

LS17 Loco frames assembly jig EM gauge

This product is intended for use with our range of loco frame etches. The width of the jig turnings is matched to our EM fold-up spacers code LS10. These products can also be used as described below to assemble loco frames of other manufacture. Used as directed, the jig will ensure that the frames are consistently assembled straight and square.

INSTRUCTIONS

1. Fettle the etched axle holes in both frames to achieve a push fit of the top hat bearings. DO NOT solder in the bearings at this stage, since this would capture the jig turnings in the frames.
2. Solder a selection of spacers to one frame only in your chosen positions, but do not fix any that will intrude into the area of the jigs, which we suggest should be used on the outermost axle holes.
3. Refer to sketch A. Assemble a nut onto one of the lengths of studding, then thread on a top hat bearing, then the first frame (ensuring that the bearing seats into the axle hole). Next thread on one of the turned brass jigs, followed by the second frame, top hat bearing and nut. Tighten so that the top hat bearings are clinched into place, then repeat for the other end of the frames.
4. Tighten all four nuts and check that the chassis is square and straight, then complete the solder joints between the spacers and the second frame.
5. Remove nuts, studding and top hat bearings then push the turned jigs out from between the frames. Insert and solder in any further spacers as required. For a rigid chassis, solder in the top hat bearings.
6. If you are assembling a chassis which has 6mm wide hornways and you wish to spring the chassis using our sprung hornblocks code LS55 the frame assembly jigs are located into the frames using our adaptor turnings code LS59 instead of the top hat bearings described above. This is shown in sketch B.

