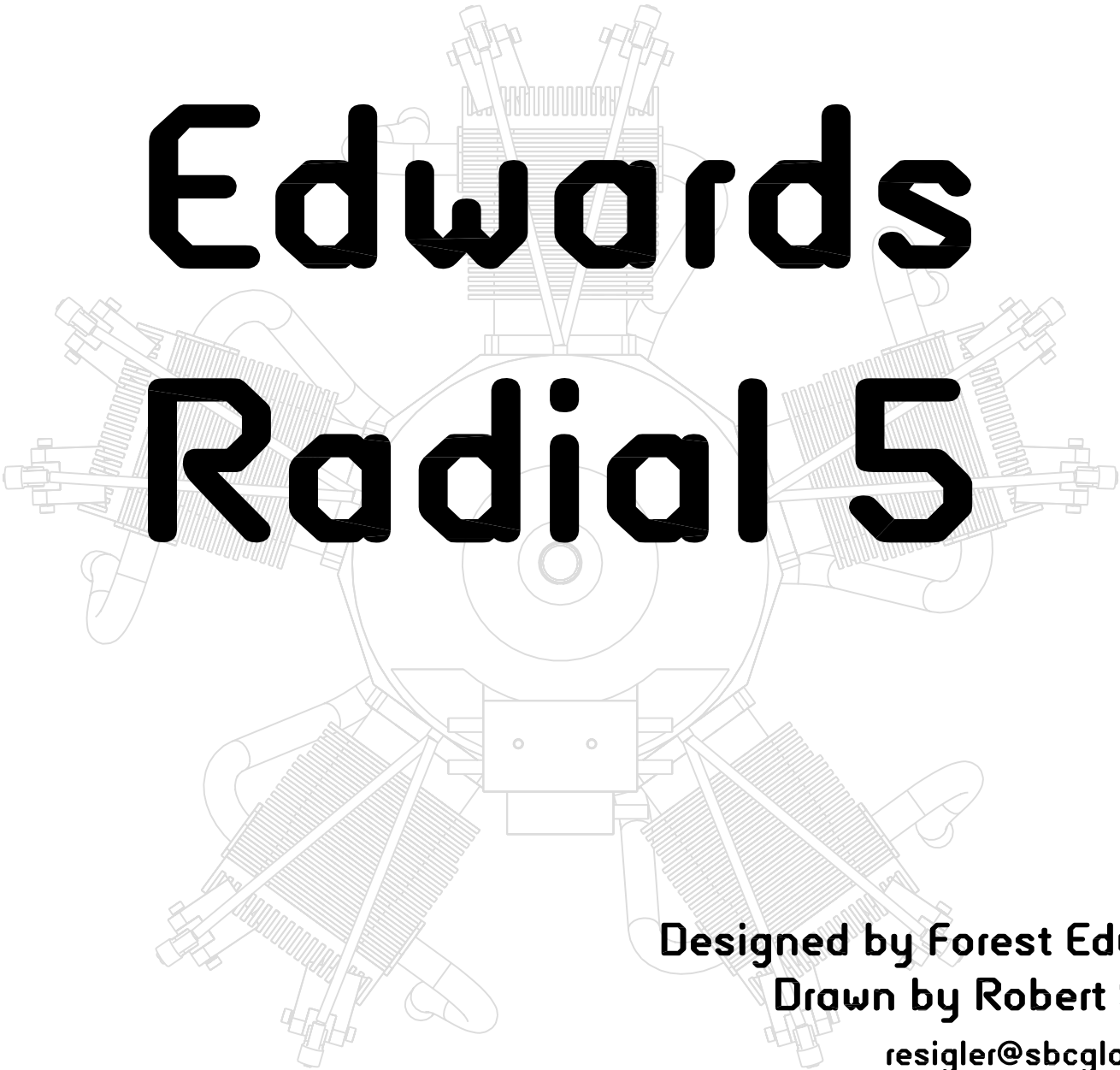




Edwards Radial 5

Designed by Forest Edwards

Drawn by Robert Sigler

resigler@sbcglobal.net

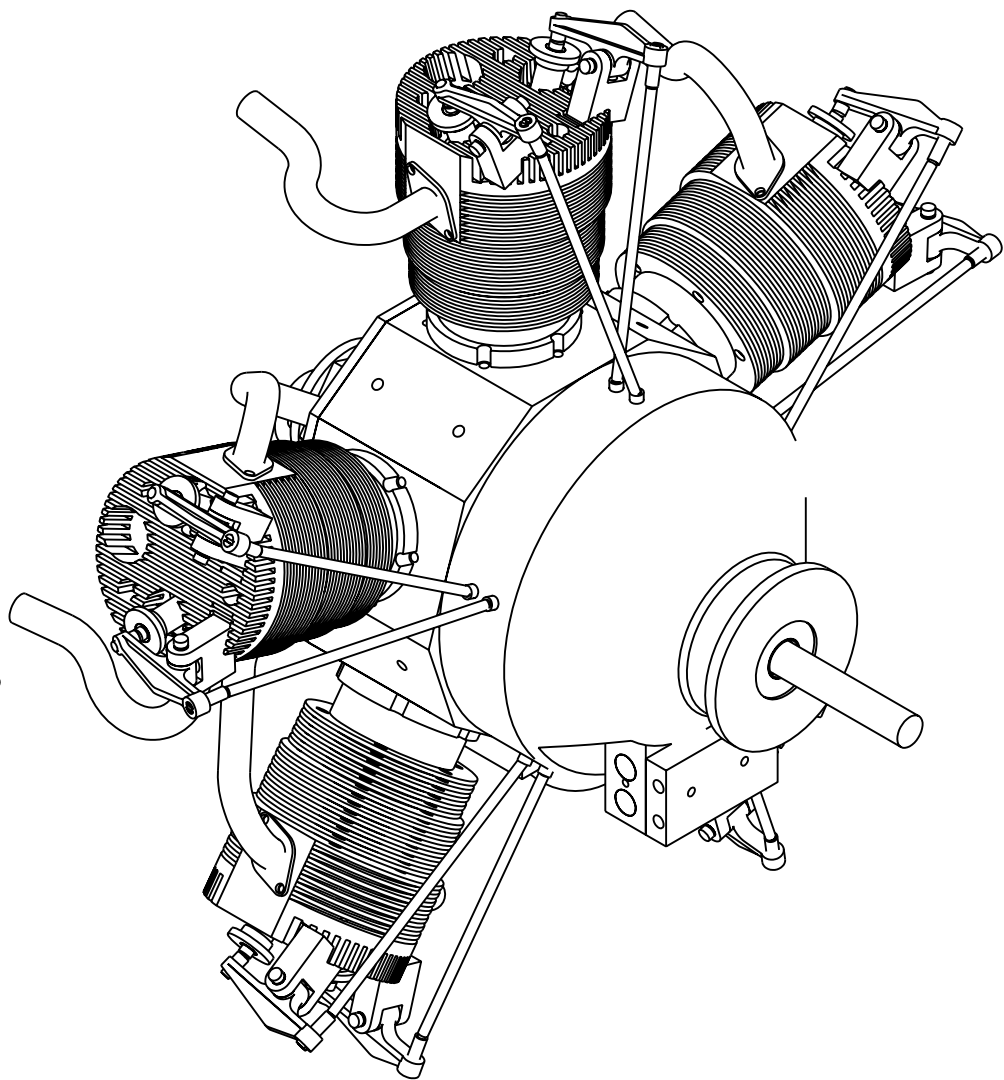
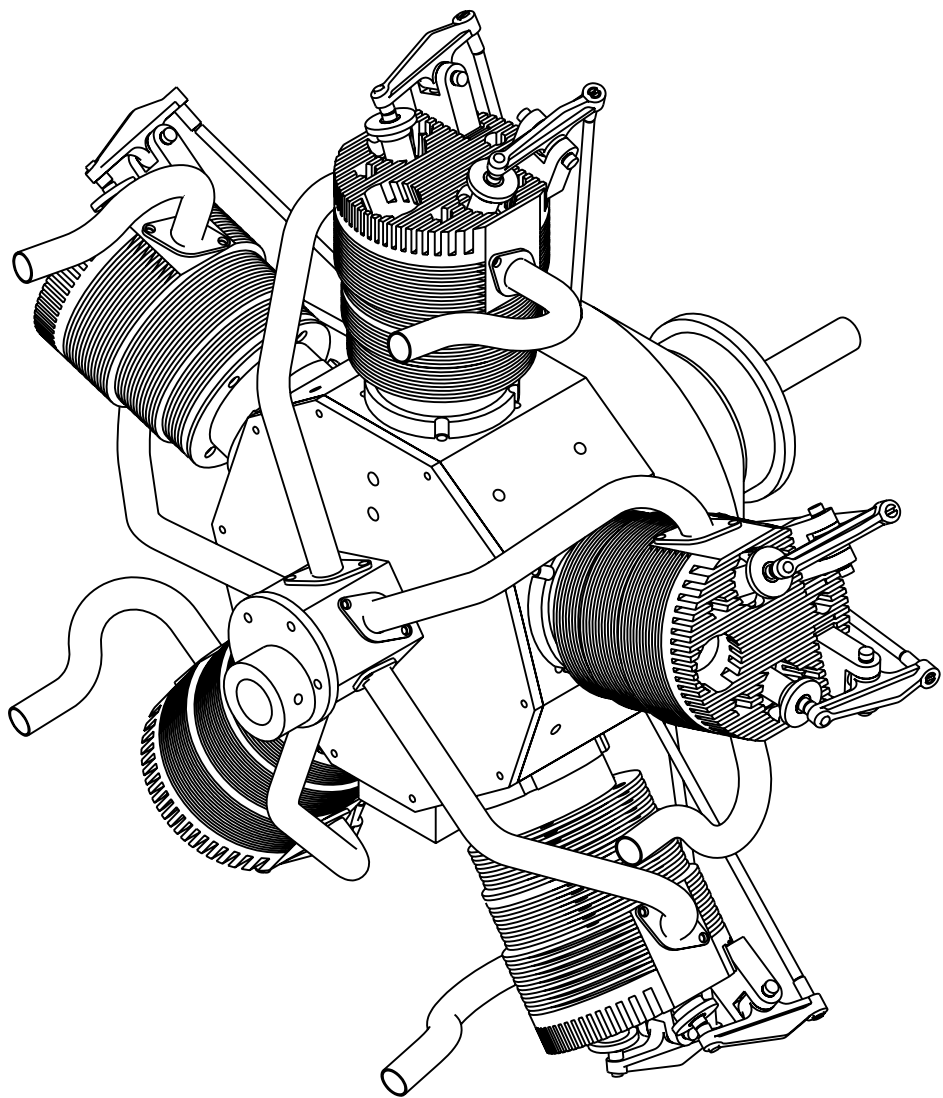


Table Of Contents

Description

Part
No.

Sheet
No.

Parts List		1
Assembly View - Side		2
Assembly View - Front		3
Assembly View - Back		4
Crankcase Orthographic View	001	5
Crankcase Auxilliary View	001	6
Crankcase Isometric View	001	7
Cam Housing Orthographic View	002	8
Cam Housing Isometric View	002	9
Cylinder Head Orthographic View	003	10
Cylinder Head Isometric View	003	11
Rocker Bracket	003-1	12
Cam Ring	004	13
Cam Profile Chart		14
Oil Pump Cam / Cam Ring Assembly	004-1	15
Master Rod	005	16
Link Rod	006	17
Cylinder Barrel	007	18
Cylinder Liner	007-1	19
Cam Follower	008-1	20
Valve	008-2	20
Valve Spring Retainer	008-3	20
Valve Retainer Lock	008-4	20
Rocker Arm	008-5	21
Rocker Button	008-6	21
Valve Adjust Screw	008-7	21
Push Rod	019-1	22
Valve Spring	019-2	22
Rocker Shaft	019-3	22
Crankshaft	009	26
Locating Pin	009-5	26
Crankpin	009-1	24

Description

Part
No.

Sheet
No.

Counterweight	009-2	24
Link Pin	009-3	24
Link Pin Retainer	009-4	24
Cone	010-1	25
Prop Hub	010-2	25
Oil Pump Body	011-1	26
Plunger	011-2	26
Plunger Spring	011-3	26
Plug	011-4	26
Oil Pump Cover	018-1	27
Oil Pump Assembly		28
Pinion Gear	012-1	29
Idler Gear	012-2	29
Cam Gear	012-3	29
Idler Bushing	012-4	29
Idler Assembly	012-5	29
Gear Spacer	013-1	30
Cam Spacer	013-2	30
Cam Bearing Spacer	013-3	30
Bearing Spacer	013-4	30
Oil Sump Body	014-1	31
Oil Screen	014-2	31
Compression Ring	015-1	32
Oil Ring	015-2	32
Parting Cap		32
Rear Cover	016	33
Manifold	017-1	34
Manifold Cover	017-2	34
Intake Tube	020	35
Flange	020-1	35
Piston	021	36

Part No.	Description	Material
001	Crankcase	7075-T6 AL
002	Cam Housing	7075-T6 AL
003	Cylinder Head	7075-T6 AL
003-1	Rocker Bracket	7075-T6 AL
004	Cam Ring	4340 Steel
004-1	Oil Pump Cam	4340 Steel
005	Master Rod	2024-T351 AL
006	Link Rod	2024-T351 AL
007	Cylinder Barrel	7075-T6 AL
007-1	Cylinder Liner	Cast Iron
008-1	Cam Follower	Drill Rod
008-2	Valve	416 SS
008-3	Valve Spring Retainer	7075-T6 AL
008-4	Valve Retainer Lock	Steel
008-5	Rocker Arm	7075-T6 AL
008-6	Rocker Button	Drill Rod
008-7	Valve Adjust Screw	4-40 Screw Stock
009	Crankshaft	4340 Steel
009-1	Crankpin	Dowel Pin
009-2	Counterweight	Steel
009-3	Link Pin	Dowel Pin
009-4	Link Pin Retainer	Steel
009-5	Locating Pin	Drill Rod
010-1	Cone	Steel
010-2	Prop Hub	7075-T6 AL
011-1	Oil Pump Body	7075-T6 AL
011-2	Plunger	416 SS
011-3	Plunger Spring	.026 Piano Wire
011-4	Plug	7075-T6 AL
012-1	Pinion Gear	Boston Gear # S2418
012-2	Idler Gear	Boston Gear # S2412
012-3	Cam Gear	Boston Gear # G677
012-4	Idler Bushing	Phosphor Bronze
012-6	Idler Shaft	416 SS
013-1	Gear Spacer	Steel
013-2	Cam Spacer	Steel
013-3	Cam Bearing Spacer	Steel
013-4	Bearing Spacer	Steel
014-1	Oil Sump Body	7075-T6 AL
014-2	Oil Screen	#100 Mesh Brass Screen
015-1	Compression Ring	Cast Iron
015-2	Oil Ring	Cast Iron

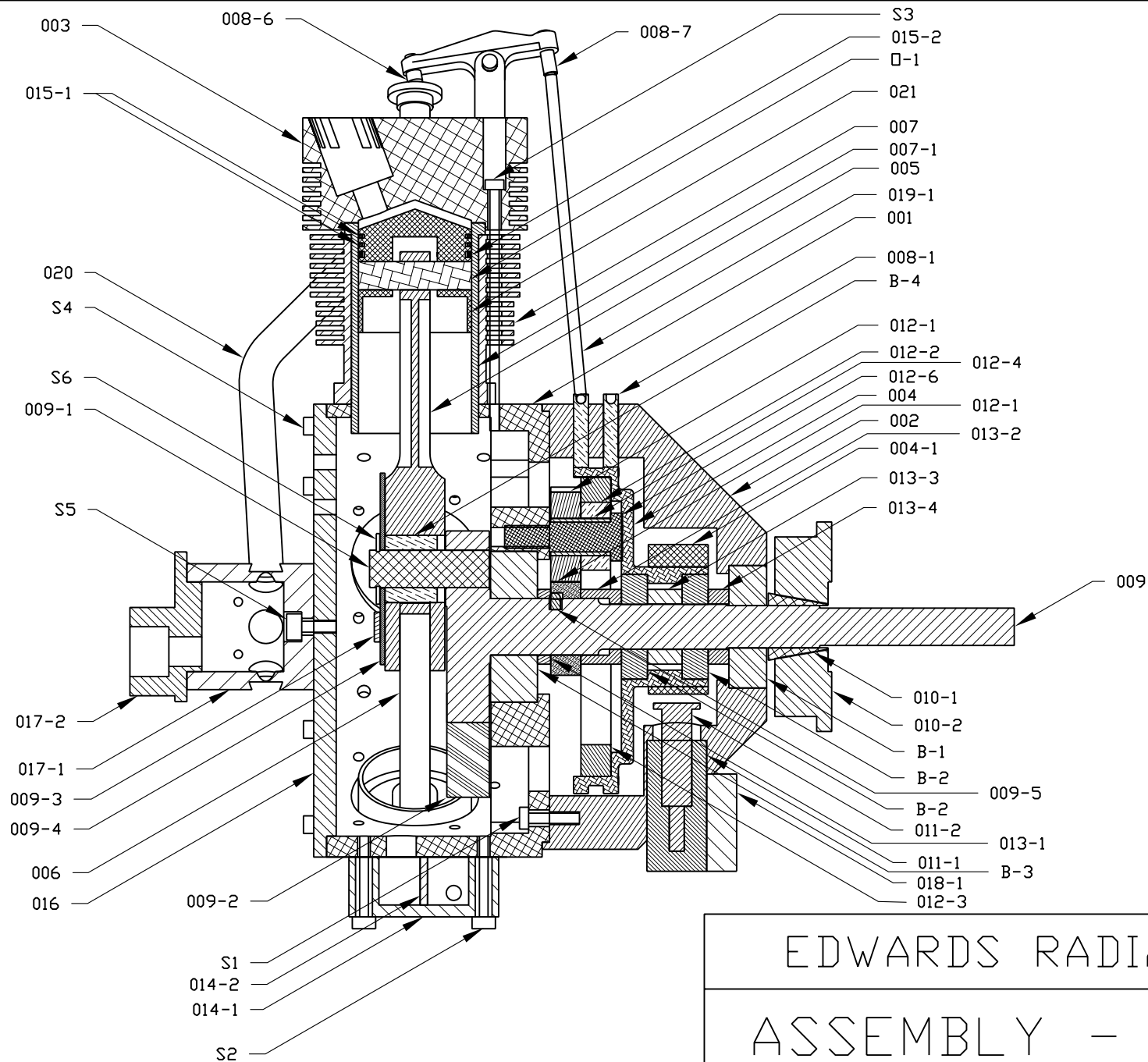
Part No.	Description	Material
016	Rear Cover	7075-T6 AL
017-1	Manifold	7075-T6 AL
017-2	Manifold Cover	7075-T6 AL
018-1	Oil Pump Cover	7075-T6 AL
019-1	Push Rod	Drill Rod
019-2	Valve Spring	.030 Piano Wire
019-3	Rocker Shaft	Dowel Pin
020-1	Flange	Steel
020-2	Intake Tube	Brass Tubing
021	Piston	2024-T351 AL
S1, S5	6-32 x 1/4	Cap Screw
S2	6-32 x 5/8	Cap Screw
S3	4-40 x 2	Cap Screw
S4	2-56 x 1/4	Cap Screw
S6	5/16 C - Clip	
S7	4-40 x 1.25	Cap Screw
S8	1/8 C - Clip	
O1	Piston Pin	OS Max # 10893
R1	1/4 x 3/8 O-Ring	
B1	26mm x 9mm x 8mm	Boca MR629-2RS-29 bearing
B2	.875 x .375 x .218	Boca R6-19 bearing
B3	32mm x 12mm x 10mm	Boca MR6201-2RS-37 bearing
B4	.562 x .312 x .437	Boca JH57-OH-40 bearing

General Notes	
1	Fuel - Methanol with 3 to 5% Nitromethane
2	Lubricant - Castor oil (Suggest 4 oz. Tank)
3	Prop - 22x8 - 20x10 (6,000 to 7,000 RPM)
4	Carburator - Perry #302 or #205
5	Glow plugs - Fox long with idle bar
6	On board battery is recommended
7	Exhaust tube not specified - builder discretion
8	Bearings available at www.bocabearings.com

EDWARDS RADIAL 5

PART LIST & NOTES

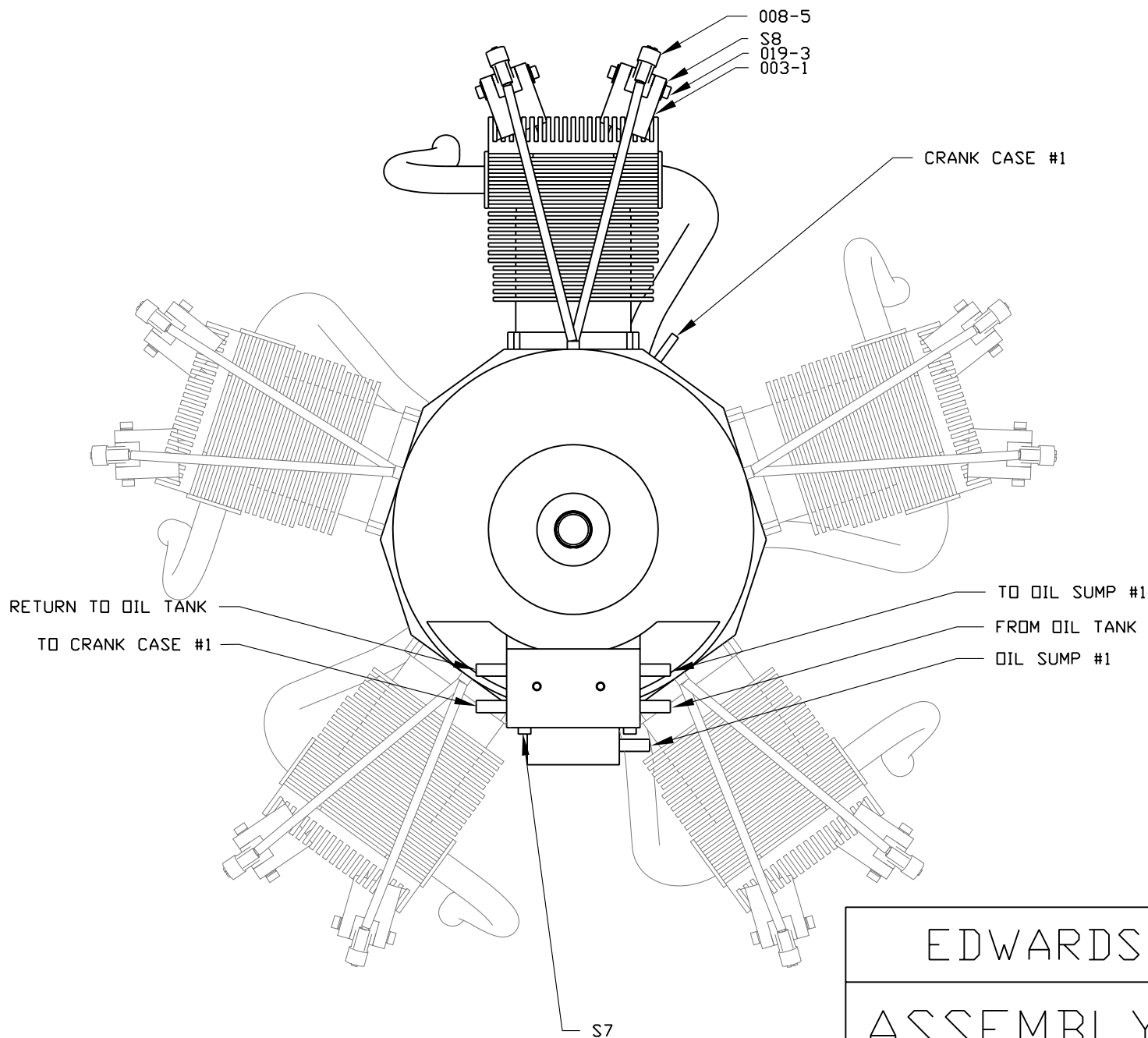
QTY REQ	MATERIAL	PART NO.	REV	SIZE
			A00	A
SCALE	DRAWN BY: Robert Sigler	SHEET	1 OF 36	



EDWARDS RADIAL 5

ASSEMBLY - SIDE

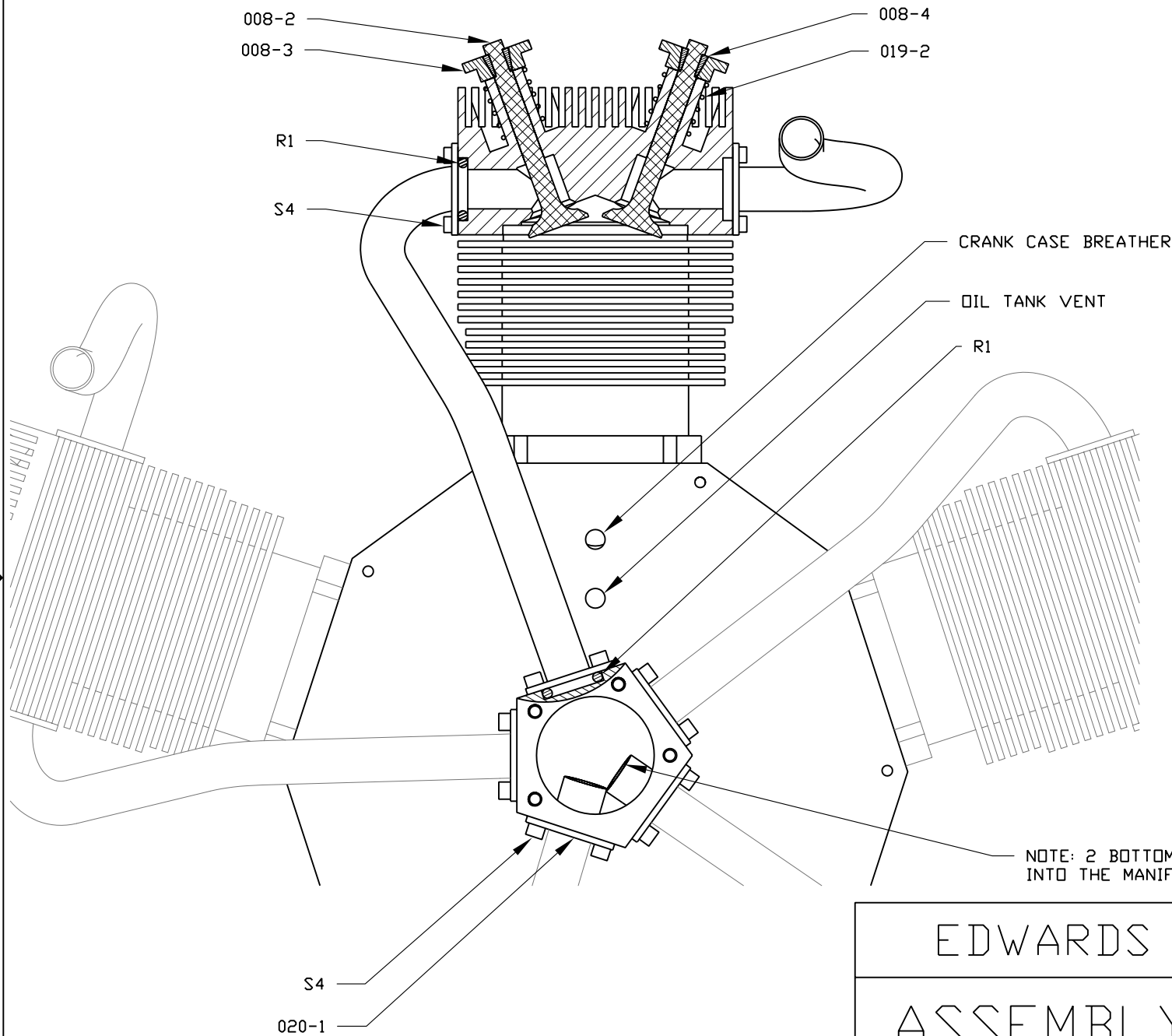
QTY REQ	MATERIAL	PART NO.	REV	SIZE
			A00	A
SCALE	DRAWN BY: Robert Sigler	SHEET	2	OF 36



EDWARDS RADIAL 5

ASSEMBLY - FRONT

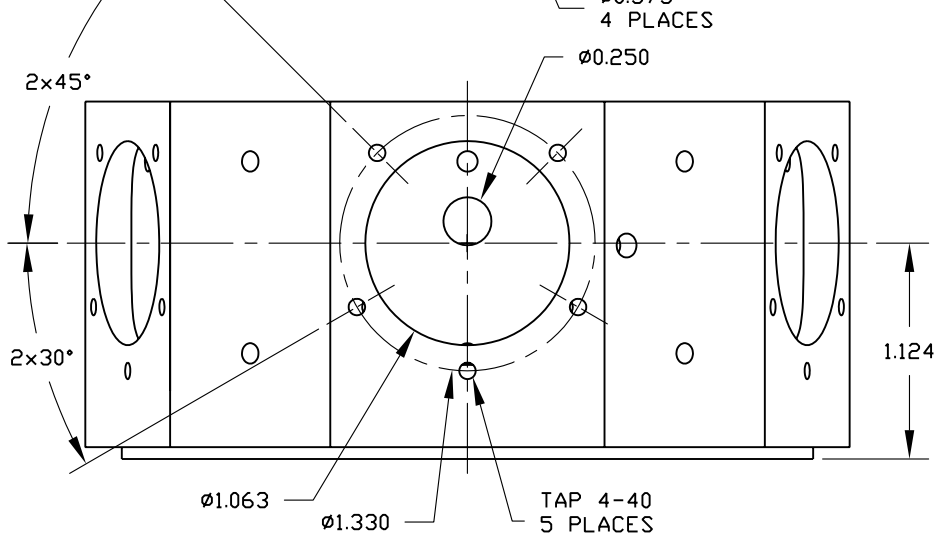
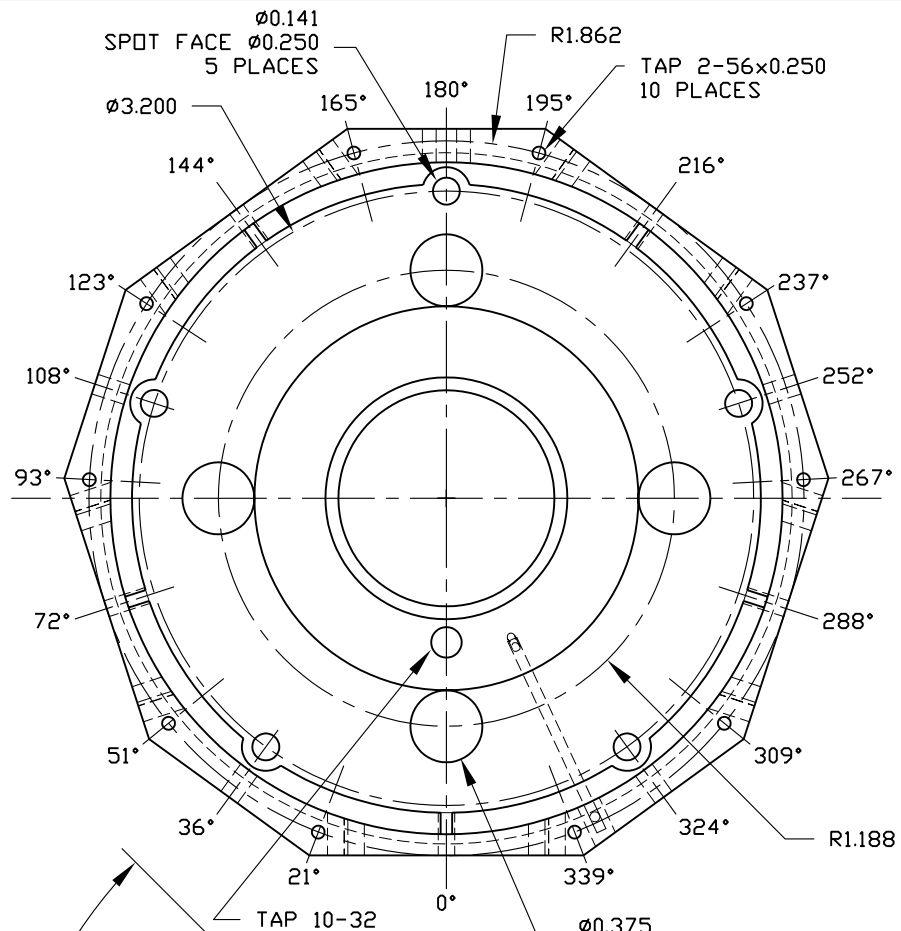
QTY REQ	MATERIAL	PART NO.	REV	SIZE
			A00	A
SCALE	DRAWN BY: Robert Sigler		SHEET	3 OF 36



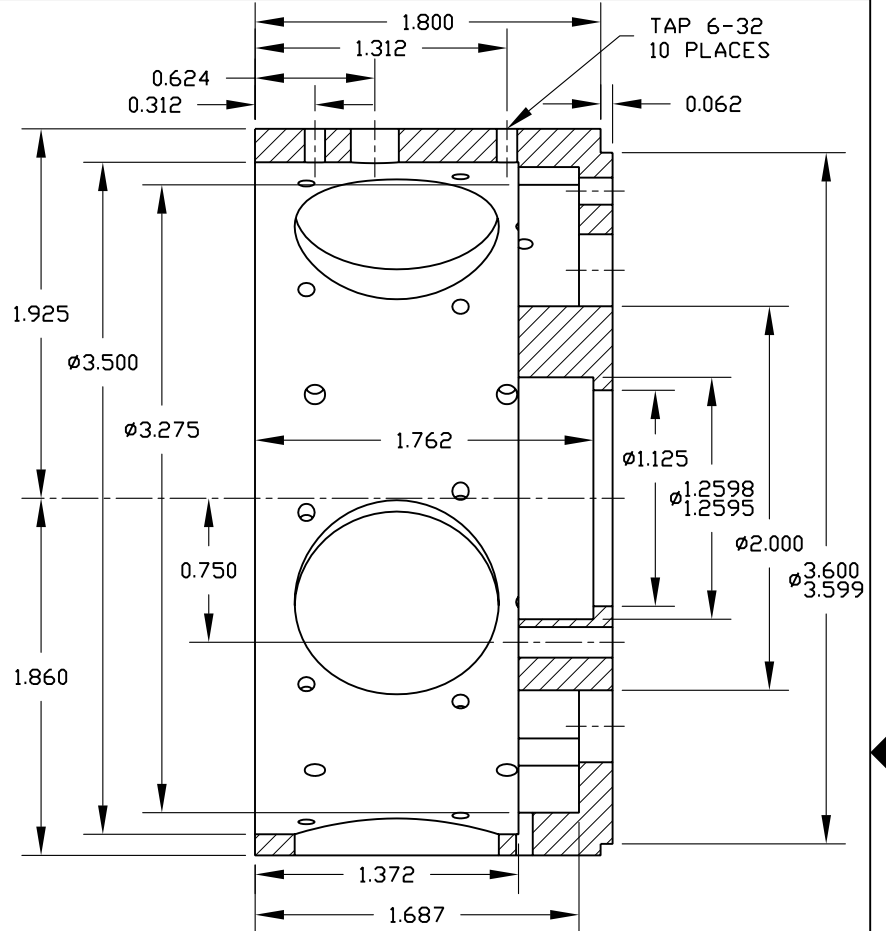
EDWARDS RADIAL 5

ASSEMBLY - BACK

QTY REQ	MATERIAL	PART NO.	REV	SIZE
			A00	A
SCALE	DRAWN BY: Robert Sigler	SHEET	4 OF 36	



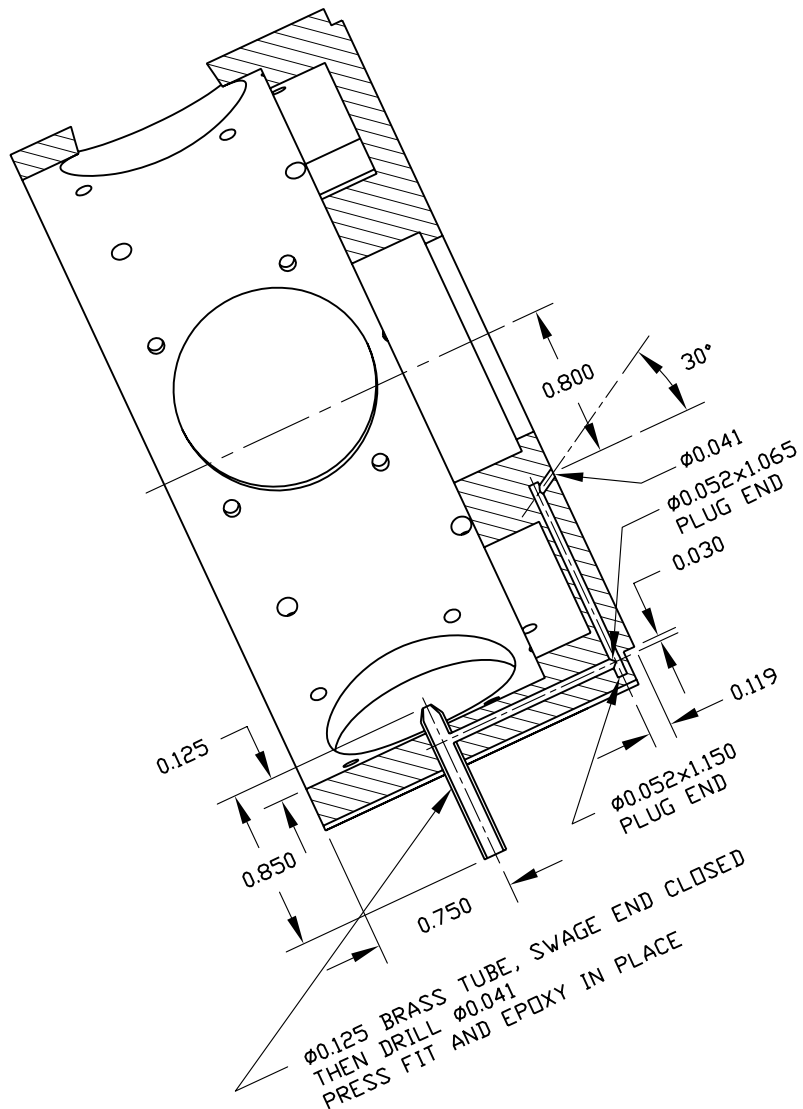
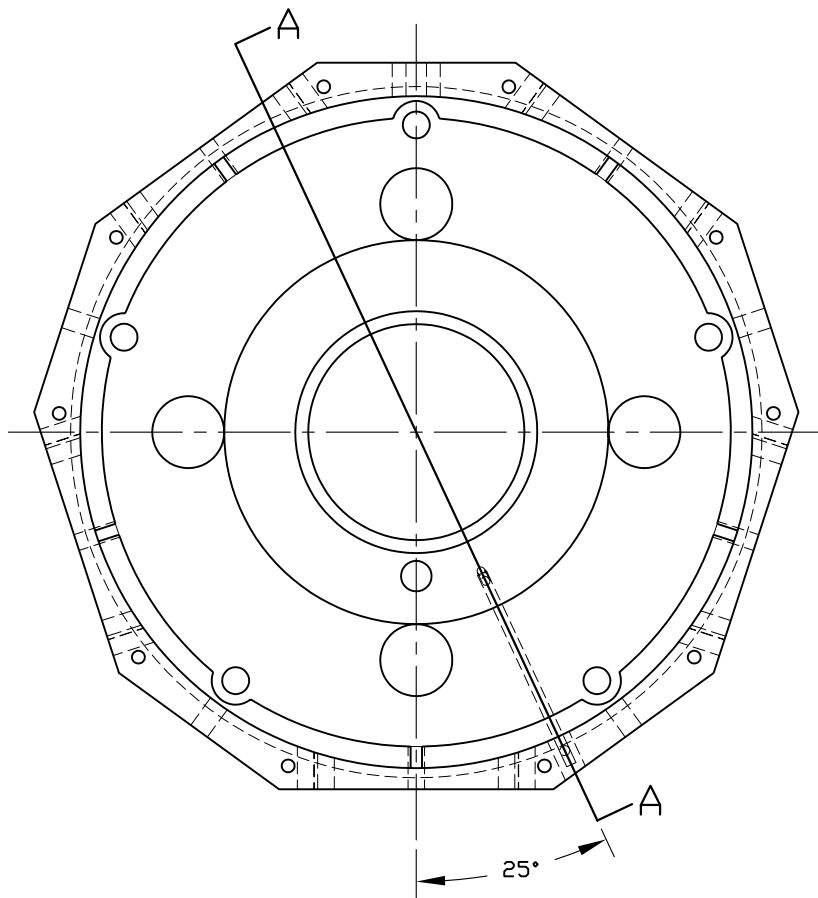
HIDDEN LINES REMOVED TO IMPROVE CLARITY



EDWARDS RADIAL 5

CRANKCASE

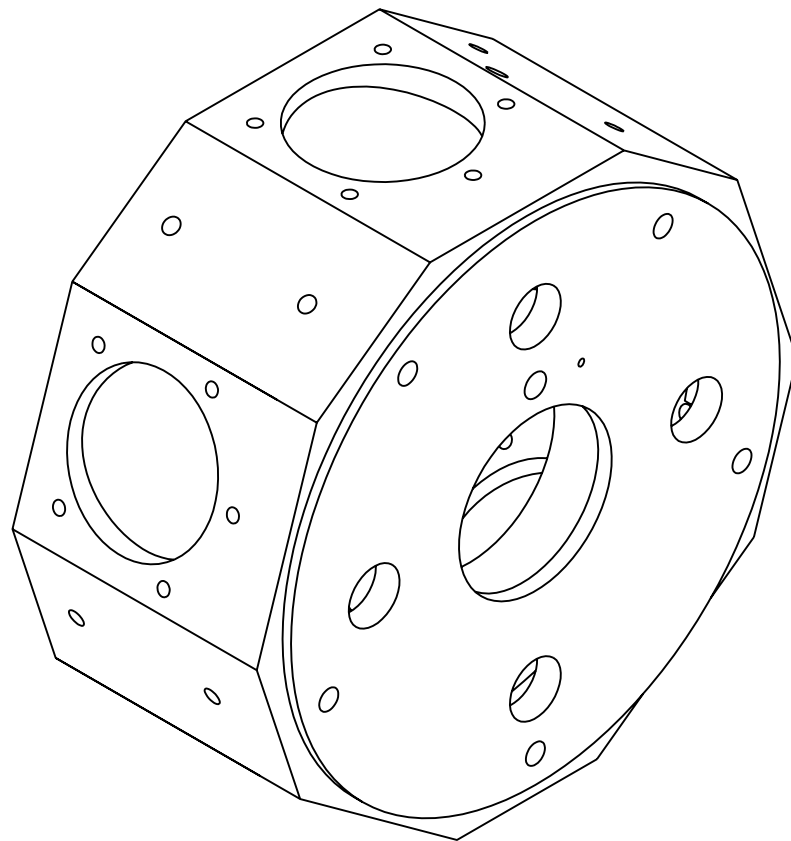
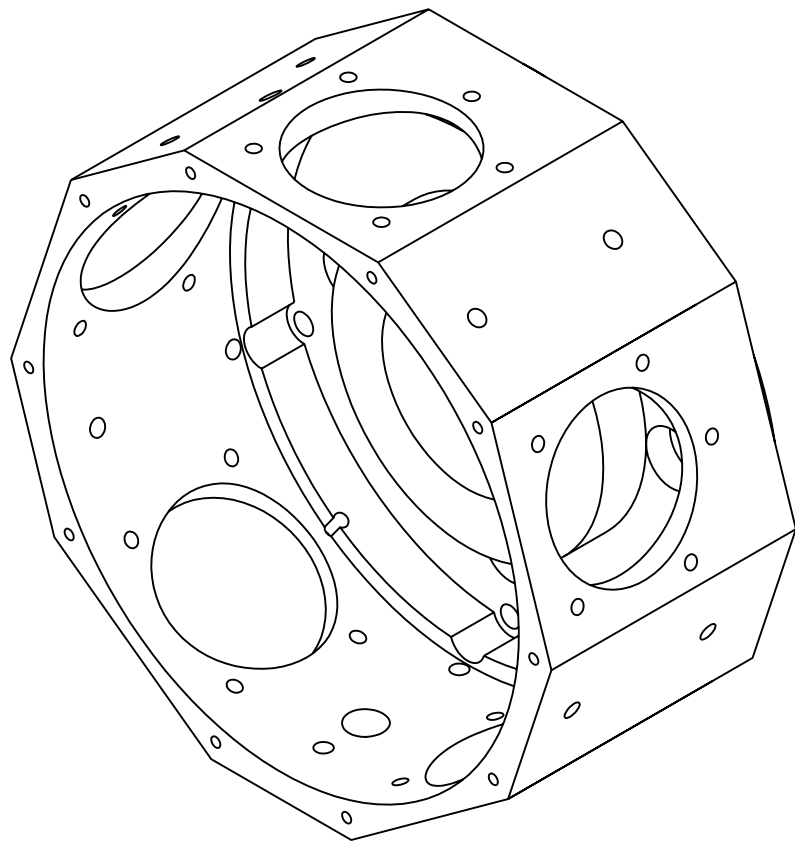
QTY REQ	MATERIAL	PART NO.	REV	SIZE
1	7075-T6 AL	001	A00	A
SCALE 1 : 1	DRAWN BY: Robert Sigler	SHEET 5 OF 36		



EDWARDS RADIAL 5

CRANKCASE - AUX

QTY REQ	MATERIAL	PART NO.	REV	SIZE
	7075-T6 AL	001	A00	A
SCALE 1 : 1	DRAWN BY: Robert Sigler	SHEET 6	OF 36	



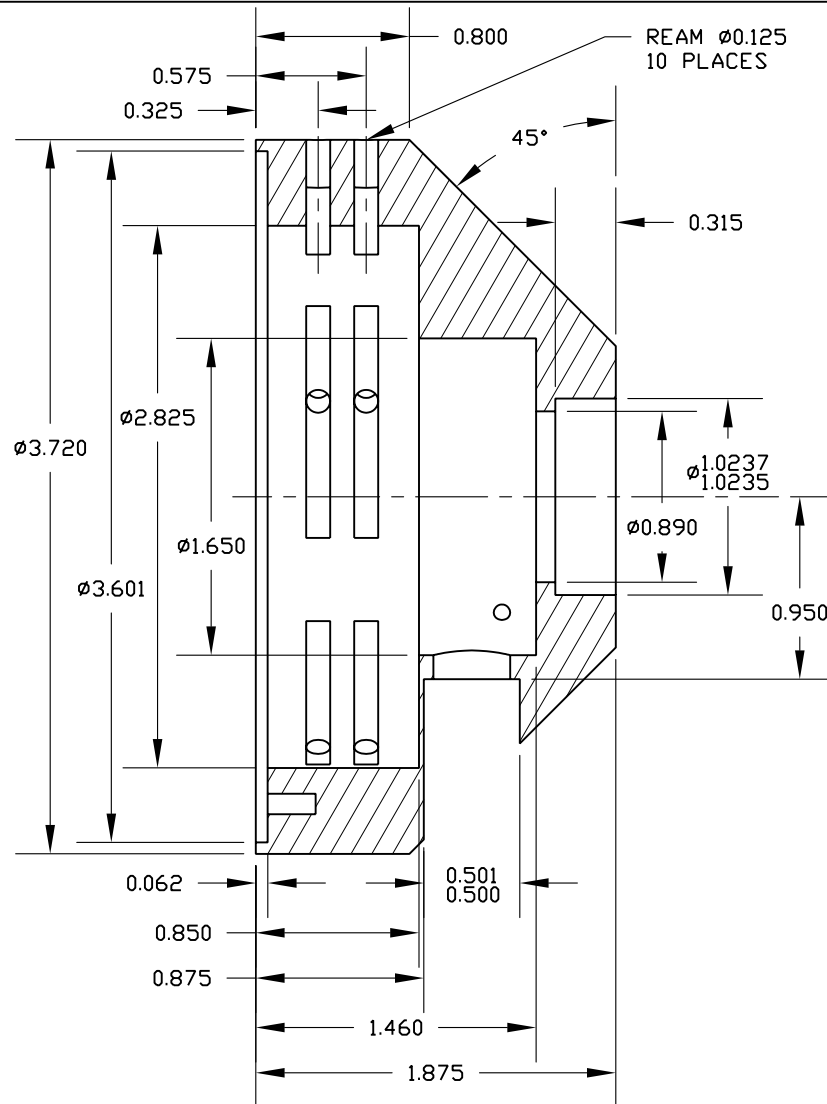
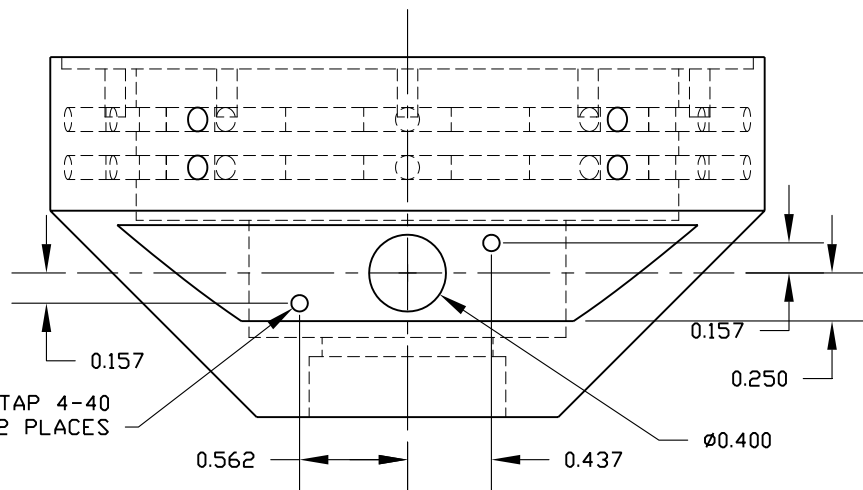
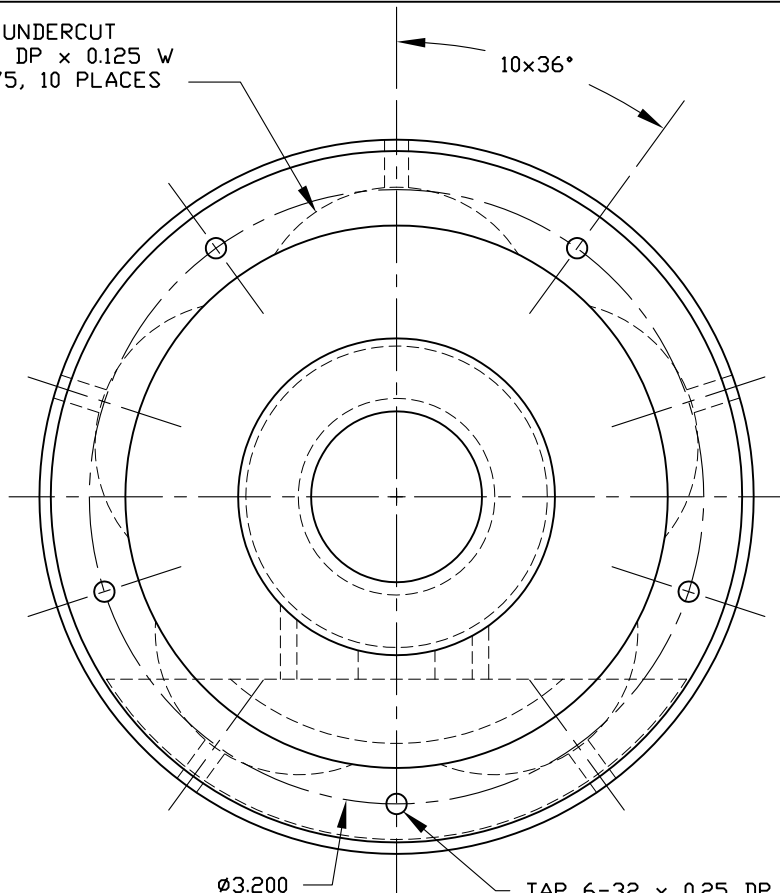
EDWARDS RADIAL 5

CRANKCASE - ISO

QTY REQ	MATERIAL	PART NO.	REV	SIZE
	7075-T6 AL	001	A00	A
SCALE	1 : 1	DRAWN BY:	SHEET	
		Robert Sigler	7 OF	36

UNDERCUT
0.200 DP x 0.125 W
R0.75, 10 PLACES

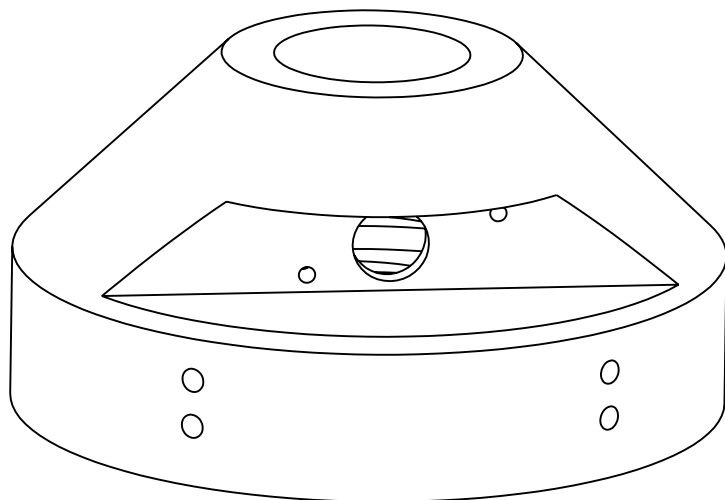
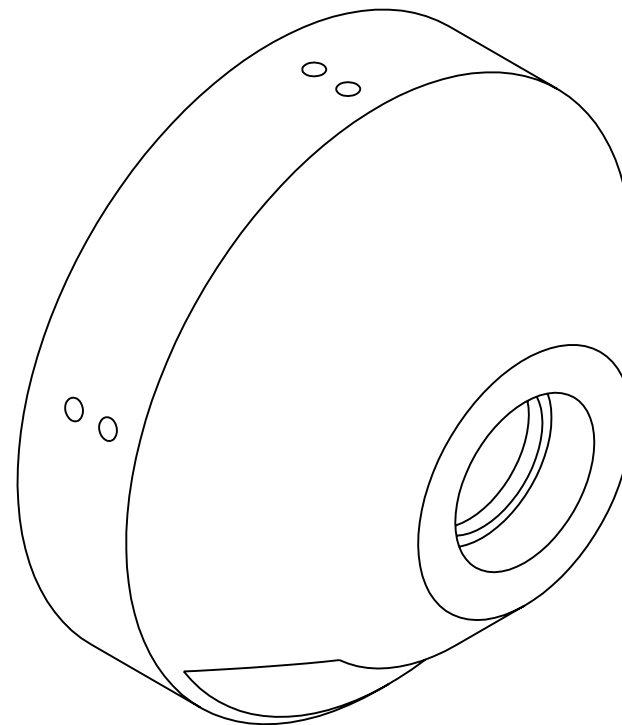
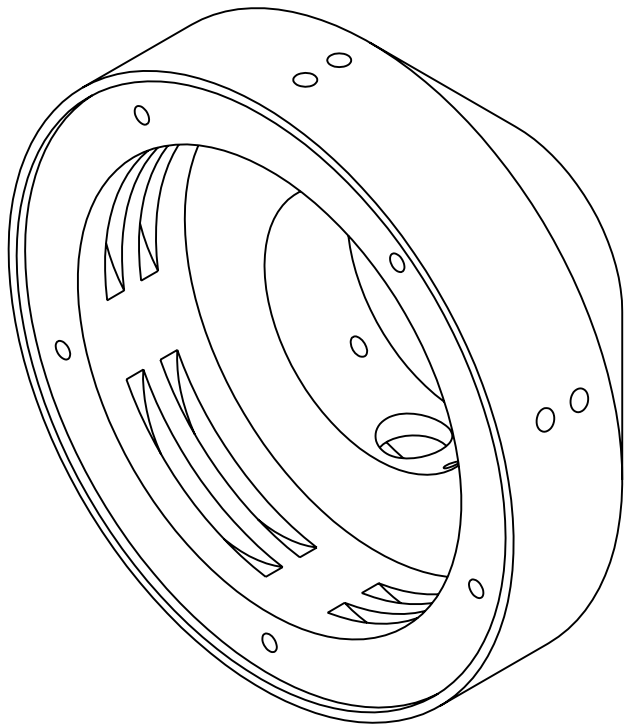
10x36°



EDWARDS RADIAL 5

CAM HOUSING

QTY REQ	MATERIAL	PART NO.	REV	SIZE
1	7075-T6 AL	002	A00	A
SCALE 1 : 1	DRAWN BY: Robert Sigler	SHEET 8	OF 36	

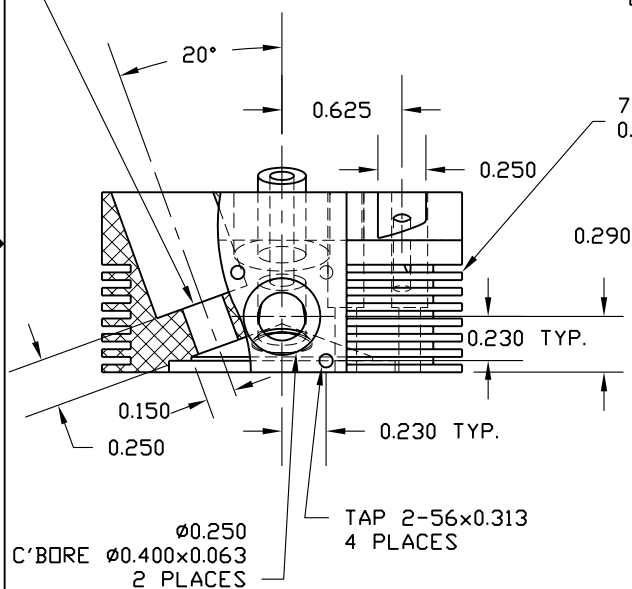


EDWARDS RADIAL 5

CAM HOUSING - ISO

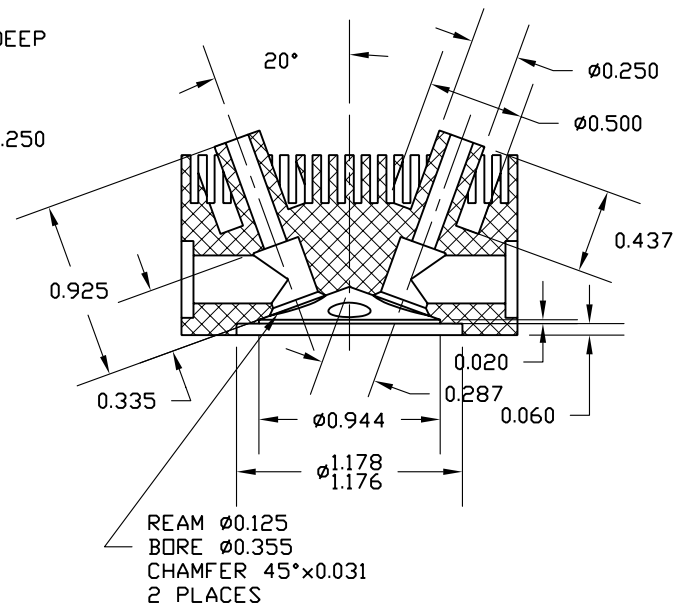
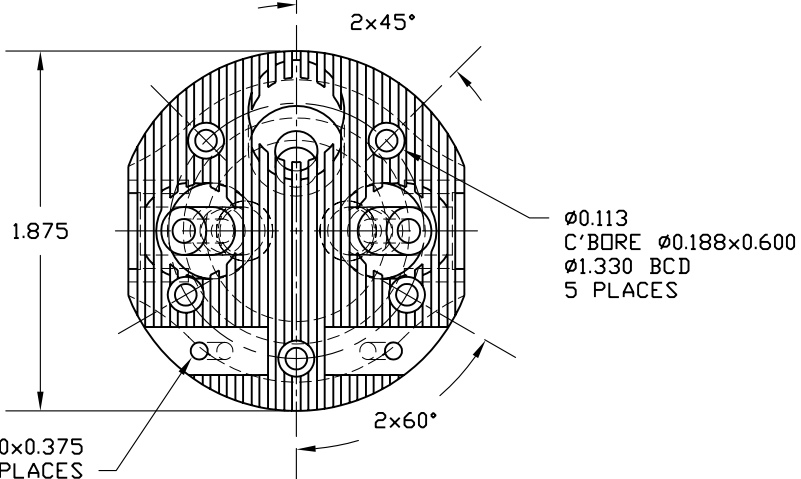
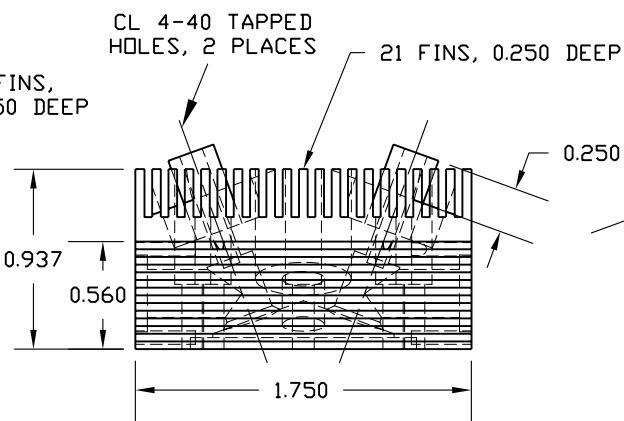
QTY REQ	MATERIAL	PART NO.	REV	SIZE
1	7075-T6 AL	002	A00	A
SCALE 1 : 1	DRAWN BY: Robert Sigler		SHEET 9 OF 36	

TAP 1-32
C'BORE Ø0.500



SOME COOLING FINS HAVE BEEN
OMITTED TO IMPROVE CLARITY

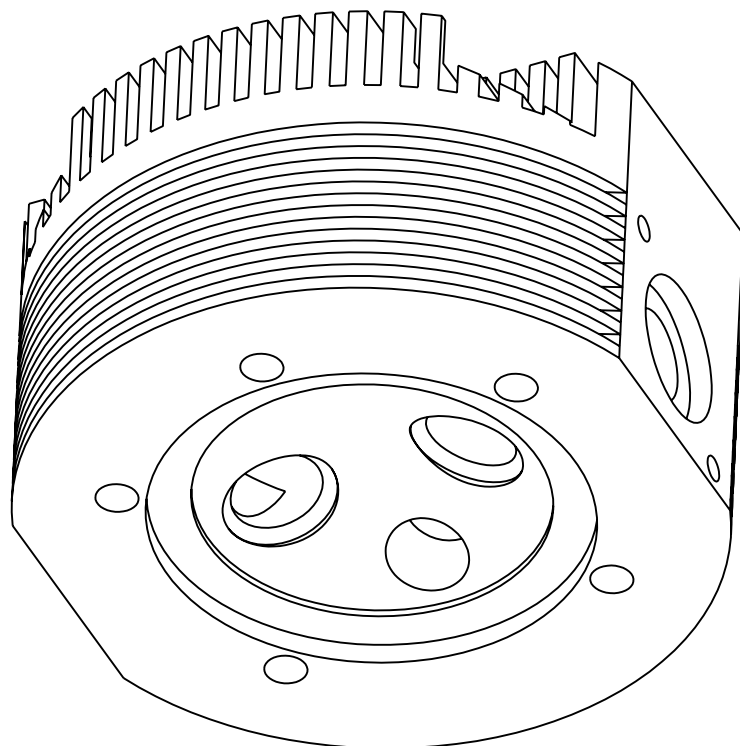
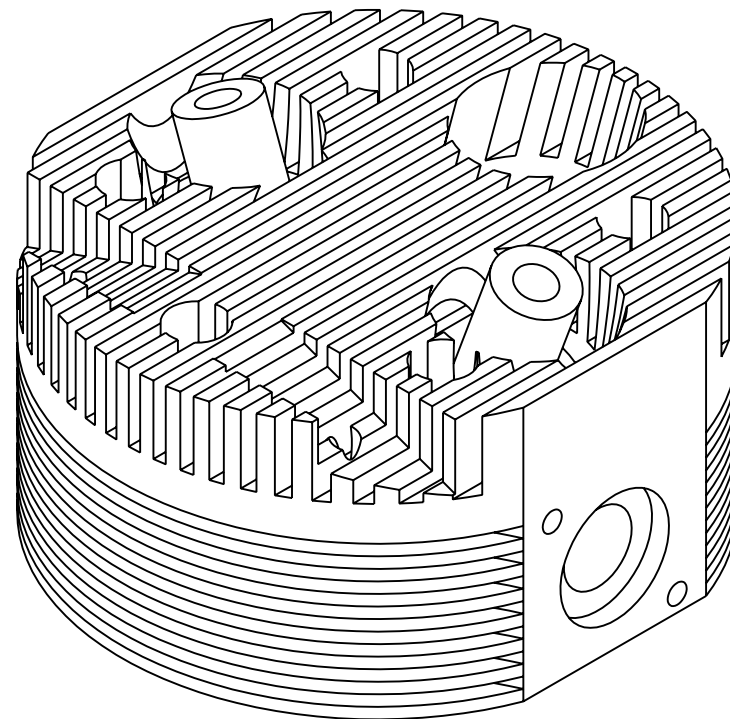
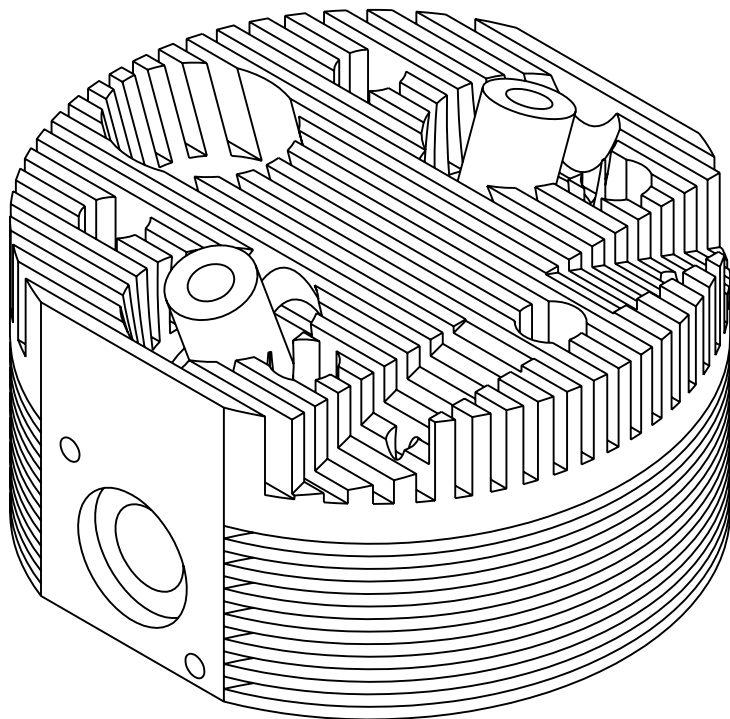
TAP 4-40x0.375
2 PLACES



EDWARDS RADIAL 5

CYLINDER HEAD

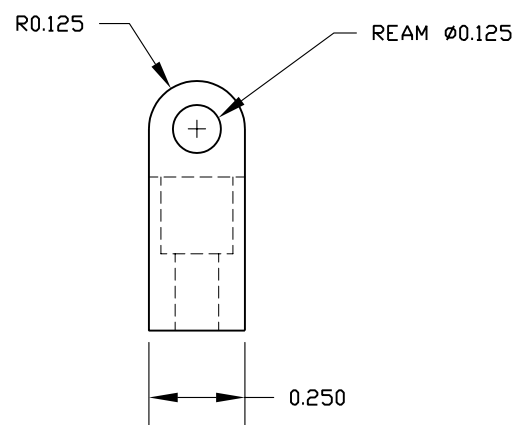
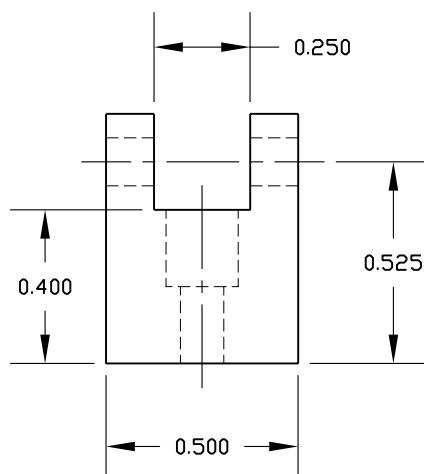
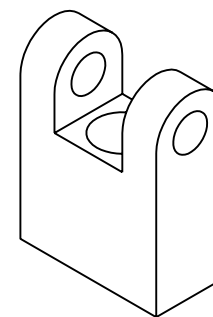
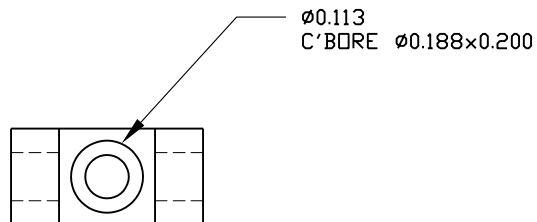
QTY REQ	MATERIAL	PART NO.	REV	SIZE
5	7075-T6 AL	003	A01	A
SCALE 1 : 1	DRAWN BY: Robert Sigler	SHEET 10	OF 36	



EDWARDS RADIAL 5

HEAD - ISO

QTY REQ	MATERIAL	PART NO.	REV	SIZE
	7075-T6 AL	003	A00	A
SCALE 2 : 1	DRAWN BY: Robert Sigler		SHEET 11 OF 36	

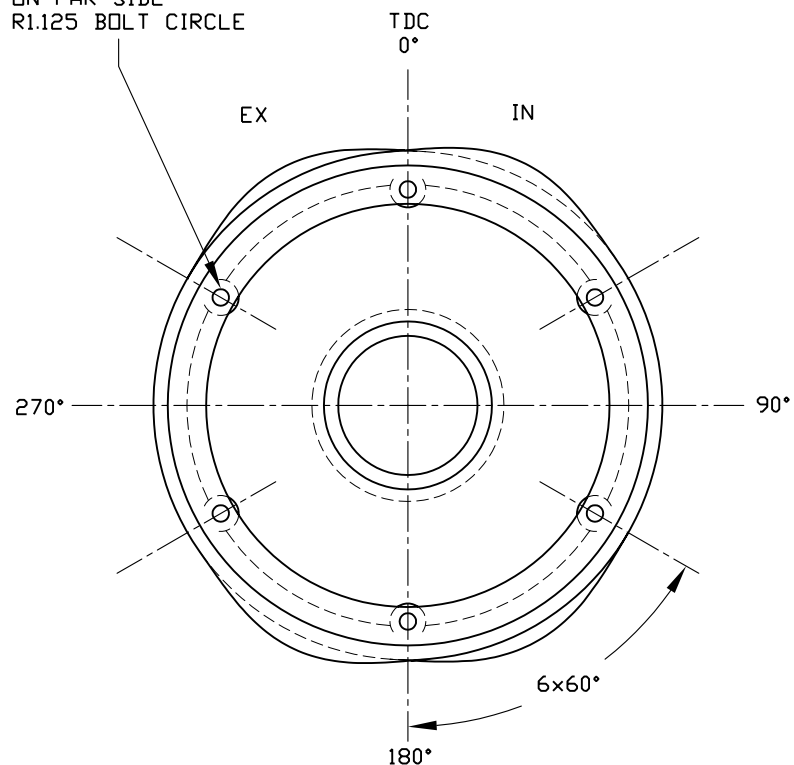


EDWARDS RADIAL 5

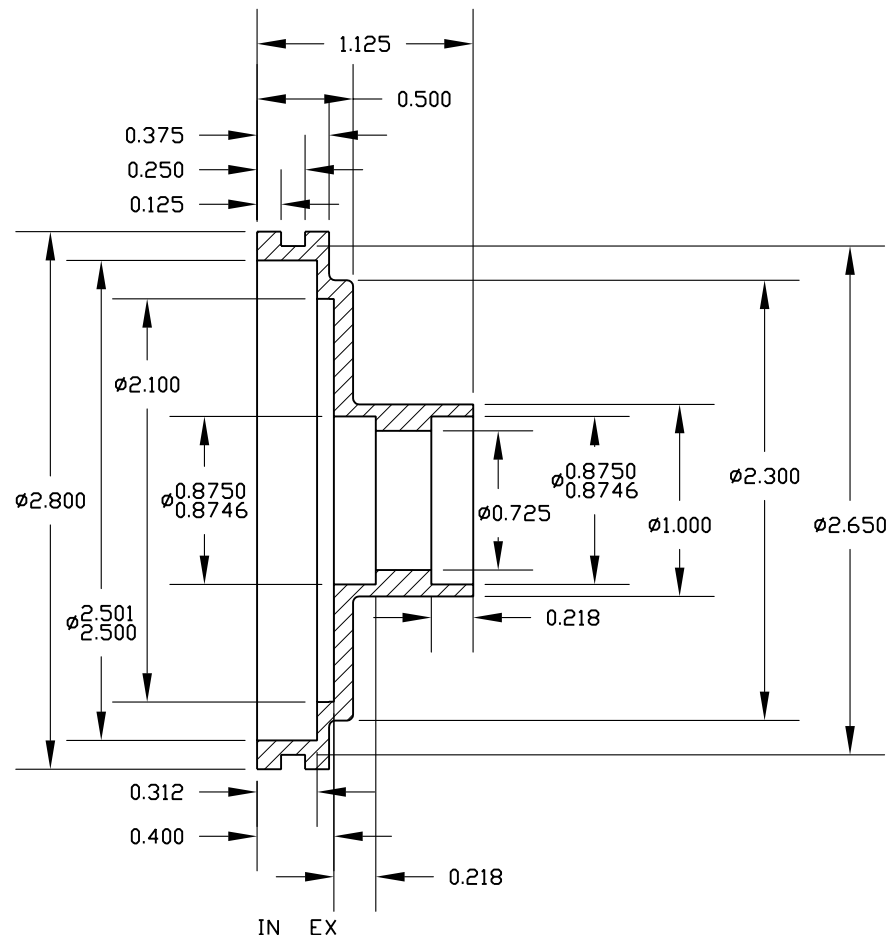
ROCKER BRACKET

QTY REQ	MATERIAL	PART NO.	REV	SIZE
10	7075-T6 AL	003-1	A01	A
SCALE 2 : 1	DRAWN BY: Robert Sigler		SHEET 12 OF 36	

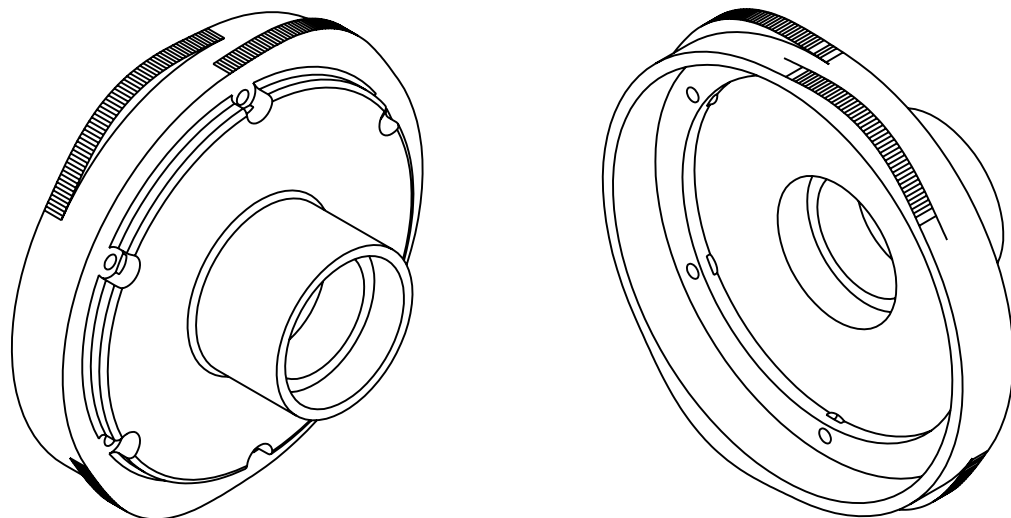
6xØ0.086, C'BORE Ø0.187
ON FAR SIDE
R1.125 BOLT CIRCLE



NOTE: CUT CAM LOBES TO FULL RISE OF 0.0750 THEN REMOVE MATERIAL TO MATCH CAM LOBE PROFILE CHART.



SOME HIDDEN DETAIL REMOVED TO IMPROVE CLARITY



EDWARDS RADIAL 5

CAM RING

QTY REQ	MATERIAL	PART NO.	REV	SIZE
1	4340 STEEL	004	A00	A
SCALE 1 : 1	DRAWN BY: Robert Sigler	SHEET 13 OF 36		

Exhaust		
Lobe 1 Deg	Lobe 2 Deg	Lift
120	300	0.0000
121	301	0.0002
122	302	0.0007
123	303	0.0016
124	304	0.0028
125	305	0.0043
126	306	0.0061
127	307	0.0083
128	308	0.0107
129	309	0.0133
130	310	0.0162
131	311	0.0193
132	312	0.0225
133	313	0.0259
134	314	0.0294
135	315	0.0330
136	316	0.0367
137	317	0.0410
138	318	0.0456
139	319	0.0491
140	320	0.0525
141	321	0.0557
142	322	0.0587
143	323	0.0617
144	324	0.0643
145	325	0.0667
146	326	0.0689
147	327	0.0707
148	328	0.0722
149	329	0.0734
150	330	0.0743
151	331	0.0748
152	332	0.0750

Exhaust		
Lobe 1 Deg	Lobe 2 Deg	Lift
153	333	0.0748
154	334	0.0743
155	335	0.0734
156	336	0.0722
157	337	0.0707
158	338	0.0689
159	339	0.0667
160	340	0.0643
161	341	0.0617
162	342	0.0587
163	343	0.0557
164	344	0.0525
165	345	0.0491
166	346	0.0456
167	347	0.0410
168	348	0.0367
169	349	0.0330
170	350	0.0294
171	351	0.0259
172	352	0.0225
173	353	0.0193
174	354	0.0162
175	355	0.0133
176	356	0.0107
177	357	0.0083
178	358	0.0061
179	359	0.0043
180	0	0.0028
181	1	0.0016
182	2	0.0007
183	3	0.0002
184	4	0.0000

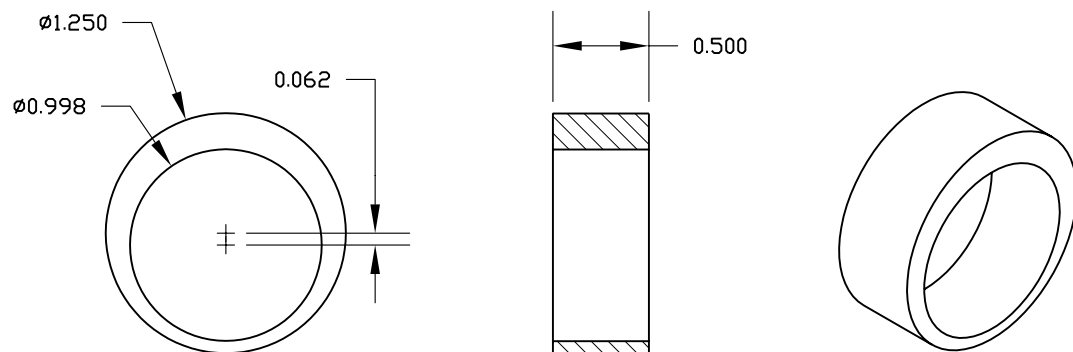
Intake		
Lobe 1 Deg	Lobe 2 Deg	Lift
355	175	0.0000
356	176	0.0002
357	177	0.0008
358	178	0.0018
359	179	0.0032
0	180	0.0050
1	181	0.0072
2	182	0.0096
3	183	0.0124
4	184	0.0155
5	185	0.0188
6	186	0.0222
7	187	0.0259
8	188	0.0297
9	189	0.0336
10	190	0.0375
11	191	0.0414
12	192	0.0453
13	193	0.0491
14	194	0.0528
15	195	0.0562
16	196	0.0595
17	197	0.0626
18	198	0.0654
19	199	0.0678
20	200	0.0700
21	201	0.0718
22	202	0.0732
23	203	0.0742
24	204	0.0748
25	205	0.0750

Intake		
Lobe 1 Deg	Lobe 2 Deg	Lift
26	206	0.0748
27	207	0.0742
28	208	0.0732
29	209	0.0718
30	210	0.0700
31	211	0.0678
32	212	0.0654
33	213	0.0626
34	214	0.0595
35	215	0.0562
36	216	0.0528
37	217	0.0491
38	218	0.0453
39	219	0.0414
40	220	0.0375
41	221	0.0336
42	222	0.0297
43	223	0.0259
44	224	0.0222
45	225	0.0188
46	226	0.0155
47	227	0.0124
48	228	0.0096
49	229	0.0072
50	230	0.0050
51	231	0.0032
52	232	0.0018
53	233	0.0008
54	234	0.0002
55	235	0.0000

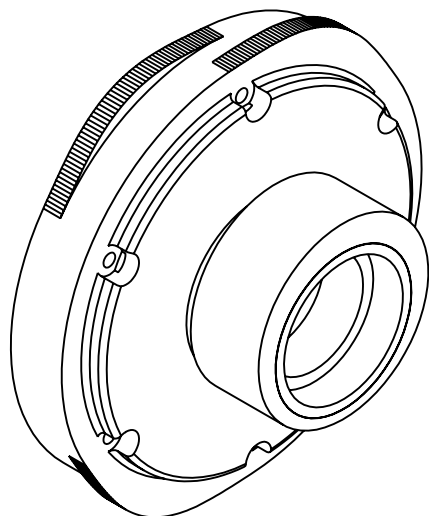
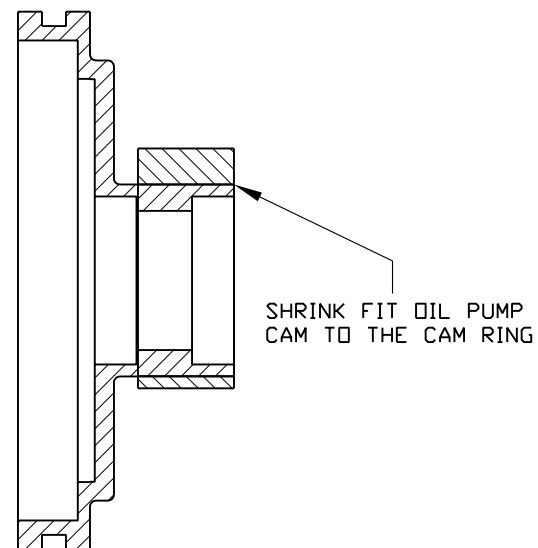
EDWARDS RADIAL 5

CAM PROFILE CHART

QTY REQ	MATERIAL	PART NO.	REV	SIZE
			A00	A
SCALE	DRAWN BY: Robert Sigler		SHEET	14 OF 36



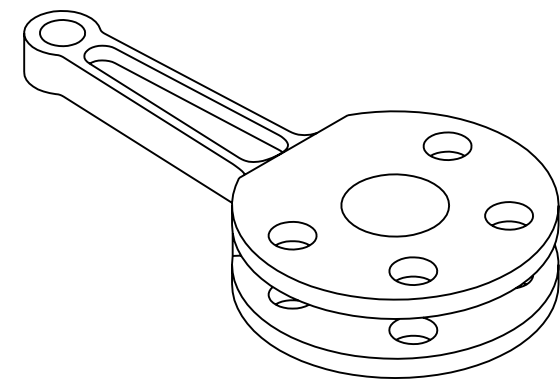
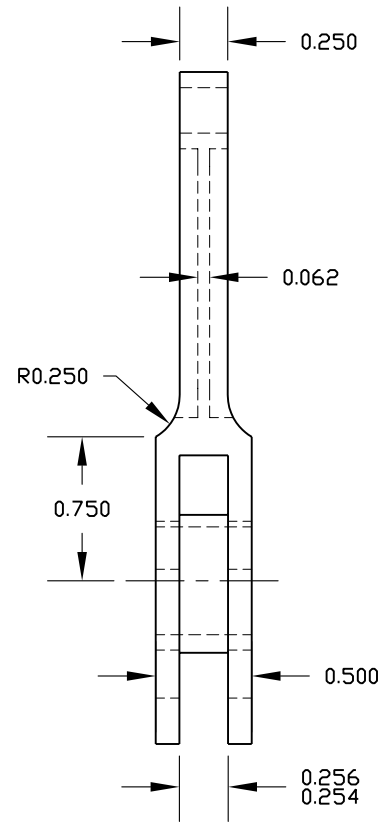
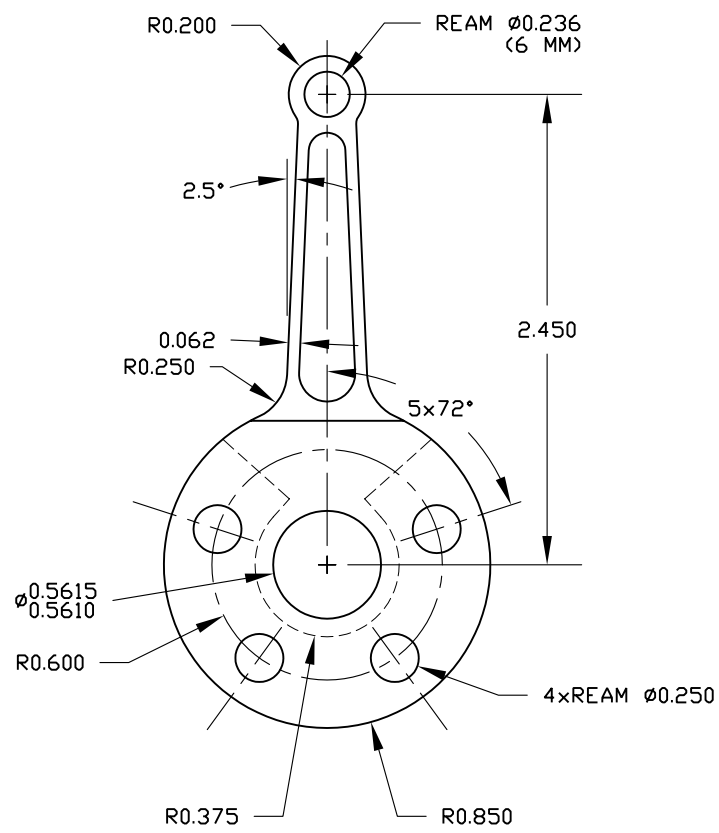
004-1 OIL PUMP CAM
4340 STEEL



EDWARDS RADIAL 5

CAM RING ASSEMBLY

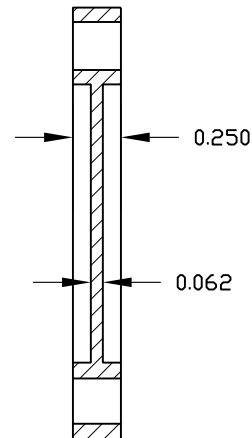
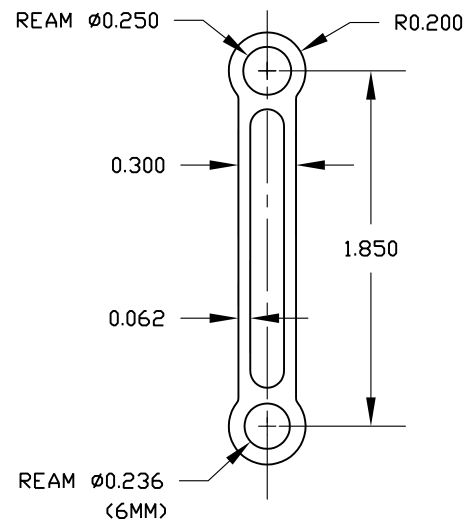
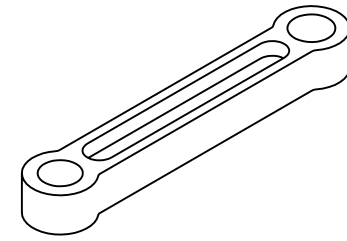
QTY REQ	MATERIAL	PART NO.	REV	SIZE
1	4340 STEEL	004-1	A00	A
SCALE 1 : 1	DRAWN BY: Robert Sigler		SHEET 15 OF 36	



EDWARDS RADIAL 5

MASTER ROD

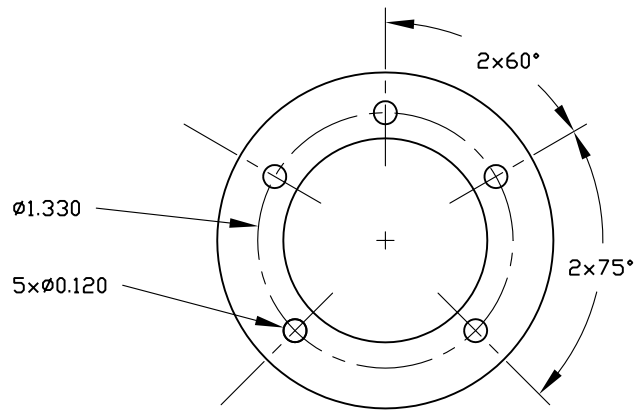
QTY REQ	MATERIAL	PART NO.	REV	SIZE
1	2024-T351 AL	005	A00	A
SCALE 1 : 1	DRAWN BY: Robert Sigler		SHEET 16 OF 36	



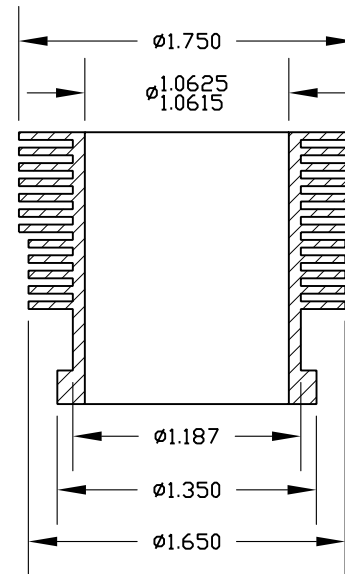
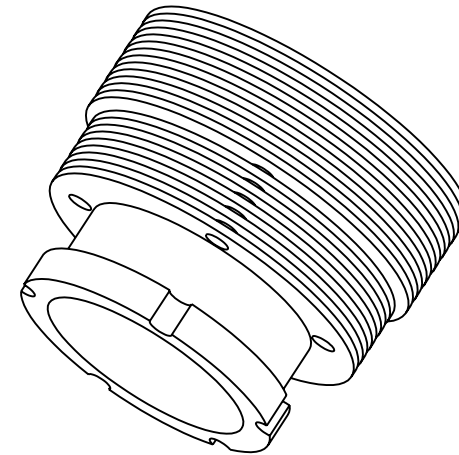
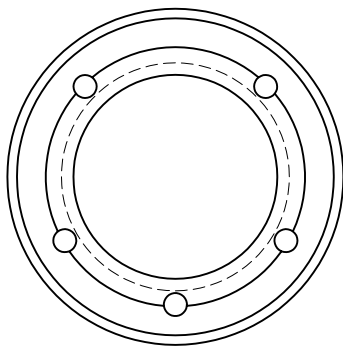
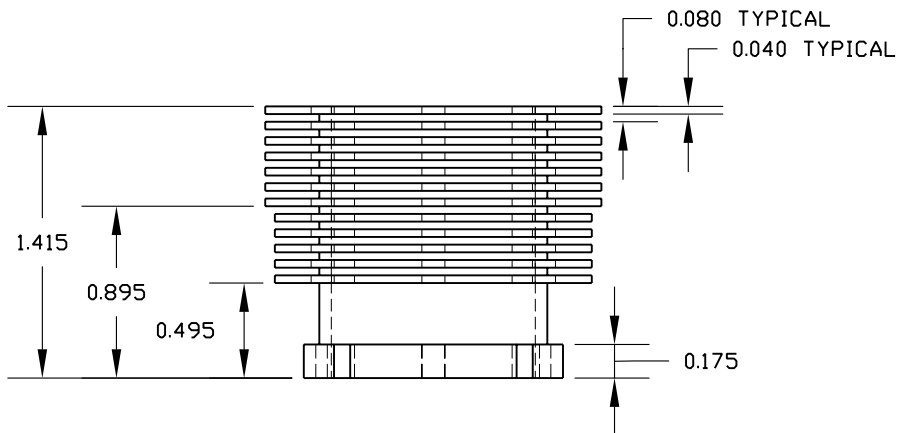
EDWARDS RADIAL 5

LINK ROD

QTY REQ	MATERIAL	PART NO.	REV	SIZE
4	2024-T351 AL	006	A00	A
SCALE	1 : 1	DRAWN BY: Robert Sigler	SHEET	17 OF 36



HIDDEN LINES REMOVED
FOR CLARITY

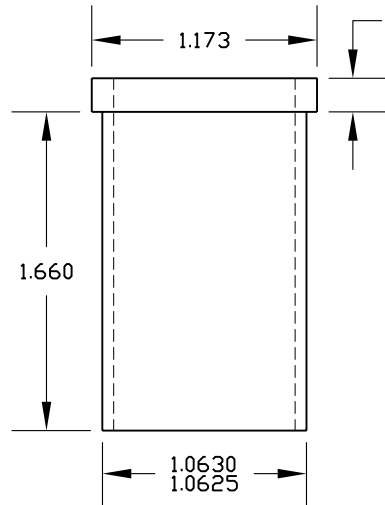
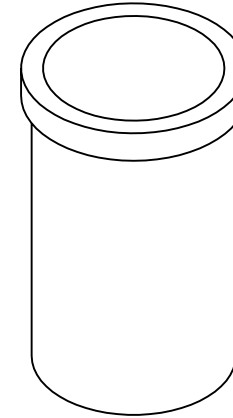
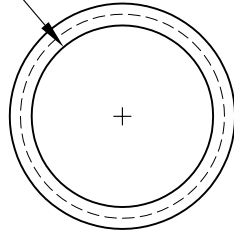


EDWARDS RADIAL 5

CYLINDER BARREL

QTY REQ	MATERIAL	PART NO.	REV	SIZE
5	7075-T6 AL	007	A00	A
SCALE	1 : 1	DRAWN BY:	Robert Sigler	
		SHEET	18	OF 36

$\varnothing 0.9455$
 $\varnothing 0.9450$

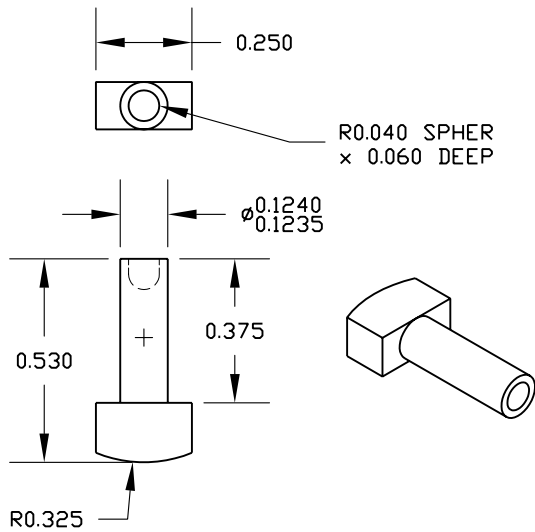


0.175 NOTE: AT ASSEMBLY CHECK
 COMPRESSION RATIO AND ADJUST TO
 8.5 : 1 BY TRIMMING TOP OF LINER
 AS NEEDED.

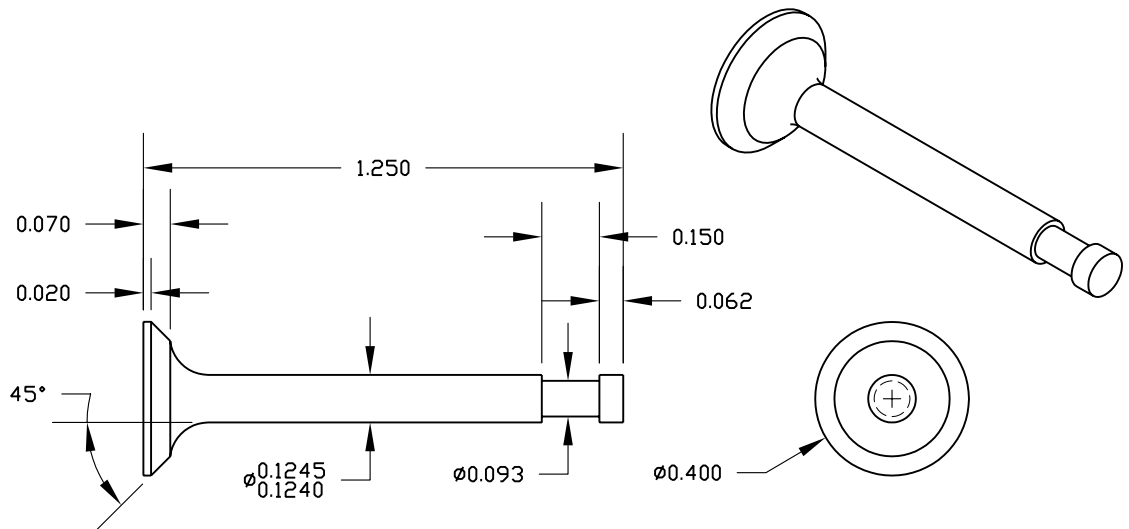
EDWARDS RADIAL 5

CYLINDER LINER

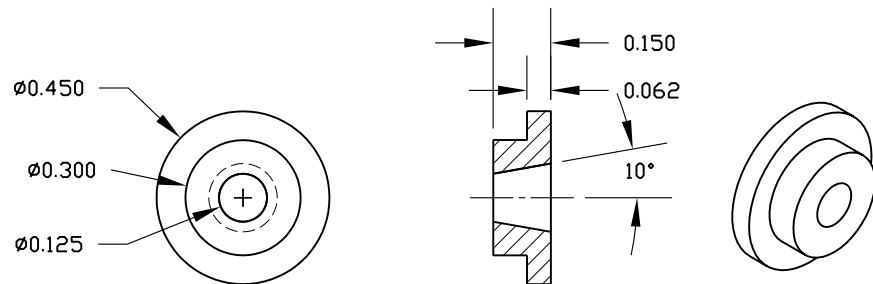
QTY REQ	MATERIAL	PART NO.	REV	SIZE
5	CAST IRON	007-1	A00	A
SCALE 1 : 1	DRAWN BY: Robert Sigler	SHEET 19	OF 36	



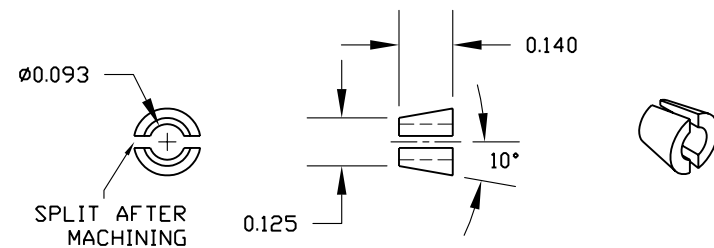
008-1 CAM FOLLOWER
DRILL ROD, HT & GRIND



008-2 VALVE
416 SS



008-3 VALVE SPRING RETAINER
7075-T6 AL

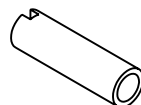
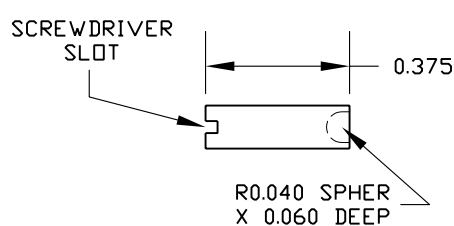
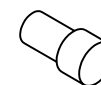
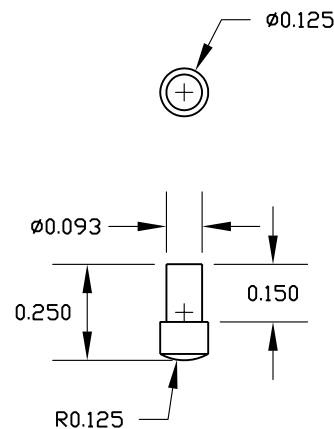
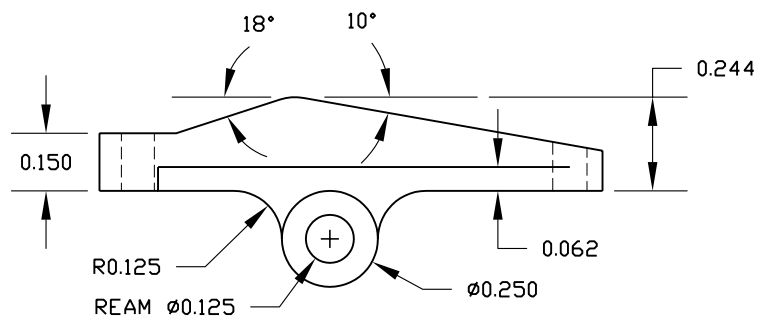
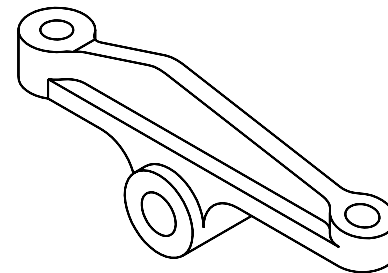
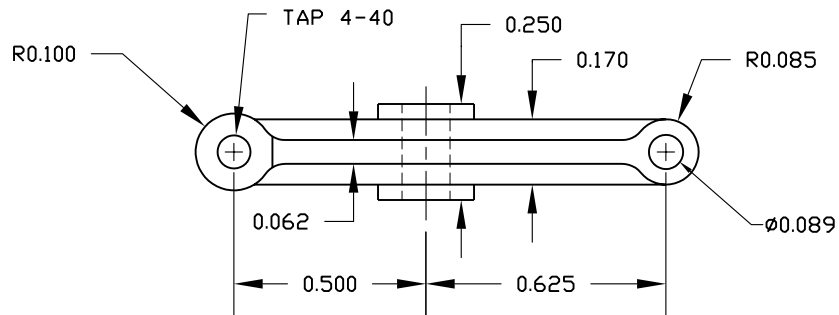


008-4 VALVE RETAINER LOCK
STEEL

EDWARDS RADIAL 5

VALVE TRAIN (1)

QTY REQ	MATERIAL	PART NO.	REV	SIZE
10EA	SEE NOTES	008	A00	A
SCALE 2 : 1	DRAWN BY: Robert Sigler	SHEET 20	OF 36	



008-5 ROCKER ARM
7075-T6 AL

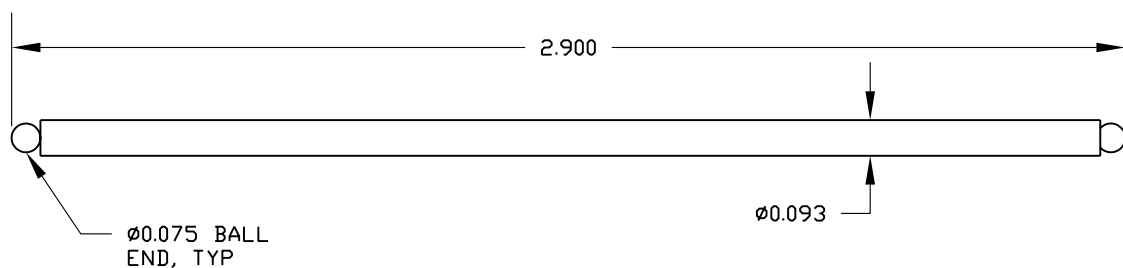
008-6 ROCKER BUTTON
DRILL ROD, HT THEN GRIND

008-7 VALVE ADJUST SCREW
4-40 SCREW STOCK

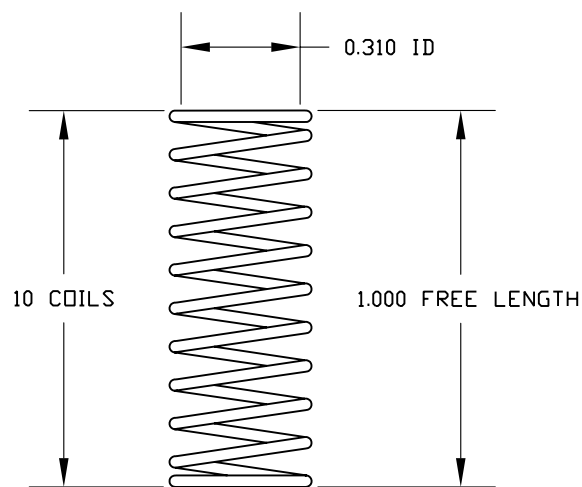
EDWARDS RADIAL 5

VALVE TRAIN (2)

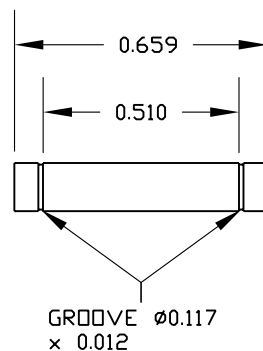
QTY REQ	MATERIAL	PART NO.	REV	SIZE
10EA	SEE NOTES	008	A00	A
SCALE 2 : 1	DRAWN BY: Robert Sigler	SHEET 21 OF 36		



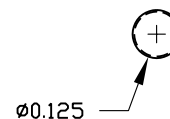
019-1 PUSH ROD
DRILL ROD



019-2 VALVE SPRING
.030 PLANO WIRE



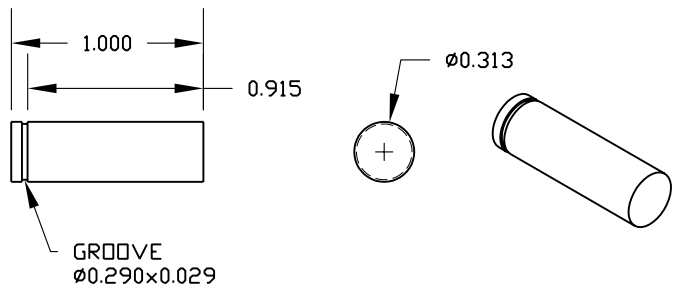
019-3 ROCKER SHAFT
0.125 DOWEL PIN



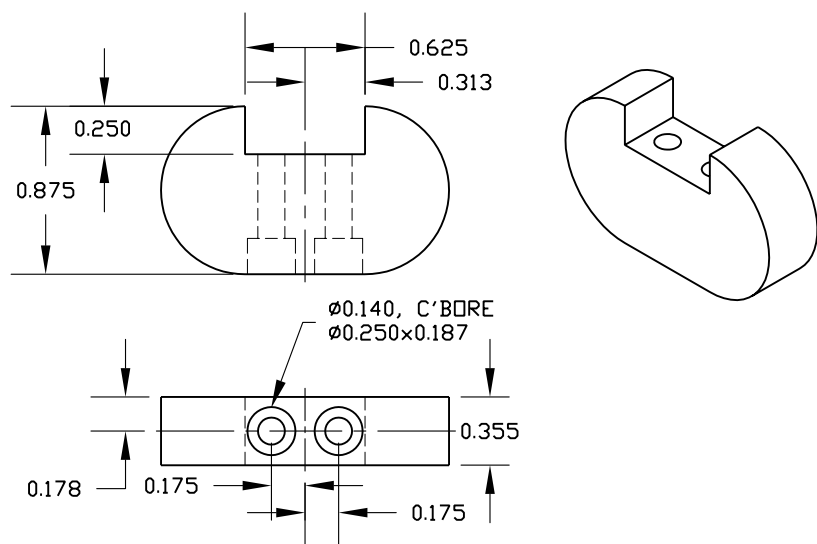
EDWARDS RADIAL 5

VALVE TRAIN (3)

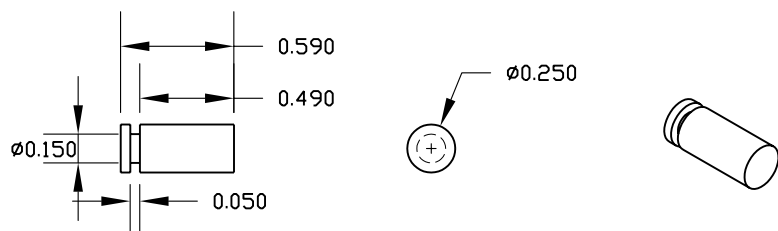
QTY REQ	MATERIAL	PART NO.	REV	SIZE
10EA	SEE NOTES	019	A01	A
SCALE 2 : 1	DRAWN BY: Robert Sigler	SHEET 22 OF 36		



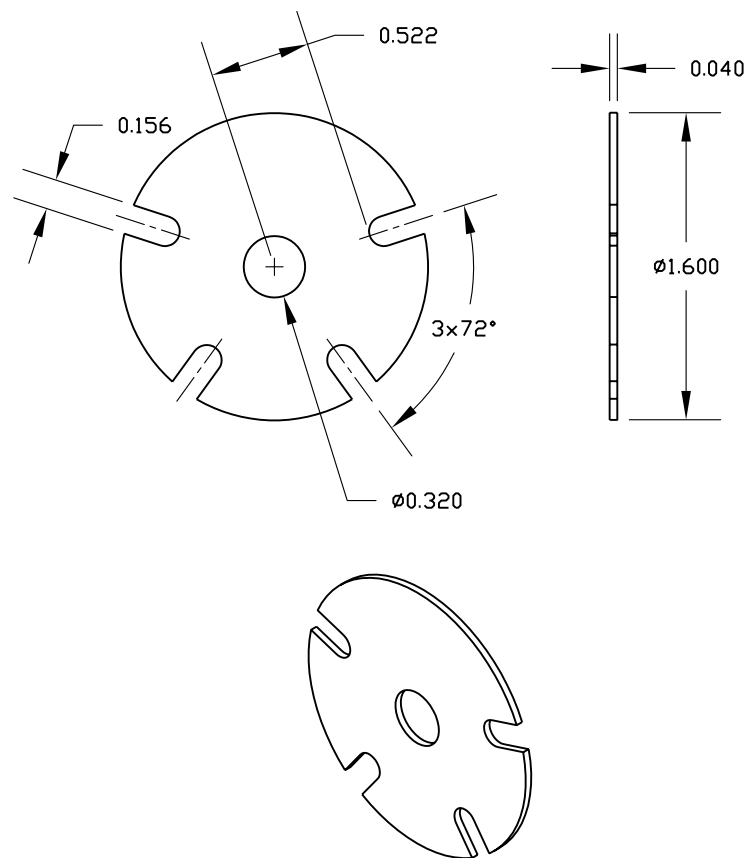
009-1 CRANKPIN
Ø0.313 BEARING ROLLER



009-2 COUNTERWEIGHT
STEEL



009-3 LINK PIN
Ø0.250 BEARING ROLLER
4 REQUIRED

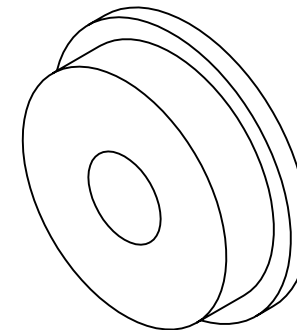
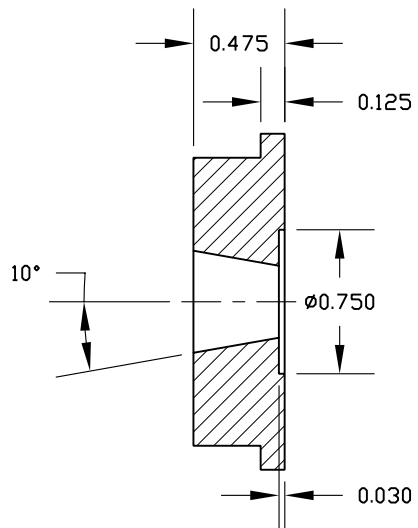
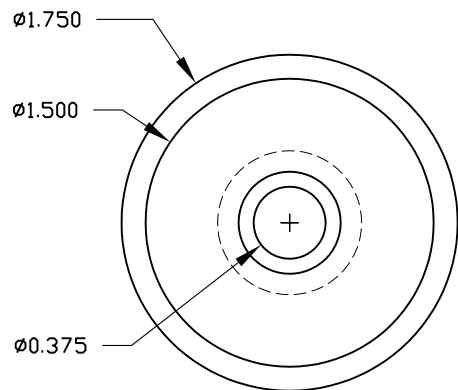


009-4 LINK PIN RETAINER
STEEL

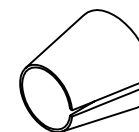
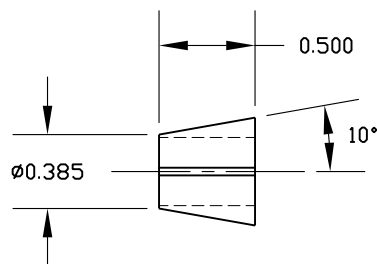
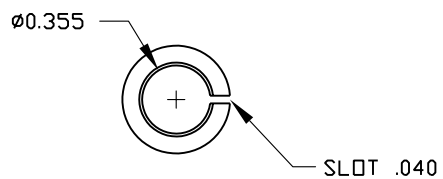
EDWARDS RADIAL 5

CRANKSHAFT MISC

QTY REQ	MATERIAL	PART NO.	REV	SIZE
1 EA	SEE NOTES	009	A00	A
SCALE 1 : 1	DRAWN BY: Robert Sigler	SHEET	24	OF 36



010-2 PROP HUB
7075-T6 AL

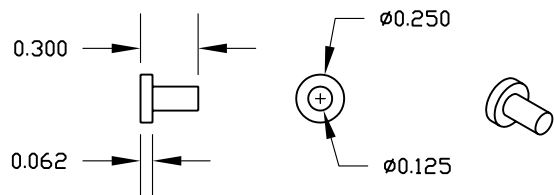


010-1 CONE
STEEL

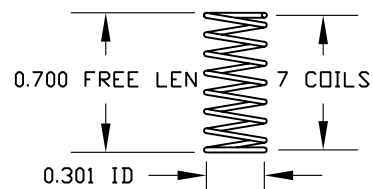
EDWARDS RADIAL 5

PROP COMPONENTS

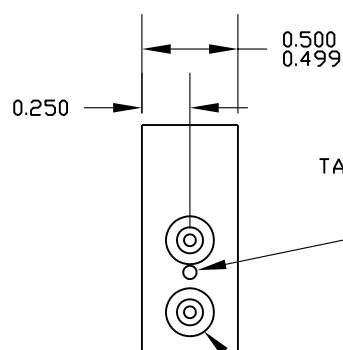
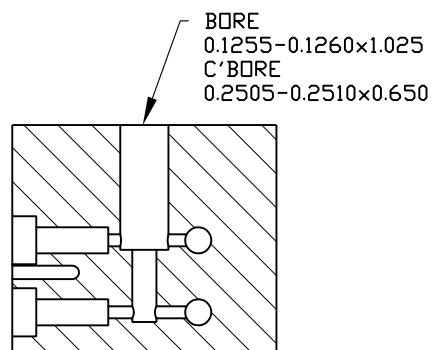
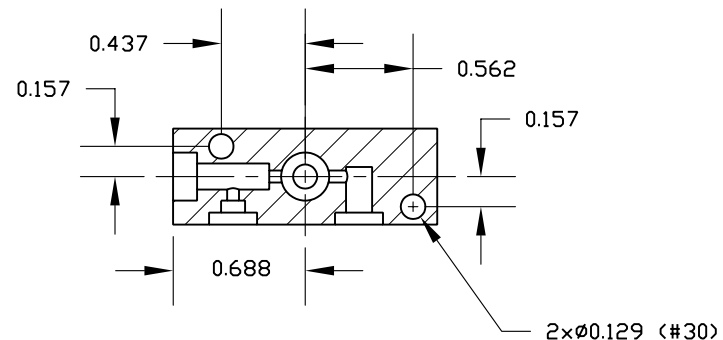
QTY REQ	MATERIAL	PART NO.	REV	SIZE
1 EA	SEE NOTES	010	A00	A
SCALE 1 : 1	DRAWN BY: Robert Sigler	SHEET	25 OF 36	



011-4 PLUG
2 REQ. 7075-T6 AL



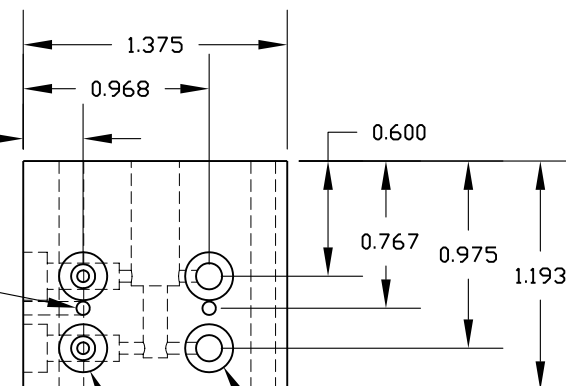
011-3 PLUNGER SPRING
Ø0.026 PIANO WIRE



TAP 2-56x0.312
3 PLACES

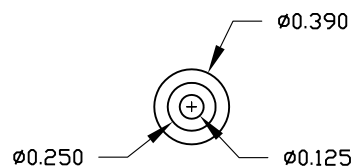
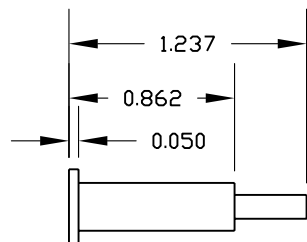
Ø0.062x0.968
C'BORE Ø0.136x0.500
C'BORE Ø0.250x0.125
2 PLACES

011-1 OIL PUMP BODY
7075-T6 AL

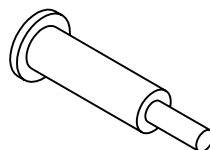


Ø0.136x0.300
C'BORE Ø0.250x0.062
2 PLACES

Ø0.062x0.250
C'BORE Ø0.125x0.125
C'BORE Ø0.250x0.062
2 PLACES



011-2 PLUNGER
416 SS



EDWARDS RADIAL 5

OIL PUMP

QTY REQ	MATERIAL	PART NO.	REV	SIZE
1	SEE NOTES	011	A02	A
SCALE 1 : 1	DRAWN BY: Robert Sigler	SHEET 26 OF 36		

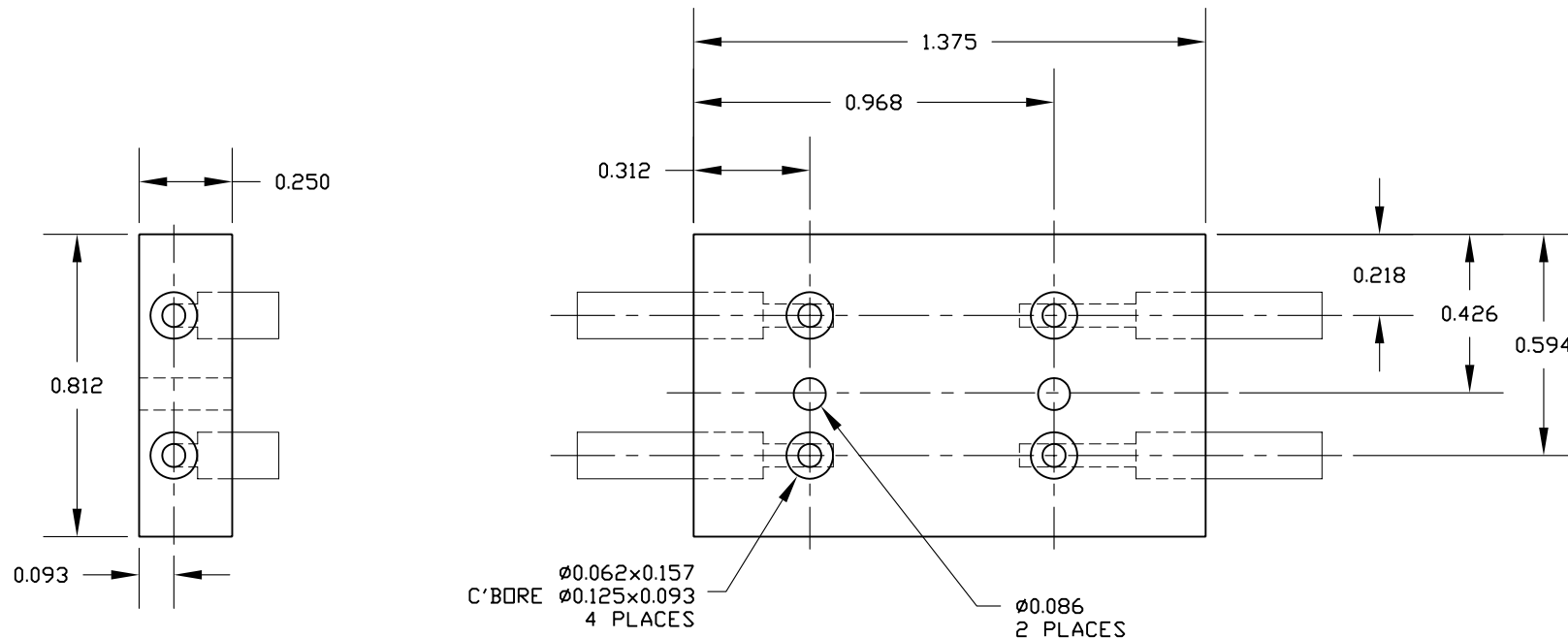
$\varnothing 0.062 \times 0.375$
 C'BORE $\varnothing 0.125 \times 0.187$
 PRESS FIT AND EPOXY
 $\varnothing 0.125 \times 0.5$ BRASS TUBE
 2 PLACES

$\varnothing 0.062 \times 0.500$
 C'BORE $\varnothing 0.125 \times 0.187$
 PRESS FIT AND EPOXY
 $\varnothing 0.125 \times 0.5$ BRASS TUBE
 2 PLACES

$\varnothing 0.062 \times 0.157$
 C'BORE $\varnothing 0.125 \times 0.093$
 PRESS FIT AND EPOXY
 $\varnothing 0.125 \times 0.219$ BRASS TUBE
 4 PLACES

$\varnothing 0.062 \times 0.157$
 C'BORE $\varnothing 0.125 \times 0.093$
 4 PLACES

$\varnothing 0.086$
 2 PLACES

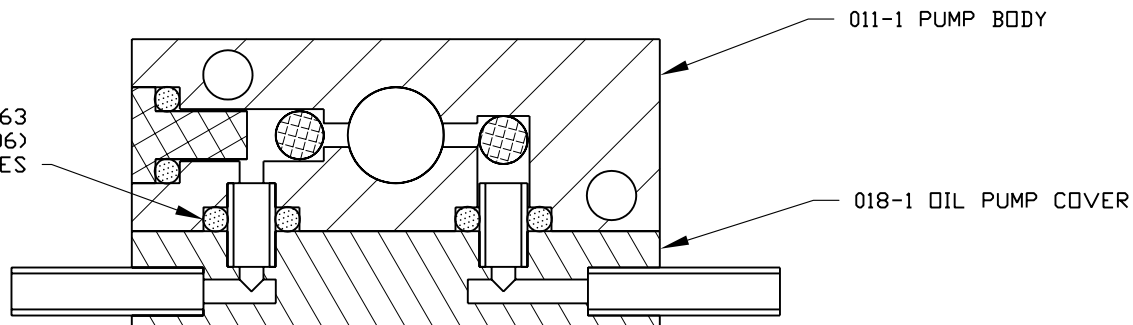


EDWARDS RADIAL 5

OIL PUMP COVER

QTY REQ	MATERIAL	PART NO.	REV	SIZE
1	7075-T6 AL	018-1	A00	A
SCALE 2 : 1	DRAWN BY: Robert Sigler	SHEET	27	OF 36

O-RING $\varnothing 0.125 \times \varnothing 0.250 \times \varnothing 0.063$
(STD SIZE #006)
6 PLACES



JOIN OIL PUMP COVER TO THE PUMP BODY
WITH 2 2-56x0.375 CAP SCREWS

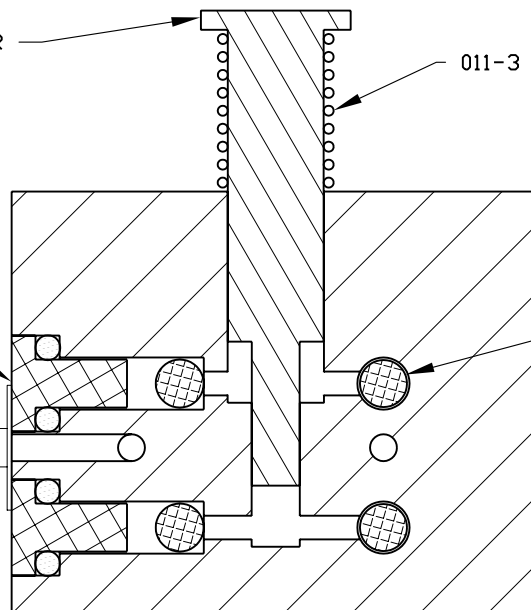
011-2 PLUNGER

011-3 PLUNGER SPRING

011-4 PLUG
2 PLACES

$\varnothing 0.125$ SS BALL BEARING
4 PLACES

2-56x0.25 CAP SCREW
& WASHER

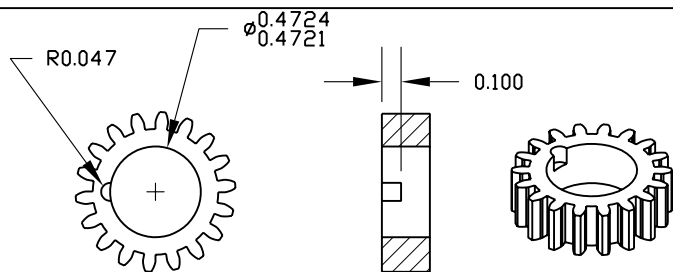


NOTE: IT MAY BE NECESSARY TO ADD WEAK SPRINGS BEHIND EACH OF
THE 4 CHECK BALLS TO PREVENT THEM FROM STICKING AND/OR TO
IMPROVE PUMP PERFORMANCE.

EDWARDS RADIAL 5

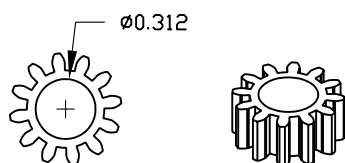
OIL PUMP ASSY

QTY REQ	MATERIAL	PART NO.	REV	SIZE
1			A01	A
SCALE	1 : 1	DRAWN BY: Robert Sigler	SHEET	28 OF 36



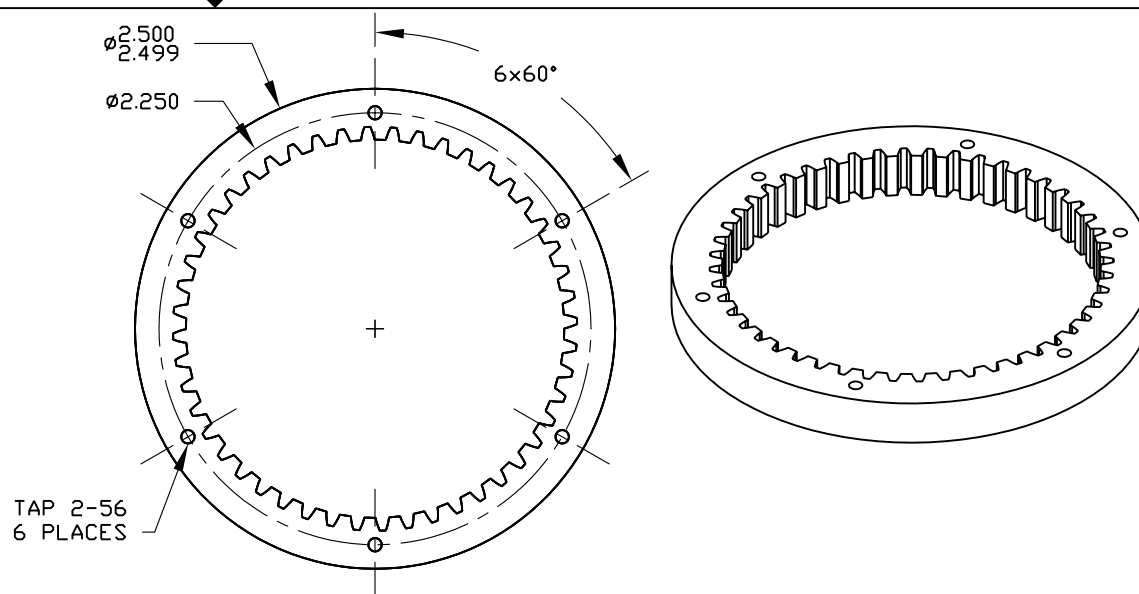
012-1 PINION GEAR

BOSTON GEAR #S2418
24 PITCH, 14.5° PA, 0.25 FACE, 18T,
STEEL, Ø0.750 PD



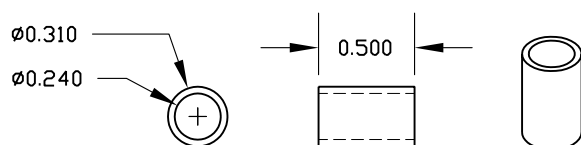
012-2 IDLER GEAR

BOSTON GEAR #S2412
24 PITCH, 14.5° PA, 0.25 FACE, 12T,
STEEL, Ø0.500 PD

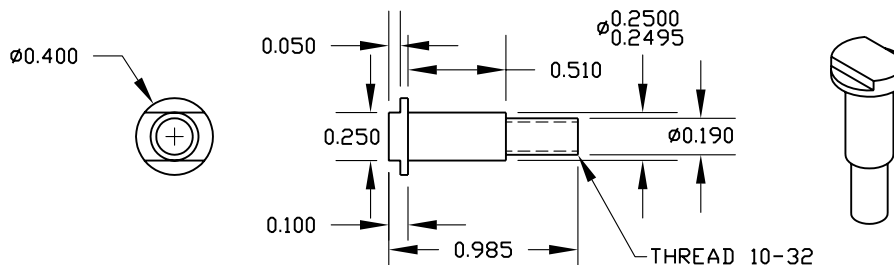


012-3 CAM GEAR

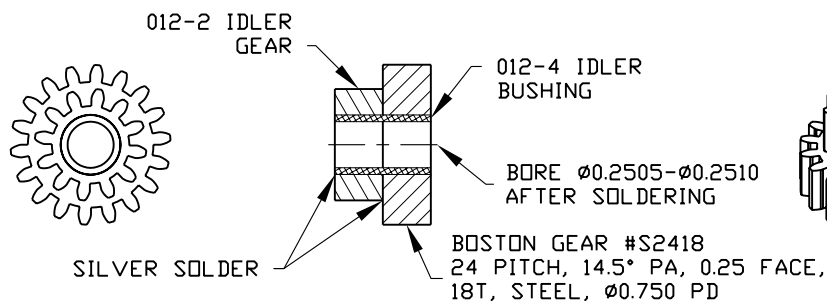
BOSTON GEAR #G677
24 PITCH, 14.5° PA, 0.25 FACE, 48T,
BRASS, Ø2.000 PD



012-4 IDLER BUSHING
PHOSPHOR BRONZE



012-6 IDLER SHAFT
416 SS

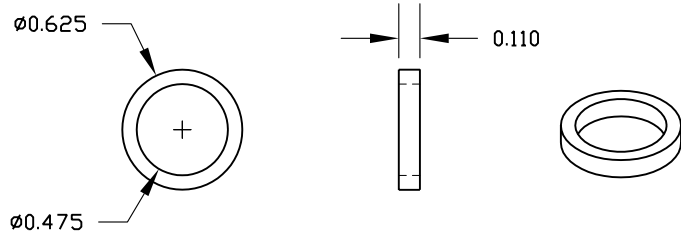


012-5 IDLER
ASSEMBLY

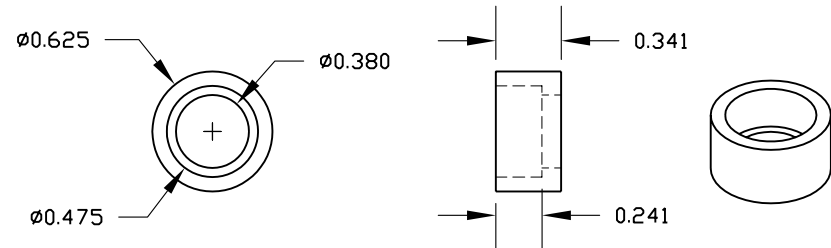
EDWARDS RADIAL 5

TIMING GEARS

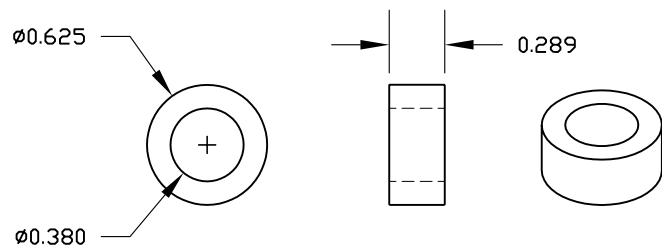
QTY REQ	MATERIAL	PART NO.	REV	SIZE
1 EA	SEE NOTES	012	A00	A
SCALE 1 : 1	DRAWN BY: Robert Sigler	SHEET	29 OF 36	



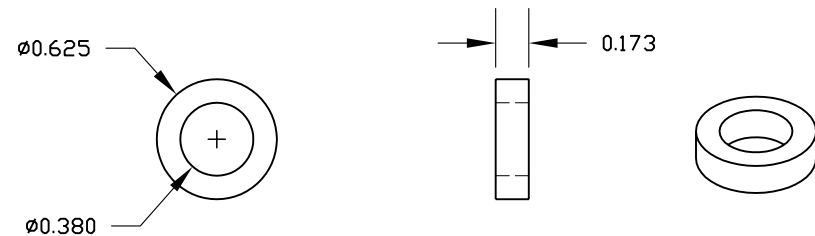
013-1 GEAR SPACER



013-2 CAM SPACER



013-3 CAM BEARING SPACER



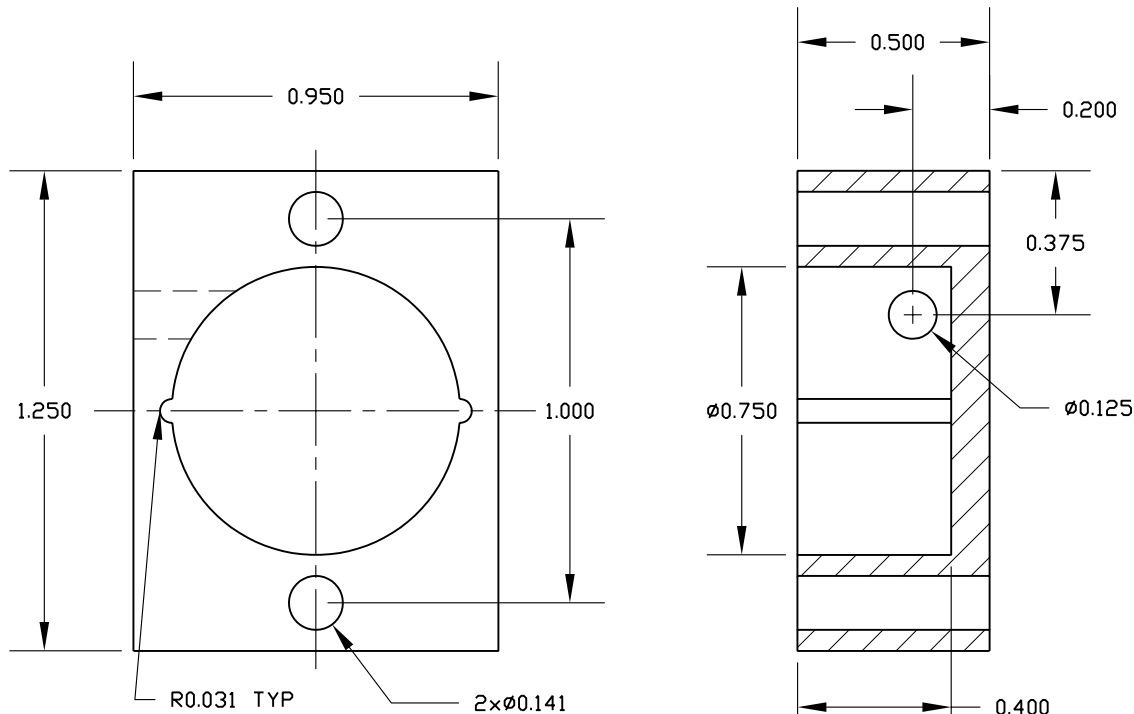
013-4 BEARING SPACER

NOTE: SPACER LENGTHS MAY REQUIRE SOME ADJUSTMENT.

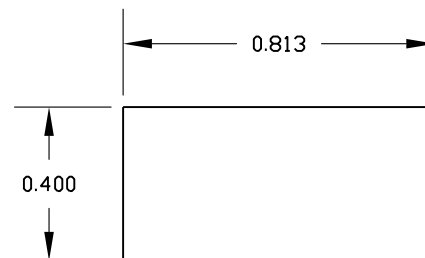
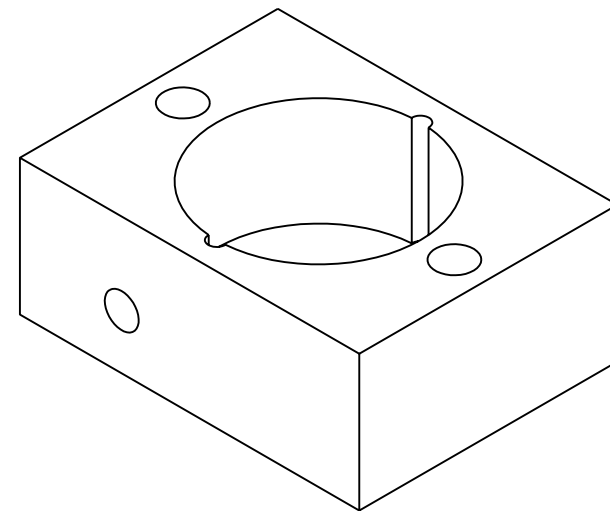
EDWARDS RADIAL 5

SPACERS

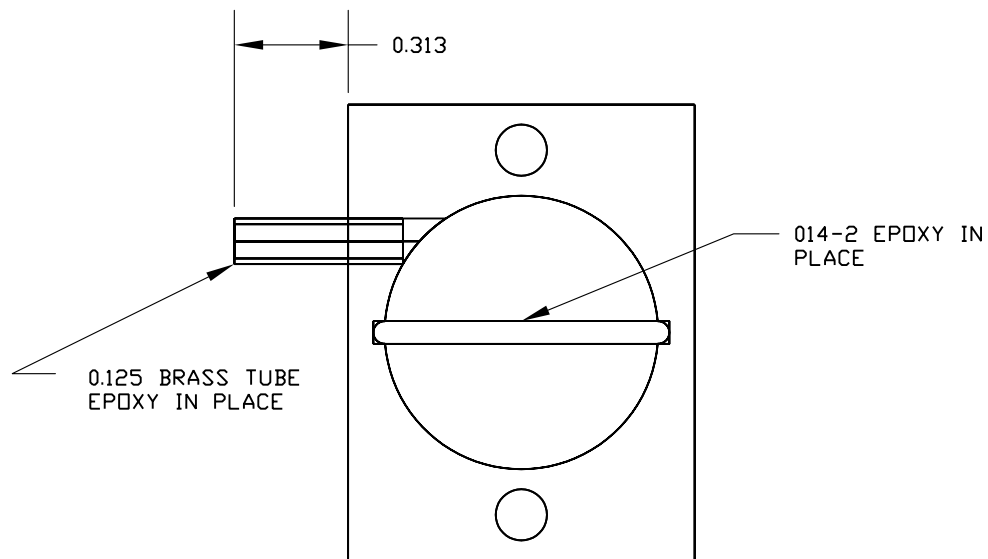
QTY REQ	MATERIAL	PART NO.	REV	SIZE
1 EA	STEEL	013	A00	A
SCALE 1 : 1	DRAWN BY: Robert Sigler	SHEET	30 OF 36	



014-1 OIL SUMP BODY



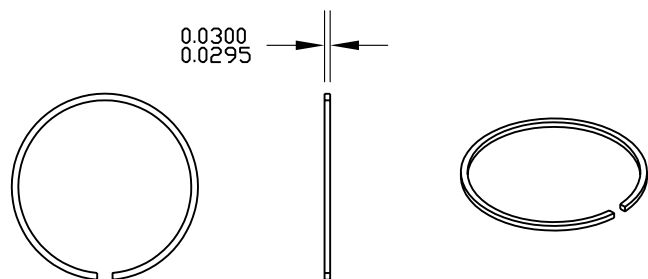
014-2 OIL SCREEN
#100 MESH BRASS SCREEN



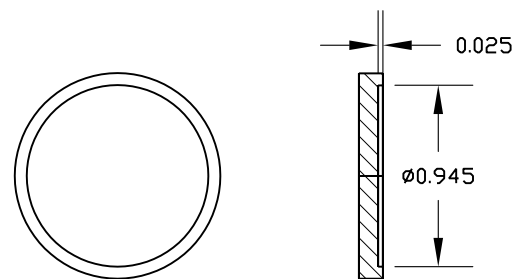
EDWARDS RADIAL 5

OIL SUMP ASSEMBLY

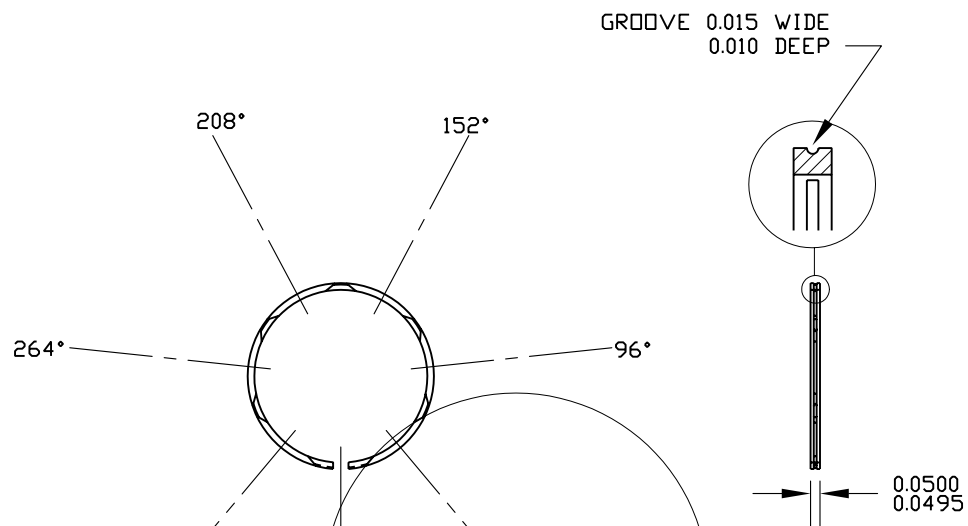
QTY REQ	MATERIAL	PART NO.	REV	SIZE
1	7075-T6 AL	014	A00	A
SCALE 2 : 1	DRAWN BY: Robert Sigler	SHEET	31	OF 36



015-1 COMPRESSION RING
10 REQUIRED



PARTING CAP
7075-T6 AL
1 REQUIRED



015-2 OIL RING
5 REQUIRED

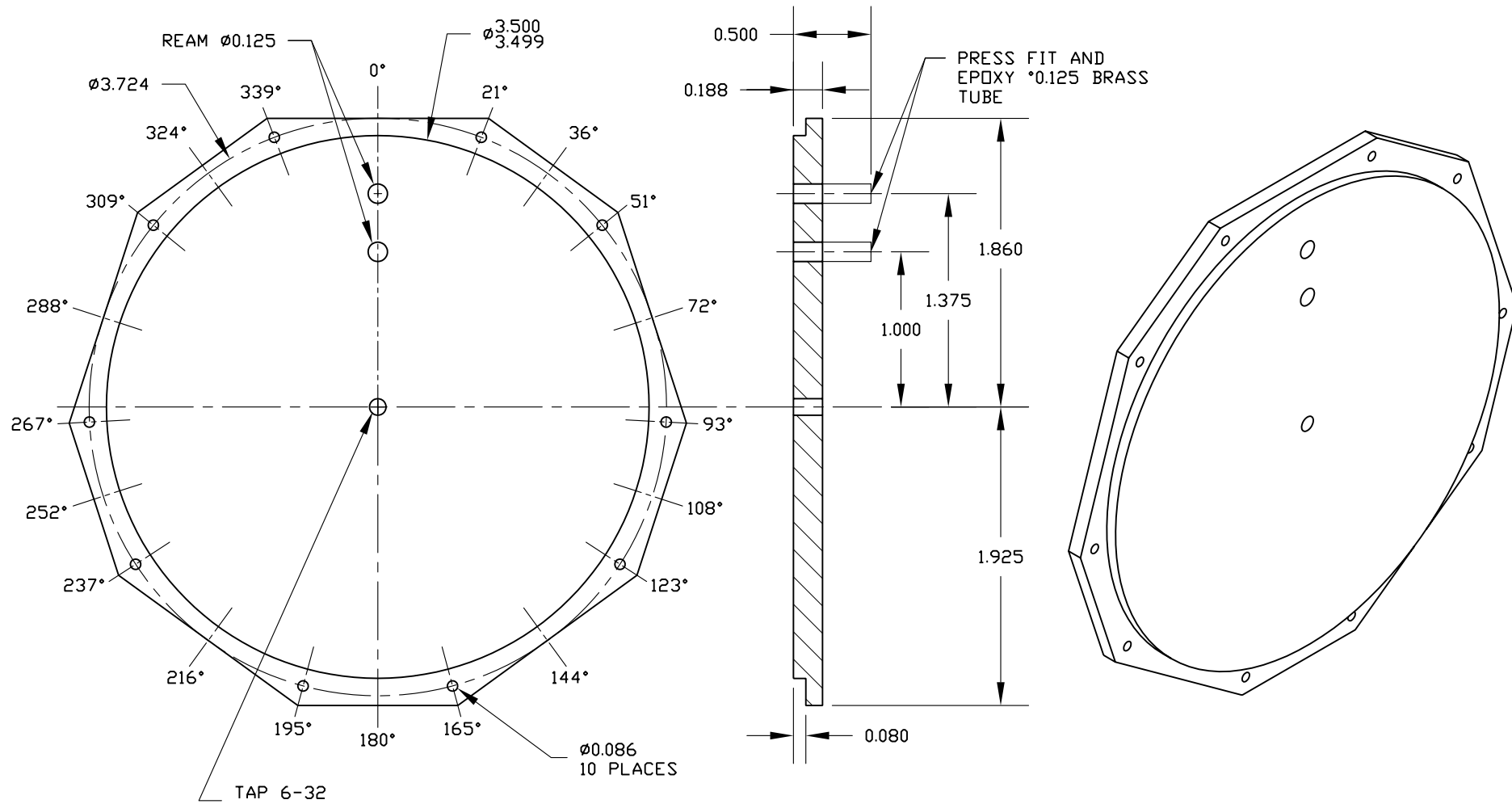
RING MANUFACTURING NOTES:

1. TURN A TUBE 2.5 IN. LONG X 1.0 IN OD, 0.875 ID.
2. MILL A 0.080 SLOT FULL LENGTH.
3. CLAMP IN LATHE CHUCK WITH APPROX. 1 IN EXTENDED.
4. TIGHTEN UNTIL SLOT IS CLOSED.
5. BORE 0.875.
6. TURN AND FINISH GRIND OD TO 0.944.
7. PUSH PARTING CAP ON END OF TUBE.
8. PART OFF THE RING.

EDWARDS RADIAL 5

PISTON RINGS

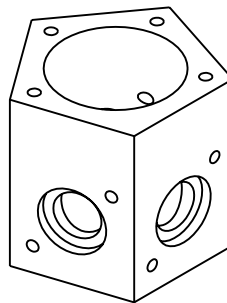
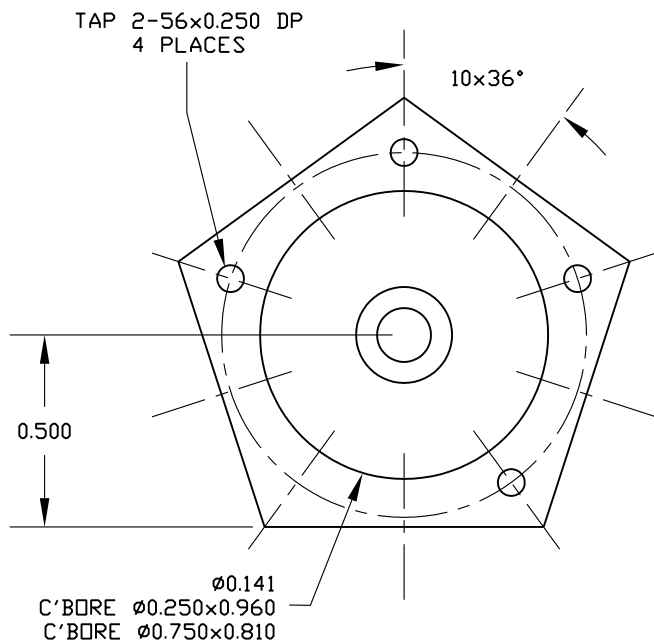
QTY REQ	MATERIAL	PART NO.	REV	SIZE
	CAST IRON	015	A00	A
SCALE 1 : 1	DRAWN BY: Robert Sigler		SHEET 32 OF 36	



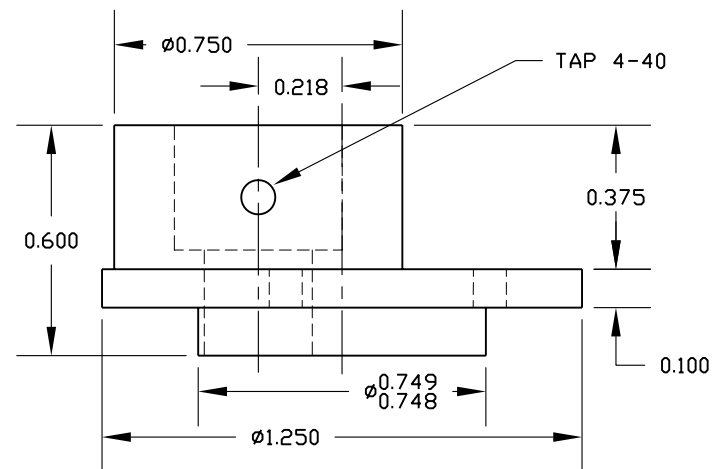
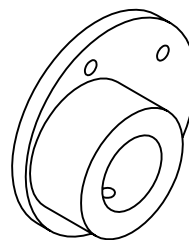
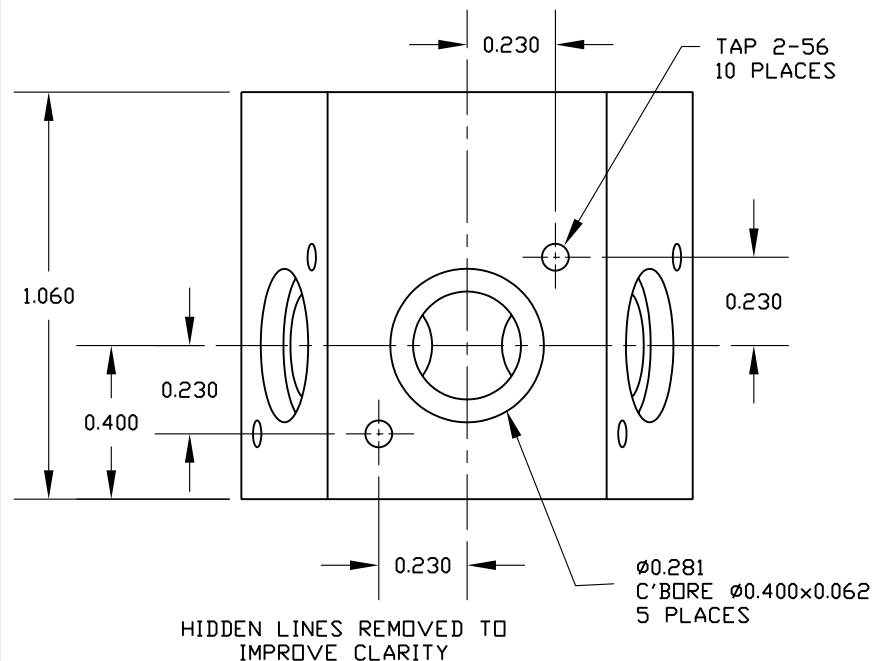
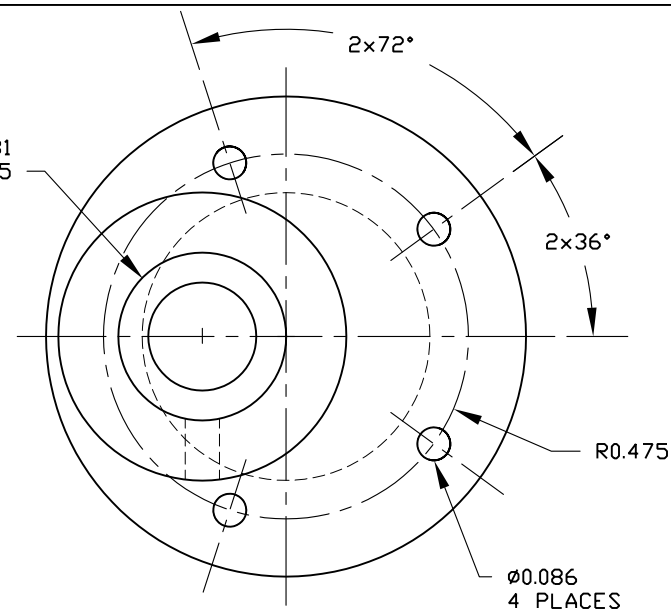
EDWARDS RADIAL 5

REAR COVER

QTY REQ	MATERIAL	PART NO.	REV	SIZE
1	7075-T6 AL	016	A00	A
SCALE 1 : 1	DRAWN BY: Robert Sigler		SHEET 33 OF 36	



Ø0.281
C'BORE Ø0.437x0.325



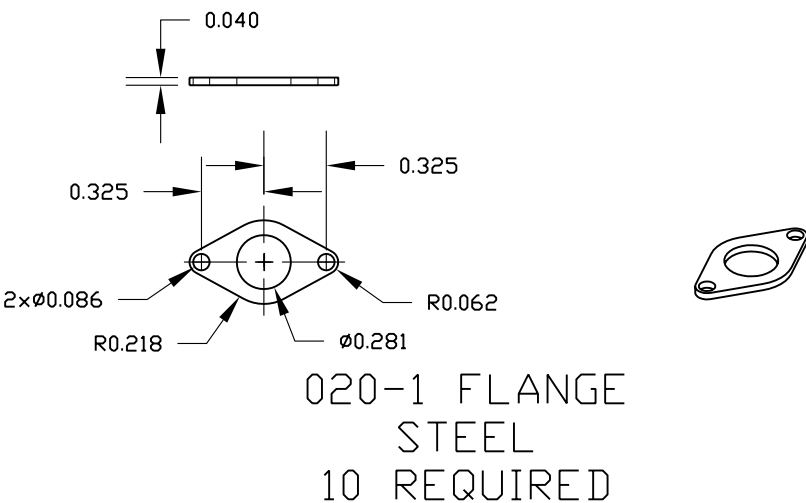
017-2 MANIFOLD COVER

017-1 MANIFOLD

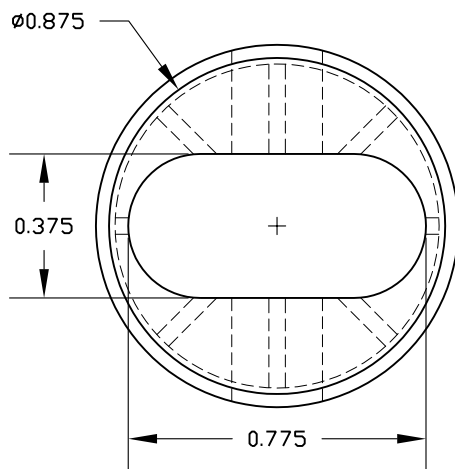
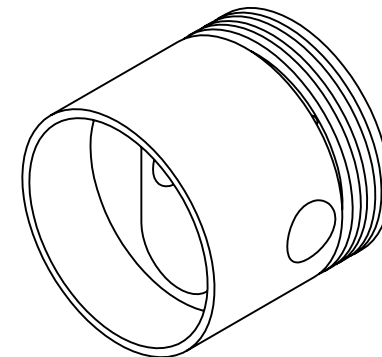
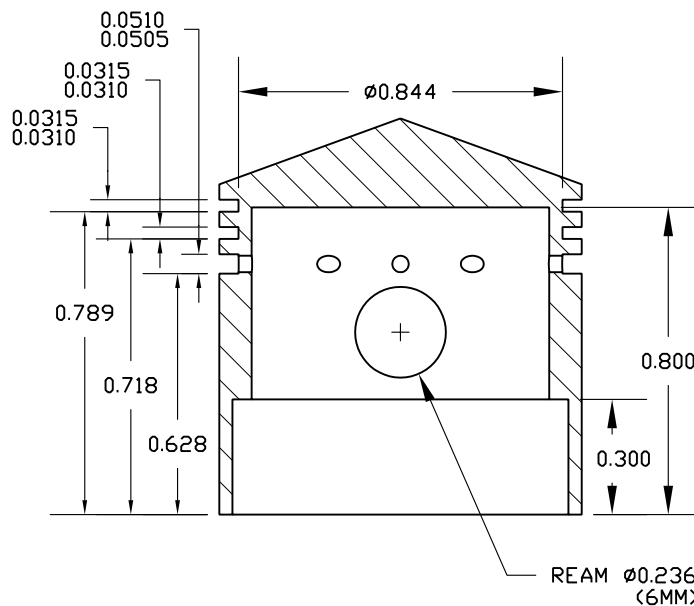
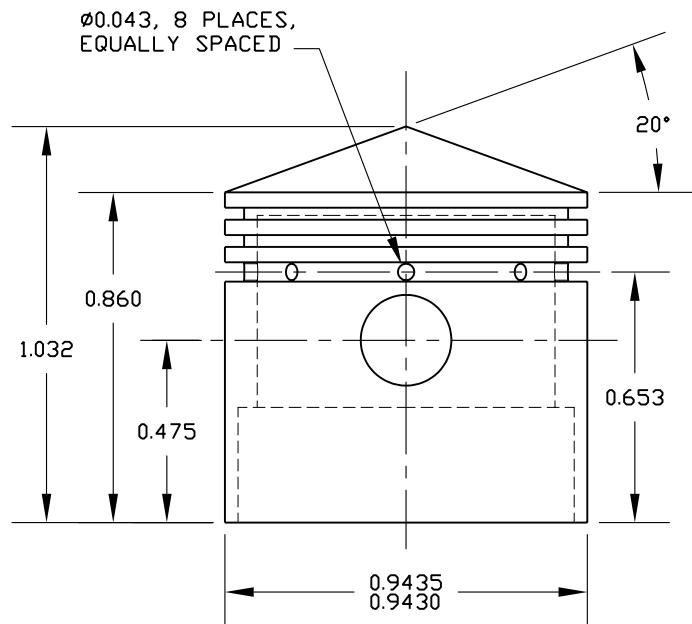
EDWARDS RADIAL 5

MANIFOLD

QTY REQ	MATERIAL	PART NO.	REV	SIZE
1 EA	7075-T6 AL	017	A01	A
SCALE 2 : 1	DRAWN BY: Robert Sigler	SHEET	34 OF 36	



EDWARDS RADIAL 5				
INTAKE TUBE				
QTY REQ	MATERIAL	PART NO.	REV	SIZE
	SEE NOTES	020	A00	A
SCALE	1 : 1	DRAWN BY: Robert Sigler	SHEET	35 OF 36



EDWARDS RADIAL 5

PISTON

QTY REQ	MATERIAL	PART NO.	REV	SIZE
5	2024-T351 AL	021	A00	A
SCALE 2 : 1	DRAWN BY: Robert Sigler	SHEET 36 OF 36		