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OPERATING INSTRUCTIONS

“PENRHYN LARGE QUARRY HUNSLET”

SAFETY FIRST

All our locomotives are safe to run, and will give many hours of pleasure, providing the following safety procedures are followed: -

- 1. Please read the instructions thoroughly before running for the first time.**
- 2. Always do a complete refill of gas, oil and water. Never refill just the gas to prolong the run.**
- 3. Never let the engine run out of water.**
- 4. When refilling the gas, do not have any naked flame present, and NO SMOKING!**
- 5. Do not pick up the engine by the bodywork, chimney or boiler, especially when hot.**
- 6. Only pick up the engine by the buffer beams and, when hot, use old gloves or a cloth.**
- 7. Do not stand over the chimney. Ejected boiling water or steam may cause serious injury.**
- 8. Do not open the smoke box door while the engine is alight.**

General Hints

As with all operating machinery, whether model or full size, wear will occur. In the model steam locomotive much can be done to help prolong its life and decrease the amount of time required in the workshop for servicing.

Keep the engine as clean as possible, and the motion free from dirt and garden debris. The valve gear, axles and crank pins should be oiled sparingly with light oil, e.g. "3-in -1 Oil". Over-oiling attracts dirt and grit, which will increase wear.

Regularly check that all screws and motion bolts are firm. Do not over-tighten, as this strips threads and shears bolts. **When filling the lubricator, always use a high temperature steam oil; this is available from other retailers. FAILURE TO USE THE CORRECT GRADE OF OIL CAN LEAD TO BLOCKED STEAM PIPES, AND WILL INVALIDATE THE GUARANTEE.**

When running your engine avoid excessive speed and acceleration, both will cause premature wear in the valve gear. Prototypically, narrow gauge locomotives ran at a speed of between 10 and 20 M.P.H., and rarely exceeded 25 M.P.H.

Positions of Fillers and Drains etc.

The gas inlet valve is in the small turret situated in the cab floor to the left rear of the firebox. The gas control valve is in the front offside of the cab and is shaped like the hand brake.

The lubricator is in the front footplate just in front of the smoke box. To drain out the condensed water from the previous run use the small syringe provided with the short length of tube supplied, attached.

The boiler water filler is under the saddle tank water filler lid. To access the boiler filler plug unscrew the tank water filler lid. The main steam regulator valve is the red painted regulator lever on the back of the fire box. ***NOTE – IT GETS HOT!***

The boiler blow down/water level check valve is under the footplate, just in front of the nearside cab step. To open the valve, turn the lever through about one turn.

The direction control is the lever in the offside of the cab. To operate pull gently outwards and move to the desired direction. The control is “gated”, and will therefore hold itself in the full forward or reverse position.

Preparation for Running

Always service the engine in the following order; first gas, oil then water.

To fill the gas tank: invert the gas can and apply the nipple to the gas inlet valve on the top of the tank turret. A screw on extended gas can adaptor is supplied with your loco. It is advisable to support the loco under the gas tank whilst filling, to prevent the engine tipping backwards. You will know when the tank is full; gas will blow back from the inlet valve in a strong jet. A small amount of gas and air will escape during filling, but the difference between this and when the tank is full is always clear. Always keep the gas can vertical when filling the gas tank. We recommend that Butane gas is used whenever possible, but the gas tank is manufactured to accept the extra pressures generated by Butane/Propane mix gases, and the burner system will also perform using this gas.

Filling the lubricator: as you will read in the instructions for the end of the run, the lubricator should be empty of oil and water. Fill up the lubricator with steam oil to about $\frac{1}{4}$ of an inch below the top. Leave the filler cap off for the present, so that any trapped air can escape. It can be refitted after you have filled up the boiler.

To fill the boiler: remove the filler cap which is under the saddle tank water filler lid and also open the water level check valve. Leave the boiler blow down valve open whilst raising steam. Fill up the boiler completely – ideally use filtered rainwater or distilled water using the large syringe provided. Replace the boiler filler cap, check that the lubricator does not need topping up, and then replace its filler cap also. Filler caps should be firm finger tight. They are sealed with a trapped ‘O’ ring and, therefore should not be over-tightened.

Lighting Up

Open the smoke box door; just pull it open by the door handle. Light your lighter/match etc. and gently open the gas control valve until a gentle hiss is heard in the burner. Apply your light into the smoke box and the flame should ‘pop’ down the fire tube and ignite the burner inside the fire tube.

If the gas valve is opened too much the flame will not pop back; it will either fail to ignite, will roar in flame out of the smoke box, or there will be a ball of flame around the front of the engine, which will then blow the whole fire out (after giving the driver a fright)!

When the fire sound has stabilised, after about 30 seconds the gas can be turned up gently. Do not turn the gas up high as the flame could damage the paint on the smoke box door. The smoke box door may be shut after about two minutes. Now leave the locomotive to raise steam.

When pressure starts to rise, water will be seen running out of the boiler blow down valve. When the water reaches its correct level steam will be seen. Now screw shut the check valve and let the locomotive raise at least 50 p.s.i.

Running

When the engine has raised about 50 psi, you are ready to start running. It is advisable to run the engine in reverse first; it clears the condensed water from the cylinders best this way. Before commencing your first run of the day, it is advisable to put a cloth loosely over the chimney for a few minutes, as condensed water will be ejected from the chimney. This is quite normal; the motion of the engine will be jerky until all condensate has been ejected.

DO NOT stand over the chimney as ejected boiling water/steam could cause serious scalding.

Place the direction lever into the reverse position, and then open the main steam valve. The engine should start to move off in the reverse direction. When starting from cold it will be jerky, this is normal, as it has to clear the condensate from the system. The more the main steam valve is opened, the faster the engine will go; our advice is to start slowly and learn the road with your engine

After a minute or so, remove the cloth and continue running. In running it is correct practice to balance the boiler pressure against the load being pulled and the track conditions. With a light load and level track the pressure may need to be only 25-30 p.s.i. therefore, turn the gas control down to keep this pressure. When running a heavy train with steep gradients, increase the pressure by turning up the gas.

The ideal running pressure can be learnt by experience and is one of the pleasures of running a live steam engine. There is no need to have the safety valve constantly blowing off (it is what its name implies – a safety vent for excess steam pressure). In all our designs, the gas has been programmed to run out just before the water, thus it is important not to refill with gas alone in order to lengthen the run by a few minutes.

When the gas runs out a complete gas, oil and water service must be done (remember GOW, also remember to shut the gas regulator before refilling, and **DO NOT** refill with gas near any other live steam loco). When the locomotive slows as the pressure falls at the end of a run, stop the engine. Gently open the water level check valve and allow the steam pressure to drain away.

End of Run

As previously mentioned, the locomotive will slow (due to pressure dropping). The locomotive should be allowed to cool. When cool, clean the engine, check the motion and oil if necessary. The locomotive should always be put away in a clean condition as it attracts less dust and is always ready for the next run (or to be shown to an admiring friend). Always leave the boiler blow down valve open so that the boiler will not be strained if subject to any temperature change. It is advisable to store the locomotive where any residual drips of oil or water do not matter.

Blocked Gas Jets

If the gas jet becomes blocked with particles of dirt within the gas, the jet will have to be removed and cleaned. With a spanner or pliers carefully undo the pipe union on the gas control valve. Remove the pipe and jet holder assembly from the burner.

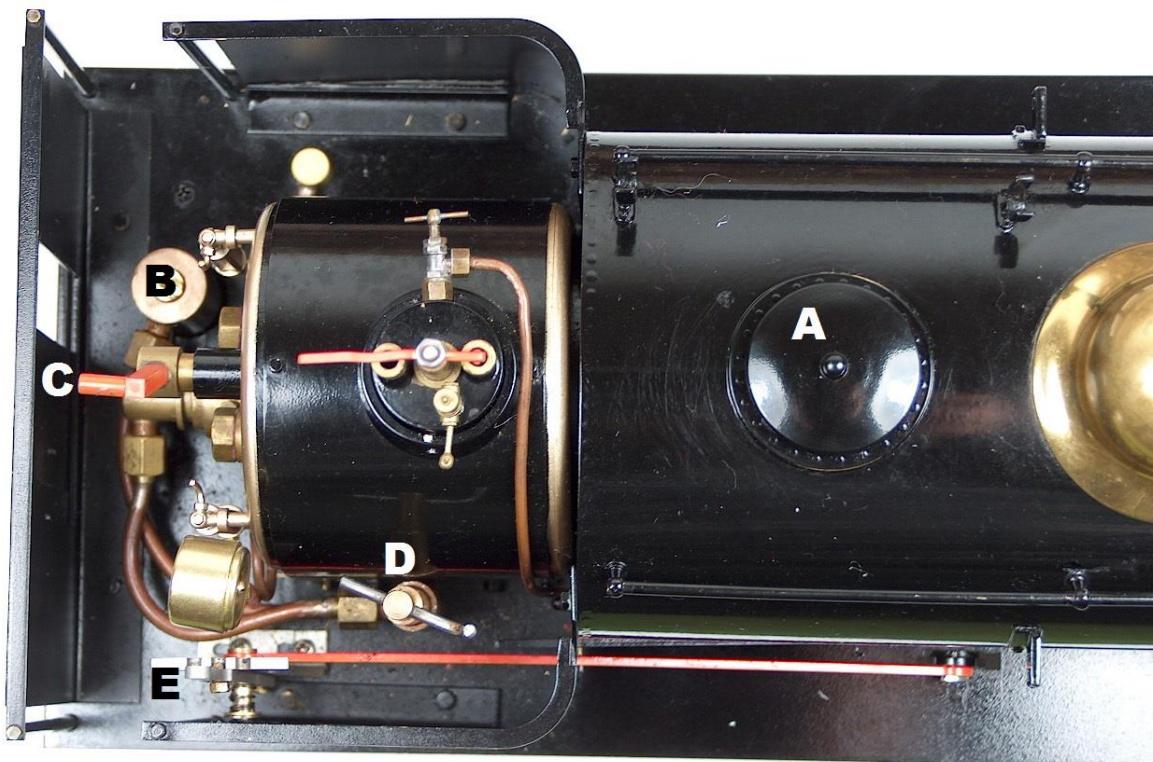
Holding the jet holder gently in a vice, unscrew the jet. To clear, place the jet nozzle against the inverted gas can nozzle and clear the jet with a blast of gas. Under no circumstances use a pricker wire, this will damage the jet hole. Replace the jet in the holder, ideally using a thread sealant sparingly on the threads. Ensure it is tightened up firmly. Replace the assembly into the burner and re-connect the pipe to the control valve. Ensure this is done up tightly, test **CAREFULLY** for gas leaks, first with a 50/50 mixture of washing up liquid and water, and then if no bubbles are showing, with a flame and the gas “just on”. Tighten if required.

Gauge Changing

All “Large Quarry Hunslet” locomotives are supplied set to 45mm gauge, but a “gauge change” kit is supplied with each engine. This will allow you to run on either 32mm or 45mm gauge track. When running on 45mm gauge track this represents a prototypical gauge of two feet, when set to 32mm gauge this represent a gauge of about 18 inches. To change the gauge, lay the engine gently on its side, on a thick cloth, loosen all the grub screws in the boss on the back of the wheels using the Allen key provided. The axles are dimpled for each gauge, so you do not have to measure for the right gauge. Slide the wheels to the gauge required and tighten up the grub screws. **These should be checked as a routine at the start of each running session.**

As with all our models, we strongly recommend a full demonstration (by our agents) before purchase, enabling you to get the best out of your model right from the start.

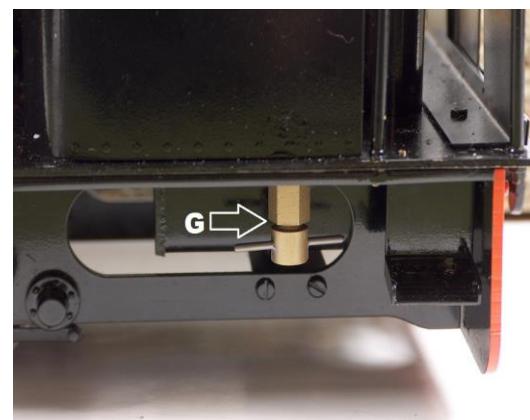
HAPPY STEAMING



- A. Boiler water filler
- B. Gas tank filler
- C. Steam regulator
- D. Gas control valve
- E. Reverse lever



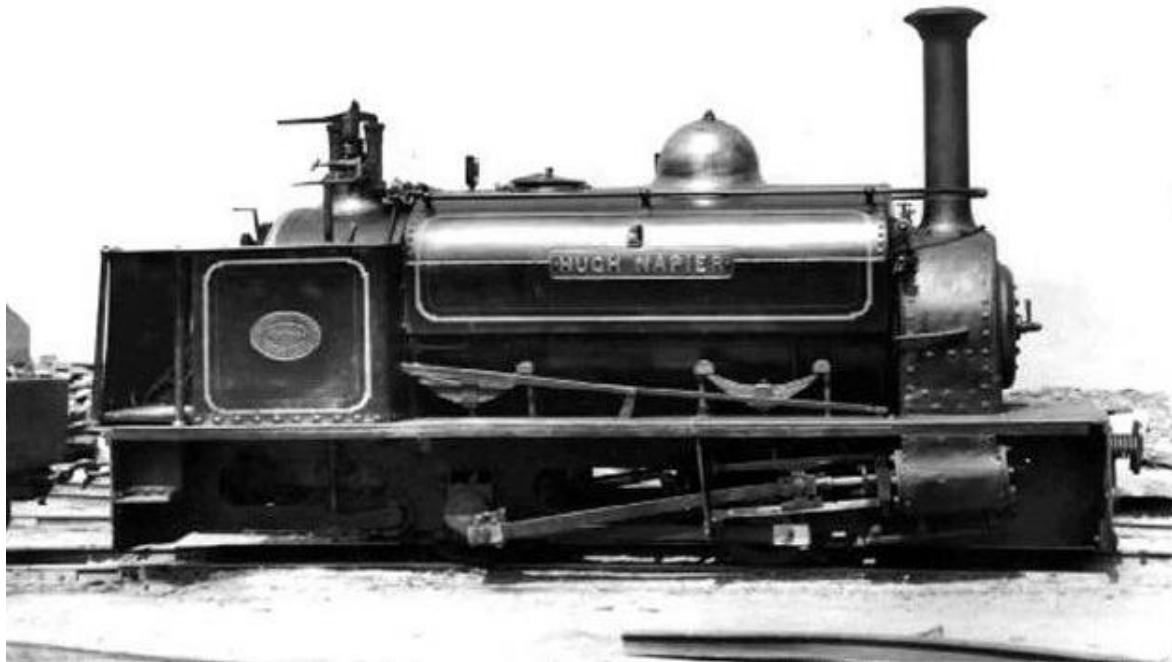
F. Lubricator filler plug.



G. Water level check valve.

By the mid 19th century, the North Wales' slate mines and quarries had a requirement for small, powerful and rugged locos to work the galleries and tramways in what was by then a rapidly expanding industry. Various manufacturers supplied narrow gauge motive power to these businesses but none became more synonymous with the area than the saddle tanks supplied by the Hunslet Engine Co. of Leeds.

These sturdy little locos were ideal for the roughly laid, temporary lines in the quarries and the class evolved from the first design, produced in 1870, to encompass a variety of sizes and types which found work at Penrhyn, Dinorwic (where many acquired the names of racehorses!) and the Nantlle valley. Remarkably the majority of those locos still in service in the 1960's survived to be preserved, some of them in America and Canada. Today Quarry Hunslets are still being produced in limited numbers by the new Hunslet Engine Co. based at the Statfold Barn Railway.



Numerous detail differences were acquired by the various members of this class during their long working lives and our locomotive most closely resembles 'Hugh Napier' which is now owned by the National Trust. Recently restored at Penrhyn Castle and Boston Lodge Works, the little loco will be used as a roving ambassador for the Trust.