NOTES:
0. ALL DRAWINGS ARE IN METRIC MEASUREMENTS
1. ALL ENGINEERING PRACTICES SHALL BE APPLIED WITH REGARDS TO HOLE AND SHAFT TOLERANCES.
2. WHERE SCREWS OR BOLTS ARE USED THE CLEARANCE HOLES SHALL BE APPROXIMATELY 5% TO 8% LARGER THAN THE MATCHING TAPPED HOLE.
3. PREFERABLY ALL TAPPED HOLES AND MATCHING SCREWS AND/OR BOLTS TO BE METRIC FINE (MF)
4. MATERIALS SPECIFIED ON THE DRAWINGS ARE INDICATIVE ONLY. THE BUILDER CAN MAKE HIS/HER OWN MATERIAL CHOICE.
5. ALL CONNECTIONS/JOINTS WHICH HAVE STEAM PRESSURE APPLIED TO IT SHALL BE SOLDERED.
6. WHERE PREferred, SCREW OR BOLTED CONNECTIONS CAN BE OMITTED AND PARTS CAN BE BONDED TOGETHER BY USING EITHER HIGH STRENGTH GLUE, POXY RESIN OR SOLDER.
7. PARTS WHICH ARE DIRECTLY EXPOSED TO STEAM AND/OR WATER SHOULD BE CONSTRUCTED USING NON-FERROUS OR NON CORROSIVE MATERIAL SUCH AS BRASS, BRONZE GUNMETAL, STAINLESS STEEL COPPER OR NICKEL.
8. THE ORDER IN WHICH THE PARTS/COMPONENTS ARE MANUFACTURED AND THE MODEL IS ASSEMBLED IS ENTIRELY LEFT TO THE BUILDER/MODELMAKER.
9. ERRORS AND/OR OMISSIONS MAY OCCUR IN THE DRAWINGS, DO NOT HESITATE TO CONTACT ME SO THAT THE ERRORS/OMISSIONS CAN BE RECTIFIED.

MATERIAL ABBREVIATIONS:
ALU = ALUMINIUM
BRS = BRASS
BRZ = BRONZE OR GUNMETAL (BRZ/GM)
CI = CAST IRON
CU = COPPER
GRA = GRAPHITE
MS = MILD STEEL/BRIGHT MILD STEEL
S/S = SILVER STEEL OR STAINLESS STEEL
SPS = SPRING STEEL
SYN = SYNTHETIC MATERIAL SUCH AS VETON, NYLON, TEFON OR RUBBER

OTHER ABBREVIATIONS
DP = DEEP
PF = PRESS FIT
PCD = PITCH CIRCLE DIAMETER
RM = REAM
HEX = HEXACON, 6SIDED
CP = COMPRESSED
KNL = KNURLED
SA-n-xxx = SUB ASSEMBLY-n-xxx

NOTES: LOOSLY BASED ON A GERMAN DESIGNED ENGINE BY GERY POSCH

V-SHAPED DOUBLE ACTING STEAM ENGINE
BORE 20mm x STROKE 24mm
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