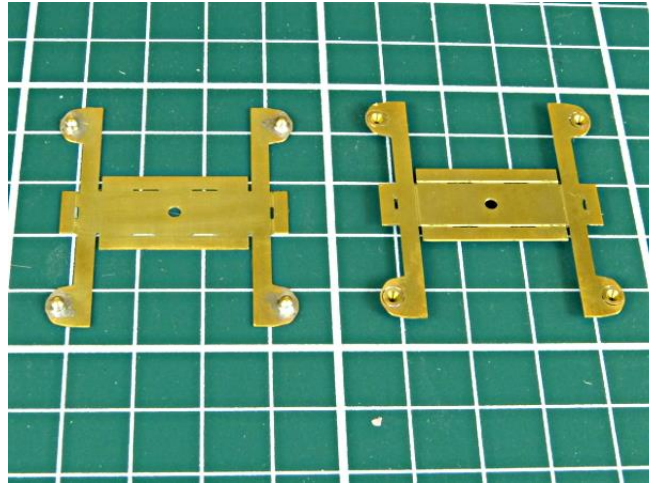


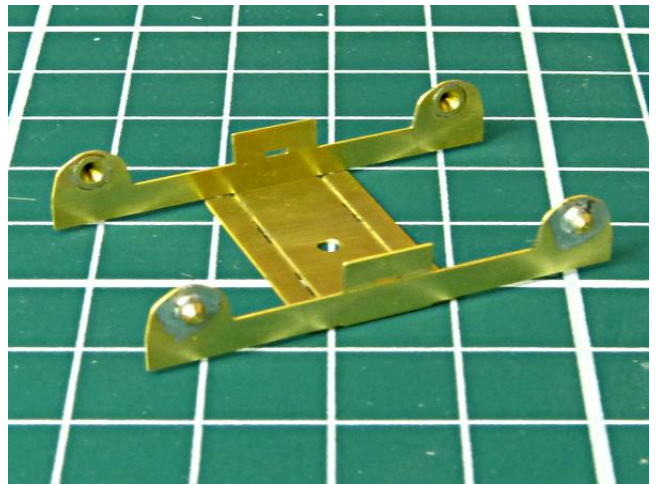
SM53B Etched bogie frames for DMU and coach 8' 6" wheelbase bogies.

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. 180° folds are made with the half etch on the outside.

1. Remove any residual half etch tabs from the bogie frame ends. Insert the pin point bearings (not supplied) into the bearing holes from the half-etched recess side and secure with minimum solder. In practise this is performed with the etch and bearings inverted as that on the bogie frame to the left. The solder is applied to the outside face of the sides. This keeps it clear of the pin point hole as on the bogie frame to the right.



2. 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 the natural tendency of the brass to spring back a little.



3. 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. Secure the side folds with a small application of solder on the inside as shown.

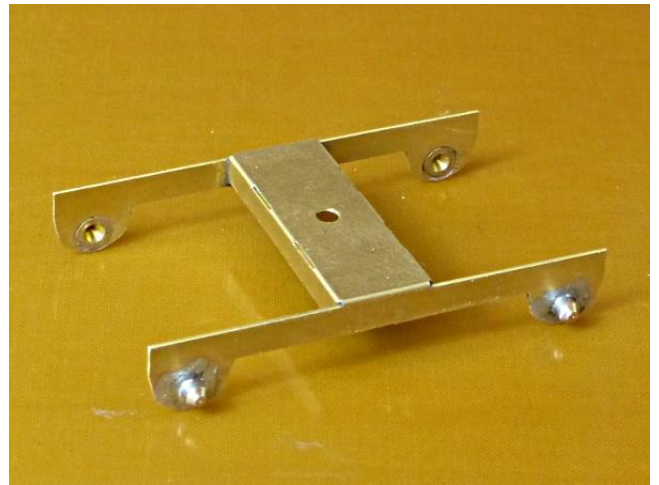


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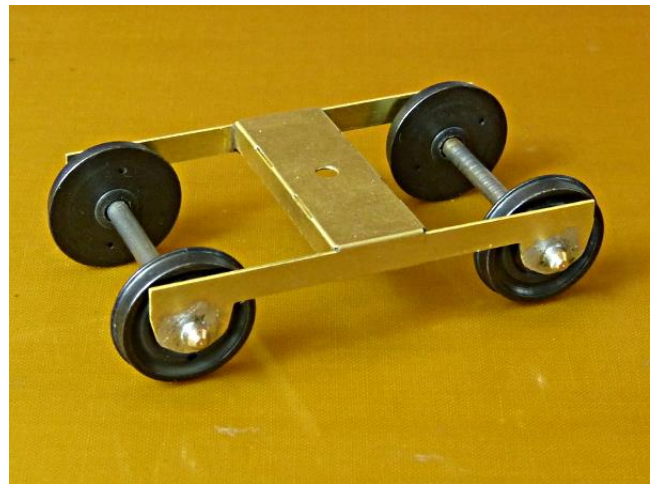
4. Fold the re-enforcing flaps at 180° in between the bolster side, and compress the fold with pliers. Apply a good fillet of solder to the re-enforcements, allowing it to flow into the joint. The finished frame must now be thoroughly cleaned to remove all traces of flux



5. Check the squareness of the frame, correct way up, on a flat surface, and adjust if necessary (unlikely) by twisting carefully. In this case a piece of Tufnol has been used. But a glass kitchen chopping board or similar could equally be used.



6. Check the fit of wheels in the frame. There should be a small amount of end float. It could be useful to double check the squareness of the bogie at this stage.



7. Cut the sides off your chosen moulded bogie and carefully slice off any projections with a sharp knife to leave smooth inside faces. Carefully open out the original bearing holes with a 2.0 - 2.2mm drill in a pin chuck so that they will fit over the brass bearing on the frame. Take your time over this as you don't want to break through to the outside.
8. Finally secure the sides on to the frame – contact adhesive is preferable as it is flexible, but two part epoxy resin is also suitable.

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