<table>
<thead>
<tr>
<th>ITEM NO.</th>
<th>Number</th>
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<td>1</td>
<td>A1-LYN-446</td>
<td>SADDLE AND CYLINDER FRAME MOUNTING FLANGE</td>
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<td>2</td>
<td>A3-LYN-486</td>
<td>STEAM CHEST DRAIN PIPE</td>
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<td>A3-LYN-489</td>
<td>STEAM TRANSFER PORT CORNER FILLER</td>
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<td>4</td>
<td>A2-LYN-494</td>
<td>EXHAUST LOWER PLATE</td>
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<td>A1-LYN-498</td>
<td>STEAM TRANSFER PORT 1</td>
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<td>A1-LYN-499</td>
<td>STEAM TRANSFER PORT 2</td>
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<td>A2-LYN-497</td>
<td>TRANSFER PASSAGE SEGMENT</td>
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<td>A3-LYN-500</td>
<td>STEAM CYLINDER CENTRAL DRAIN PLUG BOSS</td>
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<td>A2-LYN-512</td>
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<td>A3-LYN-514</td>
<td>STEAM CHEST END PLATE 2</td>
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<td>STEAM CYLINDER</td>
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<td>A3-LYN-520</td>
<td>STEAM INLET PORT BOTTOM PLATE</td>
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<td>A3-LYN-521</td>
<td>STEAM INLET PORT TOP PLATE</td>
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<td>A1-LYN-524</td>
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<td>VALVE CYLINDER</td>
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<td>VALVE INSPECTION PORT 1</td>
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<td>VALVE INSPECTION PORT 2</td>
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<td>A3-LYN-533</td>
<td>VALVE LINER POSITIONING GUIDE</td>
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<td>A3-LYN-537</td>
<td>CYLINDER LOWER SUPPORT PLATE</td>
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<td>STEAM CHEST DRAIN TUBE SUPPORT</td>
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<td>STEAM CHEST INSTRUMENTATION ACCESS PORT</td>
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<td>A2-LYN-547</td>
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<td>CYLINDER EXHAUST END TURN GUIDE SIDE 1</td>
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<td>A3-LYN-492</td>
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<td>39</td>
<td>A3-LYN-493</td>
<td>EXHAUST GUIDE REAR PLATE</td>
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</tbody>
</table>

WEIGHT = 211.18 kg

The Lynton & Barnstable Railway
The 'Lyn' Project
Technical queries to Ian on 01954 204338 or: ian.gaylor@steam-loco-design.co.uk
Drawing queries to Mike on 01954 780772 or: baldwin@machineconcepts.co.uk
NOTE

1. TOTAL QUANTITY REQUIRED = 2 OFF

2. AFTER MACHINING THE BORE TO THE DIMENSION THE EXACT FINAL DIMENSION SHOULD BE MEASURED AND USED TO CALCULATE THE OUTSIDE DIAMETER OF THE VALVE LINER. THE DIAMETER PLUS 0.134 MUST EQUAL THE FINAL OUTSIDE DIAMETER OF THE VALVE LINER.

3. AFTER MACHINING THE BORE TO THE DIMENSION THE EXACT FINAL DIMENSION SHOULD BE MEASURED AND USED TO CALCULATE THE OUTSIDE DIAMETER OF THE CYLINDER LINER. THE DIAMETER PLUS 0.220 MUST EQUAL THE FINAL OUTSIDE DIAMETER OF THE CYLINDER LINER.

4. BEFORE MACHINING, THE ASSEMBLY MUST BE STRESSED RELIEVED.
NOTES

1. CARE MUST BE TAKEN THAT THIS WELD DOESN'T OBSCURE THE PORT OPENINGS

WEIGHT = 211.18 kg

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NOTE
1. THE PLATES MUST BE FLUSH WITH THE PORTS AND ANY PERTURBATIONS CLEANED OFF

WEIGHT = 211.18 kg

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The 'Lyn' Project

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STAGE 1B ADDING THE INLET PORT PLATES

SEE NOTE 1

SEE PARTS

DO NOT SCALE

3rd Angle

45.0

182

A3-LYN-521

A3-LYN-320

A3-LYN-500

SECTION J-J

NOTE
1. THE PLATES MUST BE FLUSH WITH THE PORTS AND ANY PERTURBATIONS CLEANED OFF

WEIGHT = 211.18 kg

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STAGE 1B ADDING THE INLET PORT PLATES

SEE NOTE 1

SEE PARTS

DO NOT SCALE

3rd Angle

45.0

182

A3-LYN-521

A3-LYN-320

A3-LYN-500

SECTION J-J
ENSURE PORT ALIGNMENT IS AS SHOWN

WEIGHT = 211.18 kg

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STAGE 2 WELDING THE CYLINDER BODY

All dimensions are in mm unless otherwise stated.
No dec pl: ≤ 0.5mm
1 dec pl: ≤ 0.2mm
2 dec pl: ≤ 0.1mm
3 dec pl: ≤ 0.05mm
Angular: ≤ 0.2°
DO NOT SCALE

CHKD BY
The Lynton & Barnstable Railway
The 'Lyn' Project

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STAGE 2 WELDING THE CYLINDER BODY

All dimensions are in mm unless otherwise stated.
No dec pl: ≤ 0.5mm
1 dec pl: ≤ 0.2mm
2 dec pl: ≤ 0.1mm
3 dec pl: ≤ 0.05mm
Angular: ≤ 0.2°
DO NOT SCALE

CHKD BY
NOTE
1. THIS FILLER PIECE MUST BE CENTRAL

WEIGHT = 211.18 kg

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STAGE 3 WELDING ADDING THE CORNER PACKING
WEIGHT = 211.18 kg

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The 'Lyn' Project

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Drawing queries to Mike on 01954 780772 or:
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STAGE 4 WELDING ADDING THE INLET PASSAGES

SEE PARTS

DO NOT SCALE

3rd Angle

CLEAN

A3-LYN-031
PORTS MUST LINE UP AS SHOWN

WEIGHT = 211.18 kg

The Lynton & Barnstable Railway
The 'Lyn' Project

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Drawing queries to Mike on 01954 780772 or: baldwin@machineconcepts.co.uk

STAGE 5 WELDING ADDING THE END FLANGES AND CONNECTING PASSAGE

All dimensions are in mm unless otherwise stated.

No dec pl : ± 0.5mm
3 dec pl : ± 0.2mm
2 dec pl : ± 0.1mm
3 dec pl : ± 0.05mm
angular : ± 0.2°

DO NOT SCALE

Material: SEE PARTS

3rd Angle

Clean

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The Lynton & Barnstable Railway
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WEIGHT = 211.18 kg

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STAGE 8 ADDING THE VALVE PORT FLANGE MFG PLATES

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The 'Lyn' Project

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Drawing queries to Mike on 01954 780772 or: baldwin@machineconcepts.co.uk

WEIGHT = 211.18 kg

All dimensions are in mm unless otherwise stated.

DO NOT SCALE

See parts

The Lynton & Barnstable Railway
The 'Lyn' Project

WEIGHT = 211.18 kg

All dimensions are in mm unless otherwise stated.

DO NOT SCALE

See parts

The Lynton & Barnstable Railway
The 'Lyn' Project

WEIGHT = 211.18 kg

All dimensions are in mm unless otherwise stated.

DO NOT SCALE

See parts

The Lynton & Barnstable Railway
The 'Lyn' Project

WEIGHT = 211.18 kg

All dimensions are in mm unless otherwise stated.

DO NOT SCALE

See parts

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The 'Lyn' Project

WEIGHT = 211.18 kg

All dimensions are in mm unless otherwise stated.

DO NOT SCALE

See parts

The Lynton & Barnstable Railway
The 'Lyn' Project

WEIGHT = 211.18 kg

All dimensions are in mm unless otherwise stated.

DO NOT SCALE

See parts

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WEIGHT = 211.18 kg

All dimensions are in mm unless otherwise stated.

DO NOT SCALE

See parts

The Lynton & Barnstable Railway
The 'Lyn' Project

WEIGHT = 211.18 kg

All dimensions are in mm unless otherwise stated.

DO NOT SCALE

See parts

The Lynton & Barnstable Railway
The 'Lyn' Project

WEIGHT = 211.18 kg

All dimensions are in mm unless otherwise stated.

DO NOT SCALE

See parts
STAGE 9 ADDING THE OUTER STIFFENING GUSSETS

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The 'Lyn' Project

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All dimensions are in mm unless otherwise stated.
No dec pl : ± 0.5mm
1 dec pl : ± 0.1mm
2 dec pl : ± 0.05mm
Angular : ± 0.2°

WEIGHT = 211.18 kg

DO NOT SCALE

Material:
Finish:

CHK'D BY

3rd Angle

The Lynton & Barnstable Railway
The 'Lyn' Project

WEIGHT = 211.18 kg

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No dec pl : ± 0.5mm
1 dec pl : ± 0.1mm
2 dec pl : ± 0.05mm
Angular : ± 0.2°

DO NOT SCALE

Material:
Finish:

CHK'D BY

3rd Angle

The Lynton & Barnstable Railway
The 'Lyn' Project

WEIGHT = 211.18 kg

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All dimensions are in mm unless otherwise stated.
No dec pl : ± 0.5mm
1 dec pl : ± 0.1mm
2 dec pl : ± 0.05mm
Angular : ± 0.2°

DO NOT SCALE

Material:
Finish:

CHK'D BY

3rd Angle

The Lynton & Barnstable Railway
The 'Lyn' Project

WEIGHT = 211.18 kg

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All dimensions are in mm unless otherwise stated.
No dec pl : ± 0.5mm
1 dec pl : ± 0.1mm
2 dec pl : ± 0.05mm
Angular : ± 0.2°

DO NOT SCALE

Material:
Finish:

CHK'D BY

3rd Angle

The Lynton & Barnstable Railway
The 'Lyn' Project

WEIGHT = 211.18 kg

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No dec pl : ± 0.5mm
1 dec pl : ± 0.1mm
2 dec pl : ± 0.05mm
Angular : ± 0.2°

DO NOT SCALE

Material:
Finish:

CHK'D BY

3rd Angle

The Lynton & Barnstable Railway
The 'Lyn' Project

WEIGHT = 211.18 kg

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No dec pl : ± 0.5mm
1 dec pl : ± 0.1mm
2 dec pl : ± 0.05mm
Angular : ± 0.2°

DO NOT SCALE

Material:
Finish:

CHK'D BY

3rd Angle
WEIGHT = 211.18 kg

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The Lynton & Barnstable Railway
The 'Lyn' Project

All dimensions are in mm
unless otherwise stated.

No dec pl : ± 0.5mm
1 dec pl : ± 0.1mm
2 dec pl : ± 0.05mm
3rd Angle : ± 0.2°

DO NOT SCALE

Material.

STAGE 10 ADDING THE INNER STIFFENING GUSSETS

See parts

Clean
NOTE
1. THE CENTRELINE OF THIS PART MUST INTERSECT WITH THE HORIZONTAL CENTRELINE OF THE VALVE.
2. ONCE THIS STAGE IS COMPLETE THE UNIT MUST BE STRESS RELIEVED

WEIGHT = 211.18 kg

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