

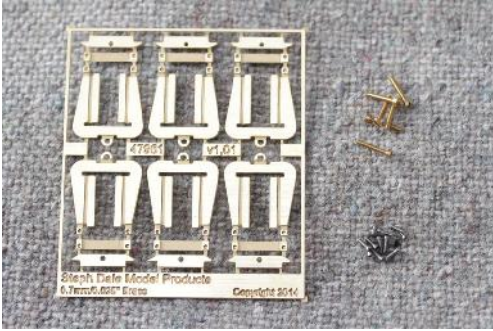
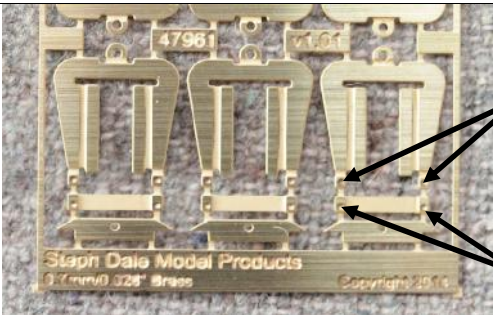
Instructions for 47961 hornguides

Introduction









1. These hornguides are much more closely toleranced than typical 'fold-up' types and care is required in their assembly.
2. Failure to follow this procedure is likely to result in a set of hornguides that will not work well – this is not a warranty issue although I will happily provide replacement frets (at cost) should you run into difficulties.
3. These gearboxes use the cusps on the fret as a means to control tolerances – DO NOT REMOVE CUSPS FROM ANY OF THE COMPONENTS UNLESS DIRECTED.
4. The 14BA and 12BA taps mentioned in the instructions can be obtained inexpensively from discount tool sellers and even from well-known on-line auction 'sites. Usually only a taper (1st) tap will be necessary. A full set of taps may be useful, especially if you find the screws to be tight.
5. All half-etched fold lines are on the inside of the fold.



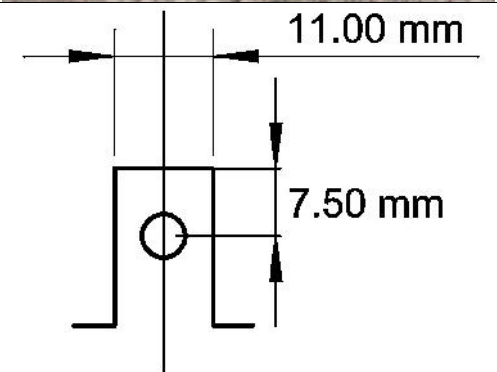
Additional items (not supplied)

1. Slater's 7961 'Insulated Square Bearings', 1pack
2. Springs. E.g. Slater's 7164, which contains 12 springs, enough for two sets of hornguides.

No.	Illustration	Symbols	Text
1			<p>First job is to check you have everything:</p> <p>Fret x1 12BA screws (brass) x6 14BA screws (steel) x12</p> <p>Plus (not shown, not supplied) Slater's 7961 'Insulated Square Bearings' x1pack Springs, e.g. Slater's 7164</p>
2		<p>0.8 mm Dia.</p> <p>1mm Dia.</p>	<p>Drill the holes to the sizes shown:</p> <ol style="list-style-type: none"> 1. 14BA tapping, 0.8mm diameter. 2. 14BA clearance, 1mm diameter.

3		<p>1.4 mm Dia. 1mm Dia.</p>	<p>Drill the holes to the sizes shown:</p> <ol style="list-style-type: none"> 12BA clearance, 1.4mm diameter. 12BA tapping, 1mm diameter.
4			<p>After drilling all the holes, cut the components from the fret.</p>
5			<p>Bend the two flanges to 90 degrees.</p> <p>Note: The frame and flanges must be well supported to avoid distortion of the components.</p>
6			<p>Check that the Slater's 7961 bearing slides easily and with minimal slop.</p>
7			<p>Bend down the top ring to 90 degrees.</p> <p>Bend up the bottom tabs to 90 degrees.</p>

8			<p>Insert the top tab and solder all the joint and fold lines.</p> <p>I use 244 degree solder to make fitting to the chassis easier.</p>
9		 <p>12BA</p>	<p>Tap the top hole 12BA</p>
10		 <p>14BA</p>	<p>Tap the bottom holes 14BA</p>
11			<p>Check fit the screws and bearing retaining strap</p>
12			<p>The spring fits on the screw as shown</p>

13		<p>The top 'shelf' is used to ensure the horn guides are in line in the chassis so any excess solder should be removed from the adjacent seam.</p> <p>At this stage you can remove the etching cusps from any visible edges, if you wish to do so.</p>
14		<p>The complete horn guide is now ready for installation in the chassis.</p> <p>Repeat steps 4 to 13 for the remaining horn guides.</p>
15		<p>Your chassis will require a slot 11mm wide, extending 7.5mm above the axle centre line for each horn guide.</p>