

PARTS LIST

ITEM	QTY	PART NUMBER	DESCRIPTION	MASS	MATERIAL
1	4	333 BS 290 - SKF 618/6	Single row ball bearings	0,002 kg	Steel, Mild
2	1	333 BS 290 - SKF 625	Single row ball bearings	0,005 kg	Steel, Mild
3	6	2727-R3-PushRod	Push rod (spring steel)	0,002 kg	Steel, Galvanized
4	6	2727-R3-PushRodTube	Push rod tube	2,495 g	Aluminum 6061
5	3	2727-R3_CamInlet	Inlet cam	0,004 kg	Steel, Carbon
6	3	2727-R3_CamOutlet	Outlet Cam	0,004 kg	Steel, Carbon
7	1	2727-R3_CamShaft	Cam shaft	0,031 kg	Steel, High Strength Low Alloy
8	1	2727-R3_GearWheel24x0.7	Gear wheel 24, m0,7	0,013 kg	Brass, Soft Yellow
9	1	2727-R3_GearWheel27x0.7	Gear wheel 27, m0.7	0,006 kg	Brass, Soft Yellow
10	1	2727-R3_GearWheel_shaft	Gear Wheel bolt	0,002 kg	Brass, Soft Yellow
11	2	2727-R3_Pinion12x0.7	Pinion 12, m0,7	0,008 kg	Steel
12	6	2727-R3_Tappet	Cam follower	0,002 kg	Steel, High Strength Low Alloy
13	8	ANSI B18.3.6M - M3x0,5 x 4	Broached Hexagon Socket Set Screw - Flat Point	0,000 kg	Steel, Mild
15	18	o-ring 6x1.5		0,000 kg	Rubber

	Date	Name	
Drawn	22.06.2014	W.Trötscher	
Checked	24.03.2015	wt	
Standard	24.03.2015	wt - as build	
State	Changes	Date	Name

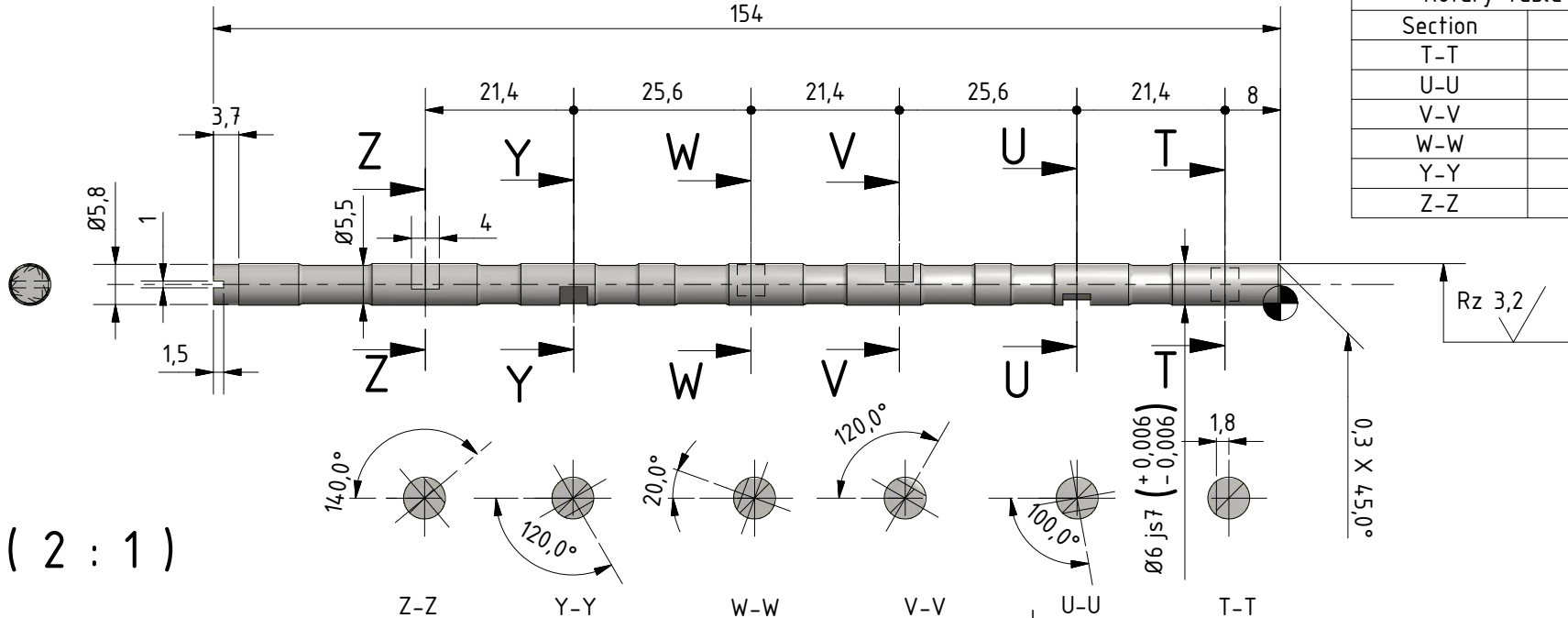
3 CYLINDER INLINE ENGINE
WTINLINE 2727-R3

2727-R3_Assembly-Cam

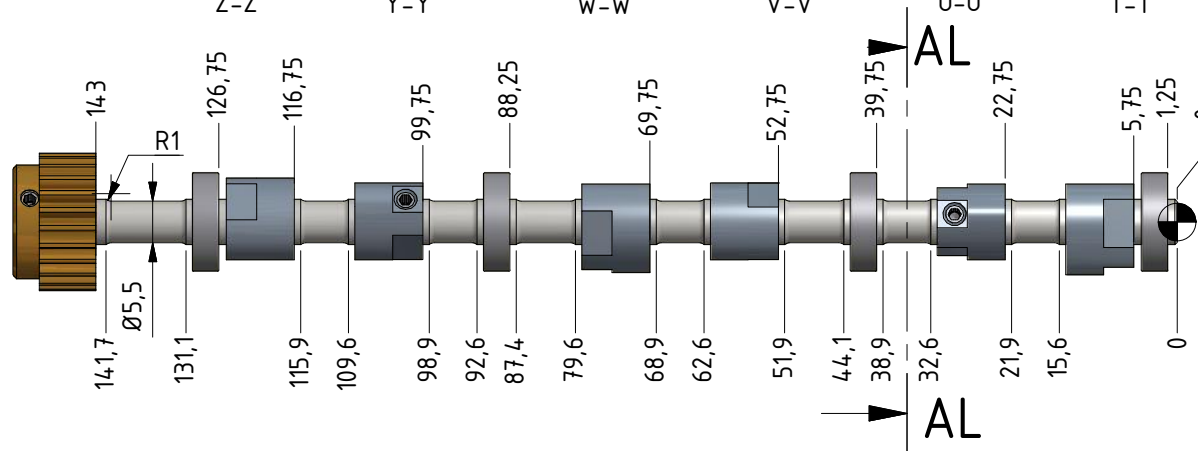
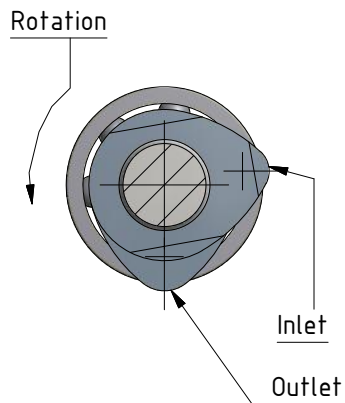
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Rotary Table Angle	
Section	Angle
T-T	0
U-U	260 (100)
V-V	120 (240)
W-W	20 (340)
Y-Y	240 (120)
Z-Z	140 (220)



AL-AL (2 : 1)



Remember bearing blocks when assembling

State	Changes	Date	Name

	Date	Name
Drawn	22.06.2014	W.Trötscher
Checked	24.03.2015	wt
Standard	24.03.2015	wt - as build

M 1 : 1

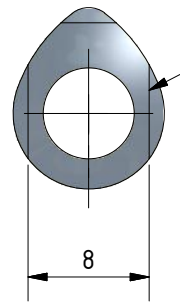
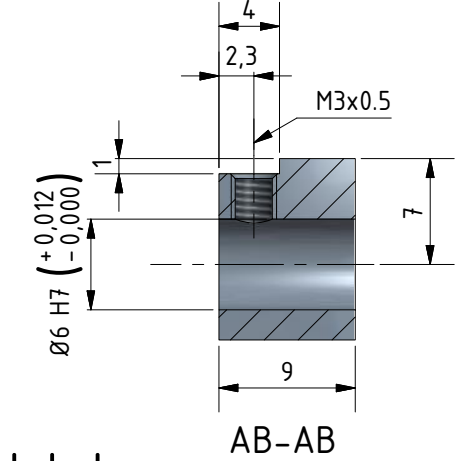
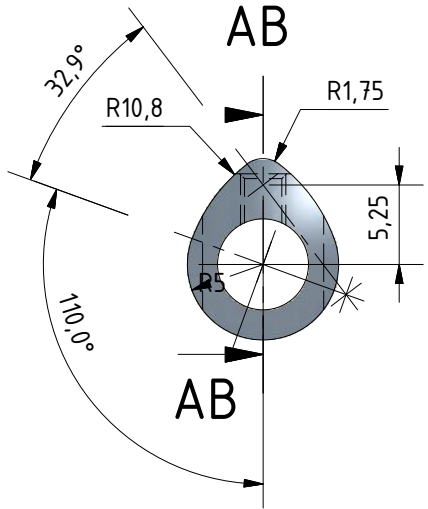
2727-R3_CamShaft

3 CYLINDER INLINE ENGINE
WT INLINE 2727-R3

Cam shaft

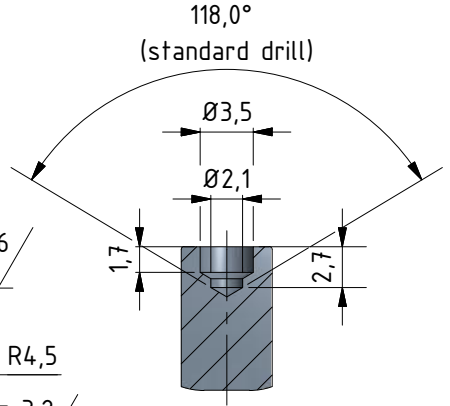
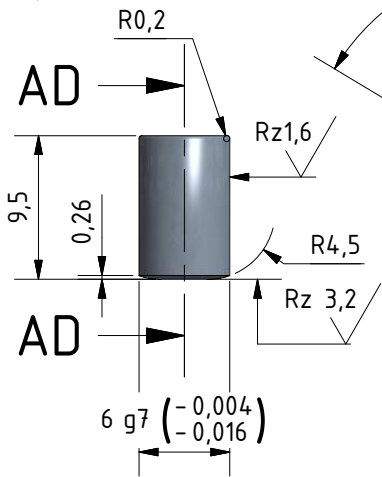
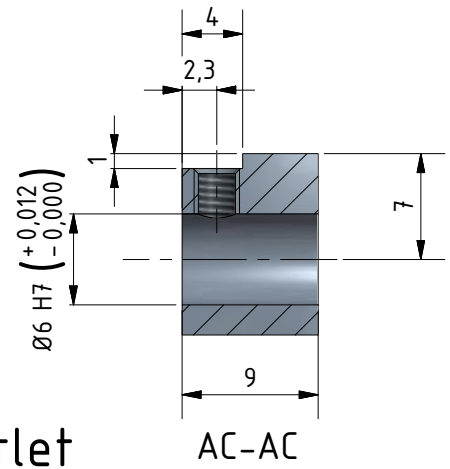
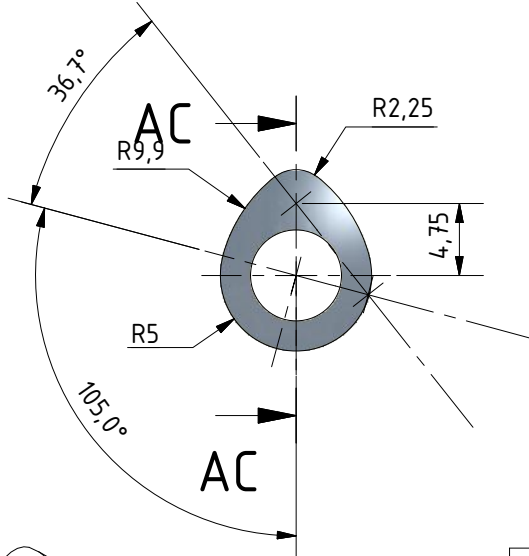
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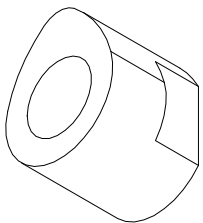
Faces for easy alignment (on all cams)

Inlet



AD-AD

Outlet



State	Changes	Date	Name

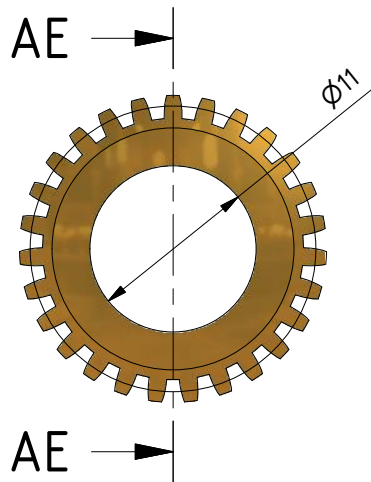
Date	Name
Drawn 22.06.2014	W.Trötscher
Checked 24.03.2015	wt
Standard 24.03.2015	wt - as build

M 2 : 1
2727-R3_CamInlet

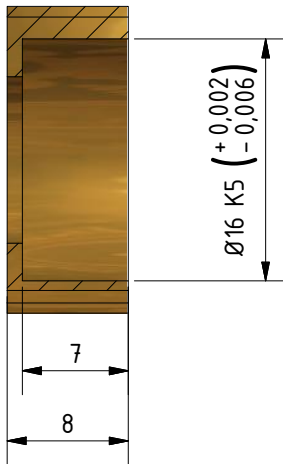
3 CYLINDER INLINE ENGINE
WTINLINE 2727-R3

Inlet cam

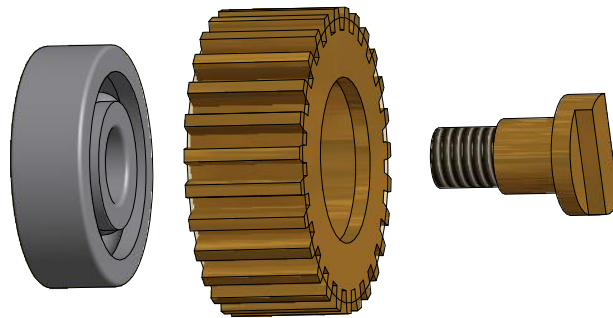
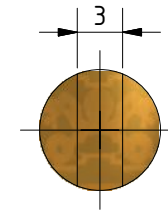
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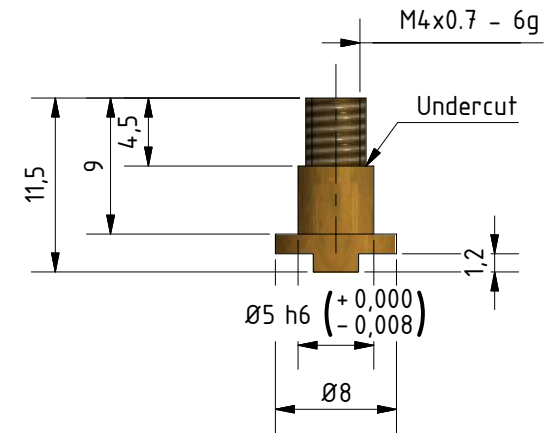
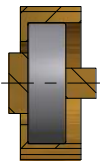
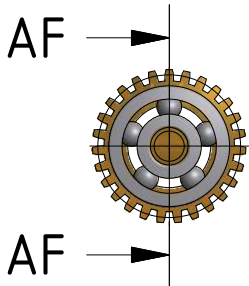
AE-AE



Gear 27 Data	
Property	Data
Number of teeth	27
Module	metric 0,7
Pitch diameter	Ø18,9 mm
Outer diameter	Ø20,3 mm
Milling depth	1,5162 mm
Cutter#	5
Index disc	15 holes
Index table (4 deg / turn)	3 turn / 5 holes
Pitch angle	13 deg 20'



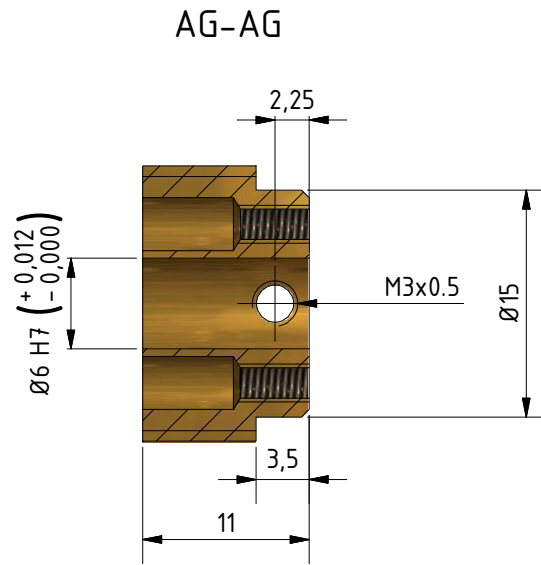
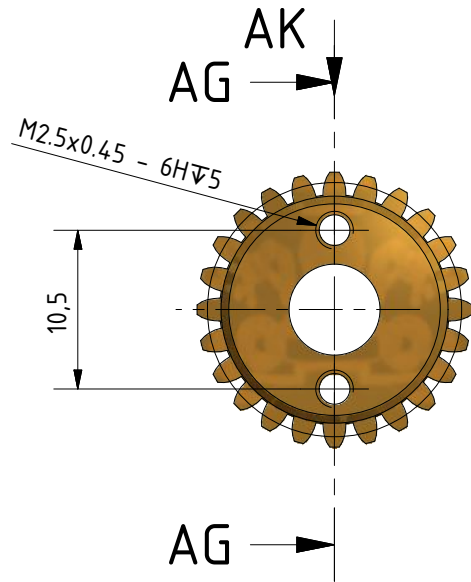
AF-AF



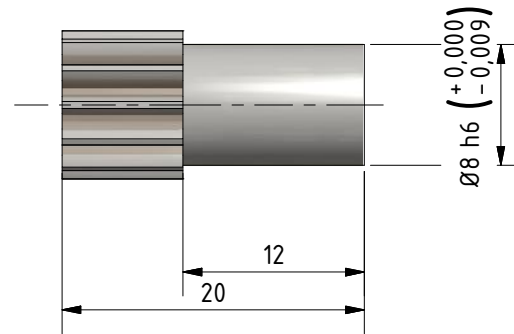
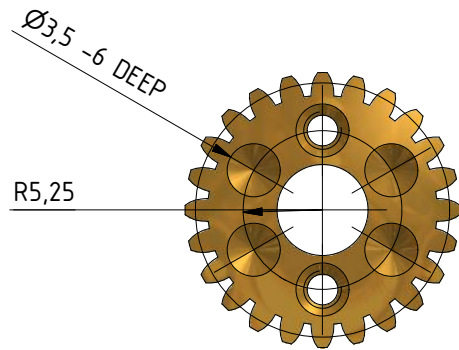
	Date	Name
Drawn	22.06.2014	W.Trötscher
Checked	24.03.2015	wt
Standard	24.03.2015	wt - as build
M 2 : 1		
2727-R3_GearWheel		
State	Changes	Date Name

**3 CYLINDER INLINE ENGINE
WTINLINE 2727-R3**

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Gear 24 Data	
Property	Data
Number of teeth	24
Module	metric 0,7
Pitch diameter	Ø16,8 mm
Outer diameter	Ø18,2 mm
Milling depth	1,5162 mm
Cutter#	4
Index disc	16 holes
Index table (4 deg / turn)	3 turn / 12 holes
Pitch angle	15 deg



Gear 12 Data	
Property	Data
Number of teeth	12
Module	metric 0,7
Pitch diameter	Ø8,4 mm
Outer diameter	Ø9,8 mm
Milling depth	1,5162 mm
Cutter#	1
Index disc	16 holes
Index table (4 deg / turn)	7 turn / 8 holes
Pitch angle	30 deg

State	Changes	Date	Name

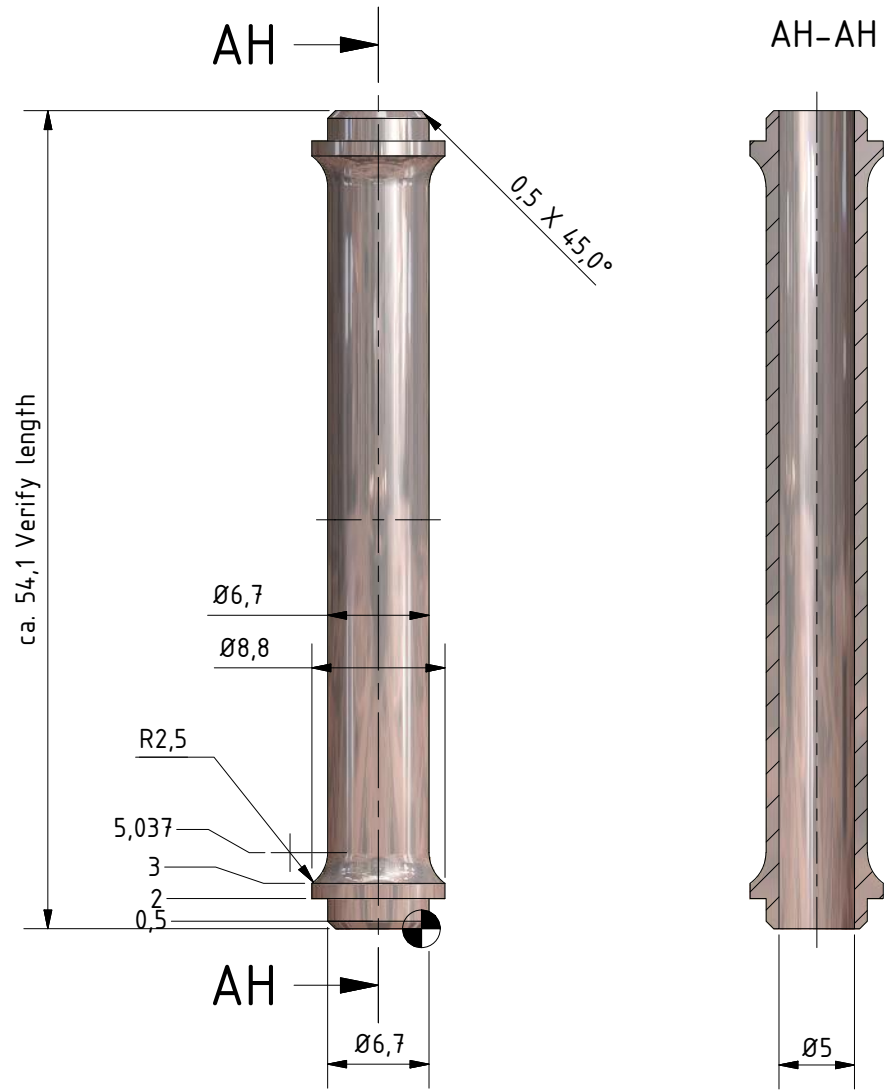
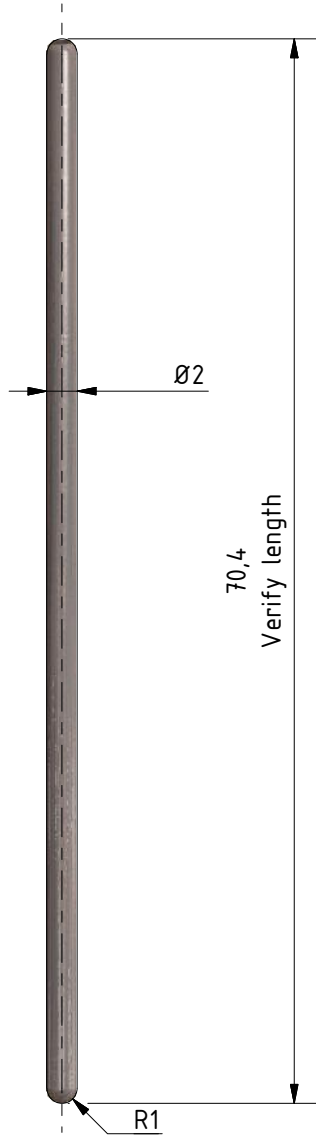
	Date	Name
Drawn	22.06.2014	W.Trötscher
Checked	24.03.2015	wt
Standard	24.03.2015	wt - as build
M 2 : 1		

**3 CYLINDER INLINE ENGINE
W TINLINE 2727-R3**

2727-R3_GearWheel24x0.7

Gear wheel 24, m0,7

5
A4



				Date	Name	3 CYLINDER INLINE ENGINE WTINLINE 2727-R3		
				Drawn	22.06.2014			W.Trötscher
				Checked	24.03.2015			wt
				Standard	24.03.2015			wt - as build
				M 2 : 1				
				2727-R3-PushRodTube		Push rod tube	6	
							A4	
State	Changes	Date	Name					