

0.5mm dia. - A
0.7mm dia. - B
0.8mm dia. - C
0.9mm dia. - D
1.0mm dia. - E
1.2mm dia. - F
1.6mm dia. - G
2.0mm dia. - H
2.2mm dia. - I
3.7mm dia. - J

(E152) - D50 - Lost Wax Brass Castings

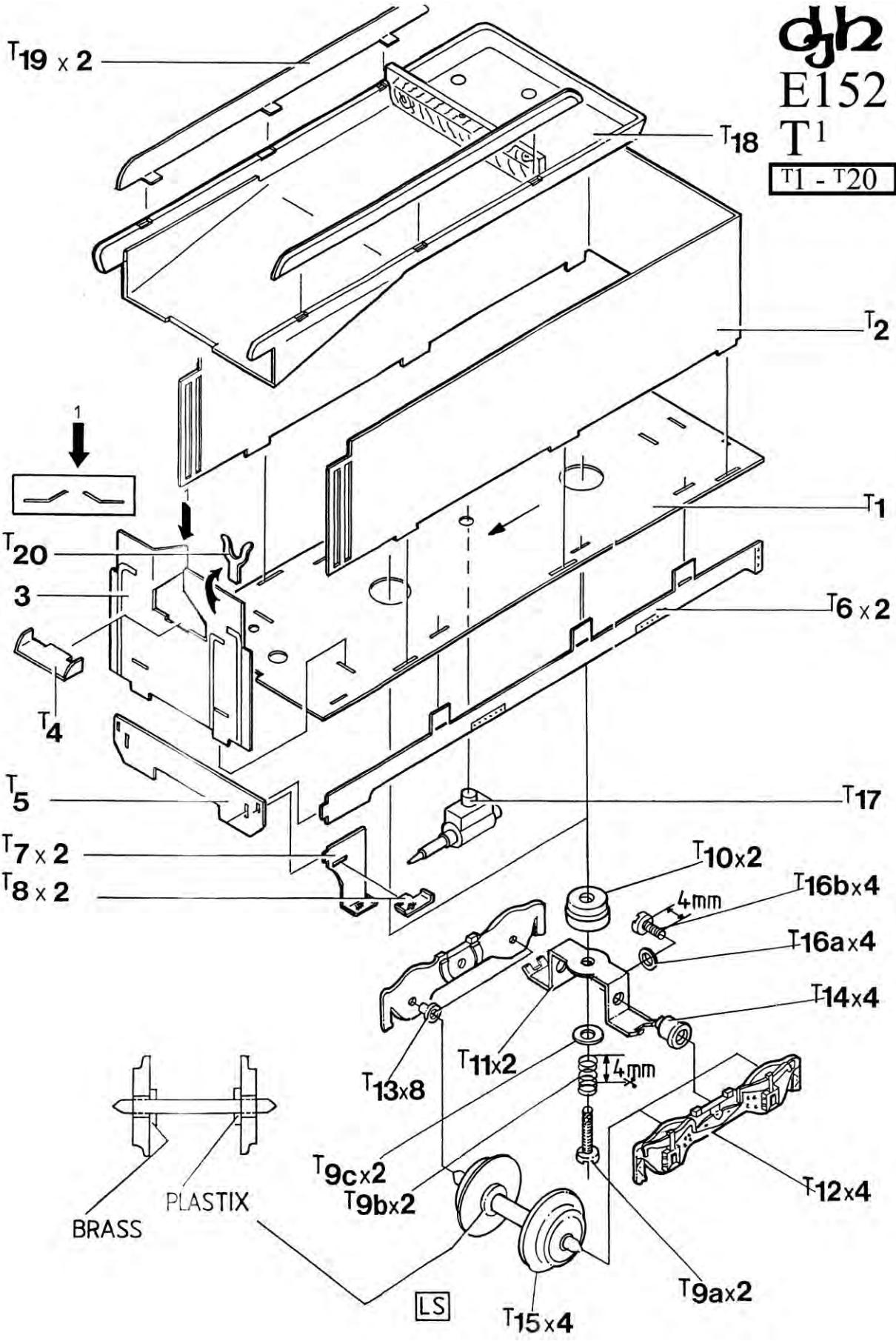


dh

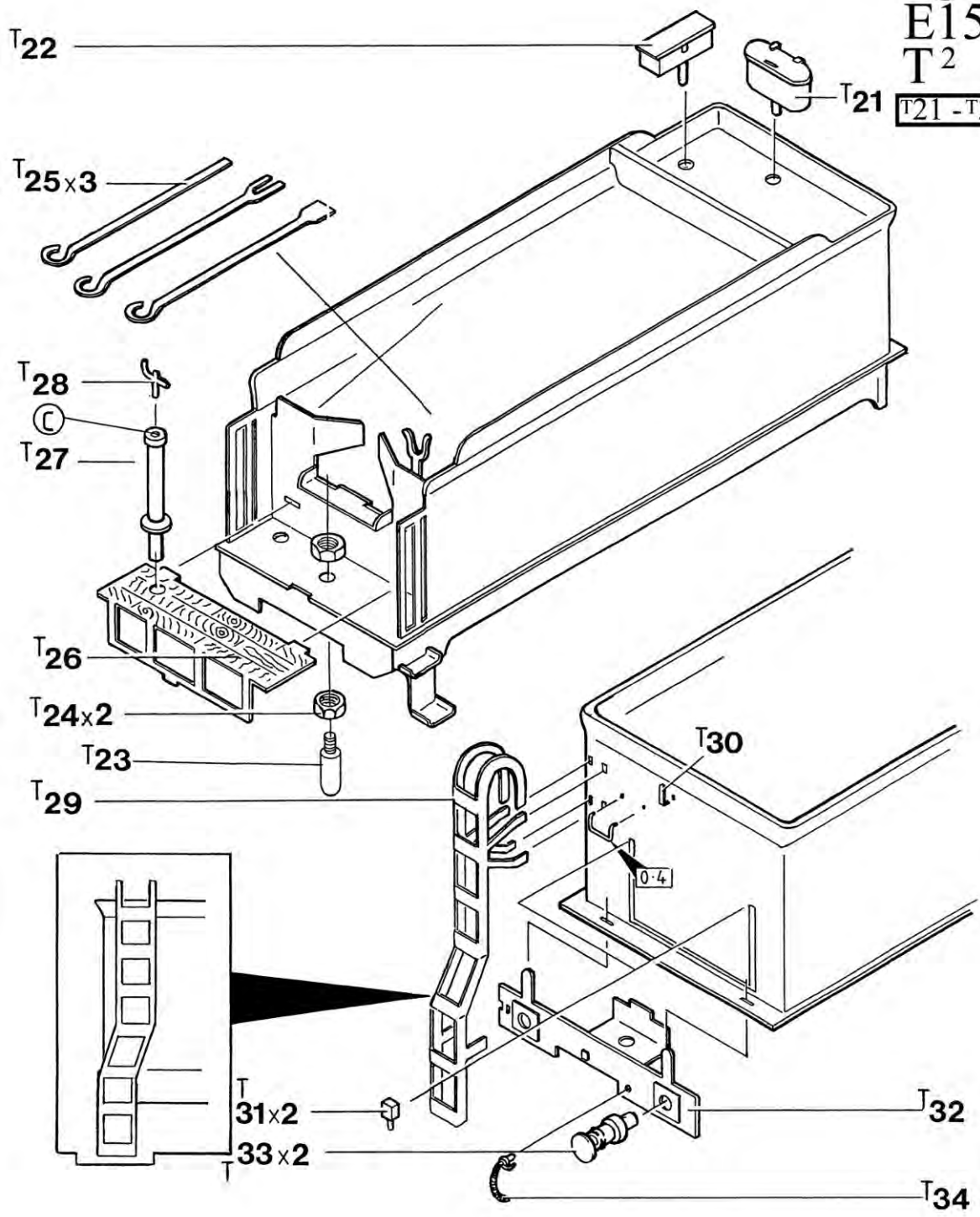
E152

T1

T1 - T20



dh
E152
T²
T21 - T34

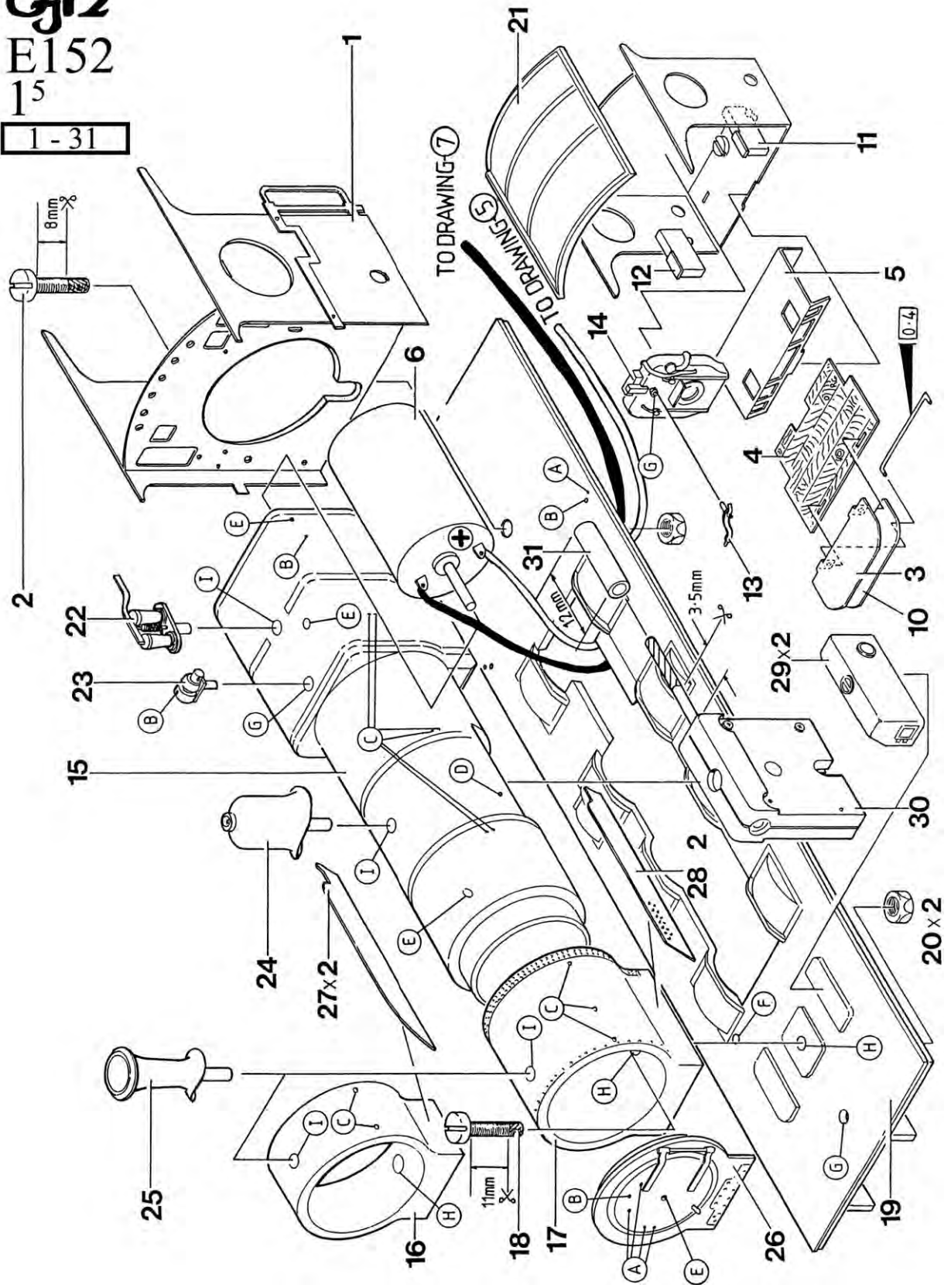


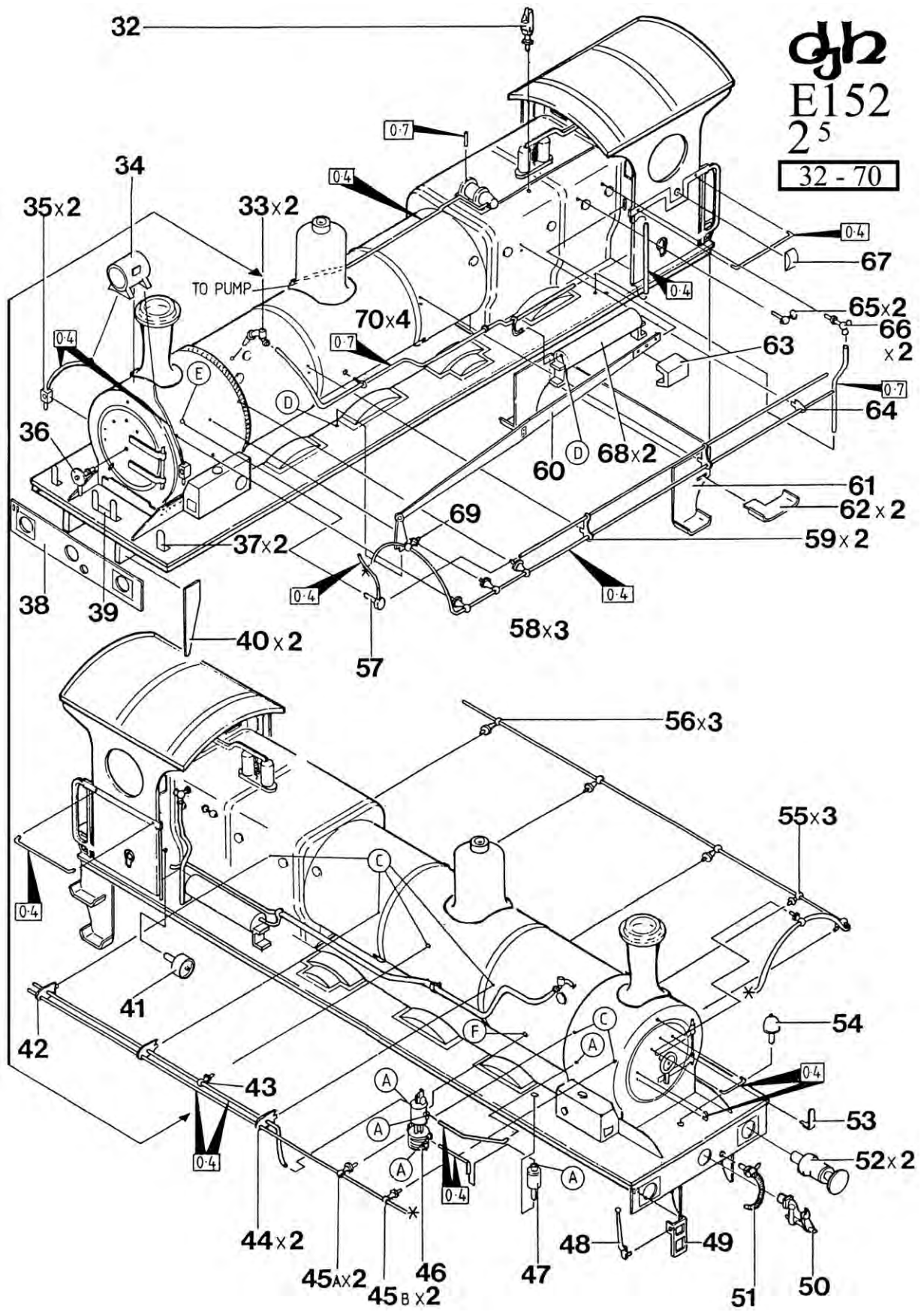
gh

E152

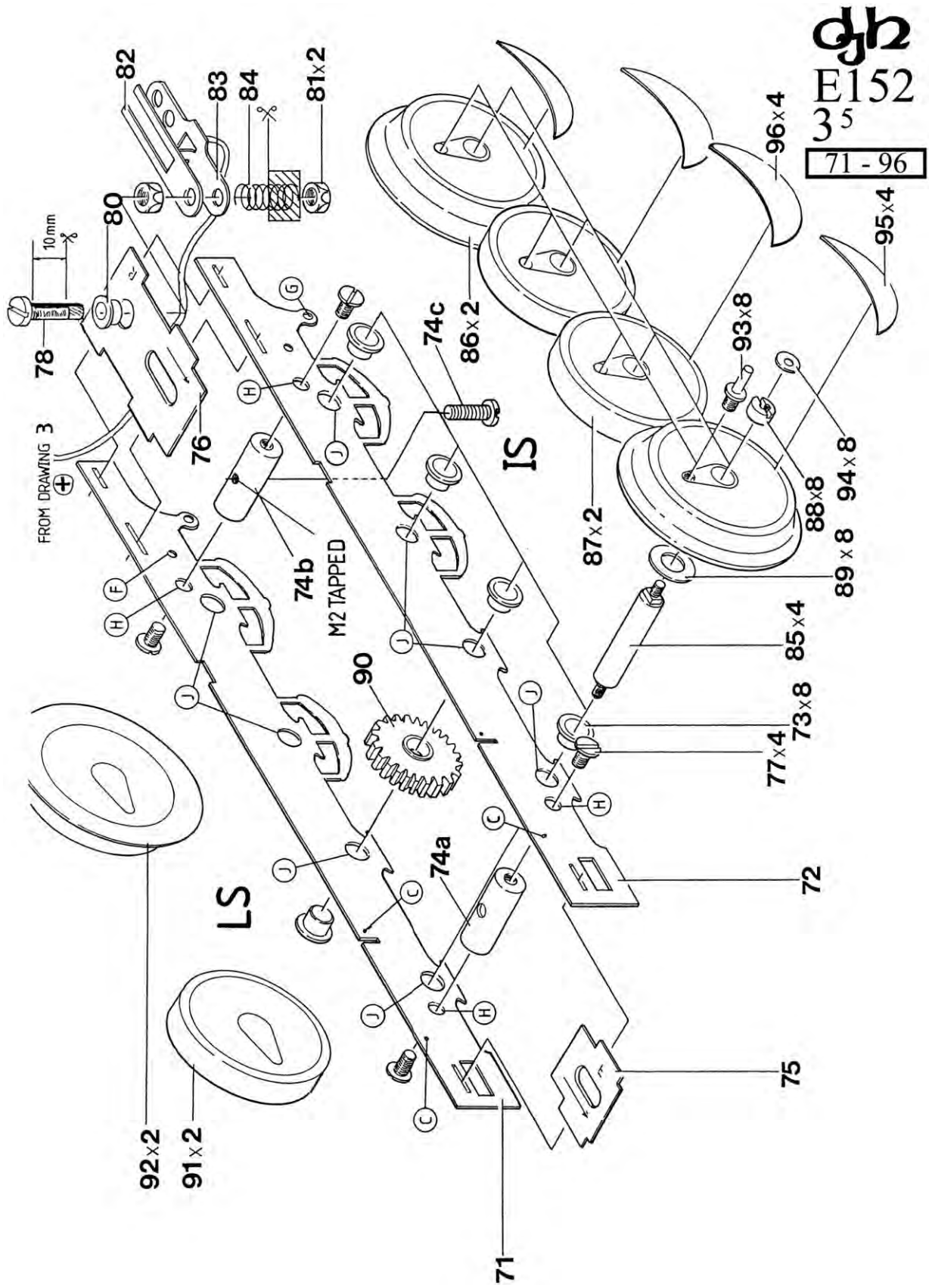
1⁵

1-31

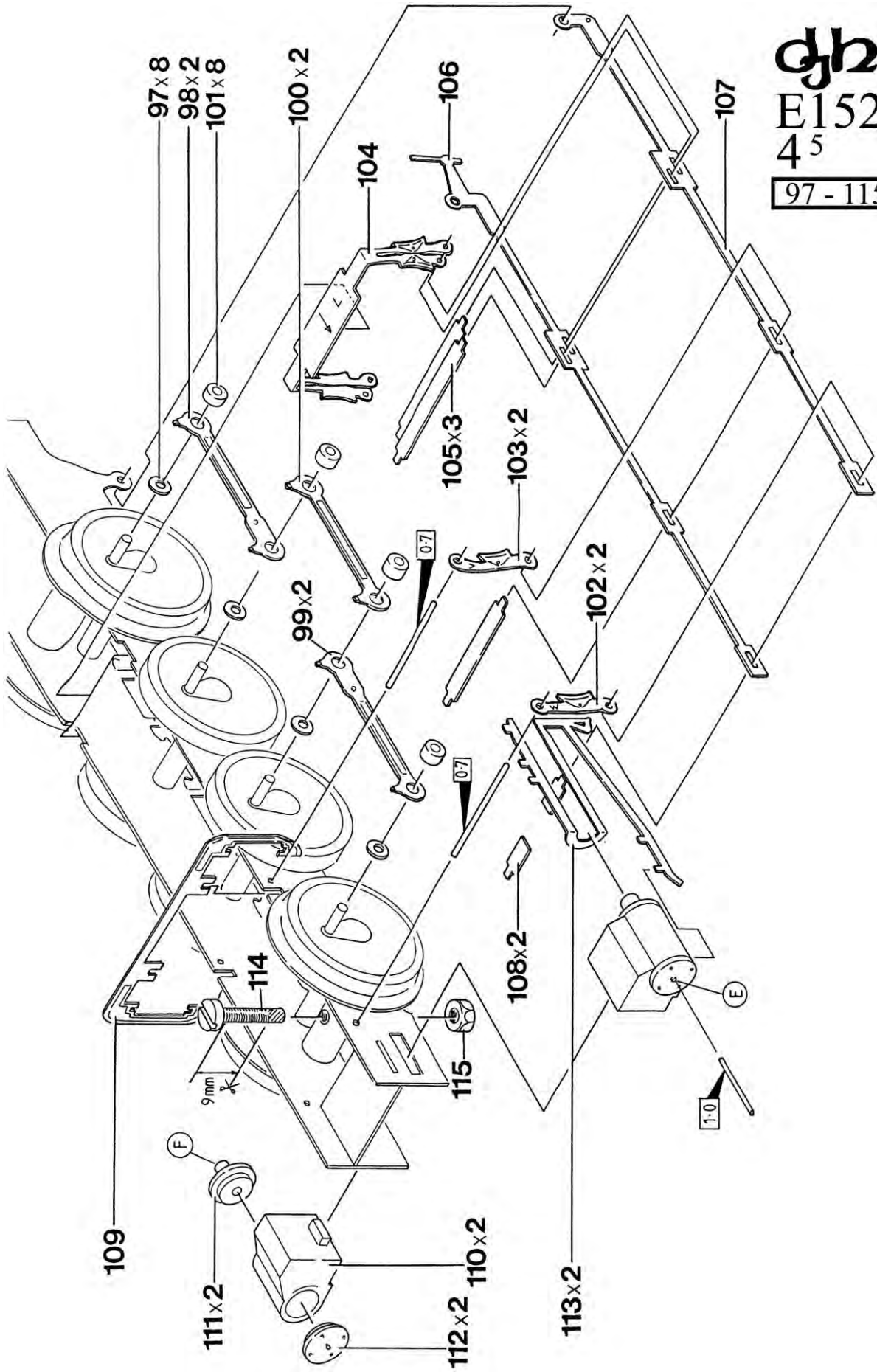





 E152
 2⁵
 32 - 70



gh
E152
4⁵
97 - 115



gh
E152
5⁵
116 - 130

