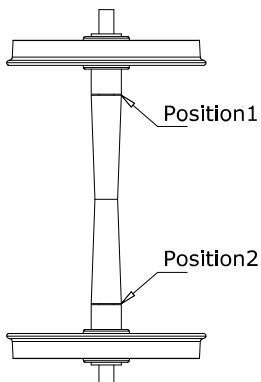


Do not scale print
If in doubt ask!

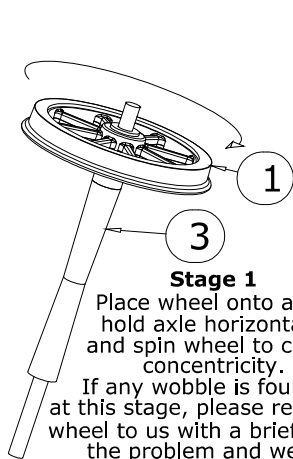
See INS 550 for information on the use of LOCTITE (601) 603



Notes

View above shows complete assembly. Note the gaps at positions 1 and 2 which are typically about 0.1mm, (for a P4 back to back of 17.67mm).

Please see Stage 6

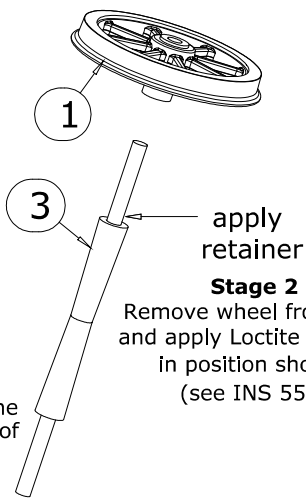


Stage 1

Place wheel onto axle, hold axle horizontally and spin wheel to check concentricity.

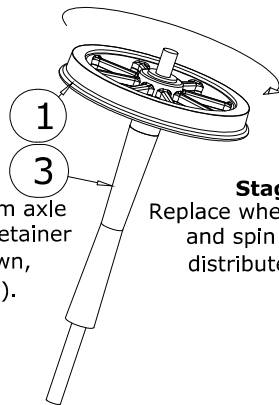
If any wobble is found at this stage, please return the wheel to us with a brief note of the problem and we will replace the wheel.

This guarantee will not apply if we find any retainer or evidence of force applied to the moulded part of the wheel.



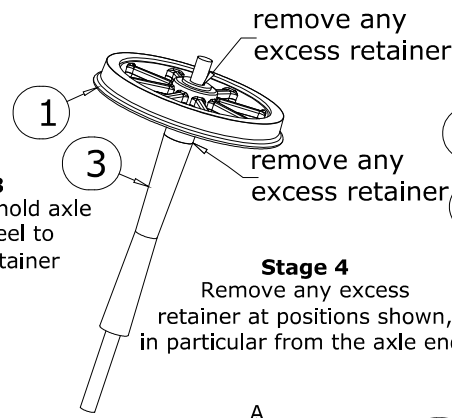
Stage 2

Remove wheel from axle and apply Loctite retainer in position shown, (see INS 550).



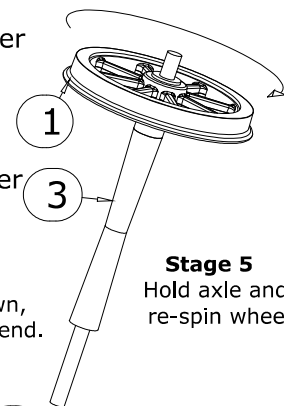
Stage 3

Replace wheel, hold axle and spin wheel to distribute retainer



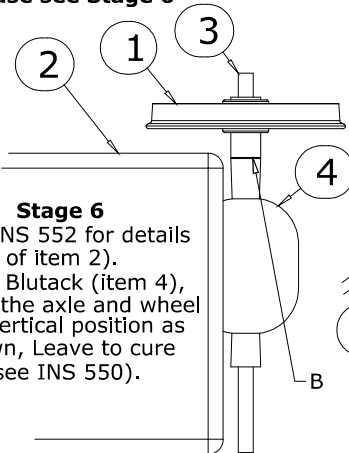
Stage 4

Remove any excess retainer at positions shown, in particular from the axle end.



Stage 5

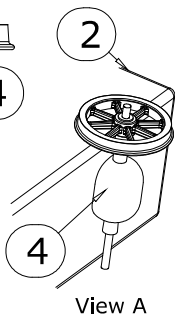
Hold axle and re-spin wheel



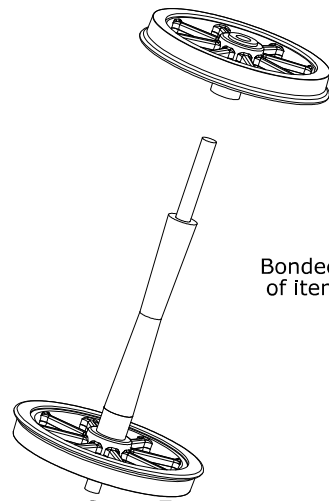
Stage 6

(See INS 552 for details of item 2).

Using Bluetack (item 4), secure the axle and wheel in a vertical position as shown, Leave to cure (see INS 550).

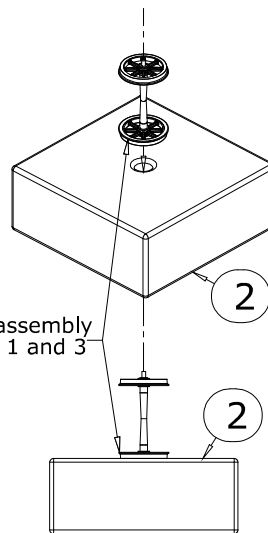


View A

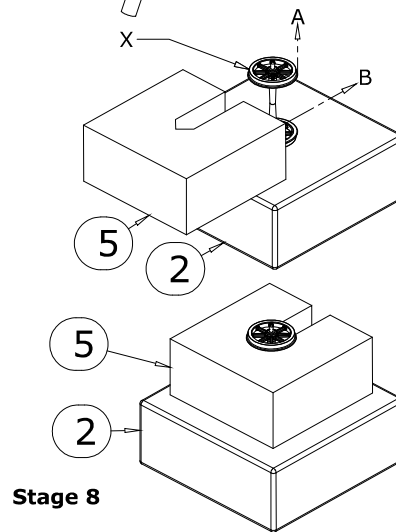


Stage 7

Take cured assembly from stage 6 and repeat stages 1 - 4 for the wheel. On other end of axle

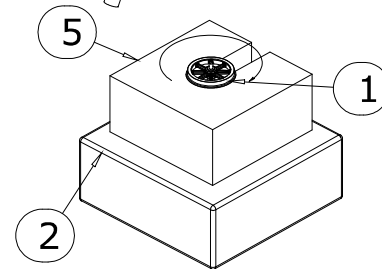


Bonded assembly of items 1 and 3



Stage 8

Place the wheels and axle on the assembly fixture (which must be on a horizontal surface) with the 'cured' wheel at the bottom resting on the surface of the fixture with its axle end in the recess in the fixture. Slide the back to back gauge (item 5) into position (you will need to lift wheel X a little), making sure the gauge is not pressed against the axle anywhere.



Stage 9

Finally, rotate wheel X making sure comes into even contact with the face of the gauge. Leave to cure (see INS 550).

If you are using a slightly wider back to back dimension and wish to equalise the gaps, you may want to use spacers to partly fill the gaps. Washers from 4CW 701A may be suitable, but make sure they are completely flat.

Item	Name	Qty
5	4CW 801 Back to Back gauge	1
4	Bluetack	1
3	4CW 501A Axle	1
2	INS 552 Assembly fixture	1
1	4CW 101A Wheel	2

Parts List

Exactoscale Limited

20 Waterson Vale, Moulsham Lodge,
Chelmsford, Essex CM2 9PB
01245 263779

Including **The P4Track Company**

Part No	INS 551
Part Name	C&W Wheel Assembly information
Material	
Date Drawn	
Scale	

Remove all sharp edges
All dimensions in MM unless otherwise stated

www.exactoscale.co.uk

Company Reg. No. 05275090 Directors: L.C.Newman & A.J.Jukes VAT Reg. No. GB 848 6751 76
Registered in England and Wales. Registered Office: Suffolk House, George Street, Croydon CR0 0NY

Instruction number
INS 551

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