

**TB7 Tender Body Pack  
LMS Stanier Coronation  
Non-streamlined**

Components required to turn this body pack into a complete tender:

TC3 7'6" x 7'6" inside frames  
TF1 chassis kit  
3 axles 4'3" Markits wheels (WH35)

This body pack is intended for use with our tender frame kit TF1, but can also be used for scratchbuilding or to improve an RTR tender.

These 10 ton 4000 gallon non-streamlined tenders were of welded construction and had a conventional layout with rear steps, tubular air vents and a single tank filler. Five were built and allocated to locos 6230-4 from 1938. However, from 1945, 6230/31 were paired with de-streamlined tenders (Comet Models code TB6). One of the non-streamlined tenders was paired from 1946 with 46223, the other ran behind various engines, but chiefly 46247 from 1952-61.

Etchings list

- |                         |                                  |
|-------------------------|----------------------------------|
| 1. Front bulkhead       | 9. Offside bunker side           |
| 2. Tank rear            | 10. Rear bulkhead overlay        |
| 3. Tank rear overlay    | 11. Front platform               |
| 4. Sides x2             | 12. Front platform inner support |
| 5. Tank top             | 13. Coal pusher rams (4)         |
| 6. Rear bulkhead        | 14. Lifting ring bases (2)       |
| 7. Bunker base          | 15. Lifting rings (2)            |
| 8. Nearside bunker side |                                  |

Castings etc. list

- |              |                    |                     |
|--------------|--------------------|---------------------|
| Tender front | Fire iron tunnel   | Handrail knob (6)   |
| Water gauge  | Coal pusher piston | 0.45mm n/s wire (2) |
| Dome         | Steam valve cover  |                     |
| Tank filler  | Tank vent (2)      |                     |

**Assembly Sequence**

Note: make all folds with the half-etch to the inside of the fold unless stated otherwise. The instructions assume that the body will be built onto the tender base from our frame kit TF1, which should be completed up to step (8) in its instructions. It is advisable to add whitmetal castings to both the frames and superstructure only when all the hard soldering of etched parts has been completed.

1. Fold up and solder the front bulkhead etch (1), locating it to the tender base by the tabs on its lower edge. Check that it is square to the frame in all directions. You may need to file a small notch each side of the base to ensure clearance for the front wheel flanges.

2. Fold out the step treads from the tank rear (2) then fold up and solder this to the tender base, tack soldering at the sides only. Again check for squareness and when satisfied locate the tank rear overlay (3) by placing its lower edge onto the tank base first, then locating the step treads through the slots in the overlay and lastly pressing the overlay tight against the tank rear. Complete the soldering of these items, then file back the vertical edges flush with the tank rear.

3. Check the fit of the tender sides against the front bulkhead. You may find the top bend needs easing slightly for a perfect fit. Before soldering the sides in place, fold up the front platform (11) and ensure that it will fit between the front edges of the sides - it may be necessary to ease the front bends slightly to achieve this. When satisfied, locate the tabs along the bottom edges of the sides into the slots in the tender base and solder in position (sketch 1).

4. If you wish to fully model the coal bunker, fold up the tank top (5) as per the sketch - note that the front bend is made with the half-etch to the outside. Slide the tank top into position - the rear end rests on the top return of the tank rear and the front on the lower edge of the cut-out in the front bulkhead, with the intermediate supports resting on the tank base. When satisfied, solder in position (sketches 3 & 5).

Alternatively, if you intend to model the tender coaled up simply bend down the intermediate supports only. In this case the front of the tank top is supported by the horizontal return of the front bulkhead. Again, slide into position and solder (sketch 2).

5. Fold the tabs on the rear bulkhead (6) to approximately 45° and solder the bulkhead to the tank top, locating it by the tabs on its bottom edge. The rear bulkhead overlay (10) can now be soldered to the rear bulkhead, ensuring that it is located centrally on the bulkhead. Now file flush the base of the water dome and solder in place with the main part of the dome forward of the bulkhead (sketch 3).

6. Solder the bunker base (7) in position, with the back edge resting on the bulkhead support tabs.

7. If you have decided to fully model the coal bunker, locate and solder in place the nearside bunker side (8). Bend the top of the offside bunker side (9) so that when in position with the top touching the tender side, the top is approximately horizontal (sketch 4). When satisfied, solder in place. If the bunker is not to be fully modelled discard part 9 and modify the nearside bunker side (8) by separating it along the half-etched line. Discard the smaller piece, and solder the larger one in place as per the sketch. The tender assembly can now be washed to remove any flux residues before proceeding (sketches 2 & 3).

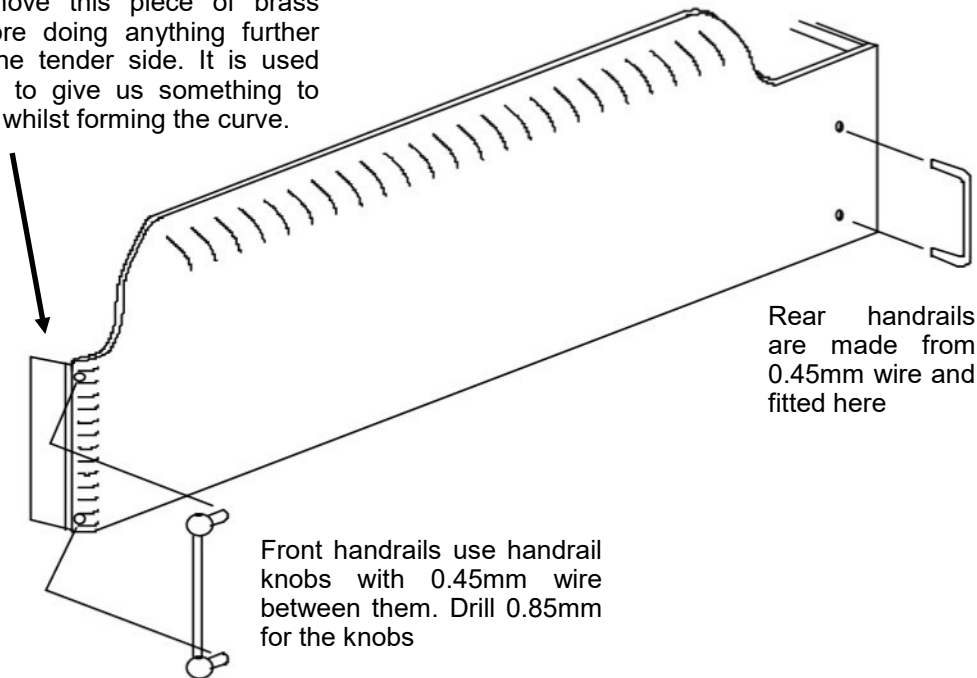
8. Fold the front platform inner support (12) to shape and solder to the underside of the front platform (11), making sure the top edges of the former are located in the inner half-etched lines of the latter, and that the inner support is the correct way up. File a notch in both the inner front platform etch and the base of the tender front casting to clear the tender chassis/frame fixing screw. Fettle the tender front casting and check for fit against the front bulkhead - it should slide into position

between the front edges of the tender sides. With the tender front casting in position (but not fixed) slide the front platform up to it and check the fit - the brake and water scoop covers should fit snugly on top of the platform. Fettle as required and when satisfied fix in position with adhesive, since you may find it difficult to make a hidden or neat solder joint.

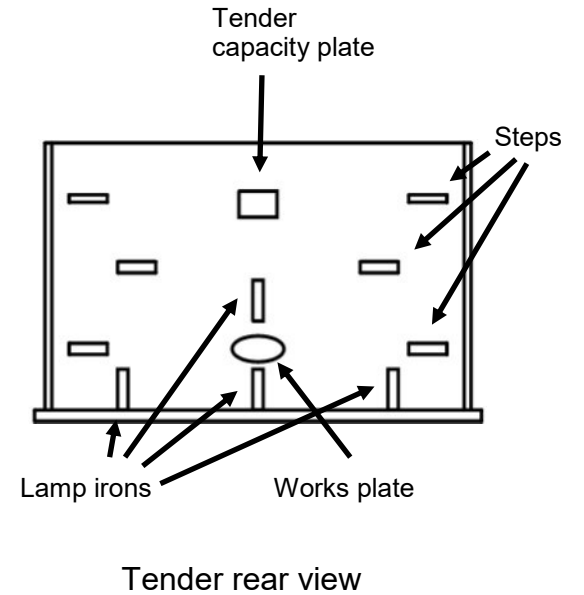
9. Fold up the coal pusher rams and solder them in place. Slightly modify the coal pusher piston as per sketch 7 and fix it in position.
10. The remaining detail may be added in any order as per the sketches. The water scoop and brake operating handles are made from handrail knobs and 0.45mm wire as per sketch 6.

This completes assembly of the tender body, and detailing of the underframe can now be completed as described in the TF1 instructions.

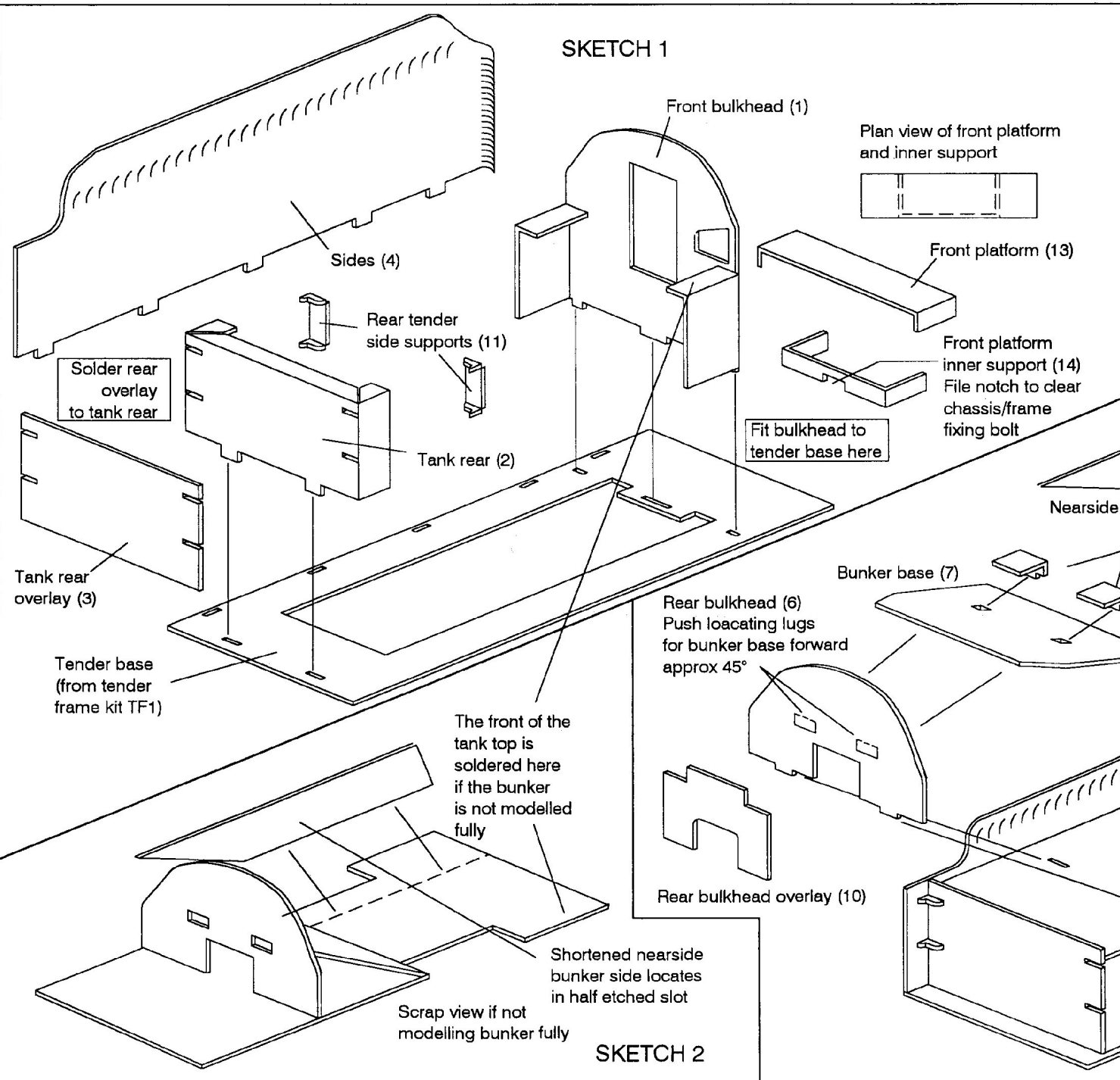
Remove this piece of brass before doing anything further to the tender side. It is used only to give us something to grip whilst forming the curve.



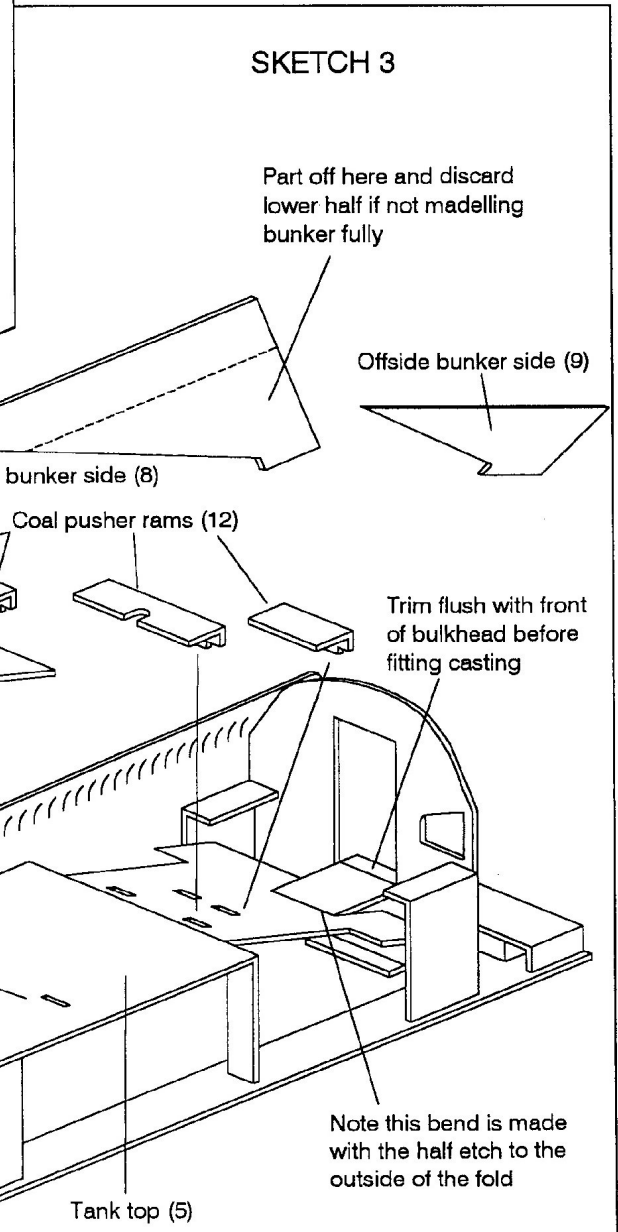
Please note that the lamp irons, works plate and capacity plate are not provided. We make the lamp irons from 'Bambi' staples cut in half. The works and capacity plates are available from other manufacturers.



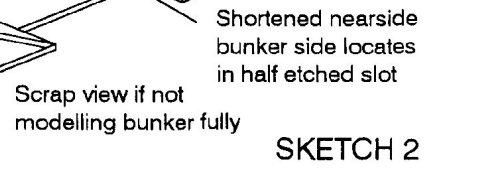
SKETCH 1



SKETCH 2



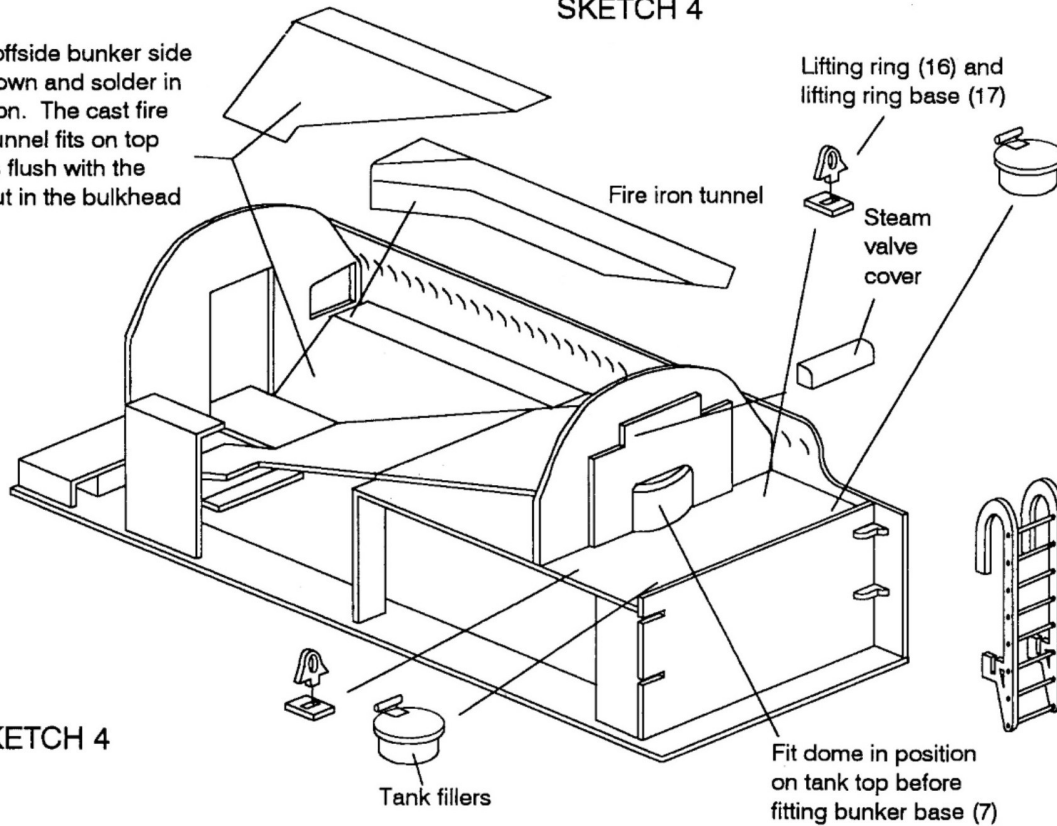
SKETCH 3



Note this bend is made with the half etch to the outside of the fold

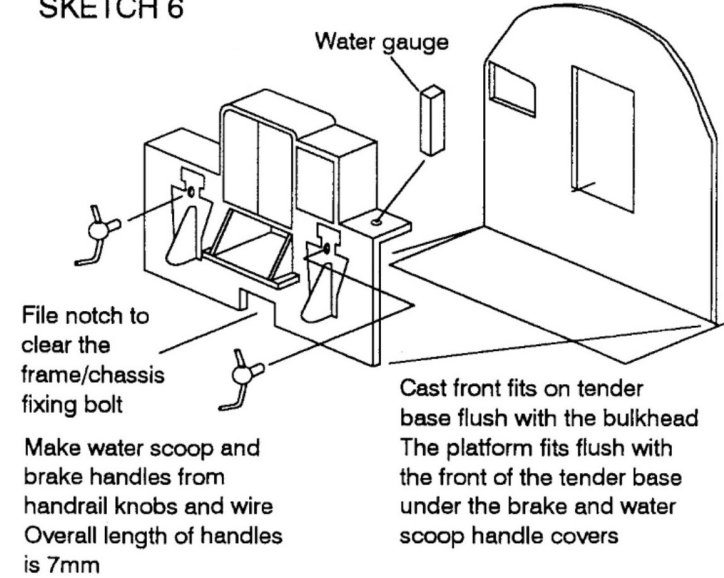
SKETCH 4

Fold offside bunker side as shown and solder in position. The cast fire iron tunnel fits on top of this flush with the cut-out in the bulkhead

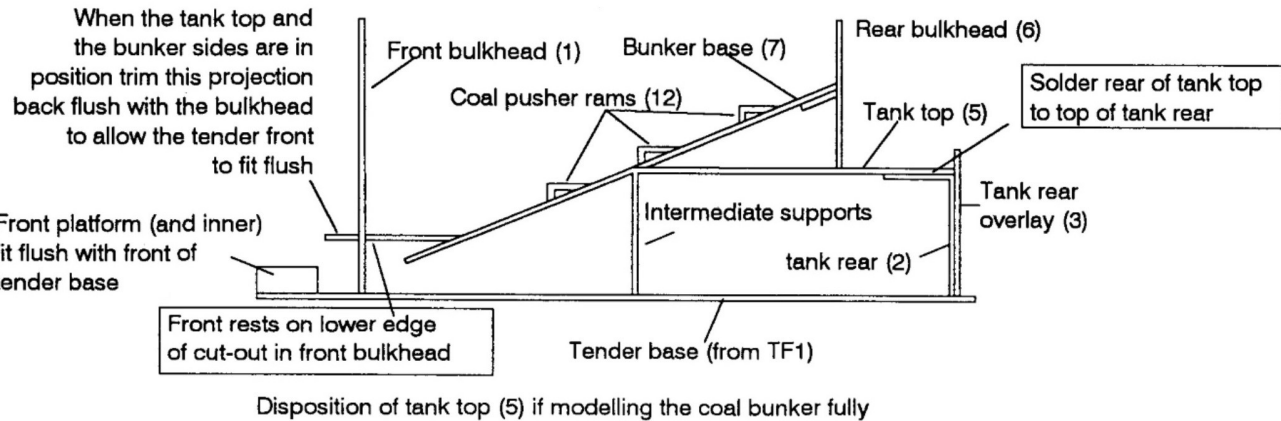


SKETCH 4

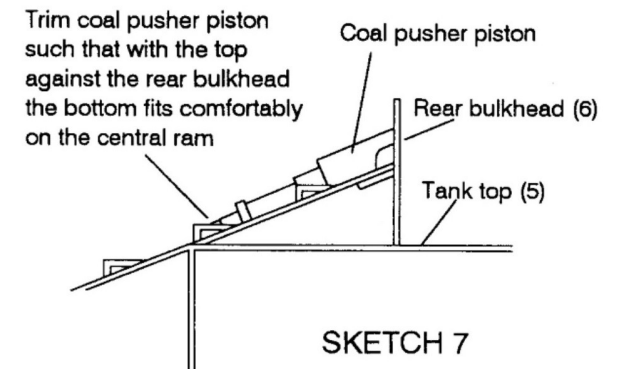
SKETCH 6



Slide ladder into slots in tank top. Hook under buffer beam and lift to fully engage slots in ladder in buffer beam. Solder in position with ladder vertical



SKETCH 5



SKETCH 7