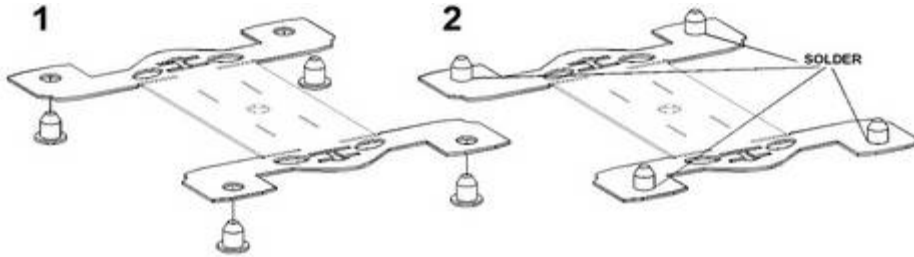


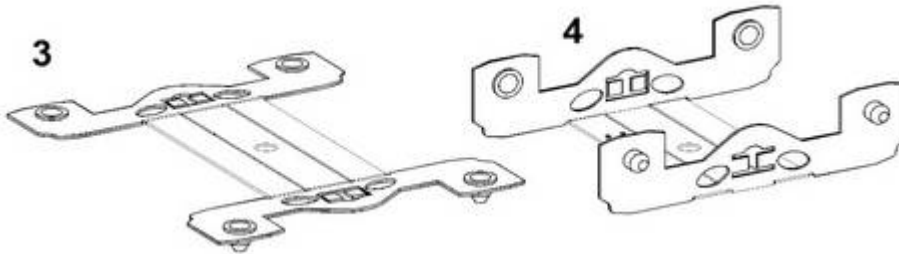
## CC52B Etched 1800mm wheelbase rigid bogie frames.

The preparation of the frames is straightforward. Bends can be made using ordinary pliers and hand pressure. They do not require the use of bending jigs such as hold and fold. 90° folds have the half etch on the inside.

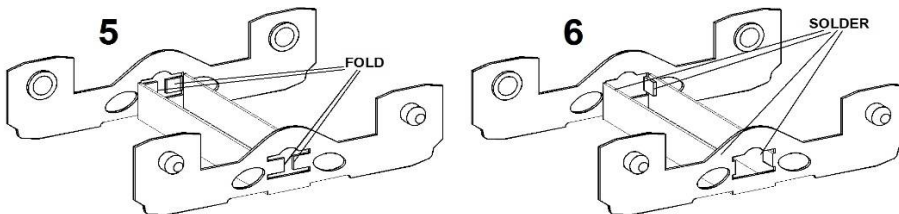
1. Insert the pin point bearings into the bearing holes as shown with the half-etched fold lines down.
2. Secure bearings with minimum solder; apply to the outside face of the bearings and sides, to keep it clear of the pin point hole.



3. Invert the frame as shown.
4. Fold up the two sides as shown so that they are at 90° to the central platform or bolster. These are folded first so that the sides are free to overcome a tendency to spring back a little.



5. Fold up the two sides of the bolster so that they are at 90° to the platform. Take care to avoid splaying the first folds on the sides.
6. Fold inwards the re-enforcing flaps at 90° in between the bolster side, and compress the folds against the bolster sides with pliers. Apply a good fillet of solder to the re-enforcements, allowing it to flow into the joints and folds. The finished frame must now be thoroughly cleaned to remove all traces of flux. Check the squareness of the frame, normal way up, on a flat surface, and correct if necessary (unlikely) by twisting carefully.



7. Check the fit of wheels in the frame. There should be a very small amount of end float. Suitable wheels are 12-12.5mm dia. with 26mm pin-point axles for most situations, but 10.5mm would apply for use with VNH bogies.
8. Secure the cosmetic side frames with contact adhesive or cyanoacrylate.
9. The bogie pivot hole is a nominal 2mm dia.
10. Fit the bogie on the pivot screw and secure with a plain nut. Run the nut all the way down so that it is lightly gripping the inside of the bolster. Carefully back the nut off by approximately half a turn (3 flats). This should give enough movement on the bogie to conform to normal track irregularities, but can be increased if required. Secure the nuts with Tippex, nail varnish, enamel or acrylic paint applied on one side of the top of the nut and the exposed screw thread – this prevents rotation in normal use, but they are still relatively easy to remove.
11. Fit the bogie on the pivot screw and secure with a plain nut. Run the nut all the way down so that it is lightly gripping the inside of the bolster. Carefully back the nut off by approximately half a turn (3 flats). This should give enough movement on the bogie to conform to normal track irregularities, but can be increased if required. Secure the nuts with Tippex, enamel, acrylic paint or nail varnish applied on one side of the top of the nut and the exposed screw thread – this prevents rotation in normal use, but they are still relatively easy to remove.

Email: [stensonmodels@btinternet.com](mailto:stensonmodels@btinternet.com)

Website: [www.stensonmodels.co.uk](http://www.stensonmodels.co.uk)