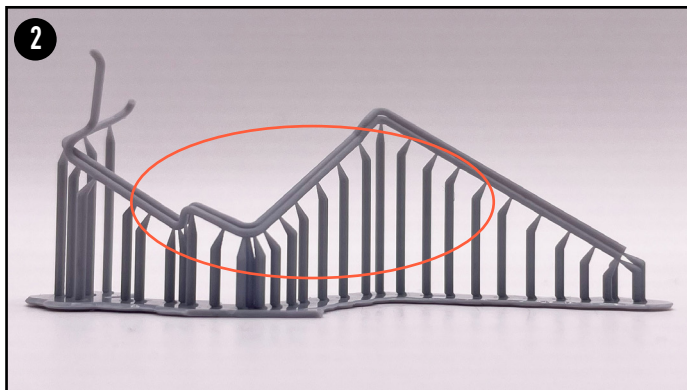
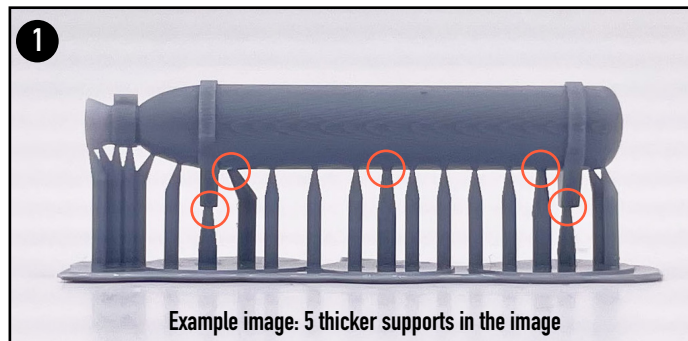


INSTRUCTIONS TO PORT SIDE DIESEL

A few tips for removing supports from parts:

- Use side cutters or a SHARP knife
- When cutting the support, also support it with your finger on the other side
- First remove the parts from each other and then from the supports
- There is two sizes of supports. Remove the thick ones first. The smaller ones may even detach themselves after that. See picture 1
- In the thinnest pipes, I recommended to start removing the supports in the middle and proceed to the ends. But before that the thick ones. See picture 2.
- The set includes a few spare parts

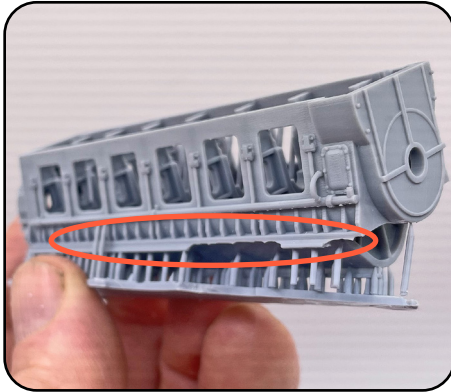


Modifications

- When you install the frame, you need to cut a place for the frame in the bulkhead.

If some parts look different in the instructions than the kit. You just received the updated part. The better one

SHEET 1 & 1B



BLOCK

NOTE: This is support. Remove it carefully. See red circle:

Also remove the motor stand from the supports. (Sheet 1b). This makes assembly much easier

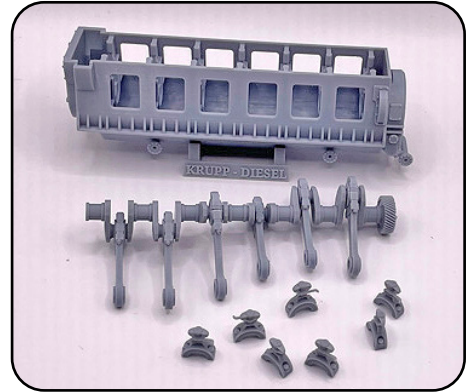


CRANKSHAFT

Carefully clean the bearing surfaces of the crankshaft from the supports so it's rotates smoothly

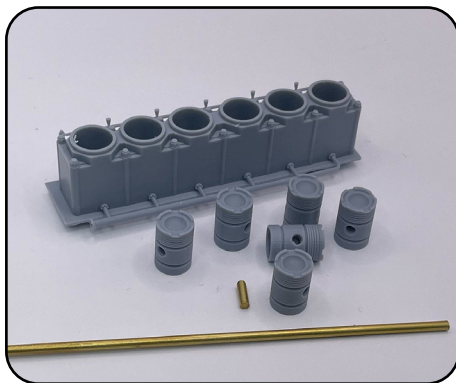
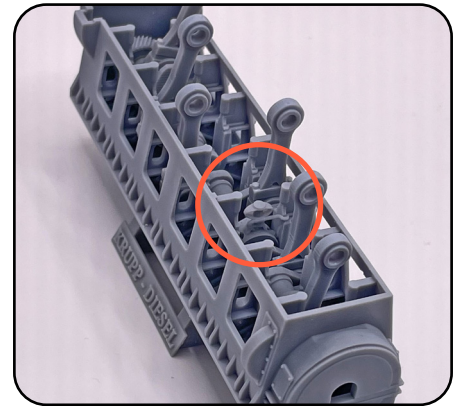
Glue the connecting rod parts together. Don't use glue to crankshaft.

Also glue the cogwheel to the crankshaft.



CRANKSHAFT BEARINGS

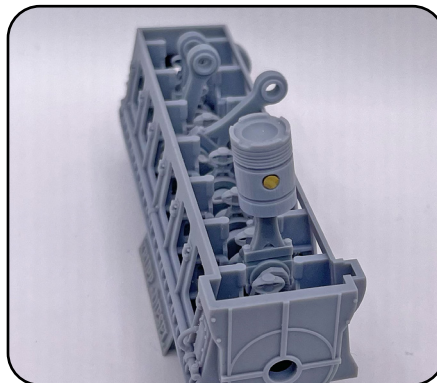
Again, don't glue crankshaft. Only bearings to block. Glue the bearings according to the pipeline. See the picture below



PISTONS AND SYLINDER TUBES

I used a brass tube to attach the pistons to the connecting rods. Size 2.06mm (0.81) No glue again!

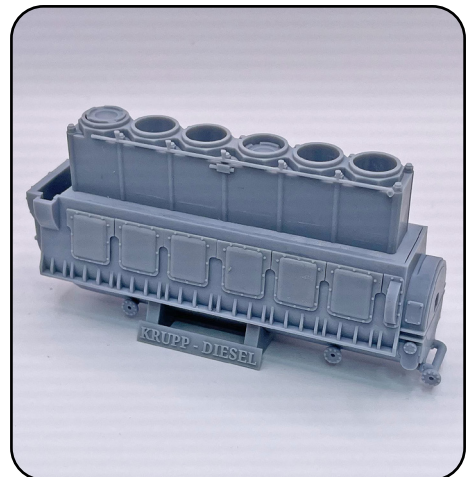
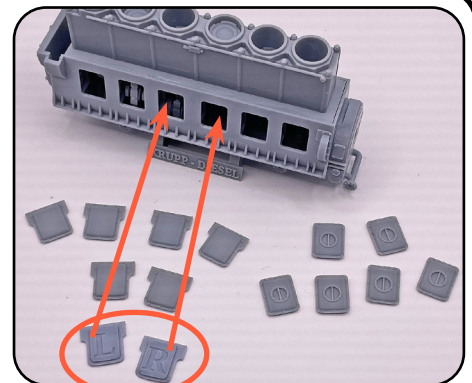
Finally, carefully glue the cylinder head in place. cylinder tubes only fit in one direction, so check the part and you will see



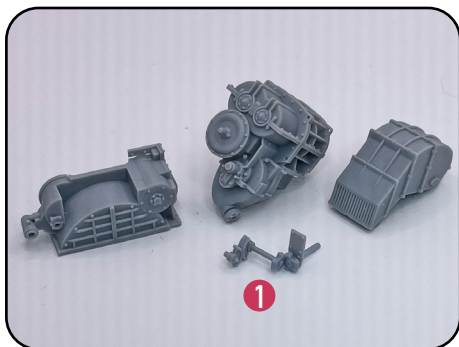
BLOCK COVERS

Install block covers that you want. You can leave some or all covers unmounted so you can see inside the engine. There are three different types of covers for the front part. See the picture how to install them.

All six covers on other side are the same. Three bolts are up and five down

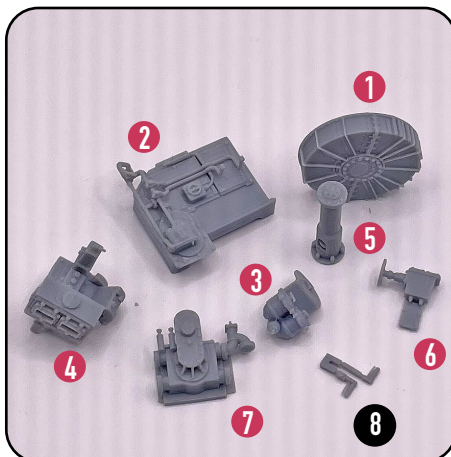


SHEET 2 & 3



SUPERCHARGER

Install the three largest parts together first and then the linkage (1)



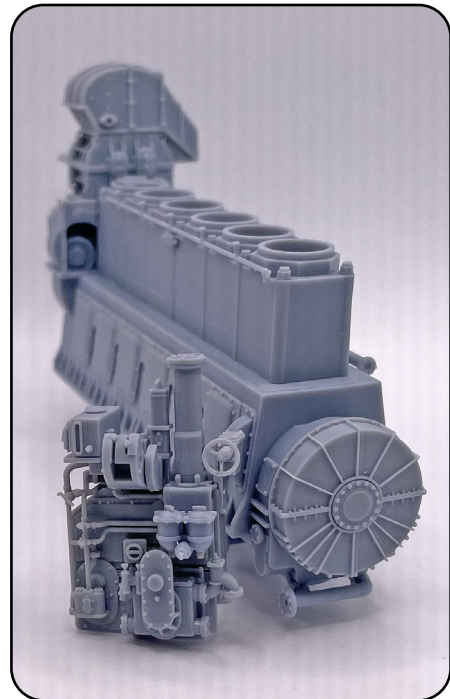
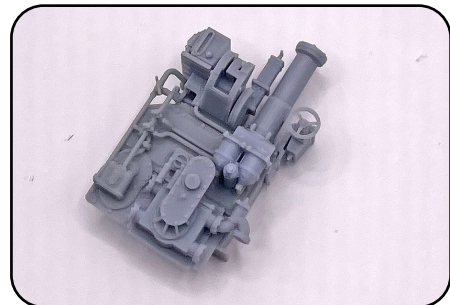
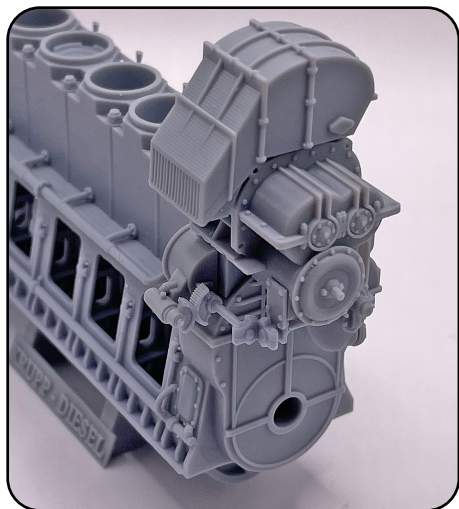
FRONT PANEL

Install first vibration damper (1) on block

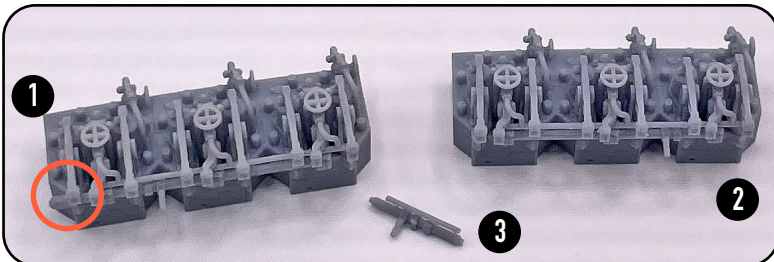
Take the front panel (2) and install the oil filter (3) on it

Install the rest parts in numerical order. The throttle linkage (8) is a quite sensitive part. You can also install it later when engine is completed.

Don't install front panel yet to block.
Build first part sheet 4

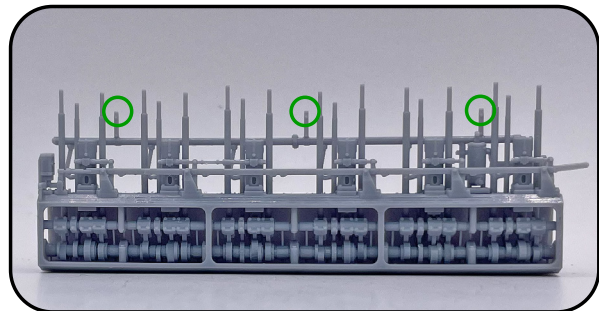


SHEET 4



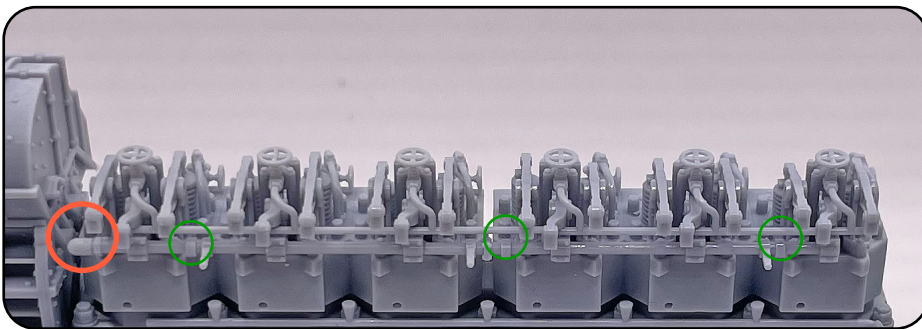
HEADS

install first head (1) to cylinder tubes (see red circle, that's you recognize head 1). Then install small pipeline (3) to head (2). After that install head (2) in place. See result below. After that install camshaft housing. See next instructions

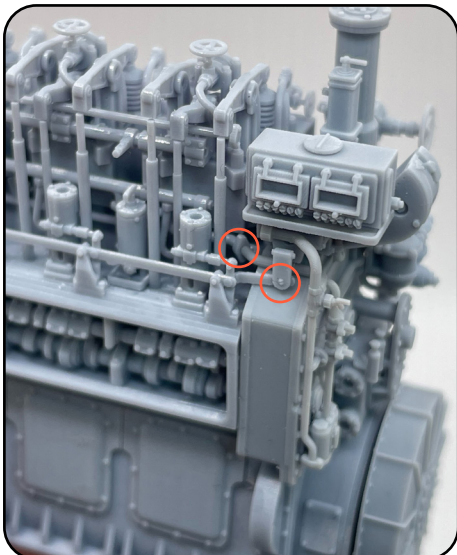


CAMSHAFT HOUSING

Carefully remove all supports, also from the inside of camshaft housing. Then glue it to the block. The pipe in the left picture has holes where the pipe clamps in the picture above are fit. Look at the green circles on both pics.

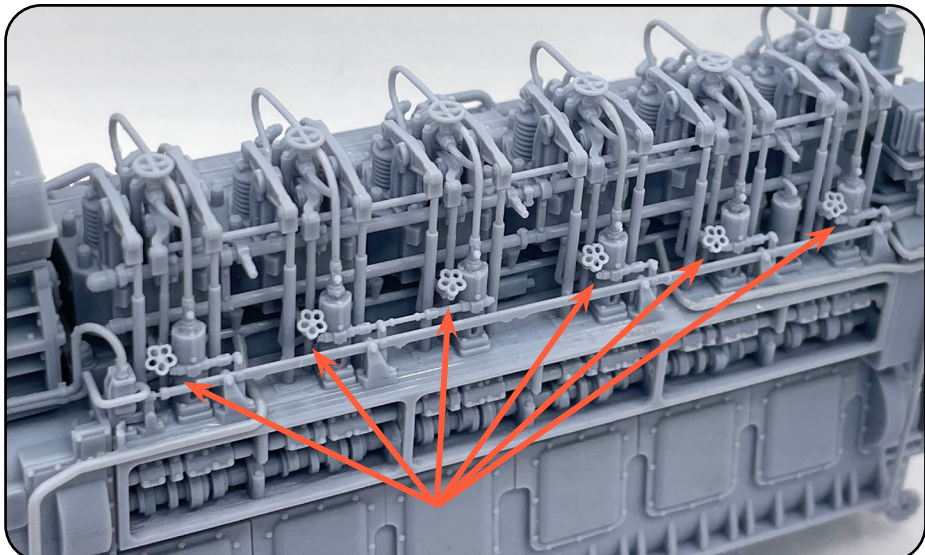


The set also includes three covers with the Krupp logo. I recommend a use knife for removing supports.



FRONT PANEL

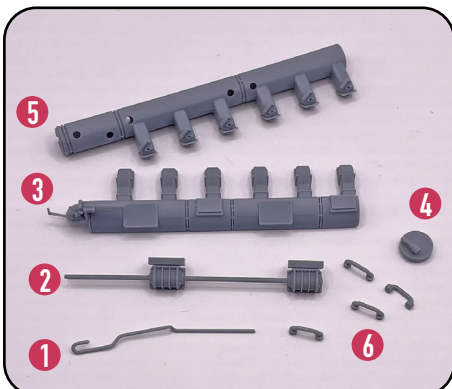
Instal Front panel.
Notice theese two red circles



VALVES

Insert valves.

SHEET 5

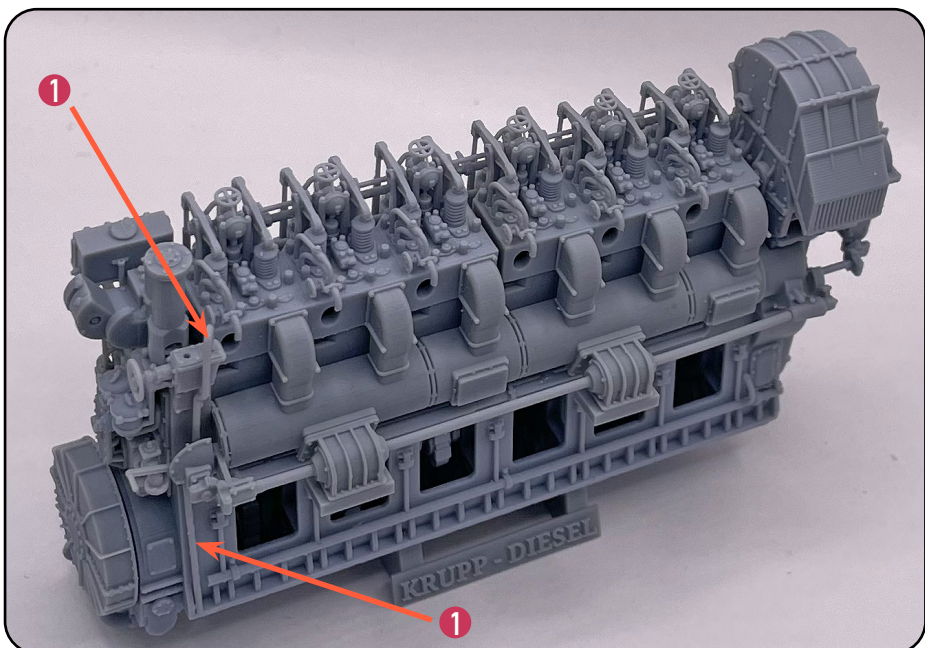


EXHAUST AND INTAKE

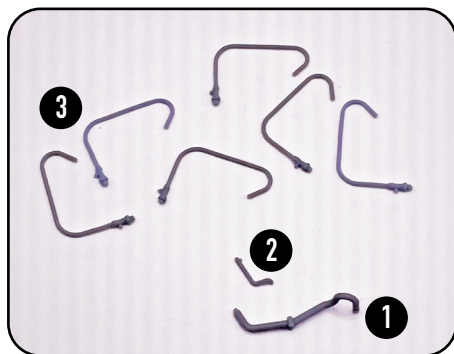
Instal first air pipe (1) to air start valve. See next picture and red arrow.

Glue the shaft where the air controls are attached (2) to the intake manifold.(3) See also next picture

Glue the end of the exhaust manifold (4) to the exhaust manifold (5). And finally, small pipes (6) for the exhaust manifold (4 pcs.)



SHEET 6

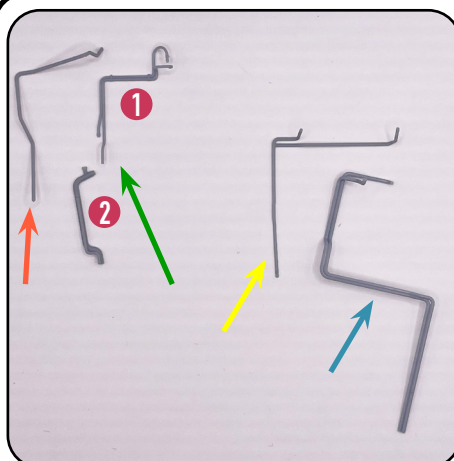
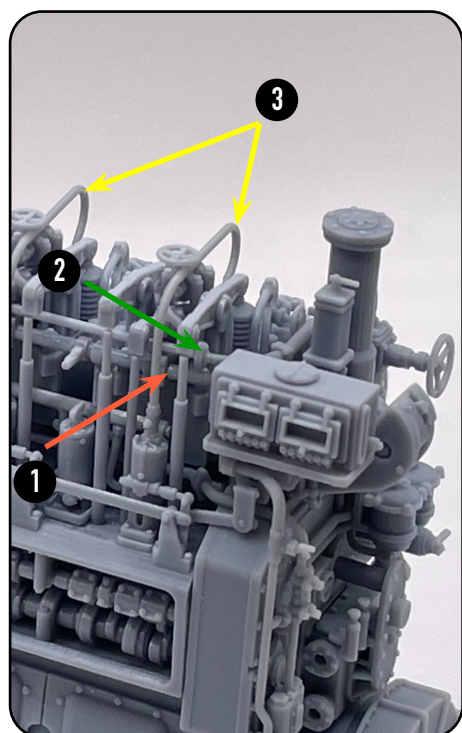
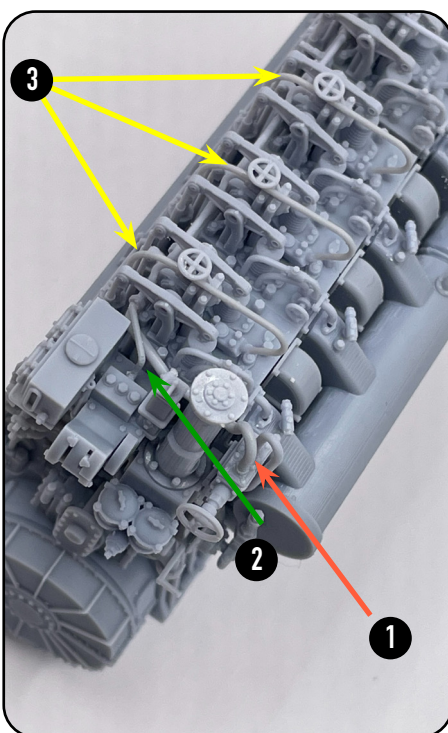


PIPES

NOTE: the set contains extra pieces of thinner tubes, in case you accidentally break some.

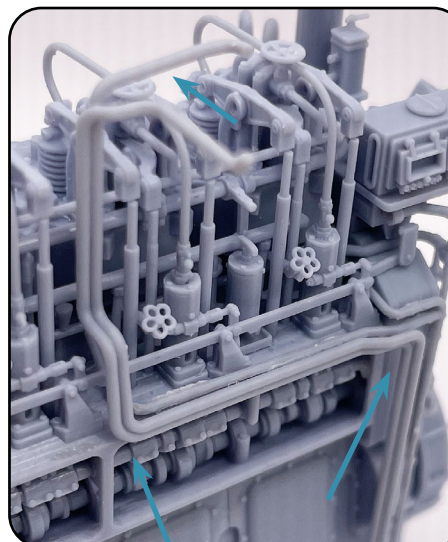
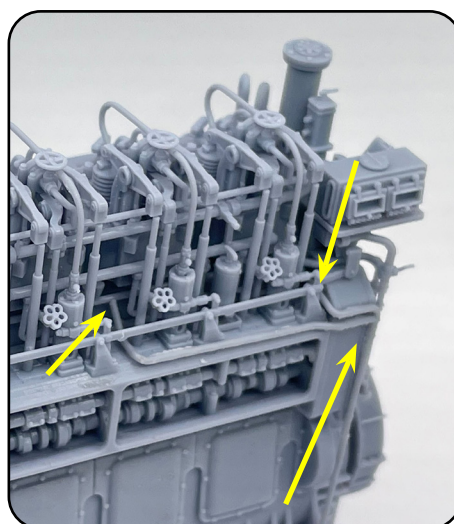
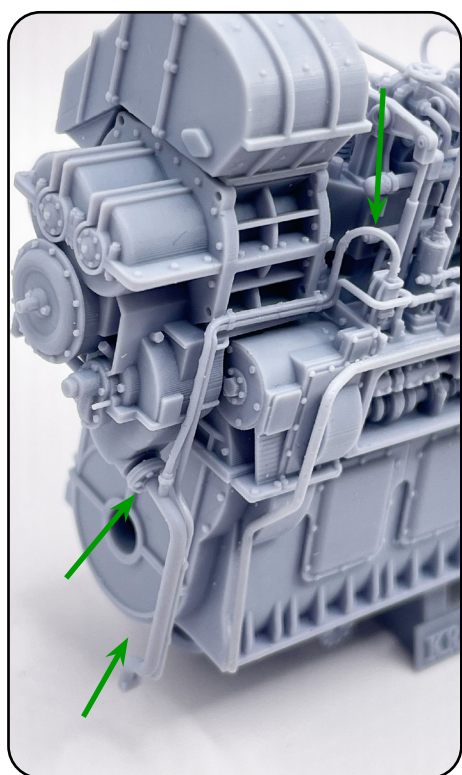
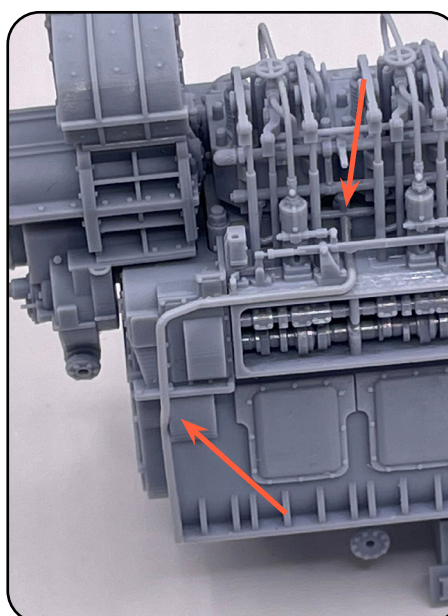
Instal first air pipe (1) to start the air intake (red arrow) and then smaller pipe (2) to start and throttle block (green arrow)

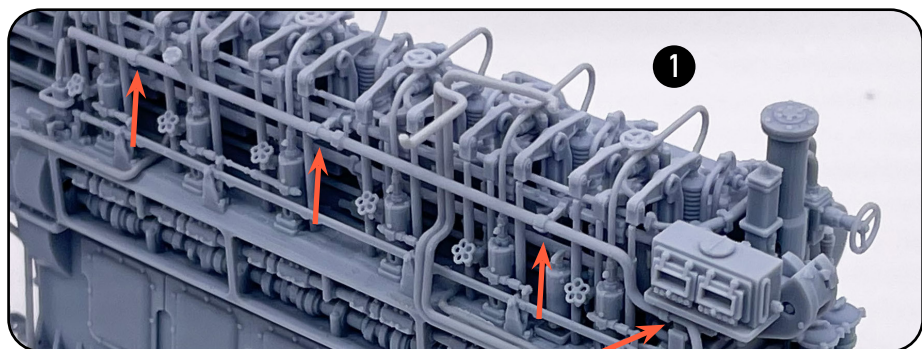
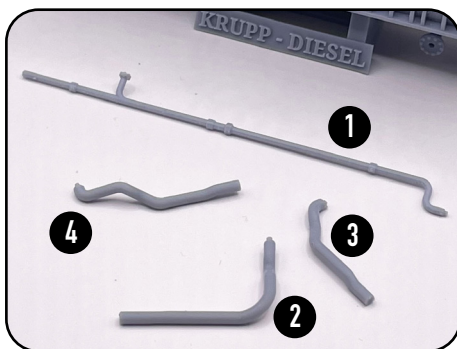
And finally the fuel pipes (3) 6 pcs (yellow arrows)



PIPES

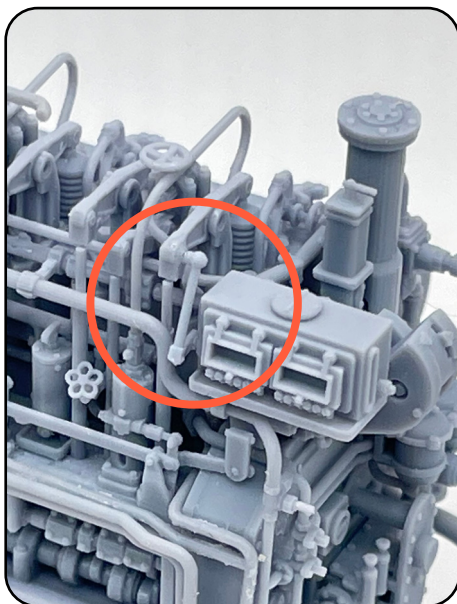
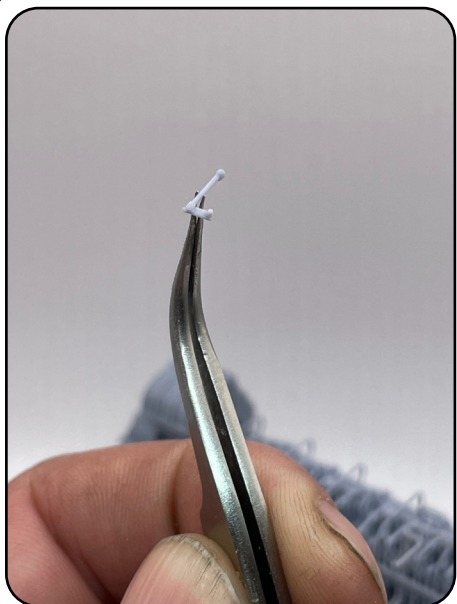
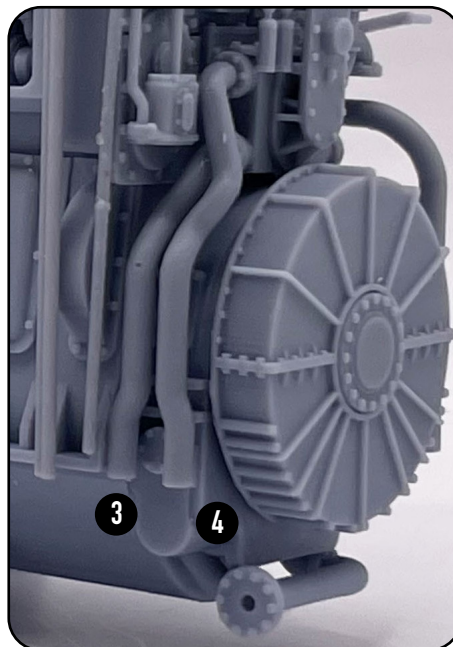
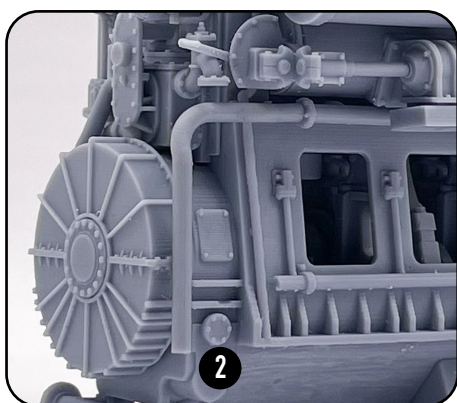
Assembly first pipes 1 and 2 together. After that, attach the pipes to the engine from left to right.





PIPES

Assembly first fuel pipe (1) then bigger ones to under front panel in numerical order. See red arrows how glue fuel pipe.

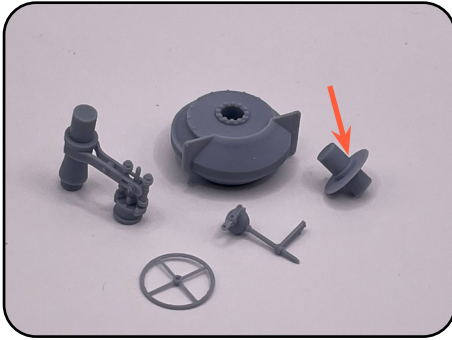


DRIVE ARM

And last on sheet 6, instal Auxiliary oil pump drive arm.

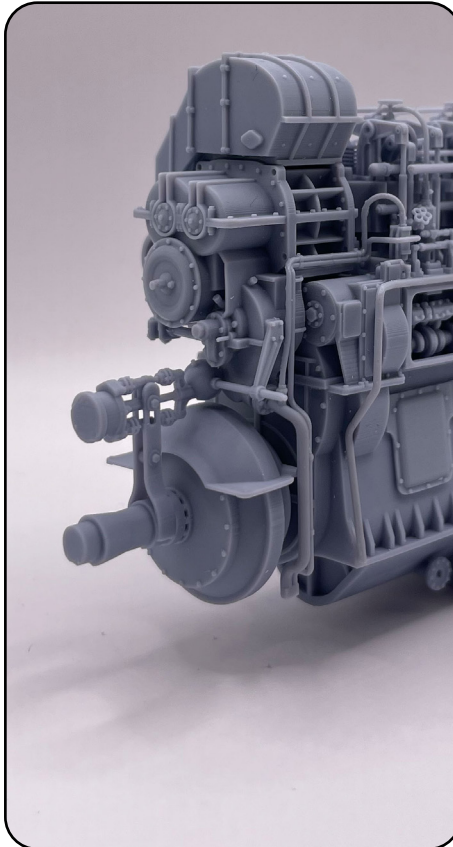
In sheet 6 has a large U-shaped tube. It is installed later with the frame.

SHEET 7



CLUTCH

Build clutch. Check next picture!
Arrow side towards the clutch.



Glue clutch to block and then the valve wheel



EXHAUST

Finally install the exhaust end. The diesel engine is now ready to instal to frame.

