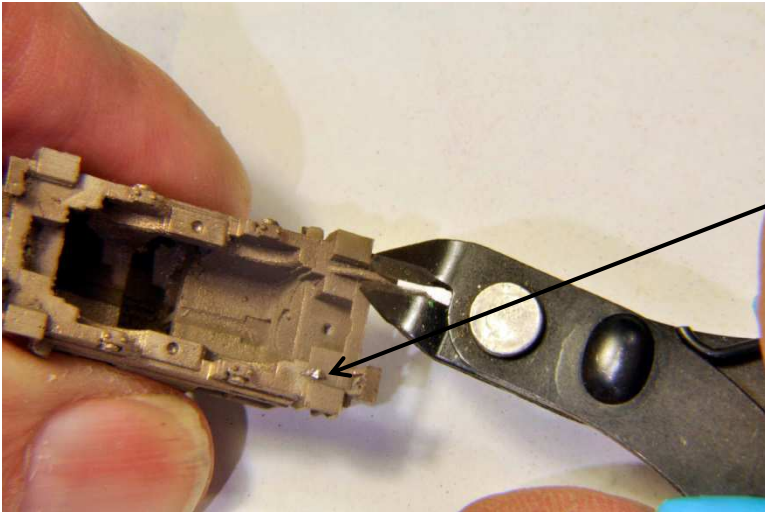
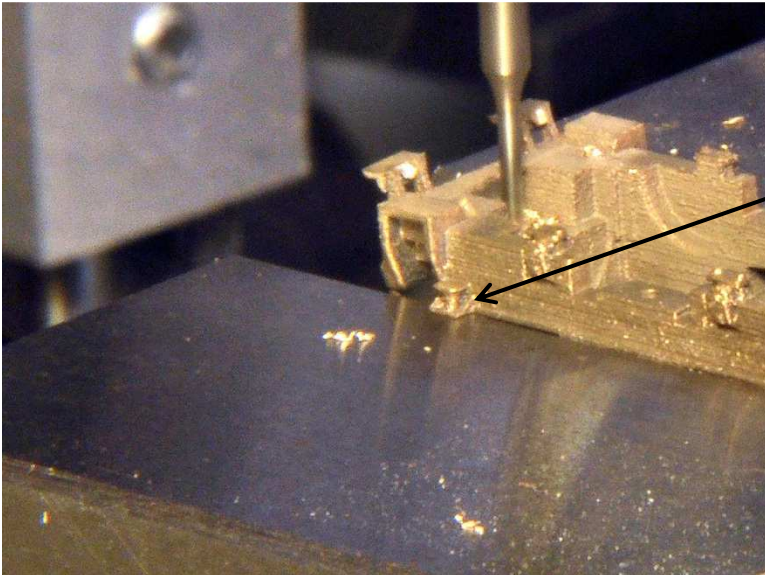


EMD40 BODY CASTING PRE-PAINTING DRILL & TAP TUTORIAL



1. Using flush cutters, remove sprue to back of steps. No need to file or grind flush as the leftover nubs will not be visible.

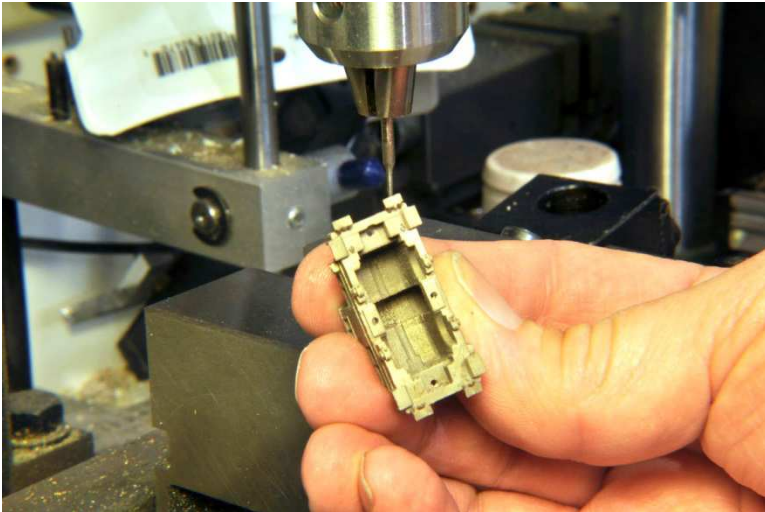


2. Clamp body casting in milling vise with bell brackets on both sides resting on top of vise.

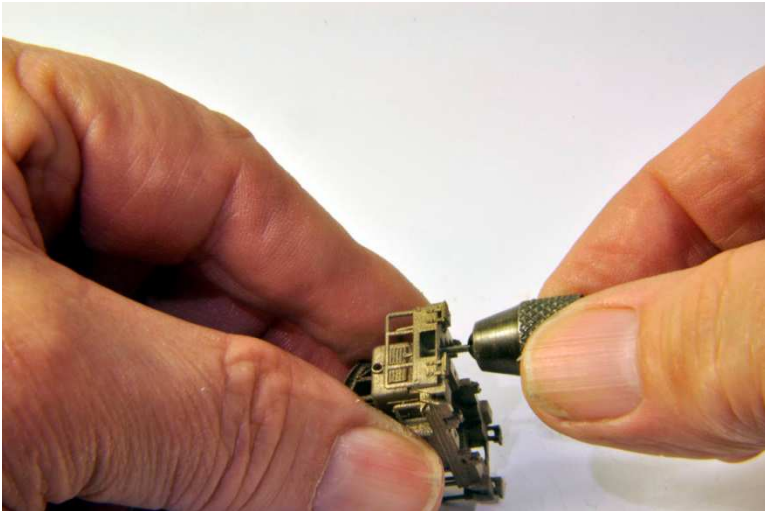


3. Drill holes at dimple locations (4) with #65 or 1mm drill. Hole should be all the way through at each location.

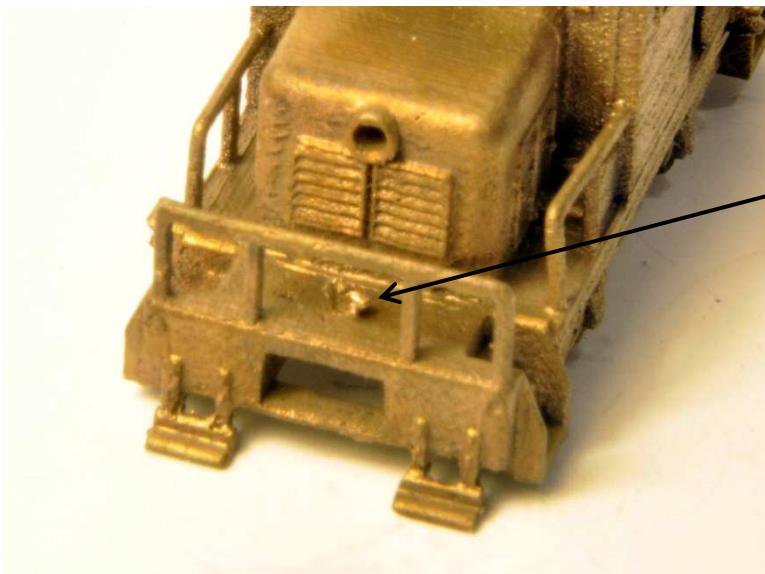
EMD40 BODY CASTING PRE-PAINTING DRILL & TAP TUTORIAL



4. Chassis with all four holes drilled through.

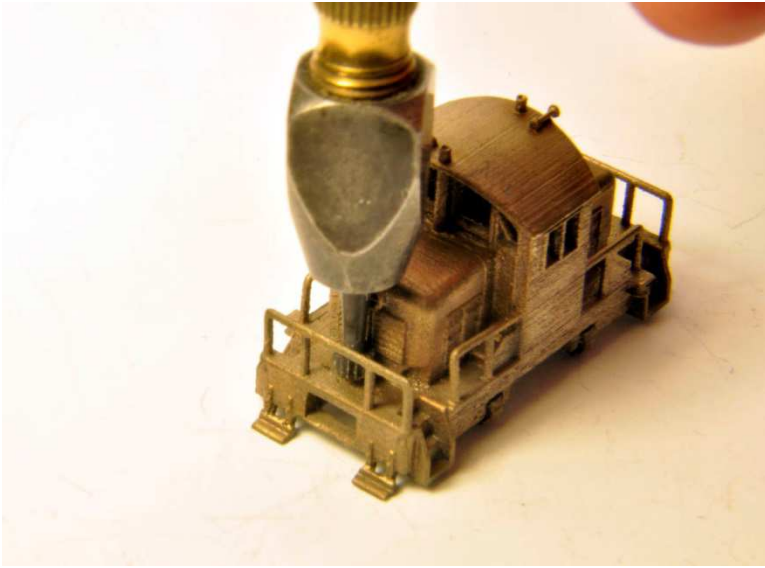


5. Tap holes with 00-90 tap. You can use one of the fancy tapping fixtures from Micro Mark, but I have not found it necessary, and just hand-tap as shown.

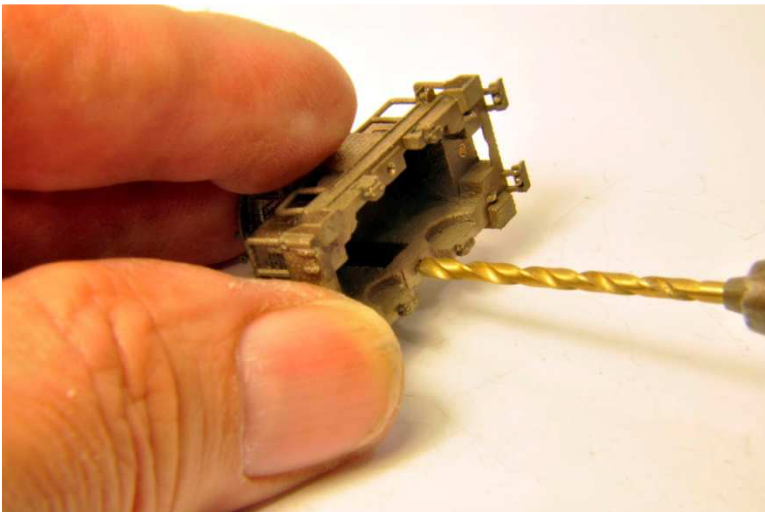


6. Drilling and tapping leaves burrs on the edges of the holes as shown here which must be removed.

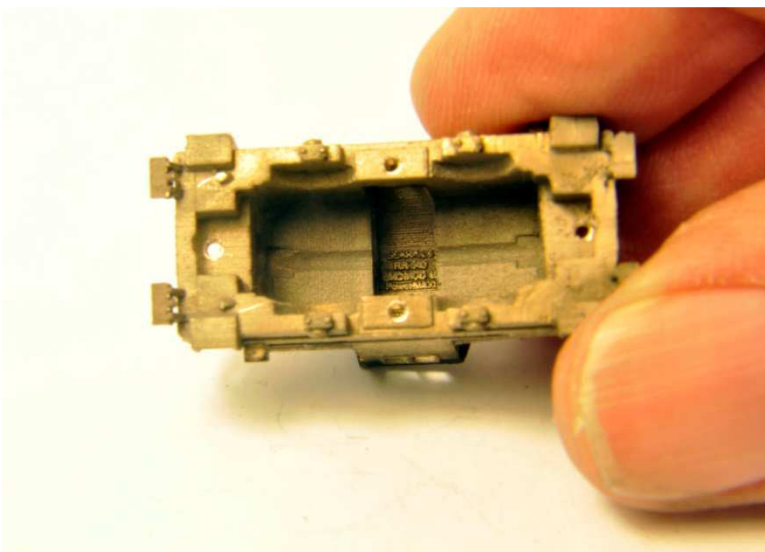
EMD40 BODY CASTING PRE-PAINTING DRILL & TAP TUTORIAL



7. I remove the burr with a small metal countersinking tool.



8. Alternatively, the burrs can be removed with a #40 drill bit, or with a file (taking care not to file off any of the detail on the top of the end platforms).



9. Completed chassis prep with all holes drilled, tapped, and cleaned up; wash chassis afterwards inside and out to remove any metal shavings which might later cause electrical shorts.