



FOR OILBATH OVERFLOW  
CONN. SEE FULL SIZE  
SECTION.

3 HOLES CORED 3/4 DIA.  
TAPPED 1/2 DIA. I.T.P.I. &  
PLUGS WELDED IN.  
SEE DETAIL OF PLUG.

NOTE: WHEN ASSEMBLING WEDGE & ADJUSTING BLOCKS IN  
PIVOT BOTTOM CASTING, ADJUST SPRINGS UNTIL CLEARANCE  
BETWEEN SPRING NUT & CASTING IS 1/8" WITH THE TWO  
ADJUSTING BLOCKS IN CONTACT.  
THIS POSITION CORRESPONDS TO A CLEARANCE OF 1/8" BETWEEN  
SPRING NUT & CASTING WHEN THE PIVOT TOP CASTING IS  
LOWERED INTO POSITION & THE GAP BETWEEN ADJUSTING  
BLOCKS OPENS TO 3/4" AS SHOWN ON THIS DRAWING.  
MEASURE DISTANCE THAT BOLT PROTECTS THROUGH NUT &  
MACHINE RECESS IN END PIECE TO SUIT.

NOTE: CASTINGS TO BE TESTED  
FOR POROSITY, BEFORE ASSEMBLY.  
BY FILLING WITH PARAFFIN.

ANALYSIS OF  
PHOSPHOR BRONZE  
COPPER 89.5%  
TIN 10%  
PHOSPHOR 0.5%

DRAWN FOR HIND ENGINE UNIT.

LETTER	NAME OF PIECE	NO PER ENG.	MATERIAL	CLASS OF WORK	REMARKS	WEIGHTS POUNDS/GRAMS
A	PIVOT CENTRE BOTTOM CASTING	2	STEEL CASTING	MACH <sup>2</sup> AS INDICATED	HARD MIXTURE	
B	" " LINER (TOP)	2	PHOSPHOR BRONZE	DC		
C	" " " (BOTTOM)	2	STEEL CLASS D	DC	OIL TREATED	
D	KEY	4	"	D MACH <sup>2</sup> ALL OVER		
E	LOCKING PLATE FOR SET SCREWS	4	"	PLATE WHERE REQ <sup>d</sup>		
F	SEALING RING	2	SYNTHETIC RUBBER MOULDED			
G	PIVOT CENTRE KEEP	2	STEEL CASTING	MACH <sup>2</sup> AS INDICATED	SOFT MIXTURE	
H	OILBATH OVERFLOW CONNECTION	2	"	BAR WHERE REQ <sup>d</sup>		

FOR ENG NO 414-2423 ONLY.

**RHODESIA RAILWAYS**  
ORDER No. 81/T.2926  
10th, 1945  
**1.5<sup>TH</sup> CLASS LOCOMOTIVES**  
SERIAL Nos. 354 TO 423  
TYPE: 4-6-4 4-6-4  
MAKER'S Nos. 7228 to 7237 - 7260 to 7279 - 7326 to 7340  
7351 to 7365 - 7555 to 7564

**Bottom Pivot Centre**  
SCALE: 3" = 1 Foot, Half and Full Size  
BEYER, PEACOCK & CO., LTD., GORTON, MANCHESTER.  
**Dr. No. 81/T.2926/258**