

Unscrew the unit wheel driving cylinder heads (36KB2 and a36KB7) from the displaced cylinders a36KB1 and remove the unit wheel driving cylinder rings 36KB3. The unit wheel driving cylinder ring pipes a36KB4 should now be unscrewed from the rings and the ring pipe unions 36KB5 unscrewed from the ring pipes, and the ring pipe union nuts 36KB6 removed from the pipes also. Assemble the unions 36KB5 and nuts 36KB6 upon the ninety-em ring pipes a36KB12 and screw the latter into the driving cylinder rings 36KB3, noting that when they are tight they occupy positions which will allow them to align with the piston block pipes (a27KC1 and a27KC2). Place the driving cylinder rings 36KB3 into position and secure them by screwing on firmly the unit wheel driving cylinder heads (a36KB7 and 36KB2). See that these heads are fitted to their correct cylinders, the left-hand one being equipped with abutment a36KB8. Note whether the piston block pipes (a27KC1 and a27KC2) require their positions adjusted to suit the ring pipes. To adjust them, unscrew the pipe lock nuts a27KC4 and screw the pipes (a27KC1 and a27KC2) into the piston block e29KC1K, lock the unit wheel driving cylinder heads with the pipes in alignment, then unscrew the piston block pipes until their unions 27KC3 engage the pipe unions 36KB5. Screw on and lock the union nuts 36KB6, and tighten the lock nuts a27KC4. Now test this assembly by revolving the unit wheel by hand and noting that the driving rack d37KB1 travels freely in mesh with the unit wheel pinion over its whole traverse.

Remove the em scale e9KB1 from the sixty-five em slide xb5KB, the em rack stop rack adjusting screw b8KB1, the em rack stop rack b7KB1, the em rack stop rack hook 7KB2 and spring 7KB3. The em rack stops (b6KB1 and a6KB2), and pointer 6KB3K may be removed complete by unscrewing the two em rack slide head screws 5KB3 and detaching the head 5KB2. The pointer should be sprung clear of the slot in the slide in which the guide pin 6KB4 runs and held in a vertical position. The whole stop assembly may then be slid out of its slot in the slide.

Place the em rack stop assembly into the ninety-em slide a5KB7K, having first removed its two head screws 5KB3, and head 5KB2; replace the latter and locate the pointer 6KB3K with its guide pin 6KB4 in the slot provided in the slide. Fit