

50 Caliber BMG Dual Mount – 3D Model Instructions

This instruction covers a series of 3D models for the 50 caliber BMG dual mount guns found on WWII PT boats as well as some other boats and ships.

Basic Instructions

All 3D models have parts mounted on sprues that require the buyer to trim off and cement parts together. Parts may be detached from the sprue(s) prior to cleaning. In some instances they may be cleaned on the sprues for easier handling. There are two materials that these parts are printed in. You may have one or the other or both. They are: Ultra Frosted Detail Plastic; White, Strong, and Flexible Plastic.

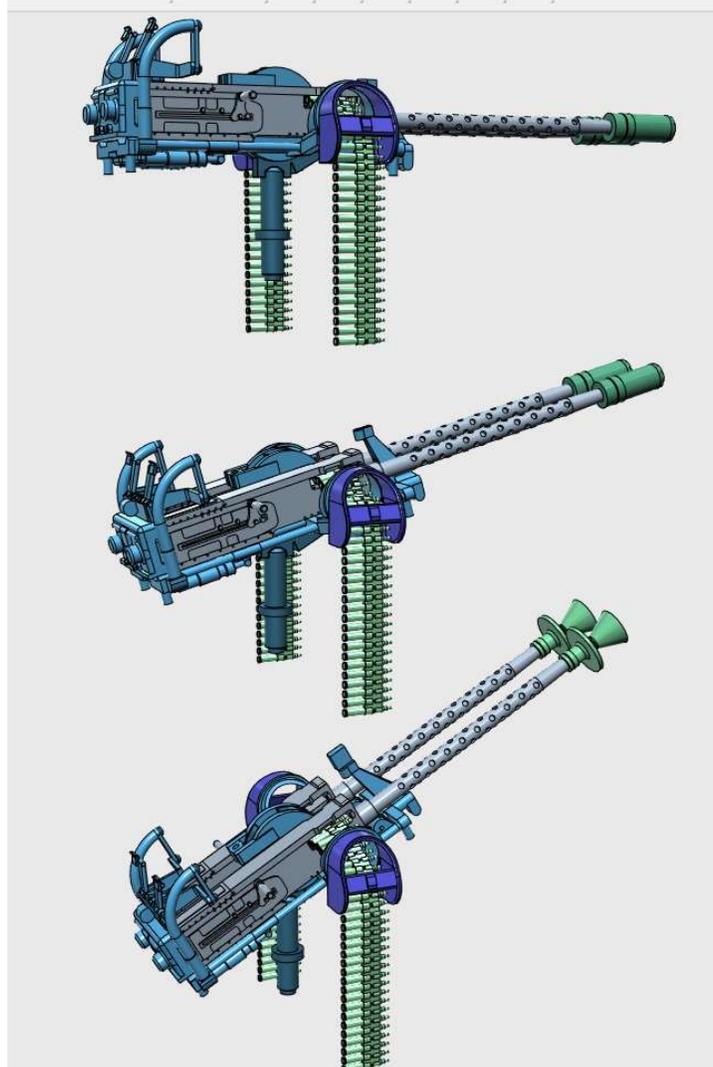
Prior to cleaning, you may wish to put the assembly in the sun for a few hours to make sure it is UV cured.

You should clean the assembly or parts. I use diluted Simple Green to remove any traces of the printing process. Rinse the assembly. (Harsh chemicals may cause damage to the pieces.) Check Shapeways' web site for more information on the materials. When you order the parts you will see the material listed.

Cut off all parts from the sprues. I recommend to sand with new 200 grit oxide or finer sandpaper. Be careful not to sand off any small details found on many of the pieces. The Frosted Plastic is brittle but sands easy. The Strong and Flexible is much tougher (and not as good for printing details) to sand.

You can cement most parts with CA cement.

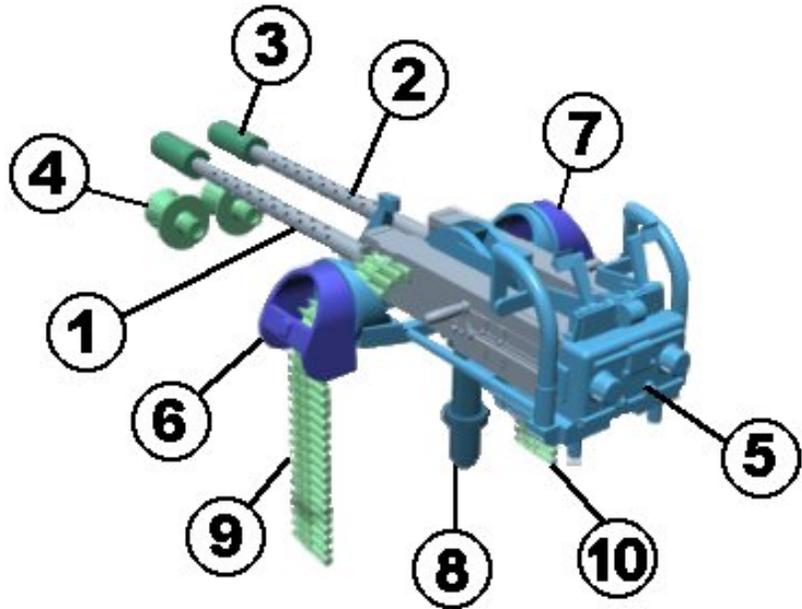
Paint the right color(s) for you model.



3D Model Parts Information

Assembly of the parts is easy and straight forward. Note that there are some left and right parts. (Left and right are as viewed from the shooters position.) Instructions on assembling the parts follows below.

Below is a list of the parts (you may not have some of them depending on what you ordered):



- 1 Left Gun
- 2 Right Gun
- 3 Straight Flash Hider (2 per gun mount)
- 4 Cone Flash Hider (2 per gun mount)
- 5 Mount
- 6 Left Ammo Belt Guide Ring
- 7 Right Ammo Belt Guide Ring
- 8 Yoke
- 9 Left Ammo Belt (Horizontal Elevation Position)
- 10 Right Ammo Belt (horizontal Elevation Position)
- 11 Left Ammo Belt (15° Elevated Position) (not shown)
- 12 Right Ammo Belt (15° Elevated Position) (not shown)
- 13 Left Ammo Belt (30° Elevated Position) (not shown)
- 14 Right Ammo Belt (30° Elevated Position) (not shown)

3D Model Parts Assembly

Flash Hiders (suppressors)

Select which flash hiders you want to use. Make sure the sprue element is removed from the barrel end (should mate to the barrel). Cement in place use CA cement. Make sure both pieces are in alignment.

Guns & Mount

The yoke should fit into the mount from the underside. There should be a slight “snap” to hold it into place.

Select which elevation you you want to use.
(See photo at the top of the front page.)
Mount the left and right guns to the mount temporarily. Feed the ammo belts by routing them through the round openings in the mount guide then slide the Guide ring up from the bottom (straight) end of the ammo belt into the mount guide opening. When everything is fitted, the parts should be cemented in place. The gun will be at a fixed elevation.

