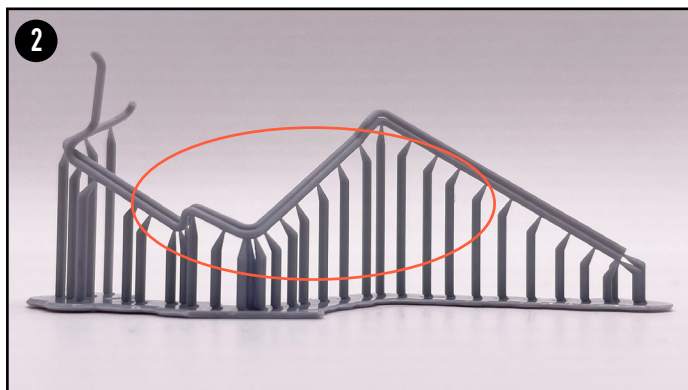
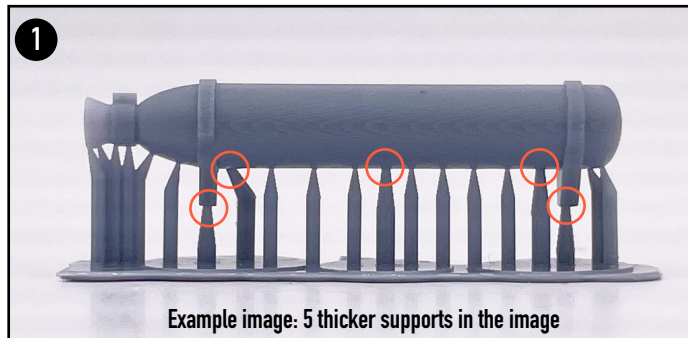


INSTRUCTIONS TO STARBOARD DIESEL

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

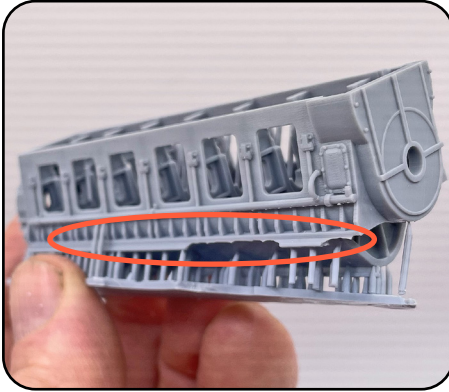


Modifications

- 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

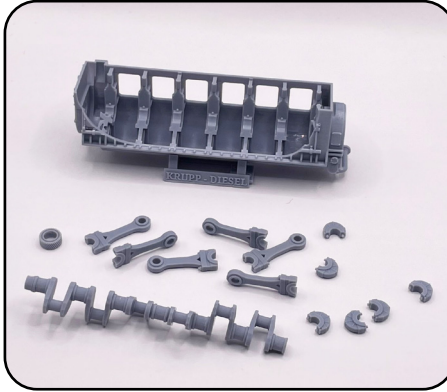
SHEET 1 & 1B



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

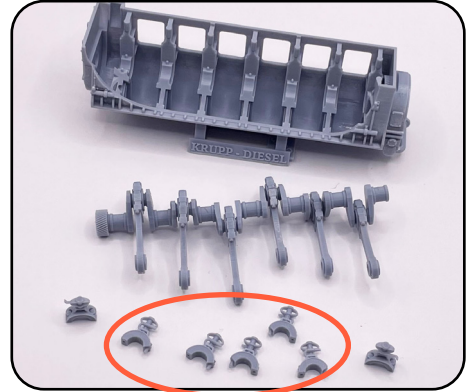


CRANKSHAFT

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.

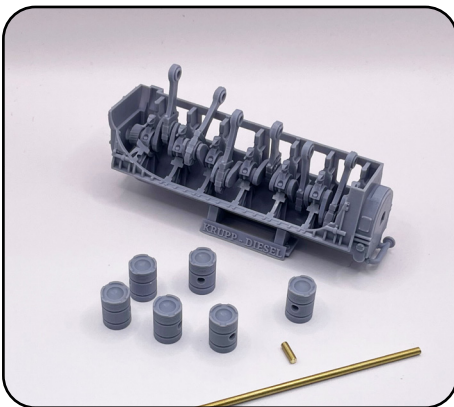
Also glue the cogwheel to the crankshaft.



CRANKSHAFT BEARINGS

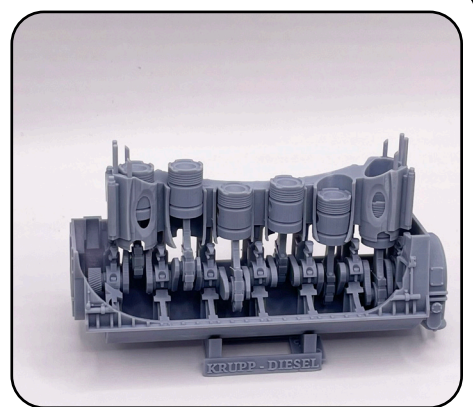
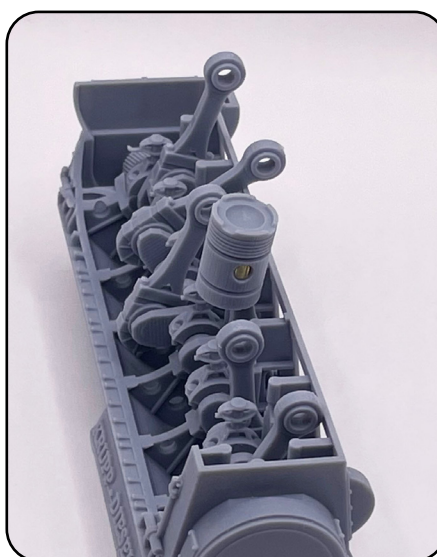
Install the crankshaft position you like. Think about how the pistons are positioned. Glue bearings.

There are two types of bearings in the kit. The "unbroken" ones come on the both sides and the five "cutted" ones in the middle (Red circle).



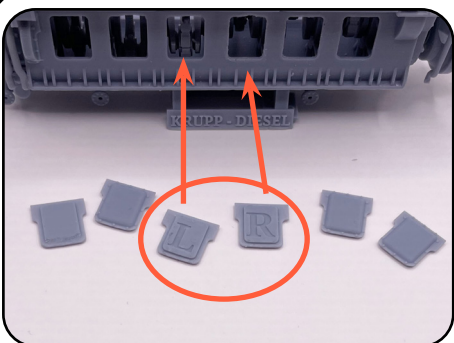
PISTONS AND SYLINDER TUBES

I used a brass tube to attach the pistons to the connecting rods. Size 2.06mm (0.81)



PISTONS AND SYLINDER TUBES

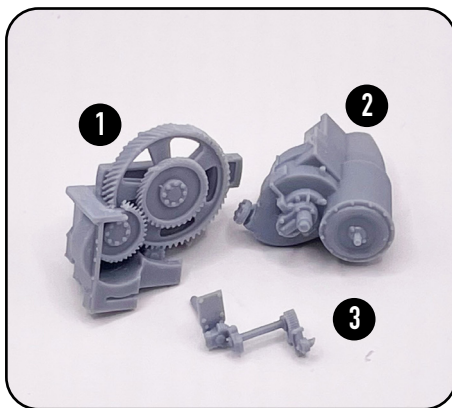
Glue the cylinder tubes in place.



BLOCK COVERS

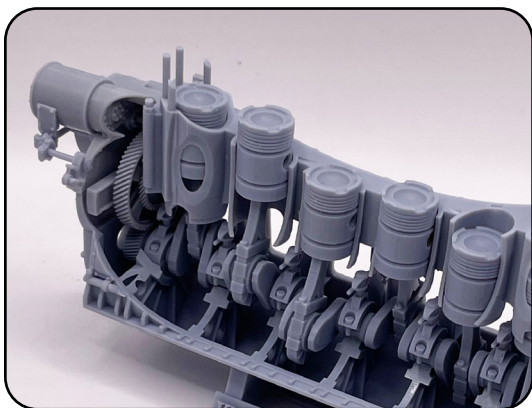
Install block covers that you want. You can leave some or all covers unmounted. There are three different types of covers for the front part. See the picture how to install them.

SHEET 2

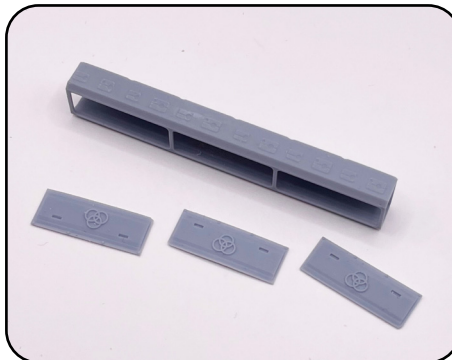


SUPERCHARGER

Install first part 1 and 2 together.
Then number 3

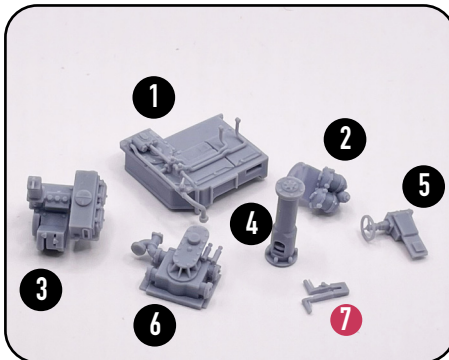


SHEET 3



CAMSHAFT HOUSING

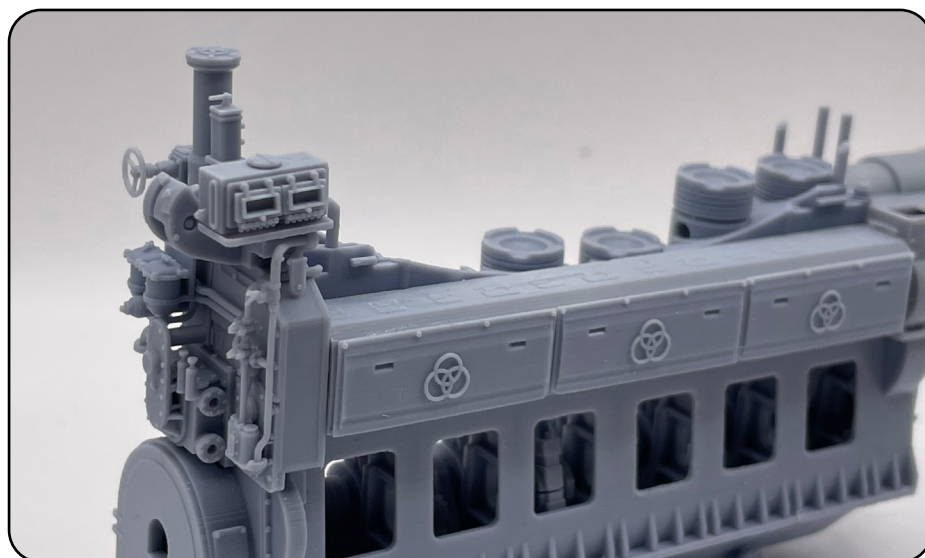
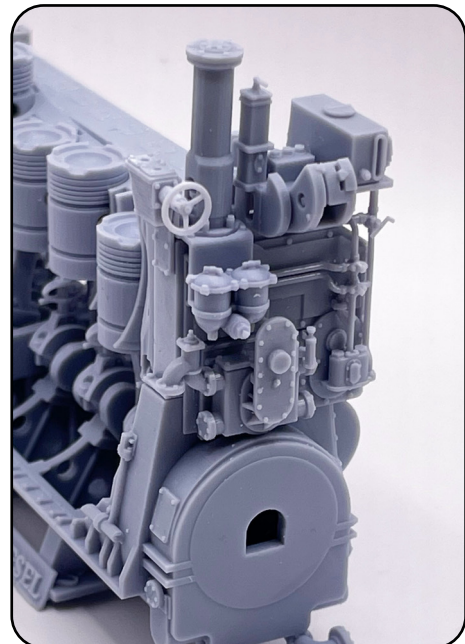
Glue three covers with the Krupp logo to housing
and instal it to block.



FRONT PANEL

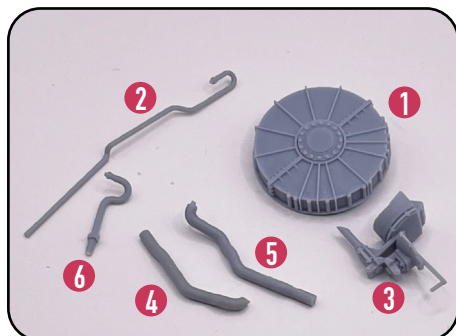
Take the front panel (1) and install the oil filter (2)
on it

Install the rest parts in numerical order. The throt-
tle linkage (7) is a quite sensitive part. You can
also install it later when engine is completed



Camshaft housing installed

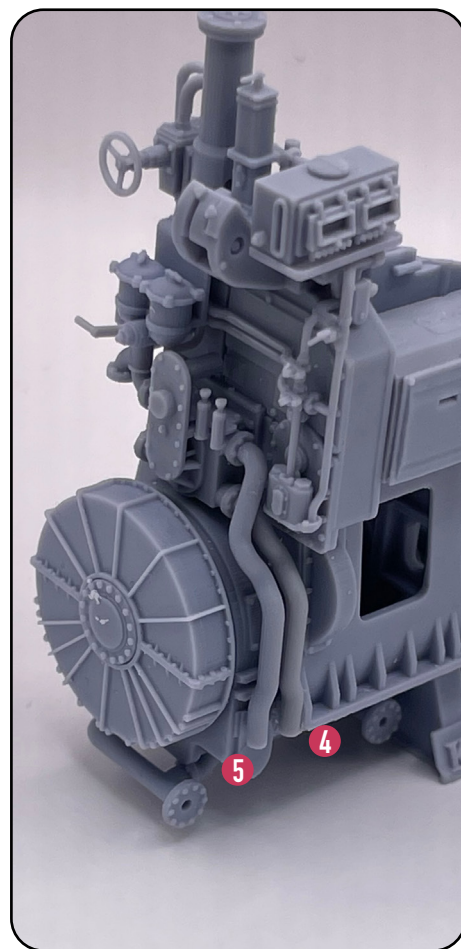
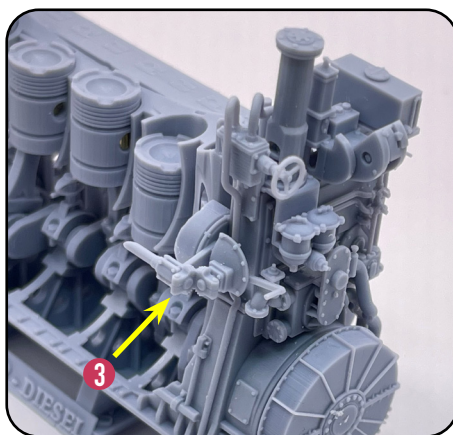
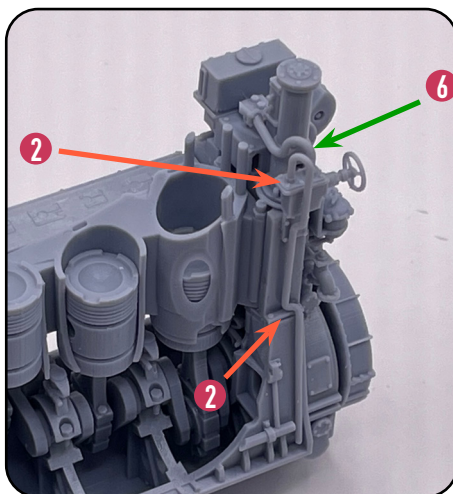
SHEET 4



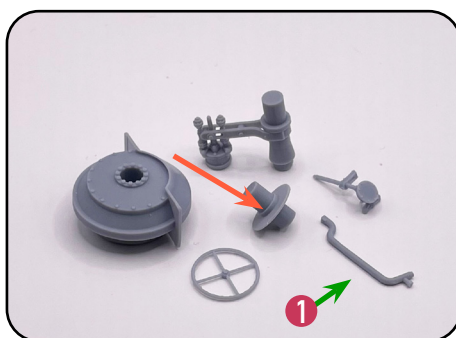
FRONT PANEL

- 1) Instal first vibration damper (1) on block
- 2) Instal first air pipe (2) to air start valve. See next picture and red arrow.
- 3) Cutted Air pipe (6) = green arrow
- 4) Valve (3) = yeallow arrow
- 5) Install pipe (4) before pipe (5)

In sheet 4 has a large U-shaped tube. It is installed later with the frame.



SHEET 5

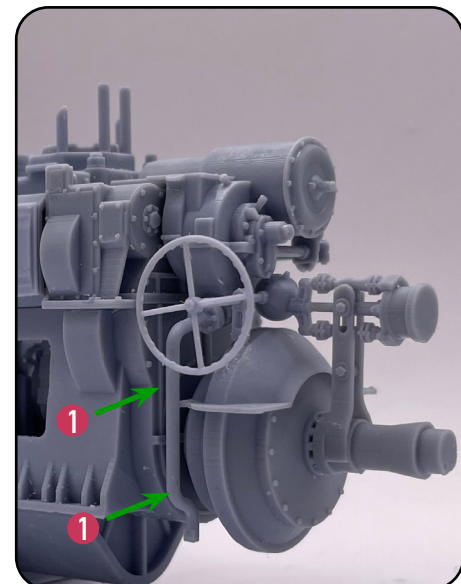


CLUTCH

Build clutch. Check next pictures!

Arrow side towards the clutch.

Insert valve last



Starboard Diesel is now ready