

TC5 TENDER INSIDE FRAMES 7'3" x 6'3" wheelbase

For LNER Group Standard Tenders

These frames are designed to enable wheelsets to be fitted without removing the wheels from the axle. They can be built rigid, sprung or compensated as desired.

Before commencing assembly you will need to prepare the etch accordingly.

1. Alternate holes are provided for the axle keeper rod. Use the upper hole for a rigid chassis and the lower for a sprung or compensated chassis. Drill out the required holes to 0.75mm.
2. If you intend to compensate the chassis remove the small tongue of metal at the top of the axle slots. Alternate pilot holes are indicated for fitting the pivot beam in front of or behind the centre axle. Drill out the desired holes to fit your chosen pivot wire and tube (not supplied).
3. In all cases drill out the holes for the brake hangers and cross shafts to 0.75mm. Fettle the axle slots if necessary to allow the axles to slide up the slots without sticking. A couple of strokes with a fine file should be all that is required for 2mm axles.

ASSEMBLY

1. Fold up the tabbed spacers to 90° and solder them both to one of the frames, making sure the half etched fold lines on the tabs at the bottom of the axle slots are on the same side as the spacers.
2. Fit the other frame in place and lightly tack solder whilst pressing the assembly onto a flat surface. Drop the axles in place and check they are square to the frame and do not rock. When satisfied with the alignment, complete the soldering on the second frame.
3. The two plain spacers can now be bent to 90° and fitted where required depending on the body mounting points etc.
4. Bend the axle retaining tabs to 90°, drop the wheelsets in place with spacing washers to eliminate sideplay on the outer axles and insert short lengths of 0.7mm wire through the holes in the retaining tabs to hold the wheelsets in place.
5. Solder 0.7mm wire through the brake hanger holes, thread on the brake shoes and solder in place whilst aligning them with the wheels. If fitting the water scoop from one of our tender frame kits it is best done at this stage.
6. Feed 0.7mm wire through the bottom holes in the brake shoes and brake pull rods and solder in place. The pull rods should line up directly below the frames with the plain end at the front of the chassis. When they are soldered in place, the plain end can be bent up to meet the frames and soldered.
7. Finally bend the guard irons to shape and check they do not foul the track. The completed chassis can now be offered up to the superstructure and the fixing arrangements can be made. We prefer bolt fixings so the chassis can be removed easily.

