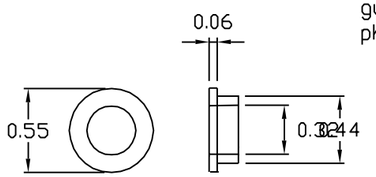
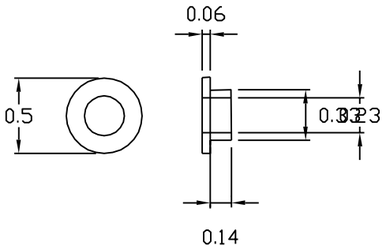
ALL JOINTS SILVER SOLDERED
PRESSURE TEST TO 80 PSI
SAFE WORKING PRESSURE 40 PSI

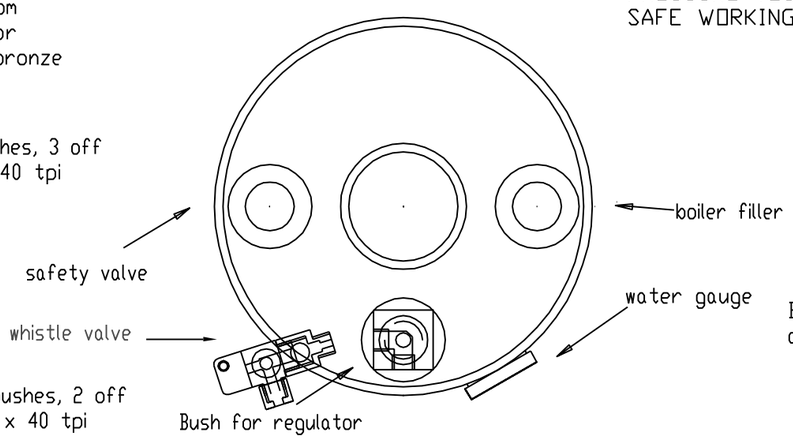
Bushes from
gunmetal or
phosphor bronze



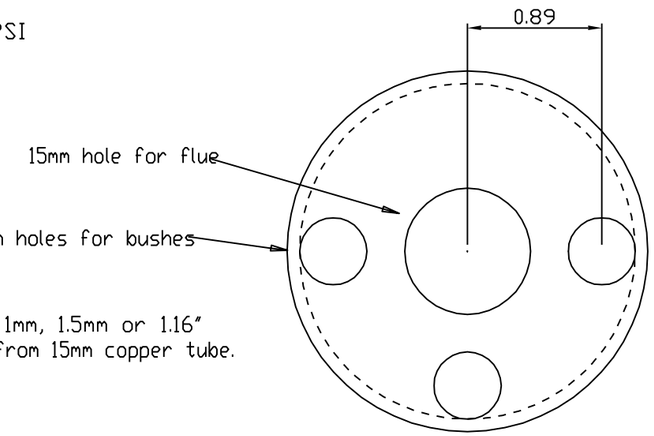
Top bushes, 3 off
1/4" x 40 tpi



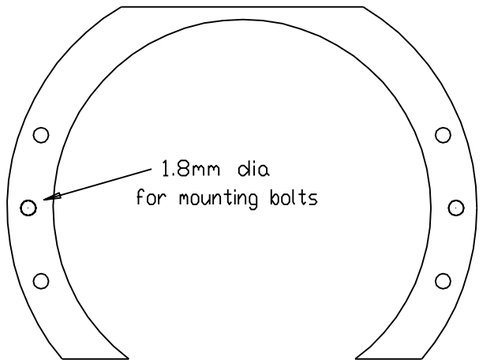
Side bushes, 2 off
3/16" x 40 tpi



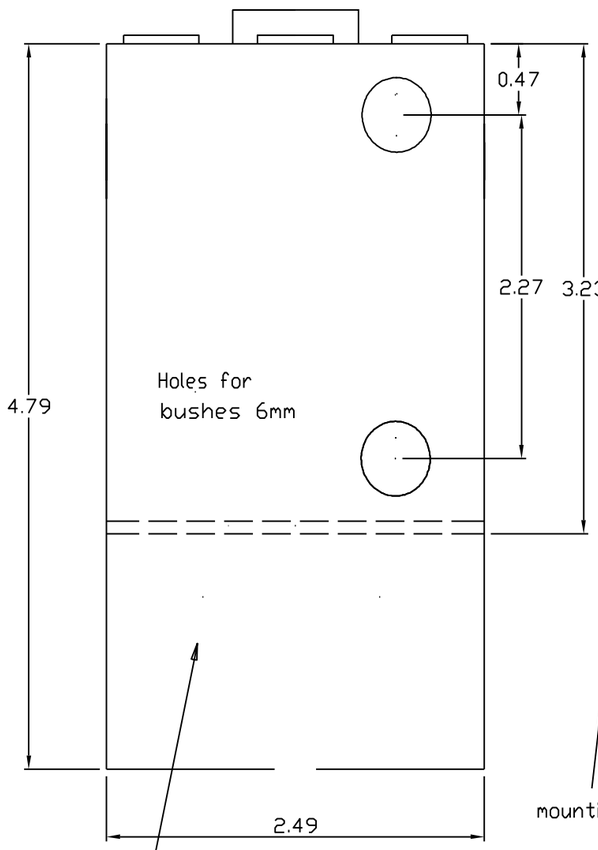
Boiler end plates from 1.5mm copper sheet



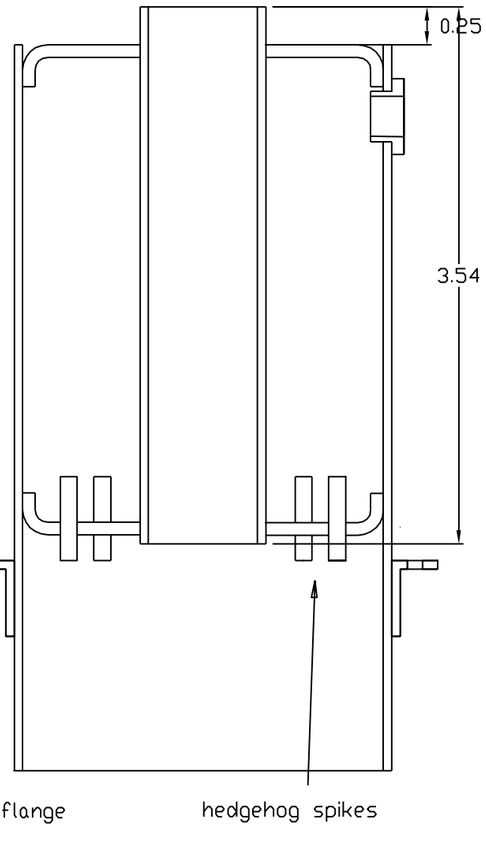
Boiler shell from 1mm, 1.5mm or 1.16"
copper tube. Flue from 15mm copper tube.



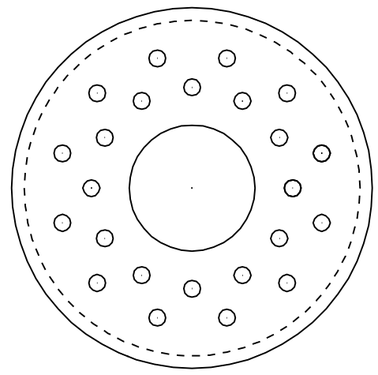
Mounting flange, fabricate
from 1mm brass sheet
bolt or rivet to firebox



air holes 5mm dia., 6 off, none on crankshaft side



Both plates initially 50mm diameter
before flanging over circular former 40mm diameter.
Drill holes after flanging



Bottom plate 43mm diameter
after flanging. Should be a
tight fit in the boiler shell.

15mm centre hole for flue,
2mm holes for hedgehog spikes
from thick copper wire.

RESCALED TO 7/8N2 1:13.7

2.10.07

Boiler for de Winton
Dave Watkins
9/8/97

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