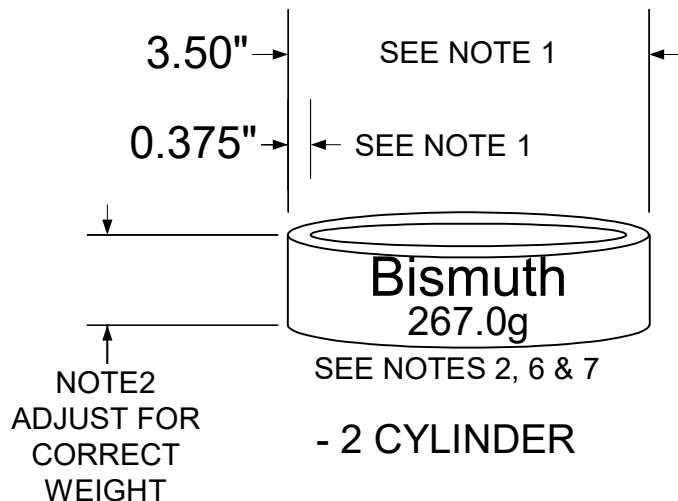


- 1 CYLINDER



- 2 CYLINDER



SEE NOTE 5

7. USE APPROX. 300GRAMS Bismuth metal Ingot chunk 99.99% pure OR SIMILAR. REF.: <https://www.ebay.com/str/hallmarkmetals>, SUGGEST MELT POT: <https://www.amazon.com/dp/B0BCNV3NL8> OR SIMILAR. LET BISMUTH COOL VERY SLOWLY IN THE MOLD.

6. MAKE MOLD OF -1 CYLINDER USING Mold Max 60 - High Heat Resistant Silicone Rubber Compound OR SIMILAR PRODUCT. POUR 1/8TH INCH BASE 5 INCH DIA. WITH 2" CENTER HOLE. AFTER MOLD BASE IS SETUP, PLACE GRAPHITE IN CENTER AND MOLD 3/4 INCH DEEP AND 5 INCH DIA. WITH A TOTAL HEIGHT OF 3/4+1/8" REFERENCE PICTURE ON SHEET 3. ELSE USE CASTING SAND, TBD.

5. MAKE FROM "OTOOLWORLD 99.9% Pure Graphite Crucible", 5KG SIZE REF.: <https://www.amazon.com/dp/B07416C8S6> MACHINE CRUCIBLE LIP DOWN TO MATCH O.D. OF CRUCIBLE AND MACHINE HOLE IN BOTTOM TO I.D. OF CRUCIBLE. THEN MACHINE INTO 2 SHORT CYLINDERS OF EQUAL HEIGHT. IF O.D. OR I.D. ARE OUT OF ROUND, MACHINE UNTIL ROUND.

4. BEVEL EDGES 0.025 INCHES OR LESS TO ASSIST IN FINE TUNING MATCHING WEIGHTS BUT DO NOT BEVEL MORE THAN 0.025 INCHES.

3. MACHINE TOP AND BOTTOM SURFACES FLAT EXCEPT FOR NOTE 4 BEVEL. MACHINE BISMUTH SLOW AND COOL WITH SHARP TOOL.

2. TARGET WEIGHT IS 267.0GRAMS BUT ALL GRAPHITE AND BISMUTH CYLINDERS CAN BE SLIGHTLY LESS IF NECESSARY IN ORDER TO MAKE ALL PIECES MATCH WEIGHT EXACTLY USING A SCALE THAT READS TENTHS OF GRAMS. ONLY THE HEIGHT OF EACH PIECE CAN CHANGE TO REMOVE WEIGHT.

NOTES: 1. ALL O.D.s MUST MATCH WITHIN +/- 0.005 INCHES AND ALL I.D.s MUST MATCH WITHIN +/- 0.005 INCHES AMONG ALL CYLINDERS. THE TARGET O.D. AND I.D. WAS 3.50 INCHES AND 2.750" INCHES BUT BOTH CAN CHANGE AS REQ. SO O.D. AND I.D. OF ALL GRAPHITE AND BISMUTH CYLINDERS MATCH. ONLY HEIGHTS CAN VARY TO MAKE ALL CYLINDER WEIGHTS MATCH PER NOTE 2.

REVISIONS:

A. SH 2, CENTER HOLE M3
B. ALL MATING PARTS
MUST BE SAME OD & ID
EVEN IF CAN'T KEEP
DIMENSIONS SHOWN.
SEE SH 3 FOR MORE REV.



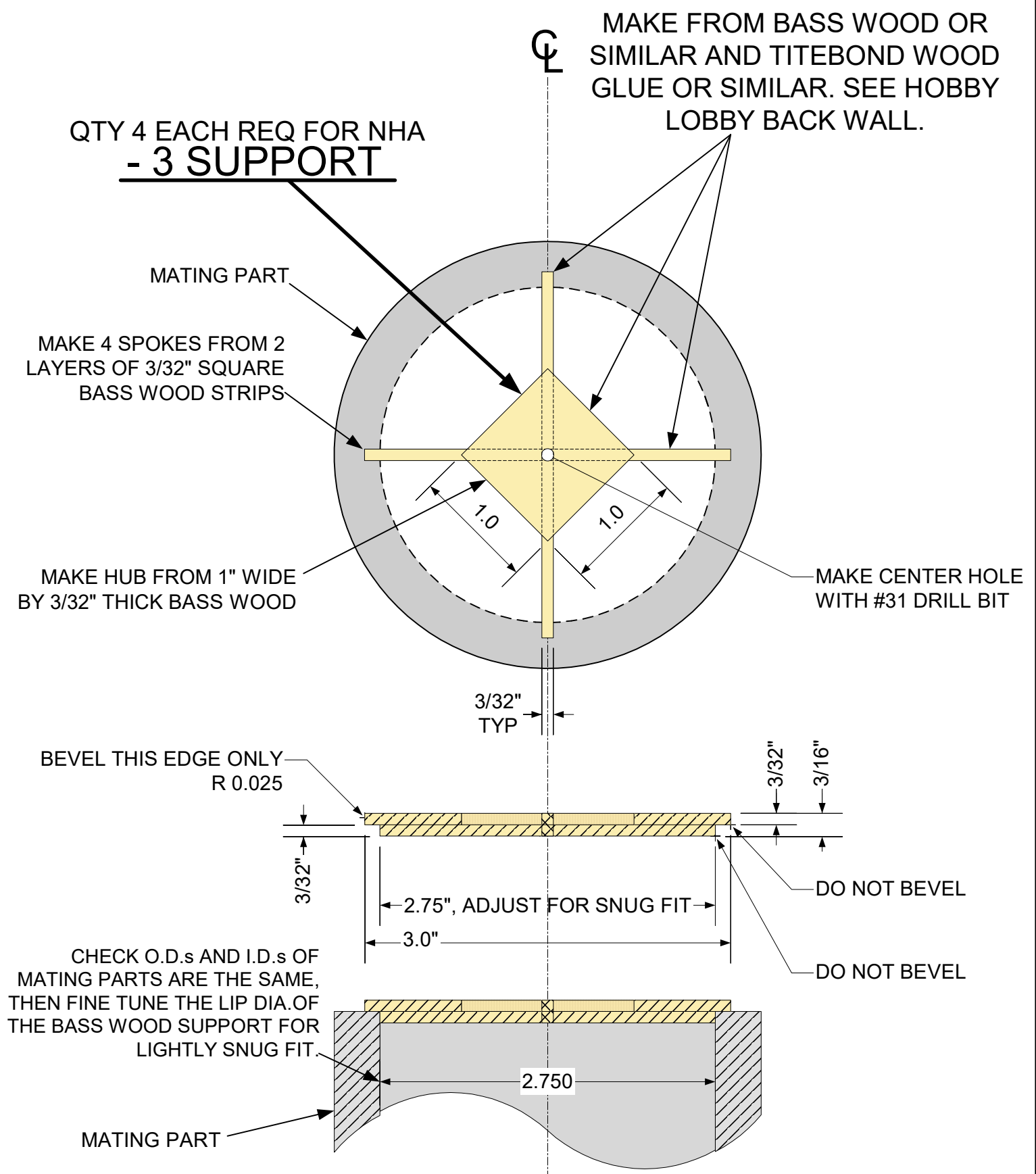
REV. C

SHEET 1 OF 3

**DWG. TITLE: MASS TEST CYLINDERS
AND SUPPORTS**

DESIGN: GEORGE BUGH

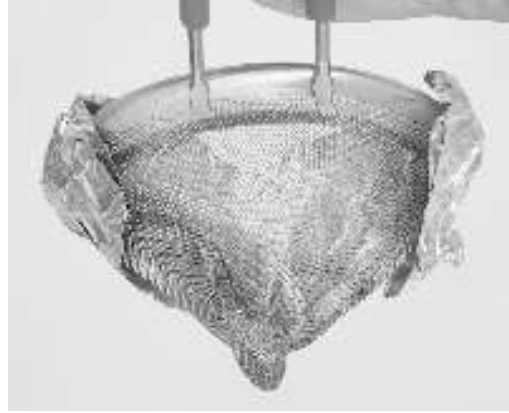
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REV. C	DESIGN: GEORGE BUGH
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REVISIONS:

C. SH2, CHANGED -3
SUPPORTS FROM
CARBONFIBER TO BASS
WOOD.



REV. C

SHEET 3 OF 3

**DWG. TITLE: MASS TEST CYLINDERS
AND SUPPORTS**

DESIGN: GEORGE BUGH

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