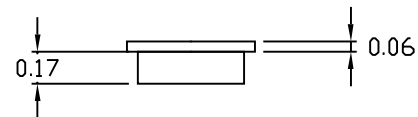


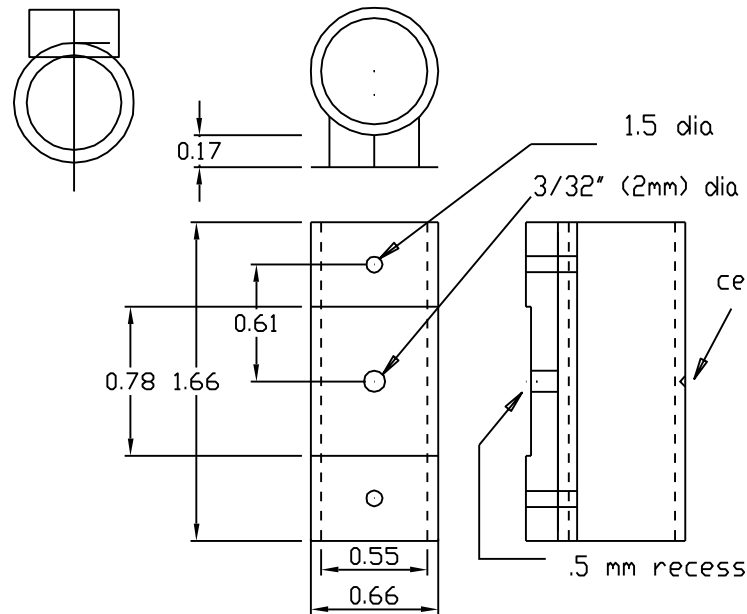
Cylinders



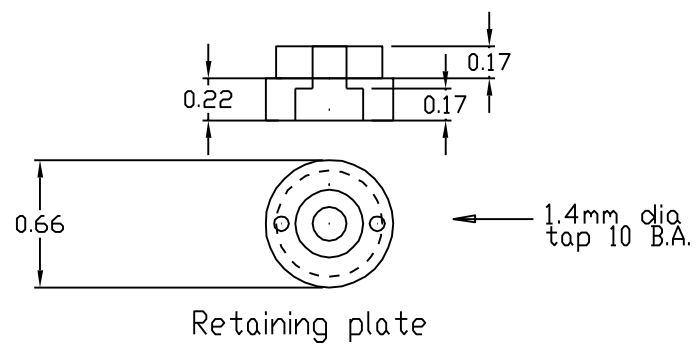
Top cover, brass
Solder or cement to cylinder



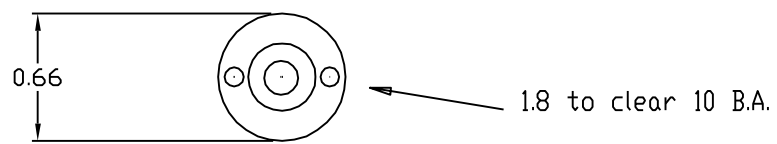
Cylinder, brass fabrication
soft solder is adequate



Bottom cover brass
1/8" (3mm) bore to fit piston rod
hole should be reamed
counter bore 1/4" (6mm)
should just nip 'O' ring lightly

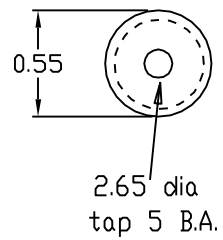


Retaining plate

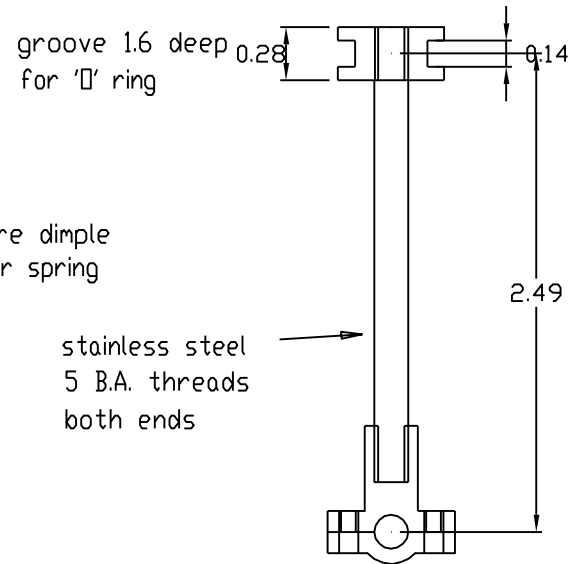


spigot to fit recess in bottom cover
nominal .5mm high
Must allow drilling to move slightly

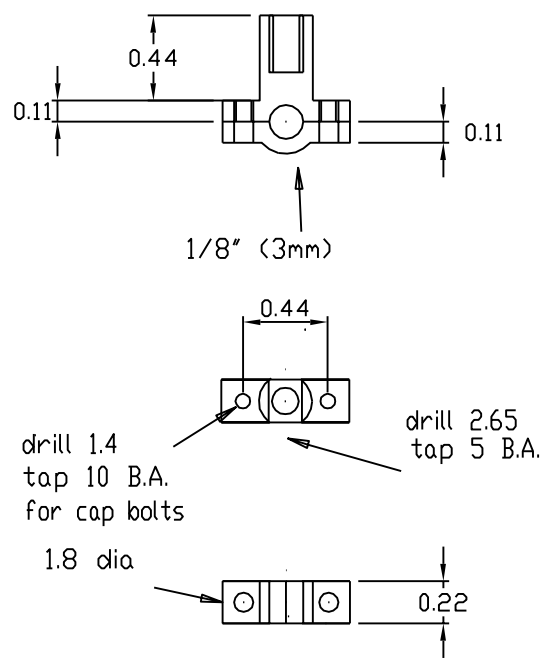
Piston & rod



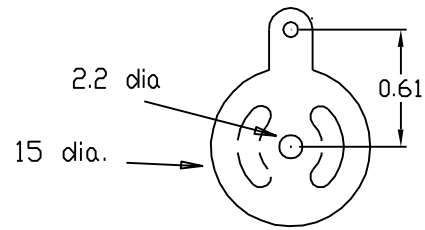
CROSS SECTION



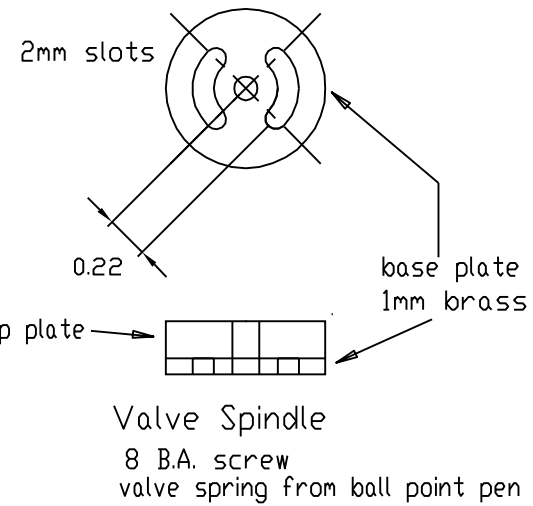
Split big end - brass



Reversing Valve

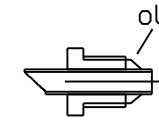


lever &
top plate

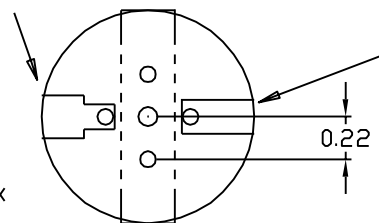
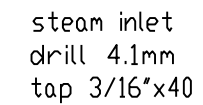


Trunnion pin

10mm of 3/32" (2mm)
silver steel



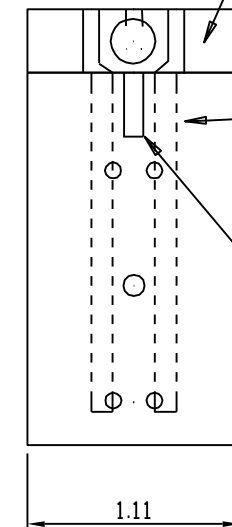
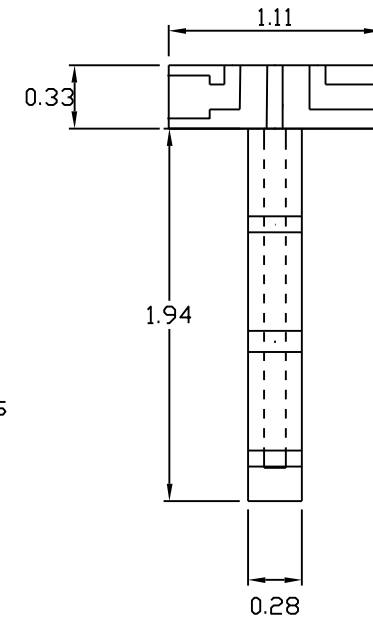
Union fitting 1/4" hex



Port Block

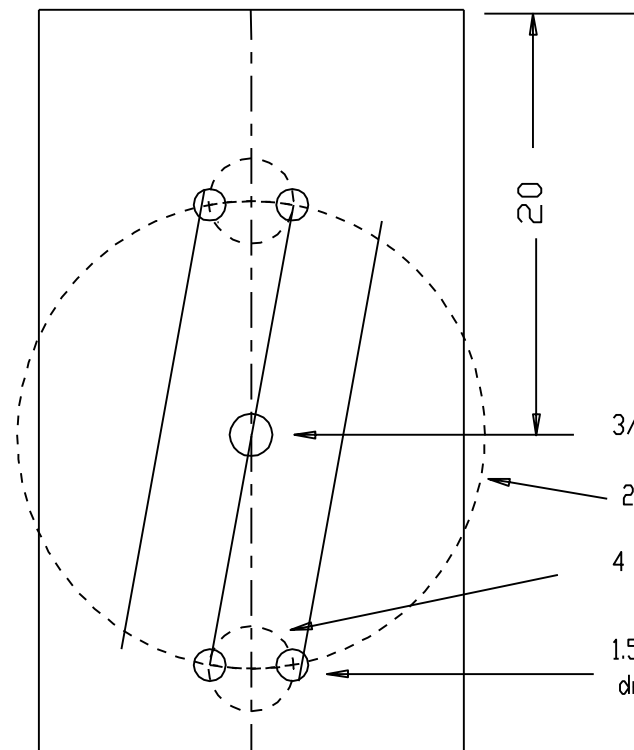
brass, fabricate with soft solder
centre hole 2.2mm
ports 1.5mm

1/8" exhaust

relieve
corners

2mm dia drilled passages
at 3mm from centre
to meet parts

1.8mm
tap
8 B.A.



Marking out ports
Locate ports from intersection
of circles as shown

TWICE FULL SIZE

3/32" (2mm) dia for trunnion pin

— 22 diameter circle

4 diameter

1.5 diameter port
drill right through

RESCALED TO 7/8N2 1:13.7

2.10.07

Cylinders for de Winton
Dave Watkins
9/8/97