NOTE: PIVOT SHAFT SHOULD BE MACHINED FOR LIGHT PUSH FIT IN BEAM.
CENTER BEAM ON PIVOT SHAFT AT ASSEMBLY & SECURE WITH LOCTITE OR A BRASS PIN CROSSDRILLED THRU
BEAM & PIVOT SHAFT.

BEAM BUSHING x 1
BEAM WASHER x 2
#2-56 UNF x 3/16 HEX HD BOLT x 2

BEAM WASHER x 4
#2-56 UNF x 1/4 HEX HD BOLT x 4
BEAM BUSHING x 2

PISTON ROD LINK x 4

CYLINDER ROD END BUSHING BOLT x 2
(#2-56 UNF x 3/16 x 3/16 HEX WITH .030 HEAD)

CROSSHEAD LINK MOUNTING BLOCK x 2
GROUND LINK END BUSHING x 2
GROUND LINK BUSHING BOLT
#2-56 UNF x 5/16 x 2

CYLINDER ROD END BUSHING

CROSSHEAD LINK x 4

PARALLEL LINK SPACER

GERRY'S BEAM ENGINE SHEET #17
EXPLODED VIEW DRAWING TO SHOW THE INNOCENT HOW ALL THE LITTLE
FIDDLEY BITS AND ODD THINGIES ARE MEANT TO FIT TOGETHER
SCALE: 2:1
MATERIAL: FREE MACHINING BRASS
BOTTOM CYLINDER HEAD 1 REQUIRED

... (Diagram with dimensions and labels)
GEREYS BEAM ENGINE SHEET #5

MATERIAL: LASER CUT STEEL PLATE 3/4" O.D. DRAUL ROD

1. REQUIRED
2. CHAINSHAFT ASSEMBLY DETAIL

PROCESS USING LASER BURIED THROW PLATES.

1. ROUGH TURN 0.1" O.D. OF THROW PLATES
2. DRAFT & REAM CENTER HOLES 1/4"
3. CENTER THROW PLATES TOGETHER WITH SHORT 1/4" DRAUL ROD
4. DRAFT & REAM 500 O.D. CENTER HOLES AS PER
5. LOCATE THROW PLATES ON 3.25" LONG CENTER HOLES AS PER
6. SILVER SOLDER THROW PLATES ON SHAFT & ALSO SILVER SOLDER THROW SHAVE.
7. USE ABRASIVE SAW TO CUT OUT CENTER OF MAIN SHAFT
8. FINISH TURN 0.1" O.D. OF THROW PLATES. FACE OUTSIDE SURFACES AND TURN SHOULDERS.

TYPICAL BOLT SIZES

D.0 .250 TYP. BOTH THROW PLATES
D.0 .220 TYP. BOTH THROW PLATES
D.0 .250 TYP. BOTH THROW PLATES
D.0 .220 X .45 DIA. CENTER
D.0 .250
D.0 .250
GERVAI BEAM ENGINE SHEET #2

MATERIAL: 3/16" ALUMINUM PLATE
1 PAN REQUIRED AS SHOWN
Laser Cutting Template For Side Frames