

Build the

PORSCHE 917 KH #20 GULF



Over
839
Parts
158 in metal



FULL KIT
1:8
Die-cast

ixoCOLLECTIONS

Build the PORSCHE 917 KH #20 GULF

Guide to the instructions

This set of step-by-step instructions will enable you to complete the build of your 1:8-scale Porsche 917 KH #20 Gulf.

Most of the steps involve simply screwing or fitting parts together, and the correct screws needed for each step are clearly labelled on the instructional images.

Please note the following:

- Where left and right elements of the same part are supplied, these are listed as (left) and (right).
- You will not be using every part you receive in your shipment in that build section. Keep any parts that are not used aside for use in a later sequence.
- You will receive extra screws with each shipment in case any screws are lost or broken.
- Screws with codes ending in the letter M drive into metal; those ending in the letter P drive into plastic.
- With M screws, first drive the screw in half-way. Then unscrew it to release the shavings created as the screw cuts its thread. Finally, drive the screw fully into the socket.
M screws should be tightened so the head makes firm contact with the fixing surface.
- With P screws, do not over-tighten them as they can damage the socket.
- When working with the pre-finished exterior surfaces of the model, work on a soft cloth. This will protect against scratching the paintwork.
- When plugging wires in, ensure the power is switched off.
- Tweezers can be used to fit the PVC cables.
In this case, grip carefully around 5 mm from the end of the cable. If the end of the cable is too narrow to fit on to the pin, cautiously insert a cocktail stick, being wary not to split the cable.
- Some smaller plastic parts are attached to sprues. You can remove these by hand, or by careful use of a cutting implement such as a scalpel.

Porsche, the Porsche shield and the distinctive design of Porsche cars are trademarks and trade dress of Porsche AG. Permission granted.



"The Gulf trademarks are used under license from Gulf Oil International Ltd."



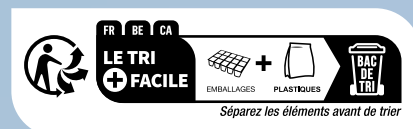
© IXOCOLLECTIONS SAS
© IXOMODELS

Customer service: contact@ixo-collections.fr
Packaged by: Les Inédits
Photography credits: Archives & Collections
© Porsche

Not suitable for children under 14 years old.
Contains small parts and accessories that can be swallowed. Keep these documents for future use.

Warning

No part of this booklet may be reproduced without permission from the publisher. The elements provided are reserved for a strictly private use, in the family circle, in accordance with the article L122-5 2° of the Code of the intellectual Property. The booklet and the elements of the model to be assembled cannot be resold, rented, lent or exploited for commercial purposes.
ALL RIGHTS RESERVED.



Numéro d'adhérent Léko :
1650353541044

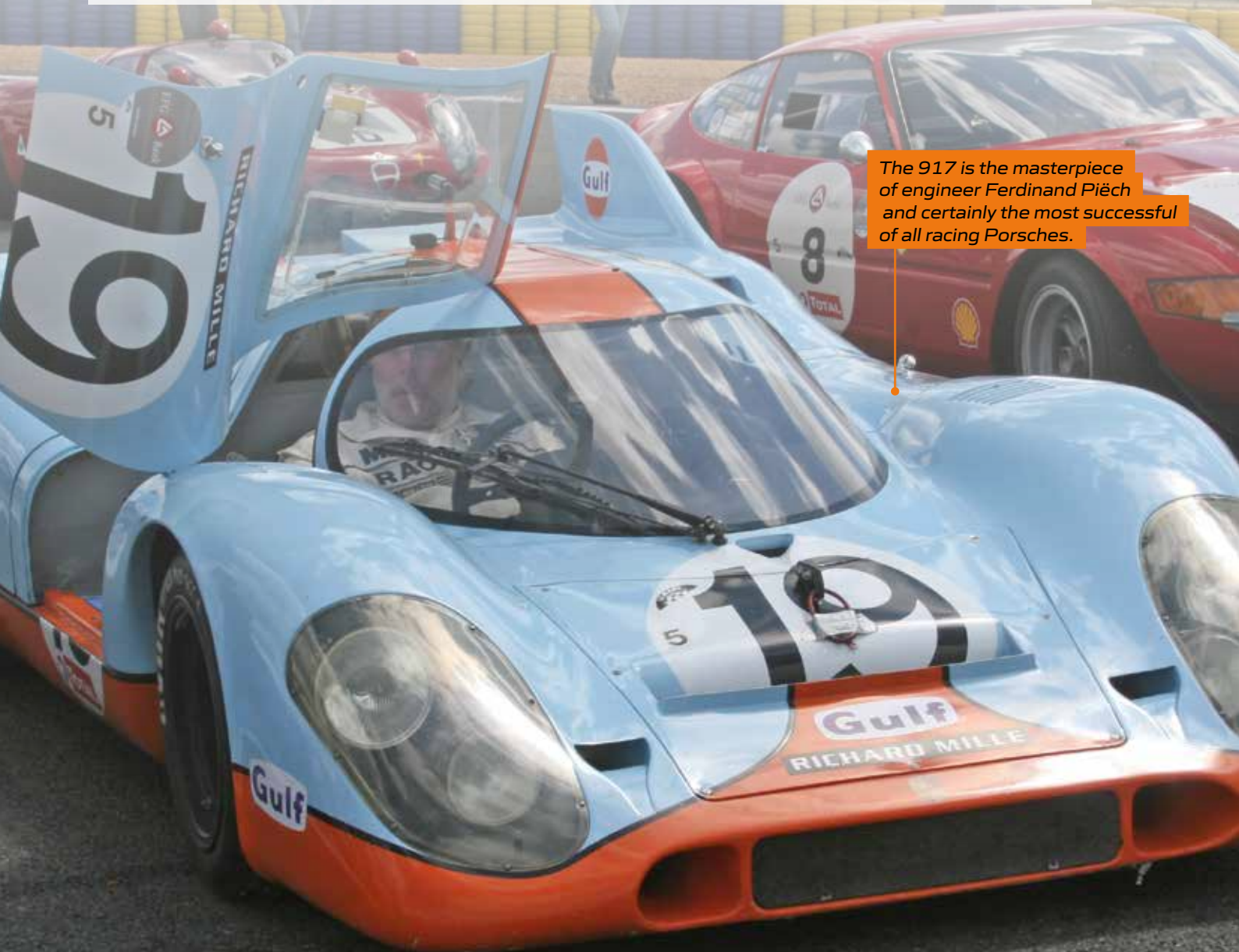
Queen of the circuits!

Launched in 1969 to compete in the World Brands Championship in the Sport category, the 917 will give Porsche its first victory at the 24 Hours of Le Mans.

At the end of 1967, Porsche already had a good track record in competition and won most of the major Endurance races such as the Targa Florio, the 1000 Kilometers of Monza or the Nürburgring, thanks to the 907 and 908

models. But the most prestigious race of all, the 24 Hours of Le Mans was missing. The following year, engineer Ferdinand Piëch started developing the 917 that would become a big triumph.

The 917 is the masterpiece of engineer Ferdinand Piëch and certainly the most successful of all racing Porsches.



In March 1968, in order to stem the rise of cars competing in Endurance races, the International Sporting Commission decided to modify the regulations of this category for the following season. Thus, the competitors of Group 6 (Sport Prototypes) see their displacement limited to 3000 cc and those of Group 4 (Sport) to 5000 cc. At the same time, the number of models is reduced by the FIA to 25 instead of the previous double. Porsche seized this opportunity with both hands and in less than a year the 917 was ready, with victory at Le Mans as the first goal.



The impressive cooling turbine covers the flat 16-cylinder, surrounded by bulky detonators.

Extrapolation of the 908

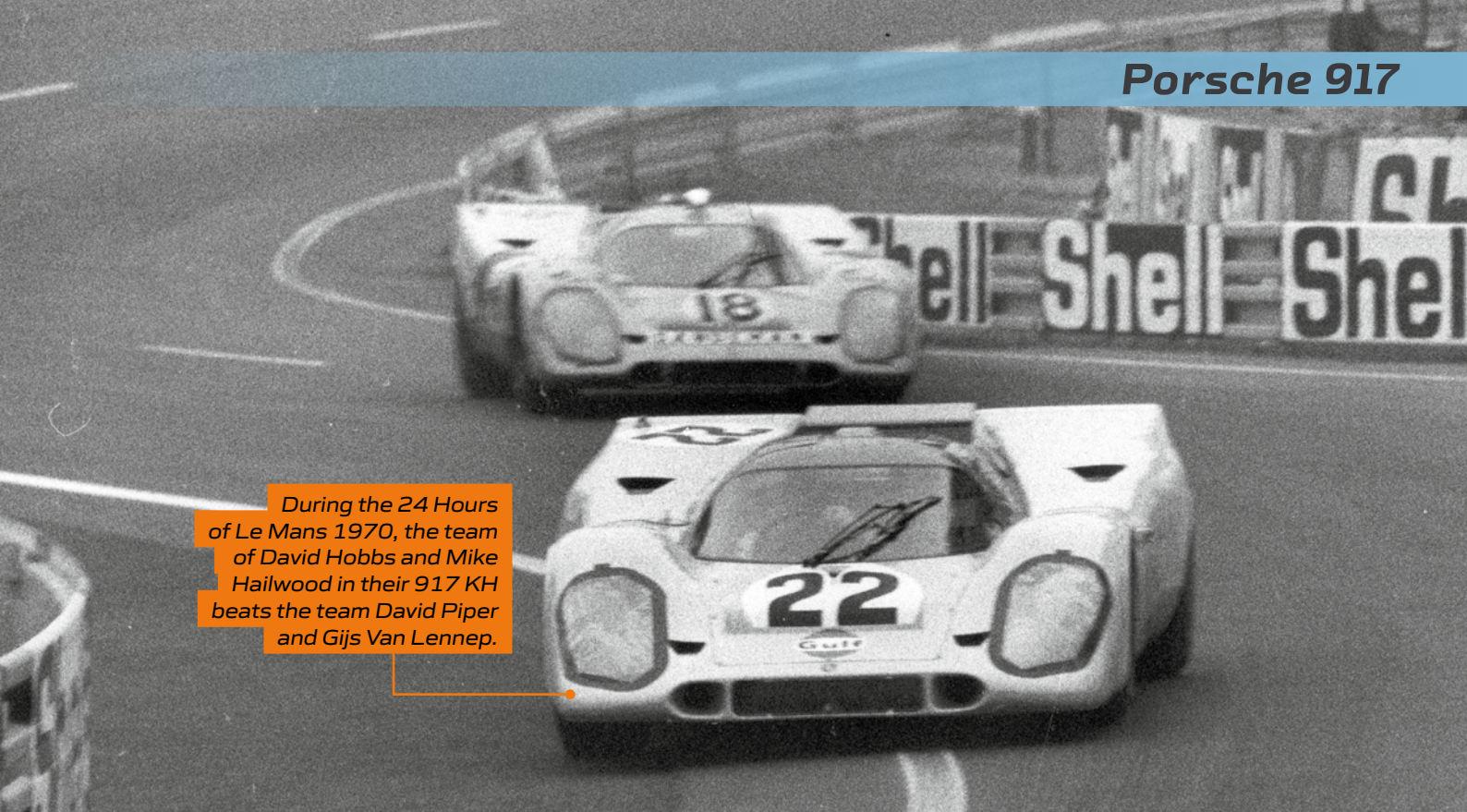
The design of the Porsche 917 began in July 1968 under the leadership of Ferdinand Piëch, head of the competition department, assisted by chassis engineer Helmuth Bott and engine manufacturer Hans Metzger. Eight months later, on March 15, 1969, prototype n°001 was presented at the Geneva Motor Show. The first driving sessions took place on the Le Mans circuit on the 29th of March and May 1st, the 25 models of the Porsche

917 were lined up in the factory yard for their homologation. Although the latest Stuttgart car is intended to be marketed as a Grand Touring model, it is nonetheless a true racing prototype in disguise. Porsche is exploiting a loophole in the new CSI regulations that forgot to specify that for the new Sports car category, the engine used should come from the existing series. The 917 was developed on the basis of the 908 from which it is part

58 Porsche 917 cars were built between 1969 and 1971, all models combined. Here we see a 1971 L version (chassis 042).



© Archives & Collections



During the 24 Hours of Le Mans 1970, the team of David Hobbs and Mike Hailwood in their 917 KH beats the team David Piper and Gijs Van Lennep.



Technical data sheet

Porsche 917 K (1970)

- Engine: Porsche Type 912-00, 12 cylinders flat, rear central longitudinal
- Displacement: 4,494 cm³
- Bore x stroke: 85 mm x 66 mm
- Power: 580 hp at 8,500 rpm
- Power supply: Bosch mechanical injection
- Ignition: double, Bosch transistorized electronics
- Distribution: double overhead camshaft, 2 valves per cylinder
- Transmission: to the rear wheels, 4 gears + M.A.
- Tires: Firestone, 4.75 / 11.30 x 12 front and 6.00 / 13.50 x 17 rear
- Brakes: ventilated discs (30.5 cm diameter)
- Length: 412 cm
- Width: 188 cm
- Height: 92 cm
- Wheelbase: 230 cm
- Front track: 152.6 cm
- Rear track: 153.3 cm
- Weight (empty): 820 kg
- Maximum speed: 340 km / h

of the tubular chassis, but this time in aluminum and no longer in steel. To save weight, the chassis side tubes act as an oil line from the front radiator to the rear engine. The platform is covered with a polyester resin body, reinforced with fiberglass, a technique used by Porsche since 1964 (908).

A unique engine

For its new racing machine, Porsche decides to keep the usual architecture of its engines, namely with the opposing cylinders lying flat and air-cooled. The design time being very short, Metzger took the 8-cylinder 3-liter fitted in the 908s to which he simply added 4 cylinders, i.e. 1.5 liters more, which remained within the limit of the 5 liters authorized. This engine which has a double camshaft per bank of cylinders is built in modern and light materials: aluminum block and cylinder head, magnesium crankcase, titanium connecting rods, chrome cylinders ... The cooling is provided by a large turbine placed horizontally on top of the engine. The initial power of the first series is 550 hp, 80 more than rival Ford GT 40. It will then increase to 580 hp at 8,500 rpm with a maximum torque of 50 mkg at 6,800 rpm. In 1970, another engine was available, the type 912-10 with 4,907 cc and 600 hp, followed in 1971 by the type 912-11



An impressive track record

During the three editions (1969 to 1971) of the World Sports Car Championship in which it participated, the Porsche 917 achieved no less than 15 wins in 31 races and enabled the German brand to claim 3 consecutive world titles. Its first success came at the 1000 km Zeltweg in 1969 thanks to Jo Siffert and Kurt Ahrens.

It was on this same circuit, in 1971, that the 917 won its last World Championship victory with Pedro Rodriguez and Richard Attwood. From 1972, the 917 PA Spider version competed in the Can Am championship (Canadian-American Challenge Cup) across the Atlantic, where it won in 1972 (6 wins) and 1973 (8 wins).



The Martini Racing Team's 917 KH, driven by Helmut Marko and Gijs Van Lennep, brought Porsche its second victory at the 1971 24 Hours of Le Mans.

Robert Choulet. The engine is identical to that of the short version, while the transmission has a 5th gear.

Two main versions

Of the Porsche 917 two main versions are produced with mainly two types of body. The

with 4,998 cc and 630 hp. Two main versions of the Porsche 917 are produced with mainly two types of body. The 917 KH short tail version (Kurz Heck), which represents the majority of cars built, is particularly suited to «slow» circuits with few long straights. For the 24 Hours of Le Mans, which at the time allowed high top speeds, Porsche is developing a specific version, the 917 LH long tail (Lang Heck). This model, built in only 5 units, will achieve a feat at Le Mans by setting the best lap time during the April 1971 tests! That day, the driver Jackie Oliver completed a lap in 3'13'600, averaging 250 km / h, and reached a top speed of 386 km / h in Les Munaudières! The 917 LH is distinguished by a longer body of 66 cm and a heavier weight of approximately 20 kg. The lines are more enveloping, with a partial fairing of the rear wheels and gills have been opened above the front fenders for better airflow. The aerodynamic study was carried out within SERA (Société Française Specialized in Aerodynamics) directed by engineer

917 KH short tail version (Kurz Heck), which represents the majority of cars built, is particularly suited to «slow» circuits with few long straights. For the 24 Hours of Le Mans, which at the time allowed high top speeds, Porsche is developing a specific version, the 917 LH long tail (Lang Heck). This model, built in only 5 units, will achieve a feat at Le Mans by setting the best lap time during the April 1971 tests! That day, the driver Jackie Oliver completed a lap in 3'13'600, averaging 250 km / h, and reached a top speed of 386 km / h in Les Munaudières! The 917 LH is distinguished by a longer body of 66 cm and a heavier weight of approximately 20 kg. The lines are more enveloping, with a partial fairing of the rear wheels and gills have been opened above the front fenders for better airflow. The aerodynamic study was carried out within SERA (Société Française Specialized in Aerodynamics) directed by engineer Robert Choulet. The engine is identical to that of the short version, while the transmission has a 5th gear.



1-8 Porsche 917 KH Car 20 packaging list

Your Porsche 917 KH full kit is broken down as follows:

Blister	Pack 1	80A, screws box(G1)	
	Pack 2	90A, 90B, 90C	
	Pack 3	1A, 1B, 1C, 1D, 1E, 1F, 1G, 1H, 1I, screwdriver (red) 2A, 2B, 2C, 2D, 2E, 2F, 2G	
	Pack 4	3A, 3B, 3C, 3D, 3E, 3F, 3G, 3H, 3I, 3J, 3K, 3L, 3M, 3N, 3O 4A, 4B, 4C, 4D, 4E, 4F, 4G, 4H 63A, 63B, 63C, 63D, 63E	
White box	Pack 5	#05-#20, #47, Tweezers, screwdriver (small)	
	Pack 6	#21-#24, #26-#35	
		#25 refer to pack 7	Pack 7
	Pack 7	#25, #38-#40	
		#26-#35 refer to pack 6	Pack 6
		#36, #37 refer to pack 8	Pack 8
	Pack 8	#36, #37, #41 - #46, #48, #49	
		screws, screwdriver (long)	
		#38, #39, #40 refer to pack 7	Pack 7
		#47 refer to pack 5	Pack 5
	Pack 9	#50-#62, glove	
		#63 refer to pack 4	Pack 4
	Pack 10	#64-#79, #81, #82	
		#80 refer to pack 1	Pack 1
	Pack 11	#83-#89, #91-#100	
		#90 refer to pack 2	Pack 2



Assembly guide

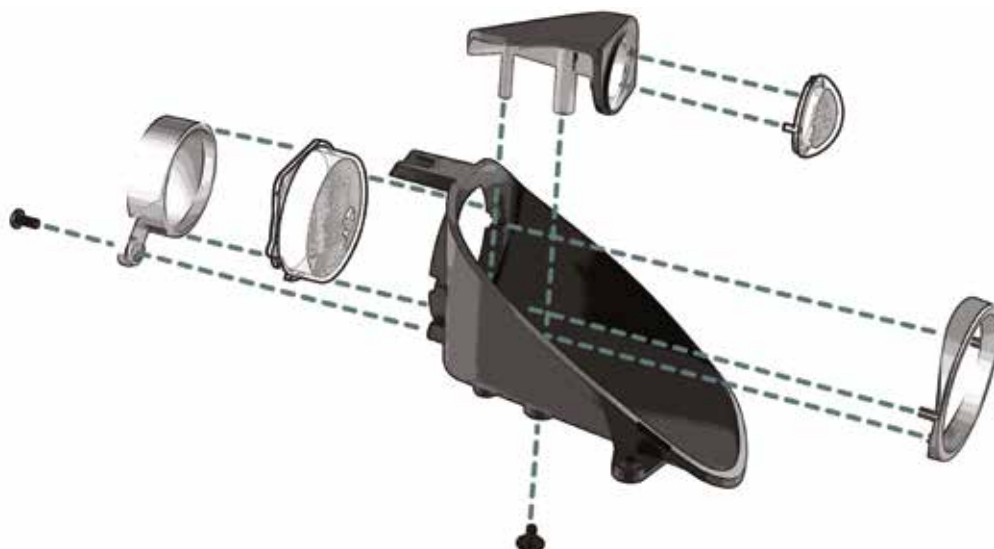
PARTS OF THE ISSUE 1

- 1A** Left side door
- 1B** Hood cover with radiator air outflow niche
- 1C** Left headlight plexiglass nacelle
- 1D** Left headlight housing
- 1E** Big headlight bezel
- 1F** Big headlight reflector
- 1G** Big headlight lens
- 1H** Small headlight housing
- 1I** Small headlight lens
- AP** Screw M1,7 x4mm (x2)
- BP** M1,7 x4x5mm (x2)



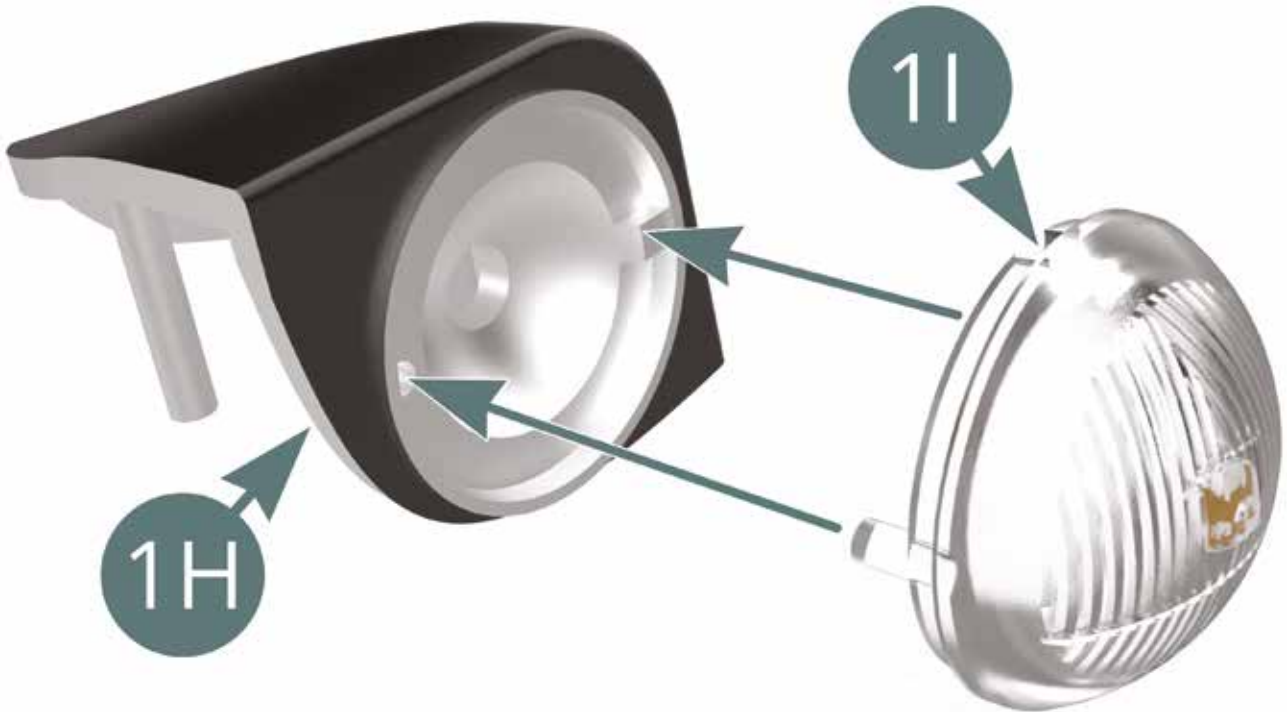
Left front Headlight assembly

ASSEMBLY DIAGRAM



STEP 1

Fit 1I Small headlight lens to 1H Small headlight housing.



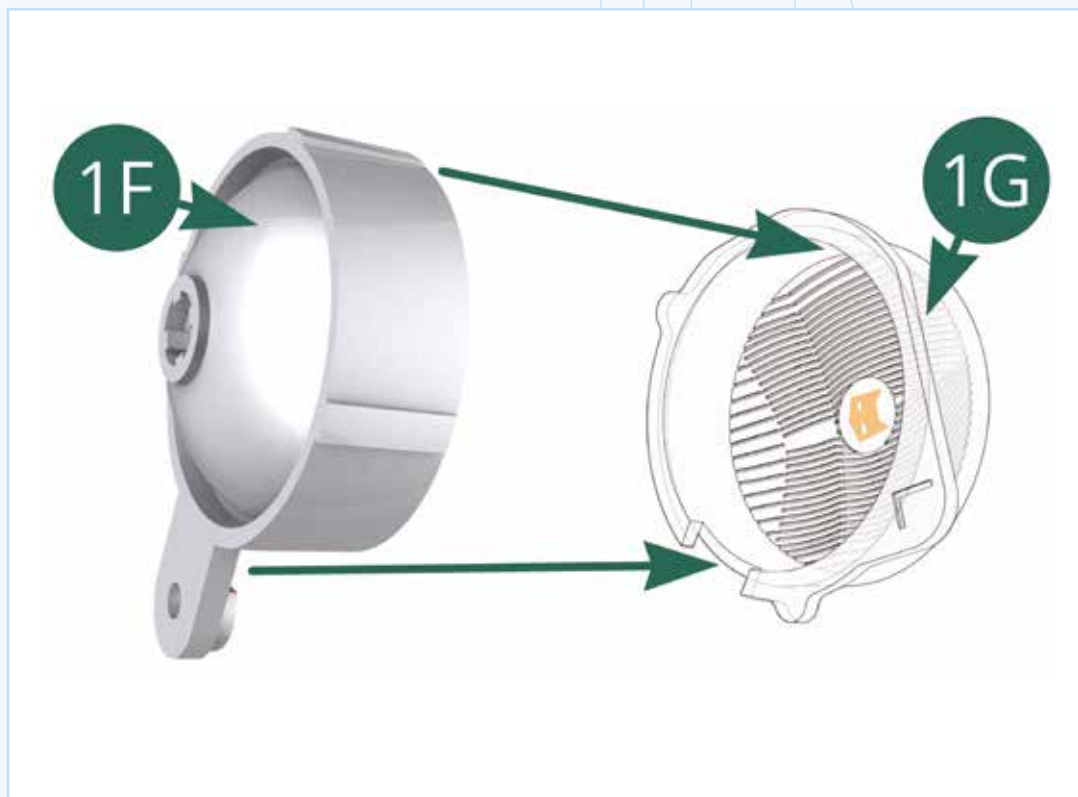
Fit 1H Small headlight housing to 1D Left headlight housing and fix with BP screw.



STEP 2



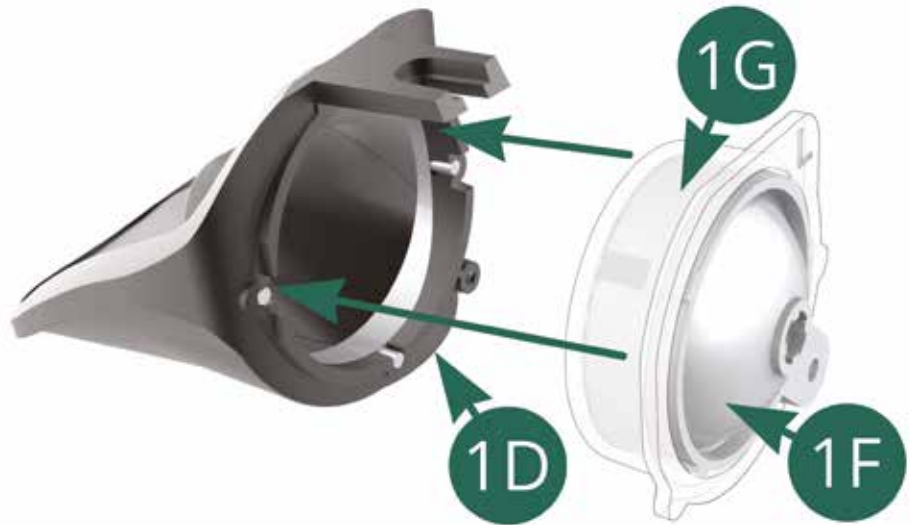
Fit 1E Big headlight bezel to 1D Left headlight housing.



Fit 1F Big headlight reflector into 1G Big headlight lens cup.

STEP 3

Fit 1G Big headlight lens with installed 1F Big headlight reflector into 1D Left headlight housing.



Fix 1F Big headlight reflector to 1D Left headlight housing with AP screw.



Preassembled Left Headlight

GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 2

2A Steering wheel

2B Steering column

2C Steering wheel badge

2D Front wheel

2E Front wheel outer rim

2F Front wheel inner rim

2G Hub cover

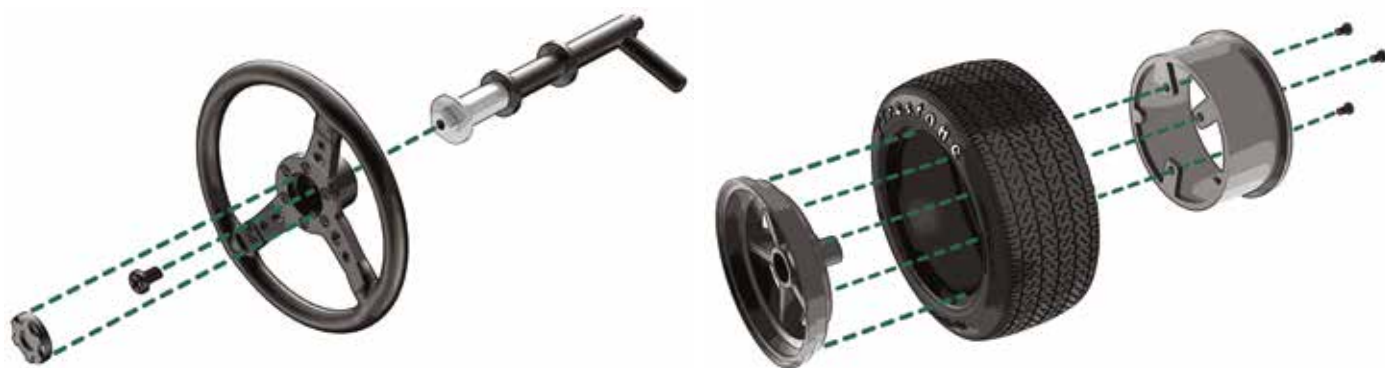
AM Screw M 1.7 x 3 mm (x 2)

BM Screw M 2.0 x 4 mm (x 4)



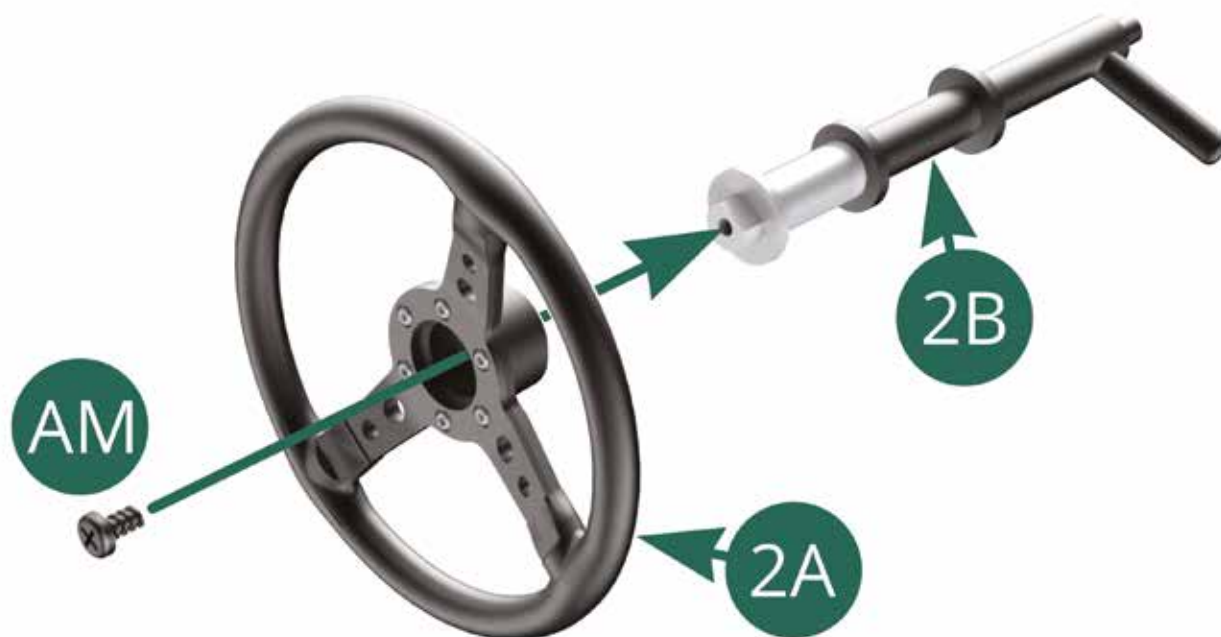
*Steering wheel
preassembly*

ASSEMBLY DIAGRAM



STEP 1

Position the steering wheel 2A on the steering column 2B and secure it with a screw AM.



Position the badge 2C in the center of the steering wheel 2A.



**STEP 2**

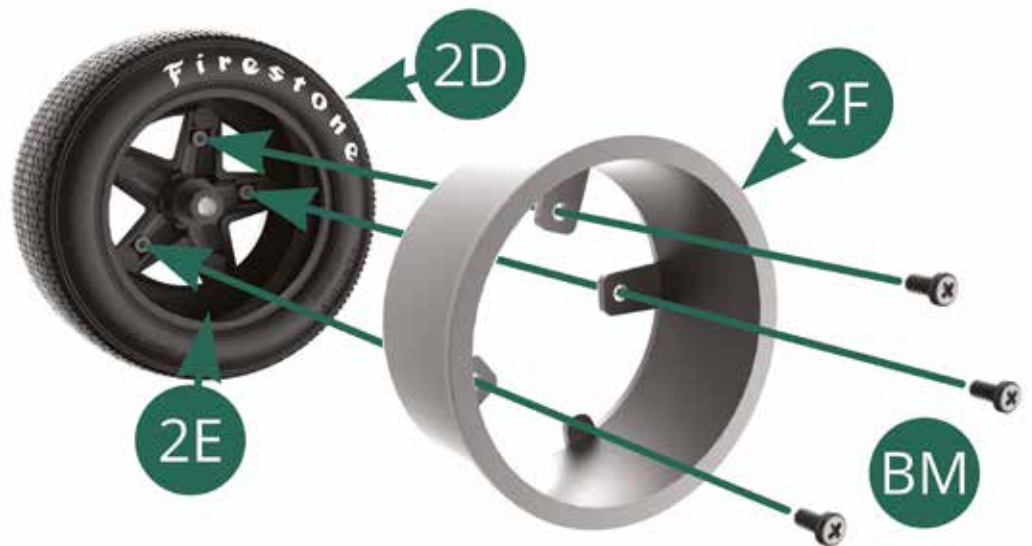
*Preassembled
Steering wheel*



Put the 2D tire in hot water for 2 minutes, then position the outer rim 2E on the front 2D wheel.

STEP 3

Position the inner rim 2F on the front wheel 2D and fix it to the outer rim 2E with three BM screws.



Front wheel
preassembly

GENERAL VIEW

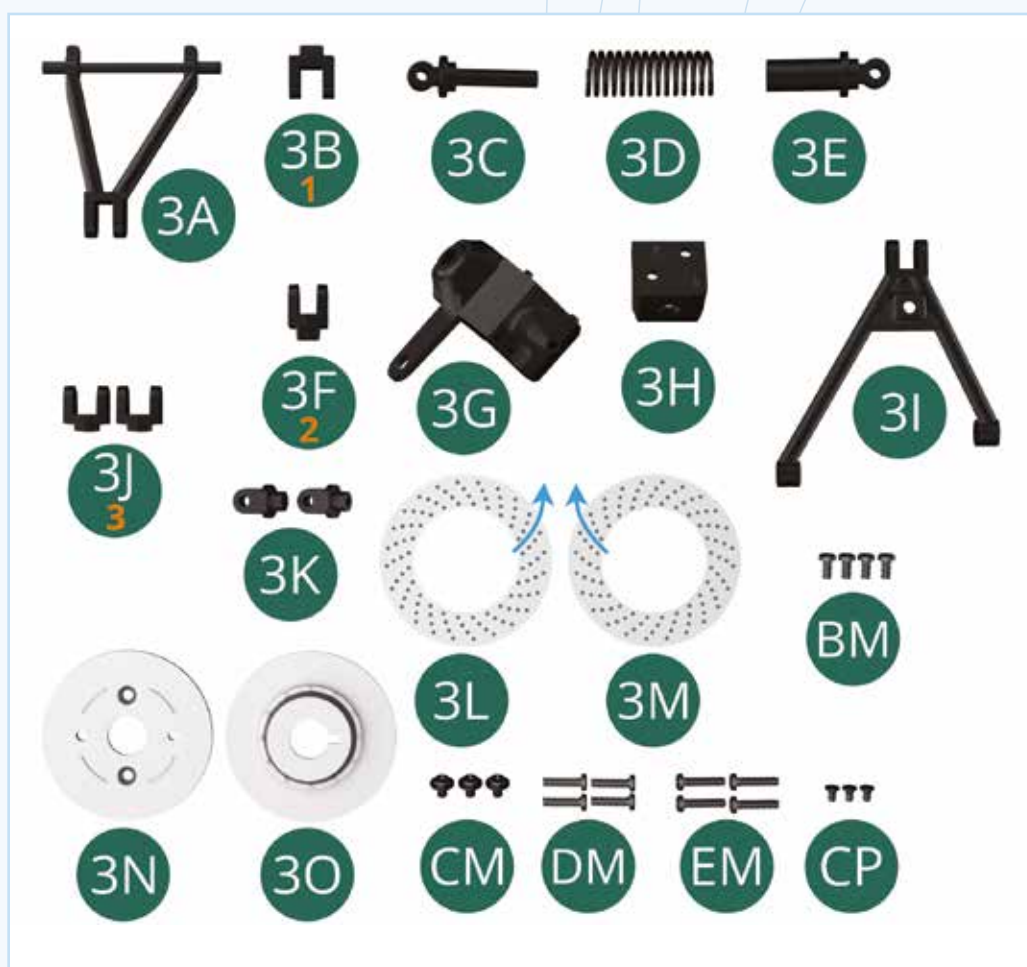




Assembly guide

PARTS OF THE ISSUE 3

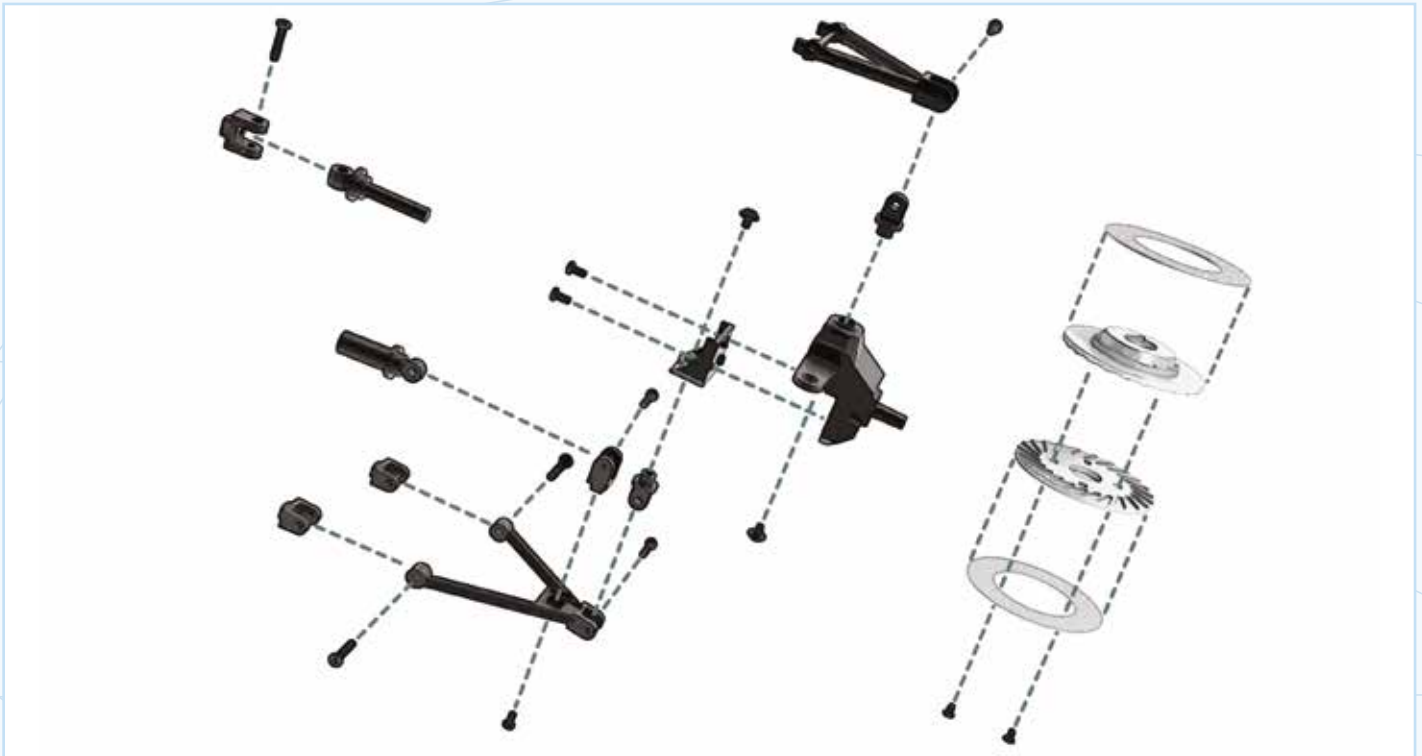
- 3A** Upper front wishbone
- 3B** Damper upper mount (marked 1)
- 3C** Piston rod
- 3D** Suspension spring
- 3E** Suspension damper
- 3F** Damper lower mount (marked 2)
- 3G** Upright upper body
- 3H** Upright lower body
- 3I** Lower front wishbone
- 3J** Lower wishbone mounts (x2 , marked 3)
- 3K** Upright eye link (x2)
- 3L** Outer brake disc (note hole pattern orientation)
- 3M** Inner brake disc (note hole pattern orientation)
- 3N** Inner rotor
- 3O** Outer rotor and hub
- BM** M2,0 x4mm (x4)
- CM** M2,0 x3x5mm (x3)
- DM** M2,0 x8mm (x4)
- EM** M2,0 x9mm (x4)
- CP** M1,7 x3mm (x3)



Front left suspension and brake disc assembly



ASSEMBLY DIAGRAM



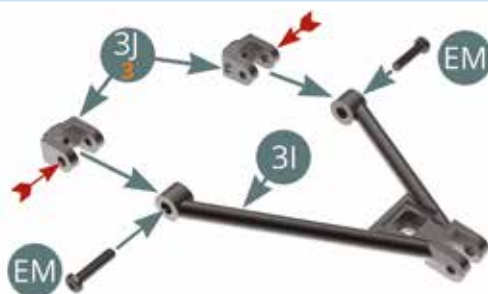
STEP 1

Fit 3K Upright eye link to 3A Upper front wishbone and fix with DM screw from bigger hole direction (red arrow) forming moving joint. Fit 3G Upright upper body to 3K Upright eye link and fix with CM screw, forming rotating joint for enabling front wheels turn.



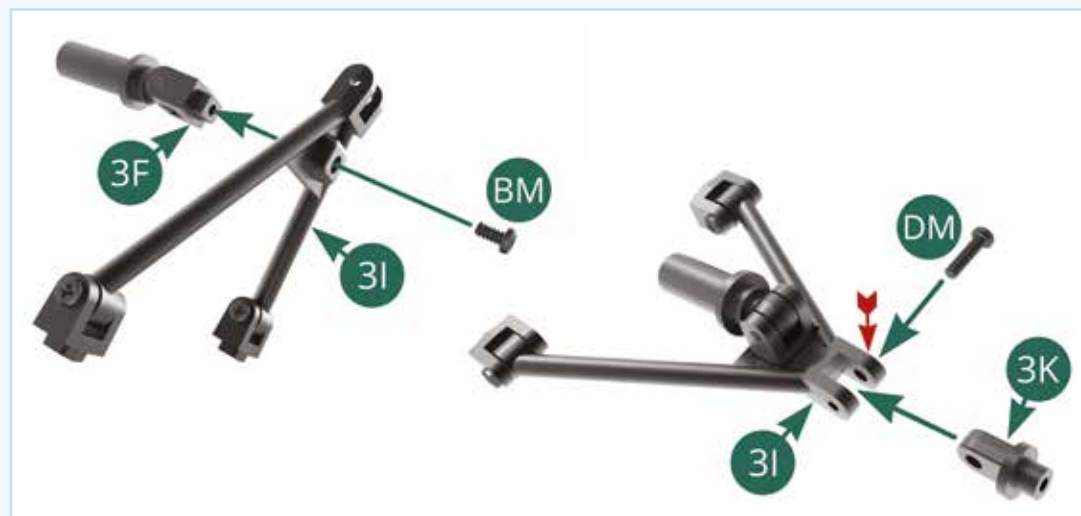
STEP 2

Fit consecutively, two 3J Lower wishbone mounts (marked 3) to 3I Lower front wishbone and fix each one with EM screw from bigger hole direction (red arrow), forming two moving joints.



Fit 3F Damper lower mount (marked 2) to 3E Suspension damper and fix with DM screw from bigger hole direction (red arrow), forming moving joint.

STEP 3

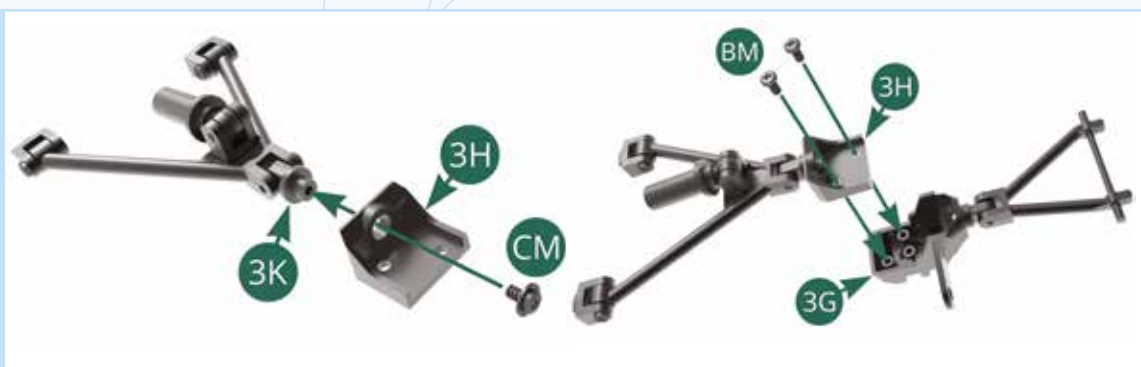


Fit 3F Damper lower mount to 3I Lower front wishbone and fix with BM screw.

Fit 3K Upright eye link to 3I Lower front wishbone and fix with DM screw from bigger hole direction (red arrow), forming moving joint.

STEP 4

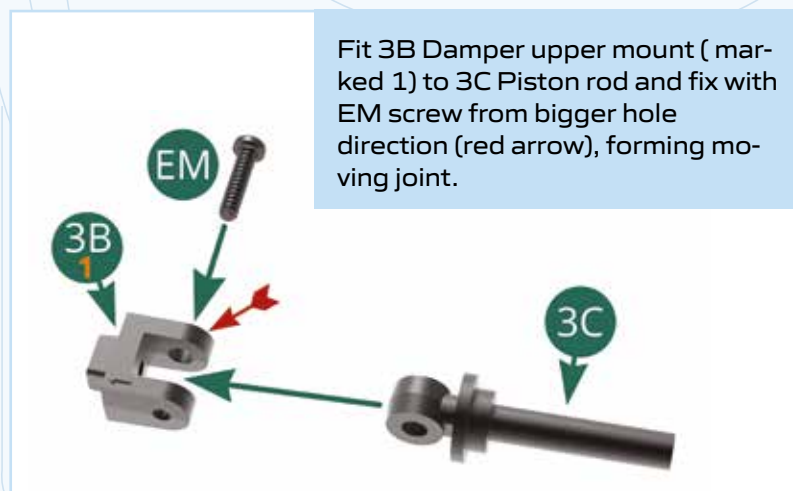
Fit 3H Upright lower body to 3K Upright eye link and fix with CM screw, forming rotating joint for enabling front wheels to turn. Fit 3H Upright lower body to 3G Upright upper body and fix with two BM screws.



STEP 5



Preassembled
Front left
suspension in
unfolded
condition

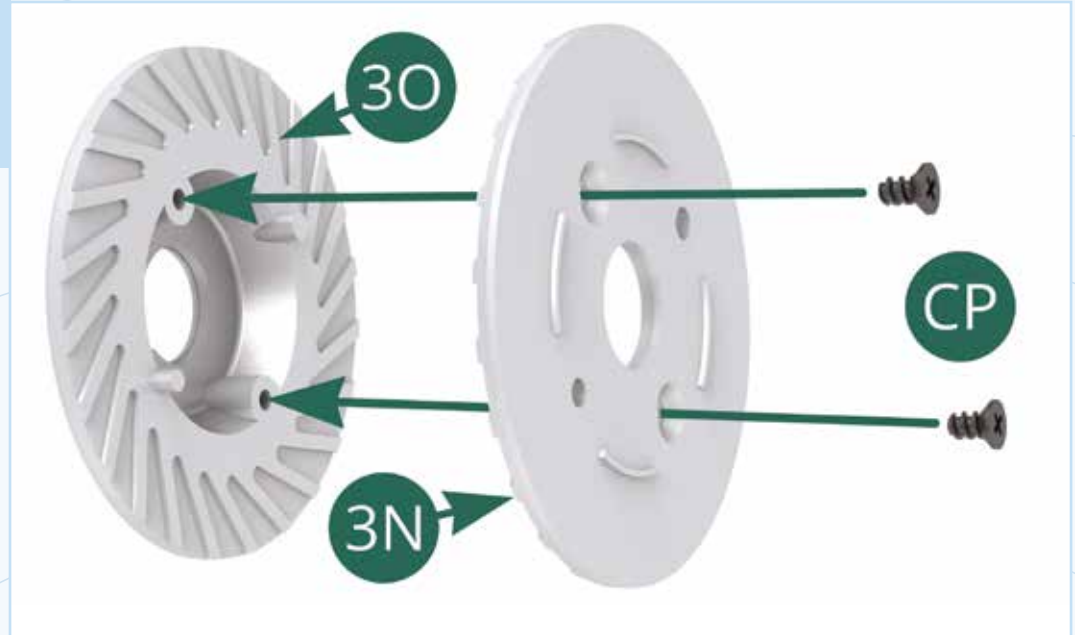


Fit 3B Damper upper mount (marked 1) to 3C Piston rod and fix with EM screw from bigger hole direction (red arrow), forming moving joint.



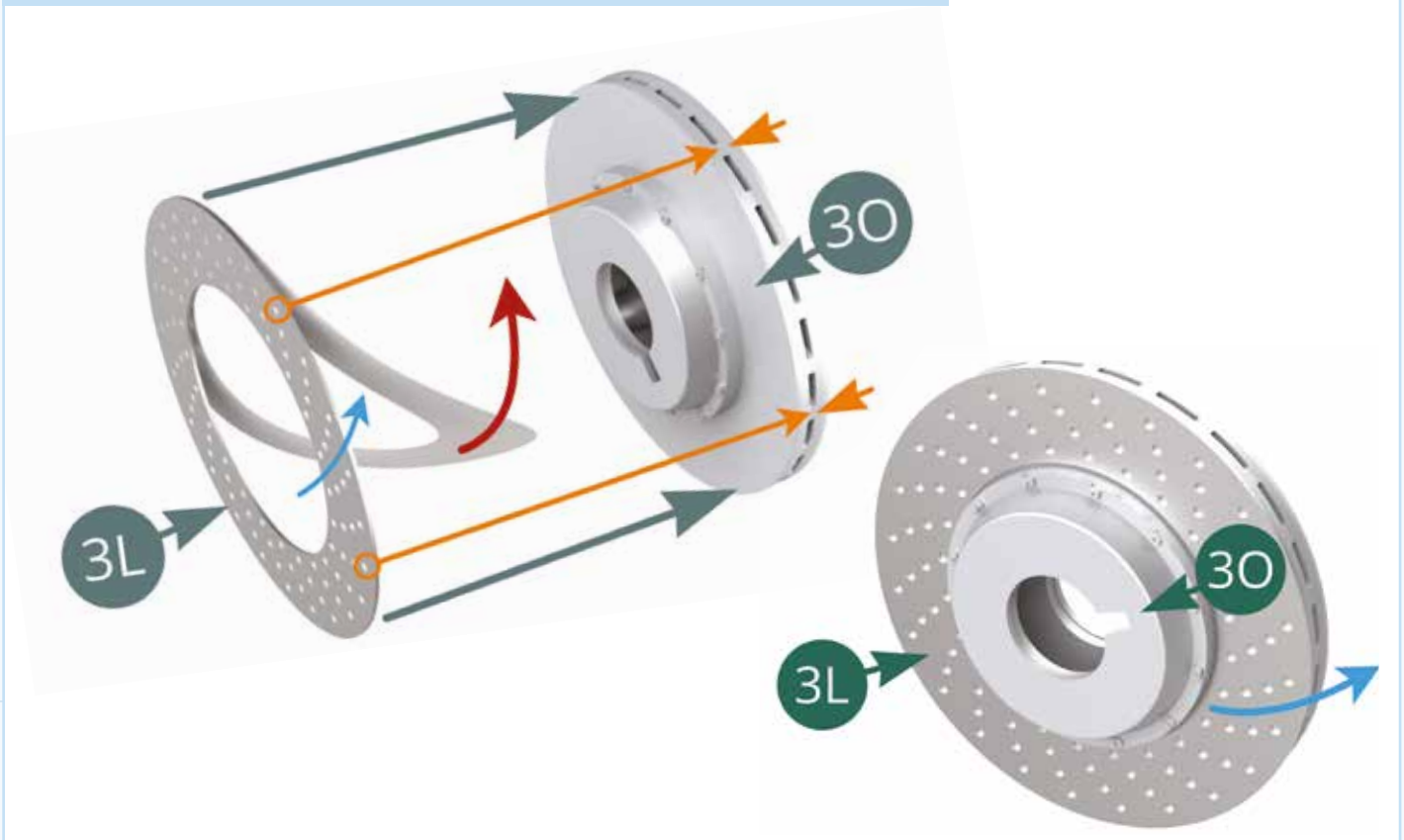
STEP 6

Fit together 3N Inner rotor and 3O Outer rotor and hub and fix with two CP screws.



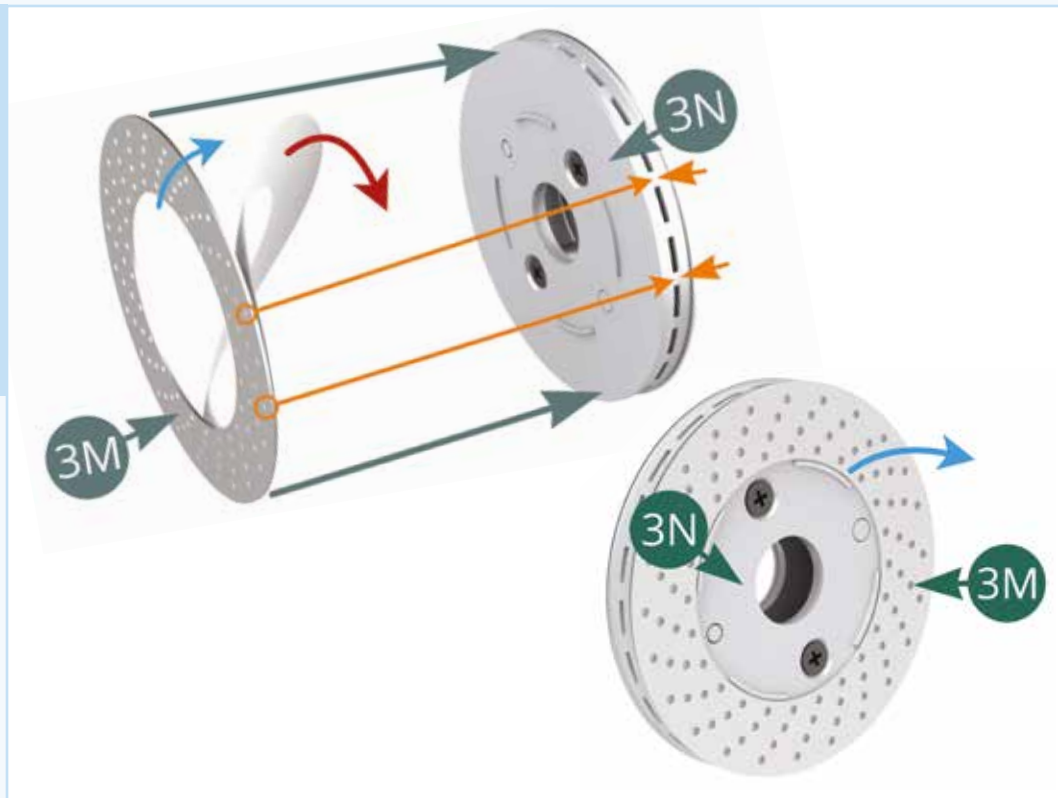
STEP 7

Peel away (red arrow) backing paper from 3L Outer brake disc (note hole pattern orientation blue arrows) and apply with its self adhesive side to 3O Outer rotor and hub, taking care to orient outermost holes opposite to 3O Rotor inner ribs (orange arrows).



STEP 8

Peel away (red arrow) backing paper from 3M Inner brake disc (note hole pattern orientation blue arrows) and apply with its self adhesive side to 3N Inner rotor, taking care to orient outermost holes opposite to 30N Rotor inner ribs (orange arrows).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 4

4A Right gearbox housing

4B Right side mounting bracket

4C Transmission seal

4D Cross

4E Transmission seal

4F Internal flector

4G External flector

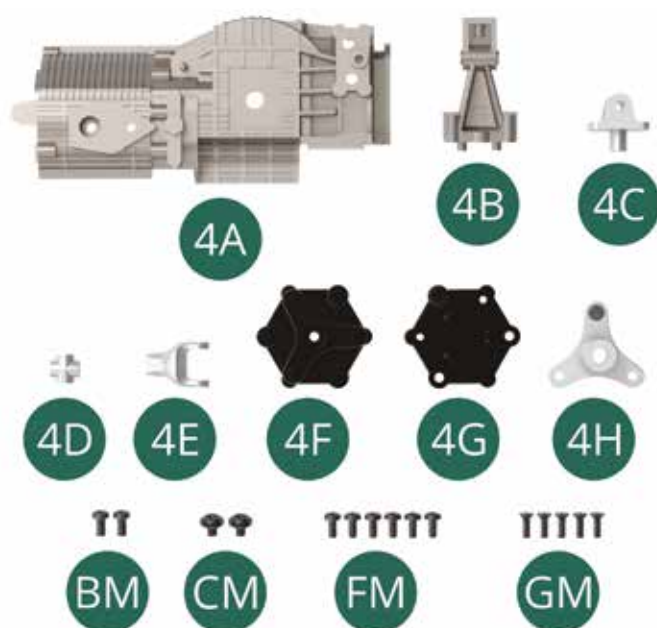
4H Cardan shaft

BM Screw M 2.0 x 4 mm (x 2)

CM Screw M 2.0 x 3 x 5 mm (x 2)

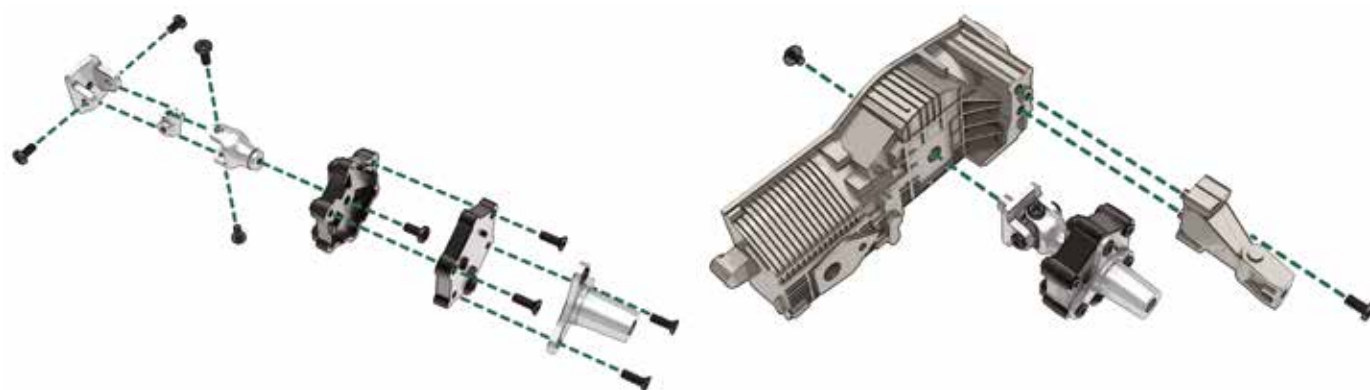
FM Screw M 1.7 x 4 mm (x 6)

GM Screw M 1, 7 x 5 mm (x 5)



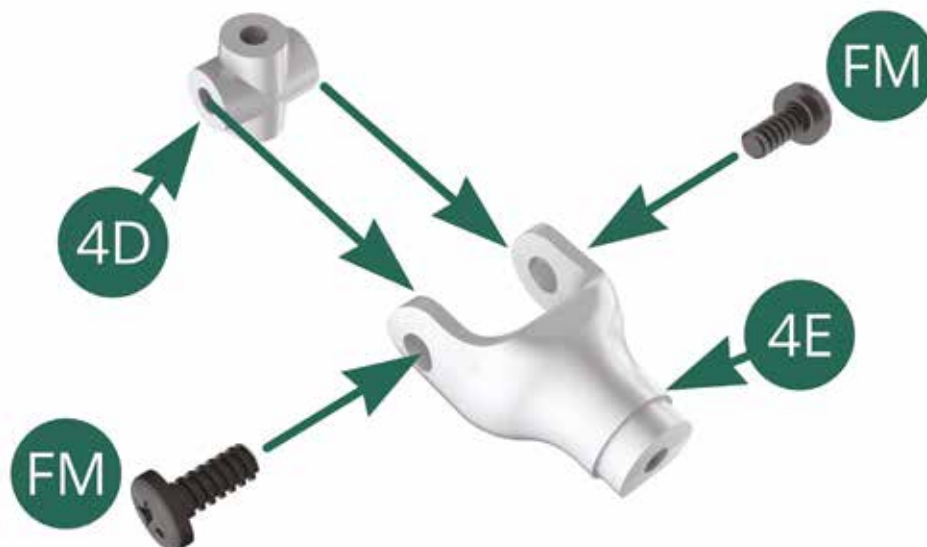
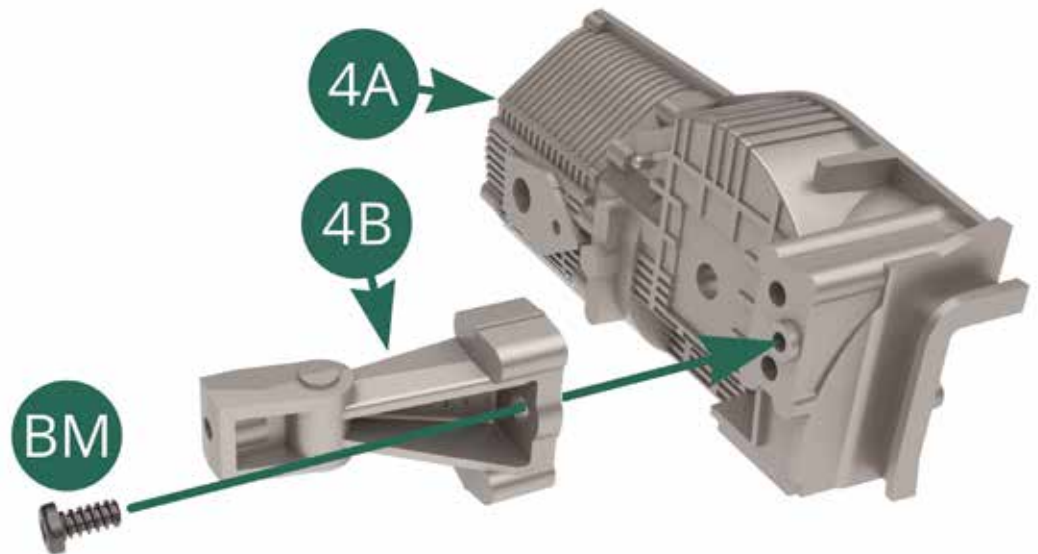
Gearbox right side casing and drive shaft preassembly

ASSEMBLY DIAGRAM



STEP 1

Position the right-side mounting bracket 4B on the right-hand gearbox housing 4A and secure it with a BM screw.

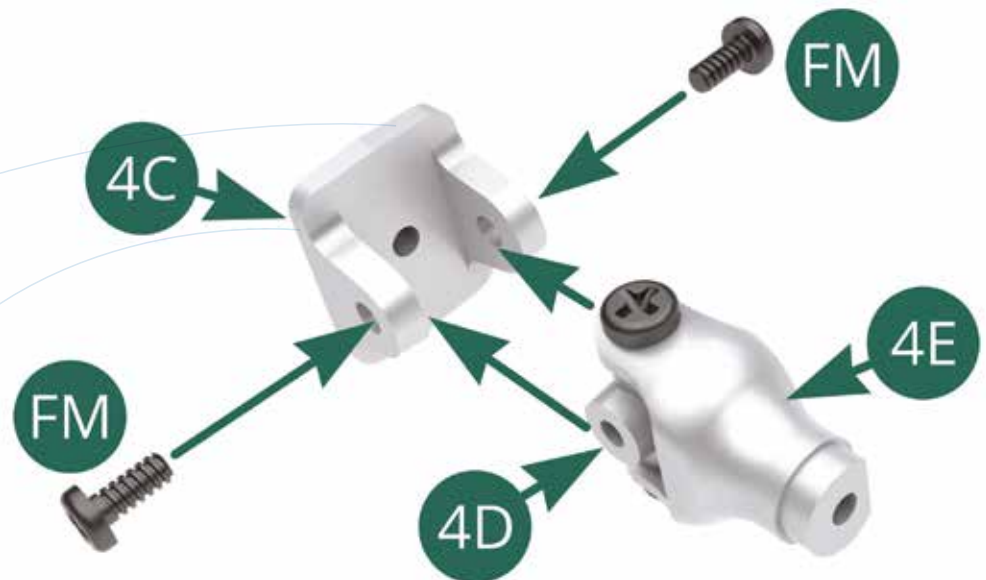


Position the 4D spider on the 4E transmission joint and secure it with two FM screws.

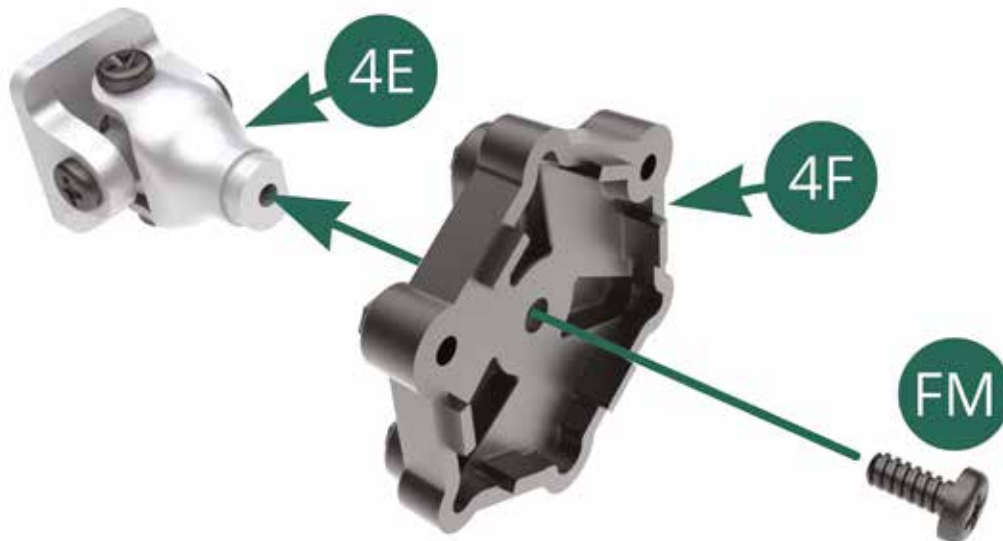


STEP 2

Position the external flector 4G on the internal flector 4F and secure it with two GM screws.

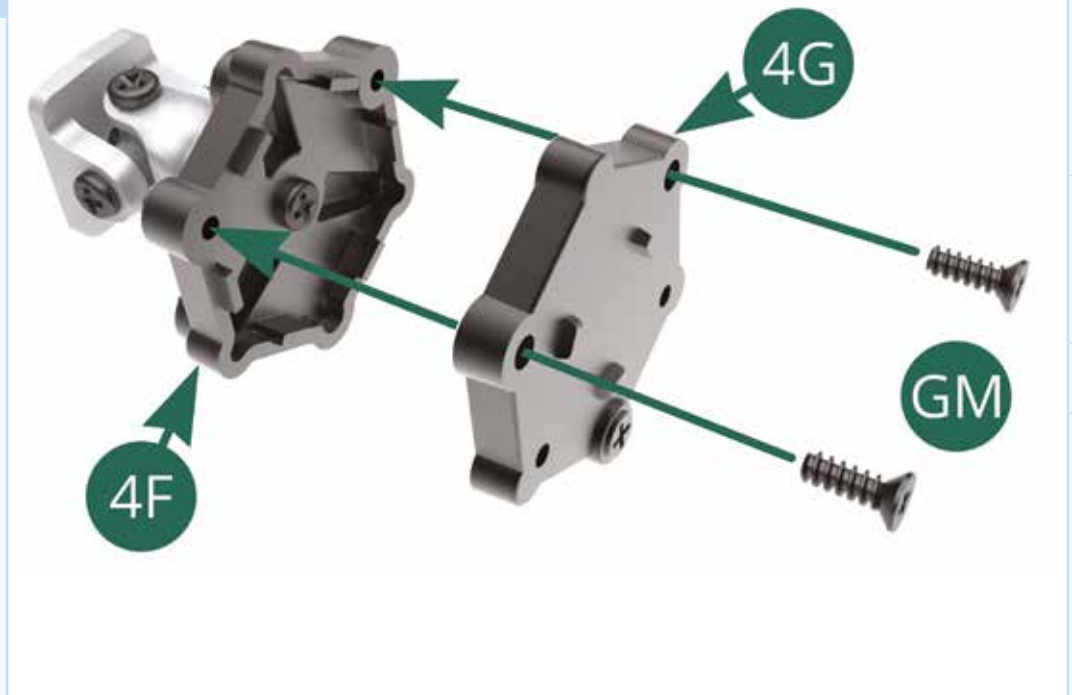


Position the inner flector 4F on the transmission seal 4E and secure it with an FM screw.

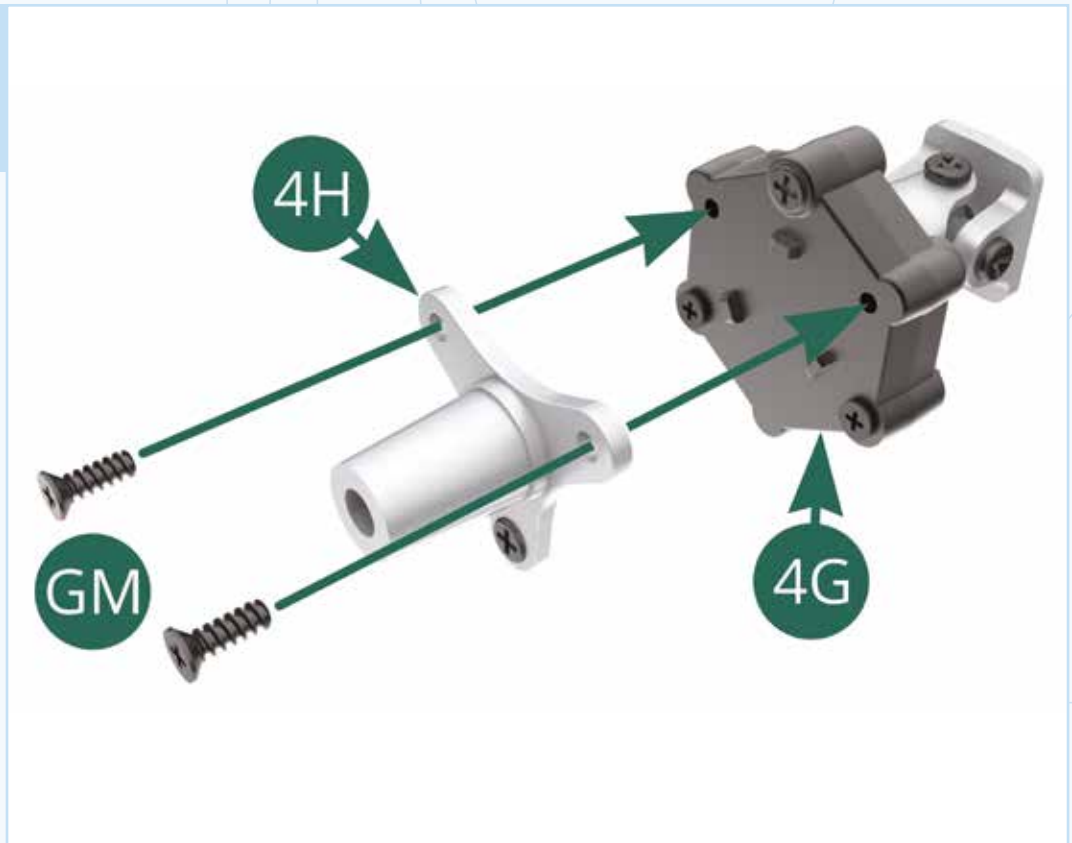


STEP 3

Fit 4G Outer shock absorber to 4F Inner shock absorber and fix with two GM screws.



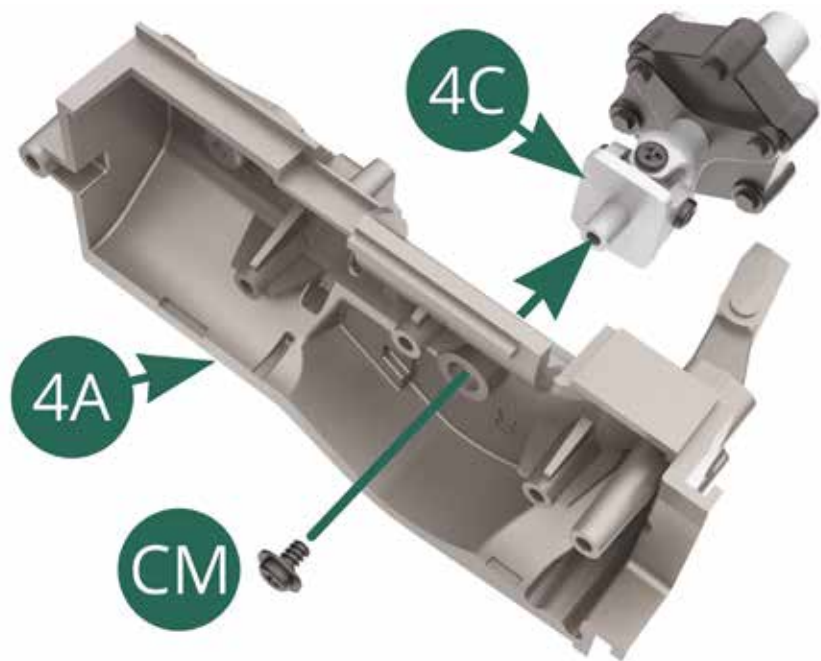
Position the 4H cardan shaft on the external 4G flector and secure it with two GM screws.



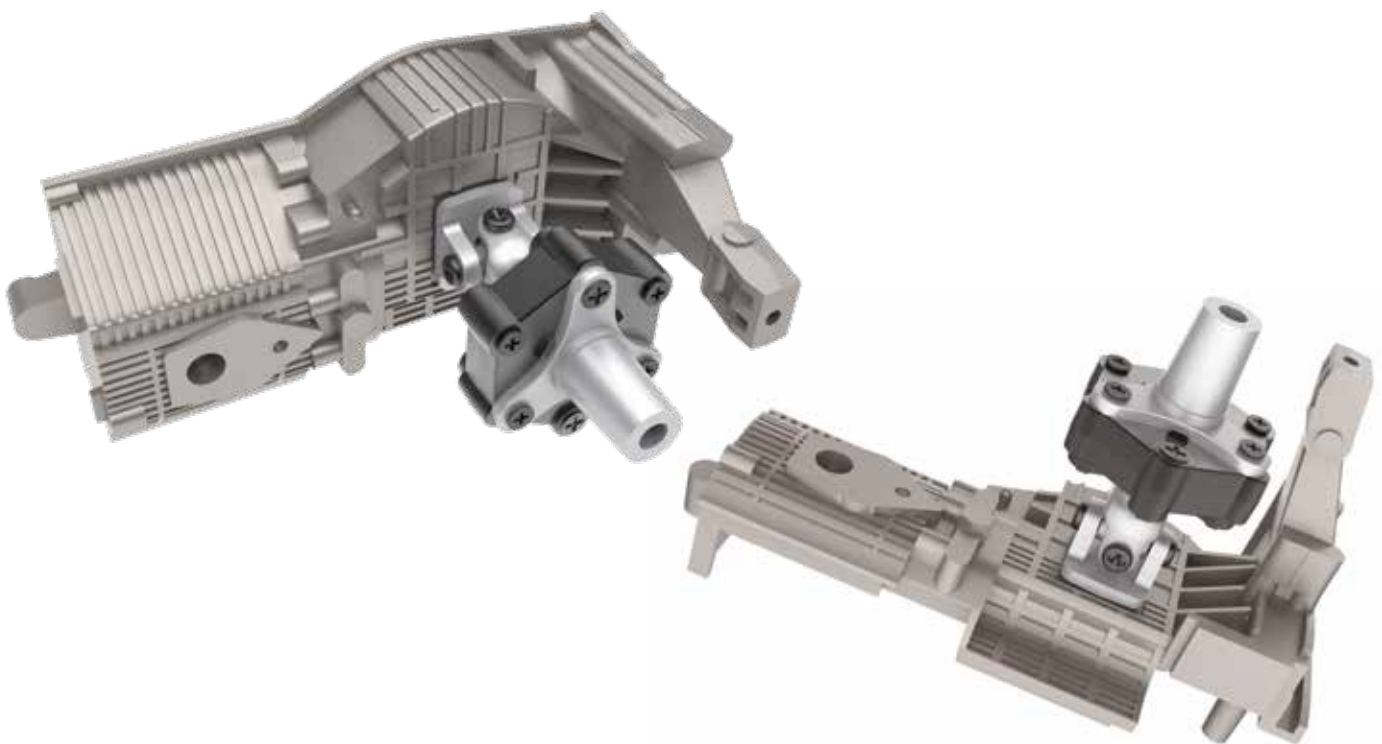


STEP 4

Position the shaft of the 4C transmission seal on the right crankcase of the 4A gearbox and secure it with a CM screw.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 5

5A Gearbox casing bottom panel

5B Inner connection bracket

5C Gearbox control support

5D Gearbox control joint

5E Stabilizing rod

5F Gearbox rear casing

5G Gearbox rear cover

5H Gearbox rear pump

5I Exhaust pipe holder

5K Starter drive side bracket

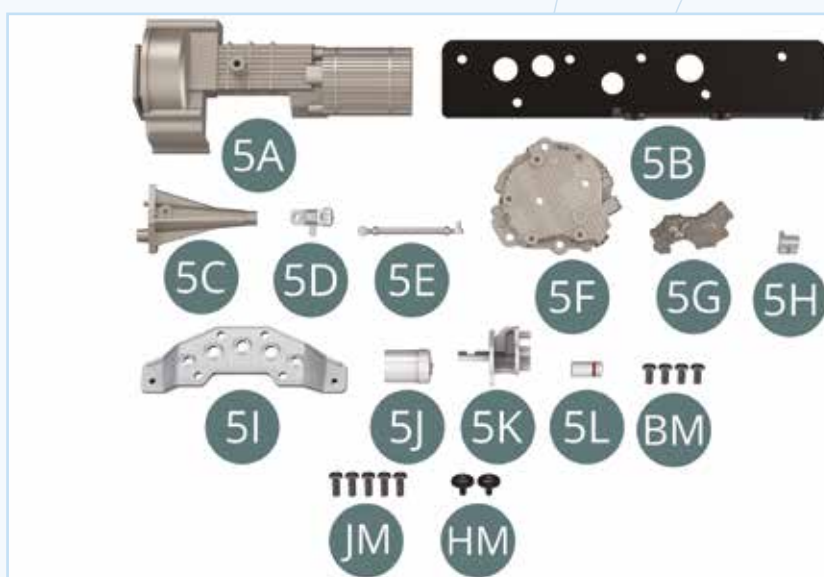
5J Starter motor

5L Starter

BM M2,0 x4mm (x4)

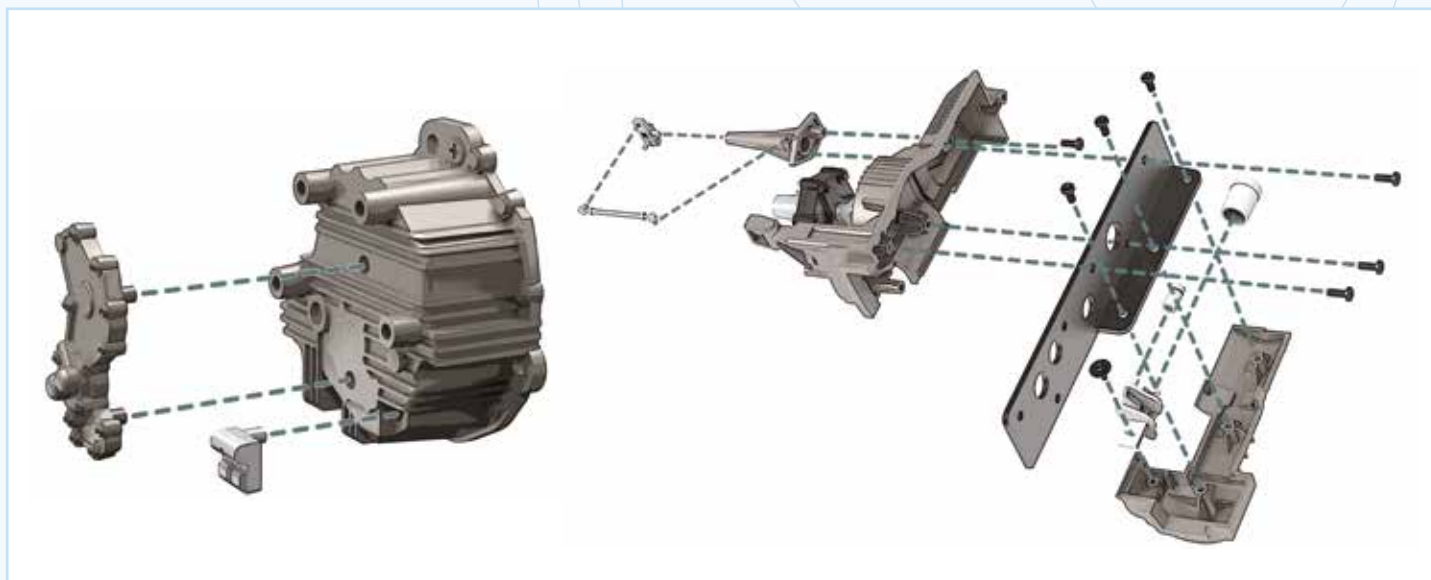
JM M2,0 x5mm (x5)

HM M1,7 x4x6 (x2)



Starter unit
assembly

ASSEMBLY DIAGRAM



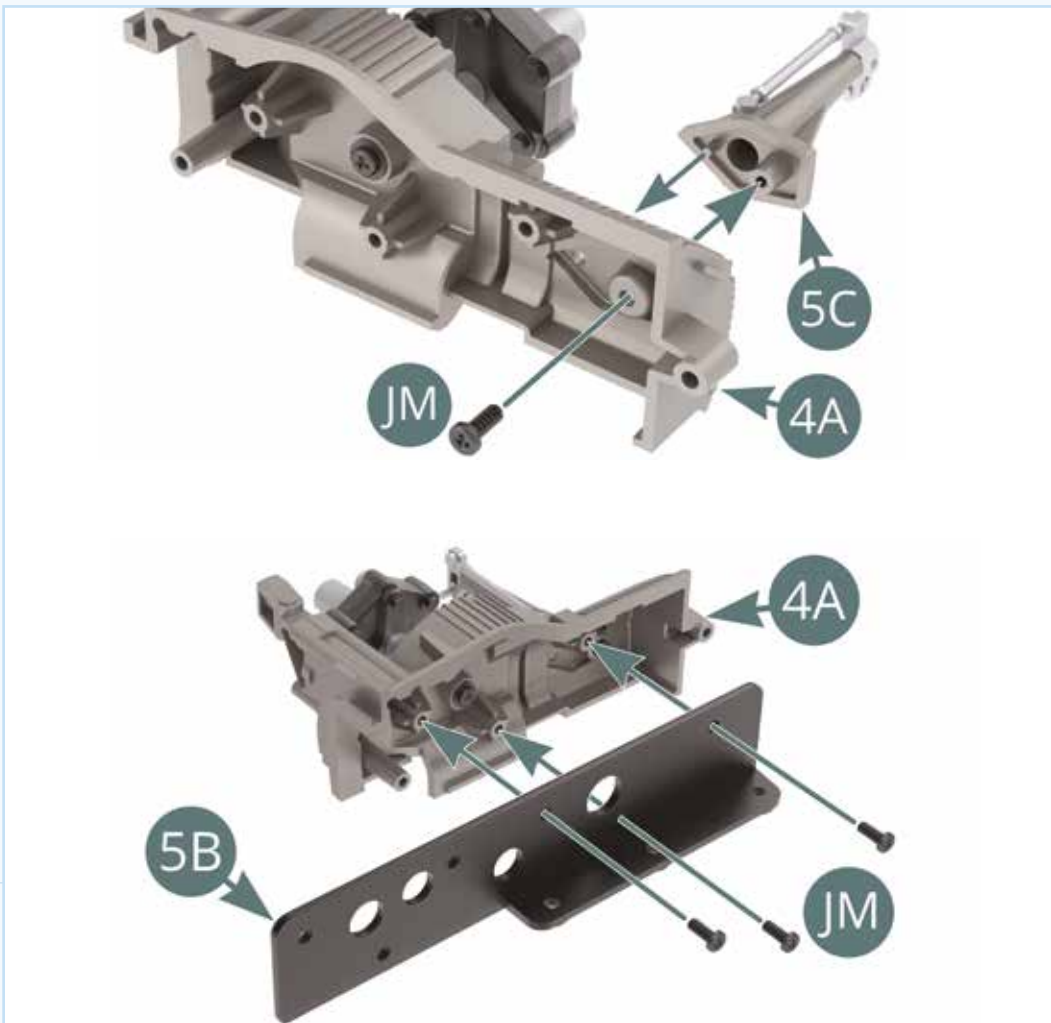


STEP 1

Fit 5D Gearbox control joint to 5C Gearbox control support. Fit 5E Stabilizing rod to 5D Gearbox control joint, and then with rotation motion (blue arrow) fit its end peg into 5C Gearbox control support socket (lower illustrations).



STEP 2

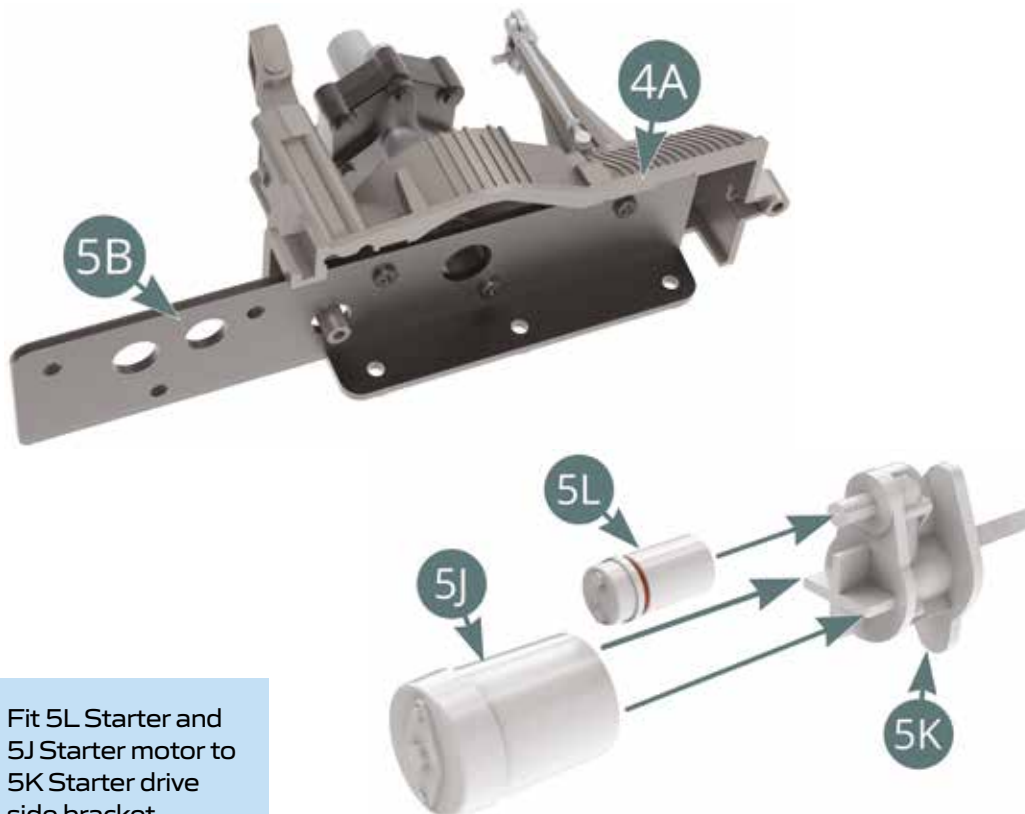


Fit 5C Gearbox control support to 4A Gearbox right side casing and fix with JM screw.

Fit 5B Inner connection bracket to 4A Gearbox right side casing and fix with three JM screws.

STEP 3

5B Inner connection bracket attached to the inner side of 4A Gearbox right side casing.



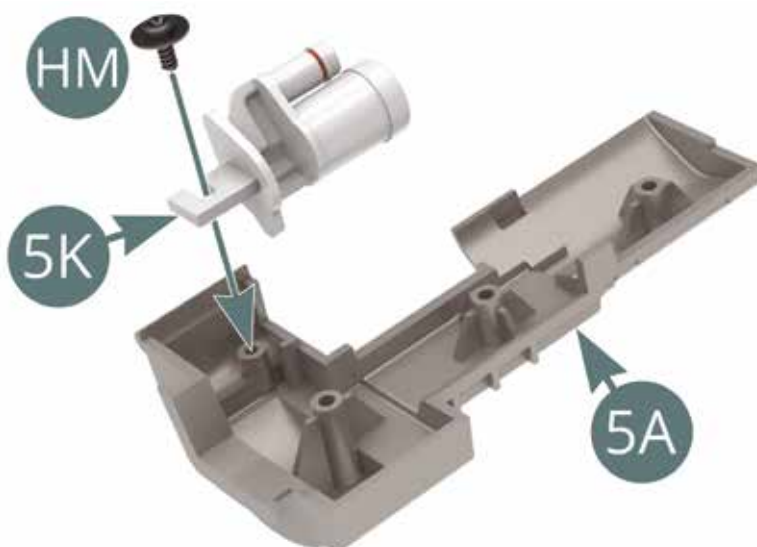
Fit 5L Starter and 5J Starter motor to 5K Starter drive side bracket.

STEP 4

Assembled Starter unit



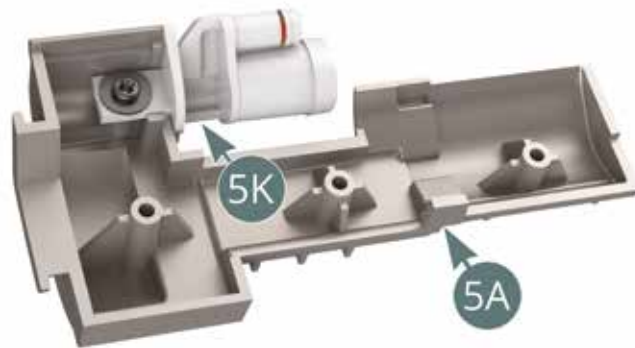
Fit assembled Starter unit by its 5K Starter drive side bracket to 5A Gearbox casing bottom panel and fix with HM screw.



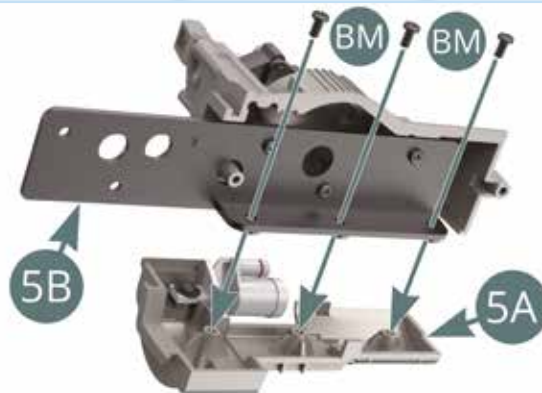


STEP 5

Starter unit attached to Gearbox casing

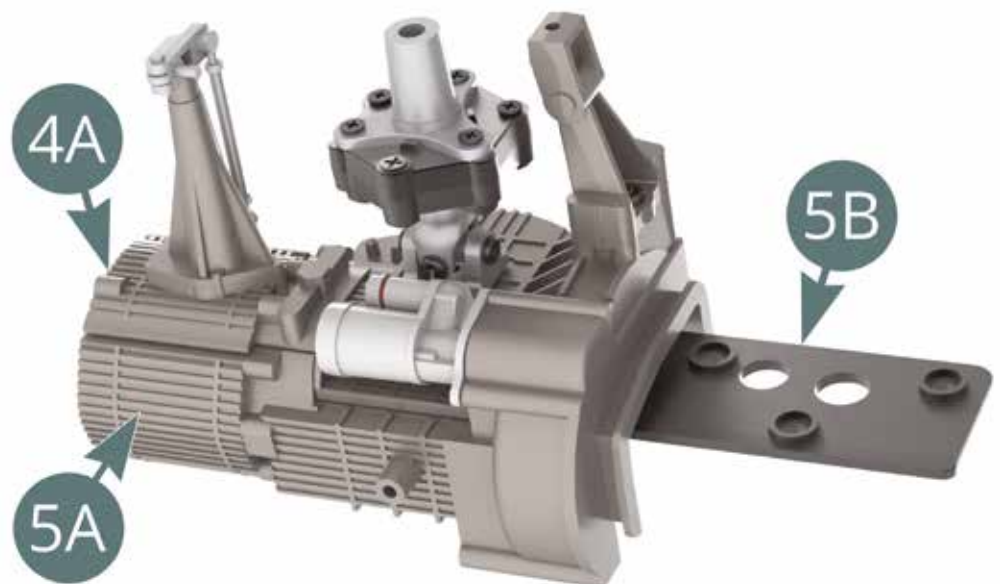


Fit 5A Gearbox casing bottom panel to 5B Inner connection bracket and fix with three BM screws.



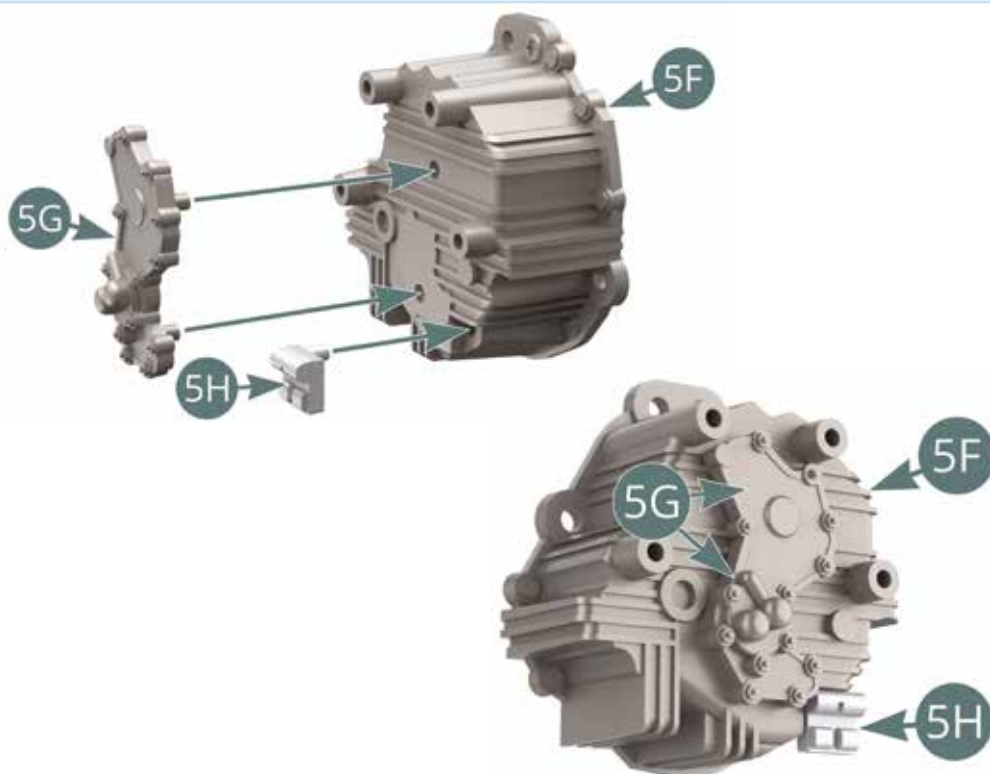
STEP 6

Preassembled 4A Gearbox right side and 5A Bottom Casing panels



STEP 7

Fit 5G Gearbox rear cover and 5H Gearbox rear pump to 5F Gearbox rear casing (top and bottom illustrations).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 6

6A Left gearbox housing

6B Left side mounting bracket

6C Transmission joint

6D Cross

6E Transmission joint

6F Flector interior

6G Flector outdoor

6H Cardan tulip

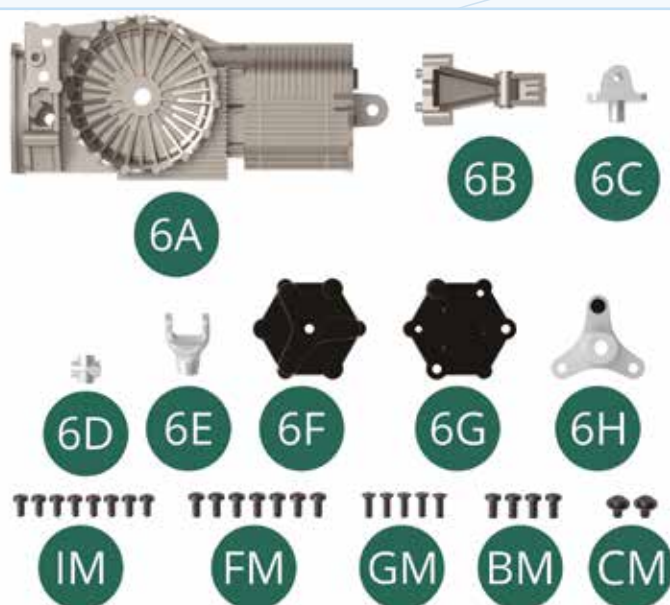
IM Screw M 1.7 x 3.5 mm (x 8)

FM Screw M 1.7 x 4 mm (x 7)

GM Screw M 1.7 x 5 mm (x 5)

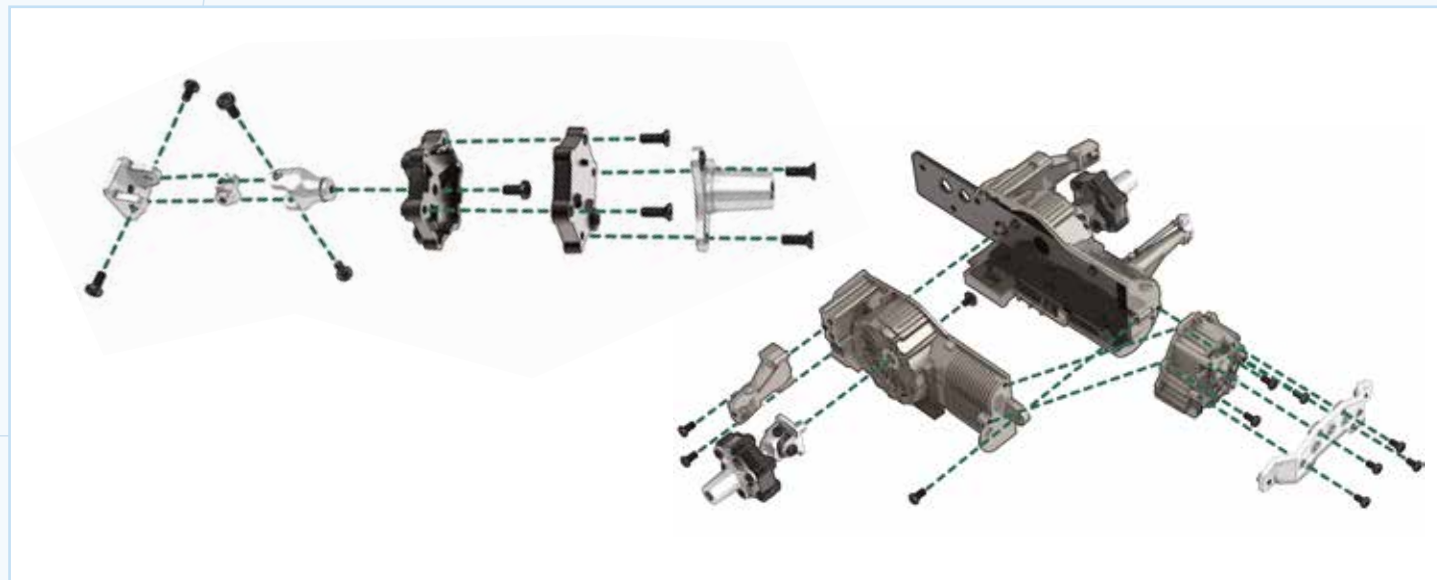
BM Screw M 2.0 x 4 mm (x 4)

CM Screw M 2,0 x 3 x 5 mm (x 2)



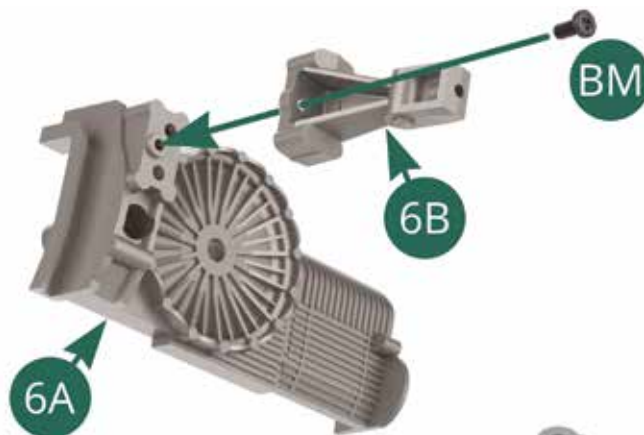
*Gear box left side
casing and drive shaft
preassembly
Full gearbox casing
assembly*

ASSEMBLY DIAGRAM

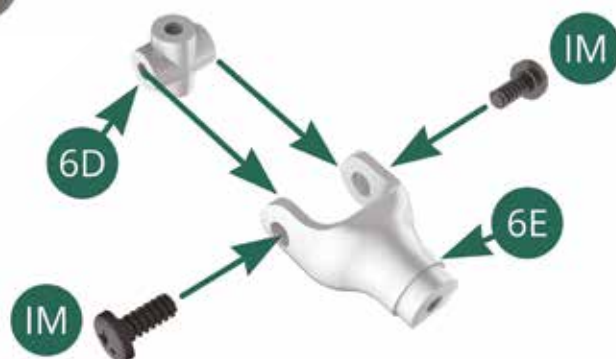


STEP 1

Position the left side mounting bracket 6B on the left gearbox housing 6A and secure it with a BM screw.

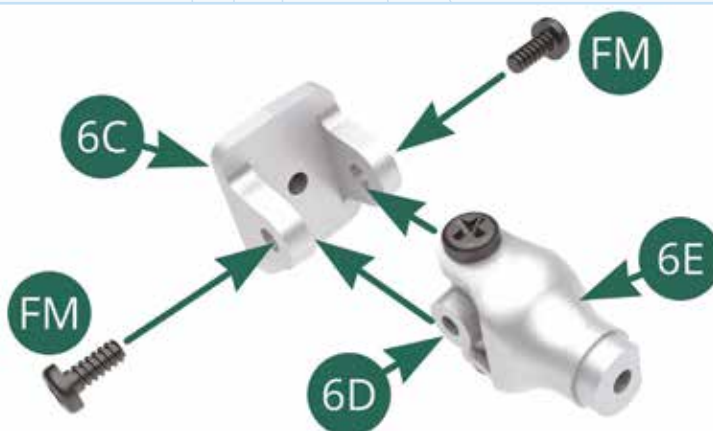


Position the crossbar 6D on the transmission joint 6E and secure it with two IM screws.



STEP 2

Position the crossbar 6D on the transmission joint 6C and secure it with two FM screws.



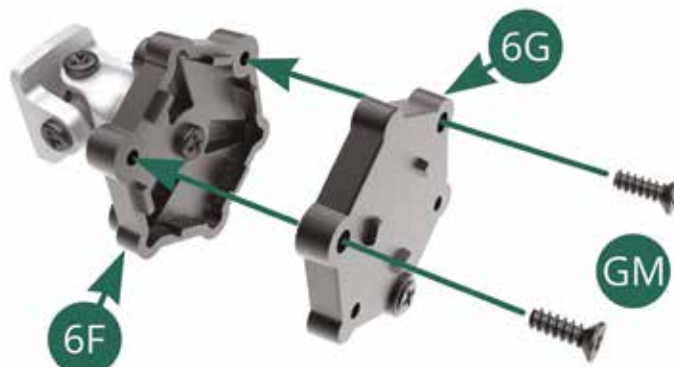
Position the inner flexor 6F on the transmission joint 6E and secure it with an IM screw.



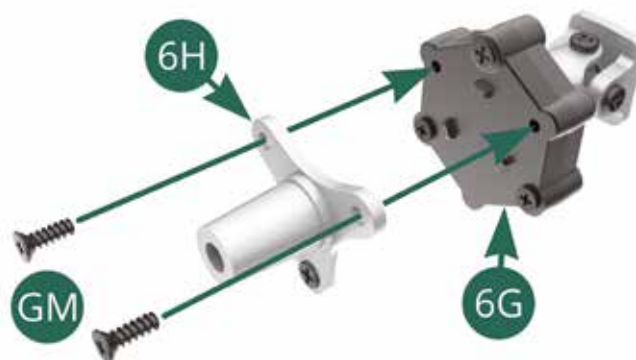


STEP 3

Position the exterior Flector 6G on the interior Flector 6F and secure it with two GM screws.

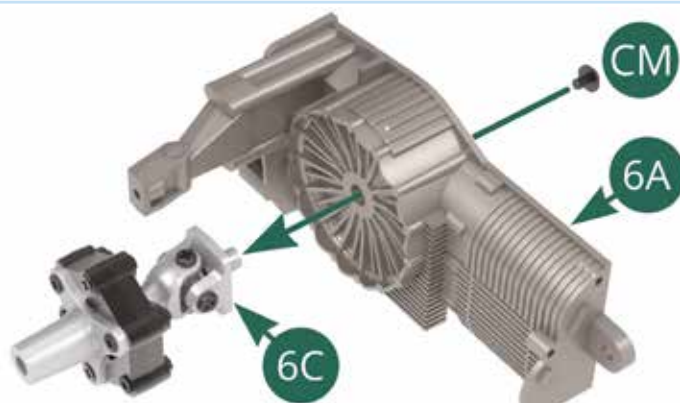


Position the 6H cardan tulip on the 6G external Flector and secure it with two GM screws.

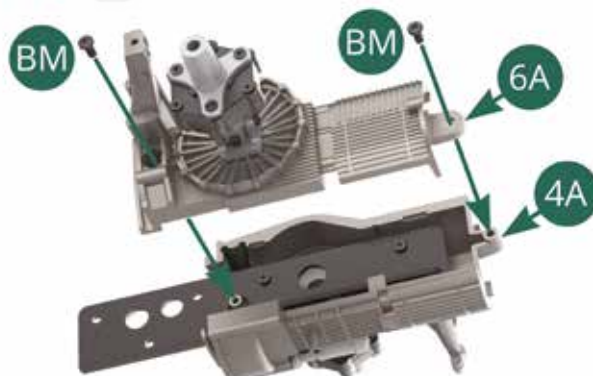


STEP 4

Position the shaft of the 6C transmission seal on the left housing of the 6A gearbox and secure it with a CM screw.

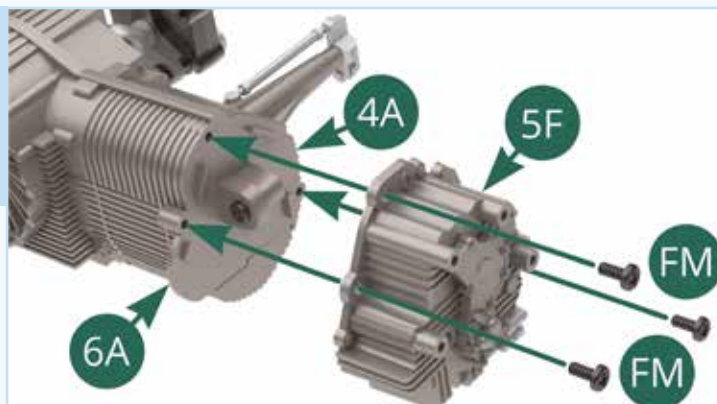


Position the left casing of the 6A gearbox on the right casing 4A and secure the assembly with two BM screws.

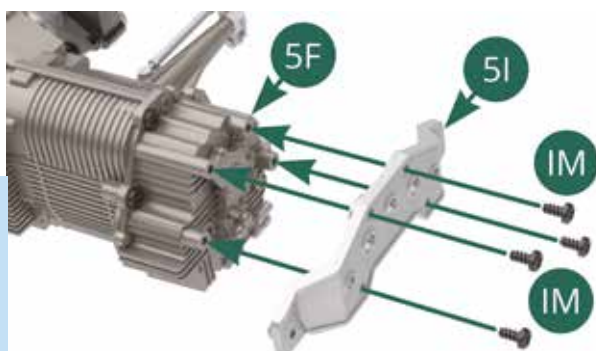


STEP 5

Position the 5F gearbox rear casing on the end of the right and left casings and secure it with three FM screws.



Position the 5I exhaust pipe bracket on the 5F gearbox rear housing and secure it with four IM screws.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 7

7A Right Engine block

7B Camshaft drive housing

7C Camshaft drive cover

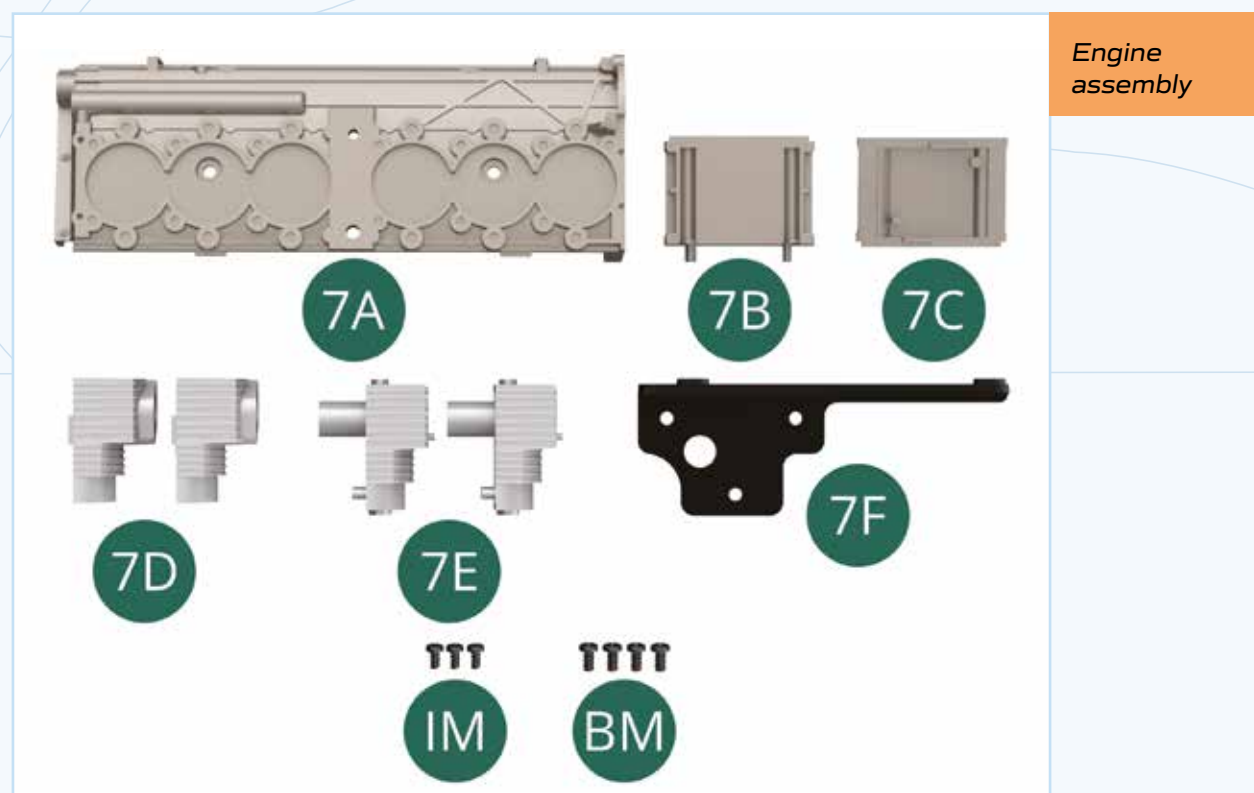
7D Cylinder upper part (x2)

7E Cylinder lower part (x2)

7F Connection bracket

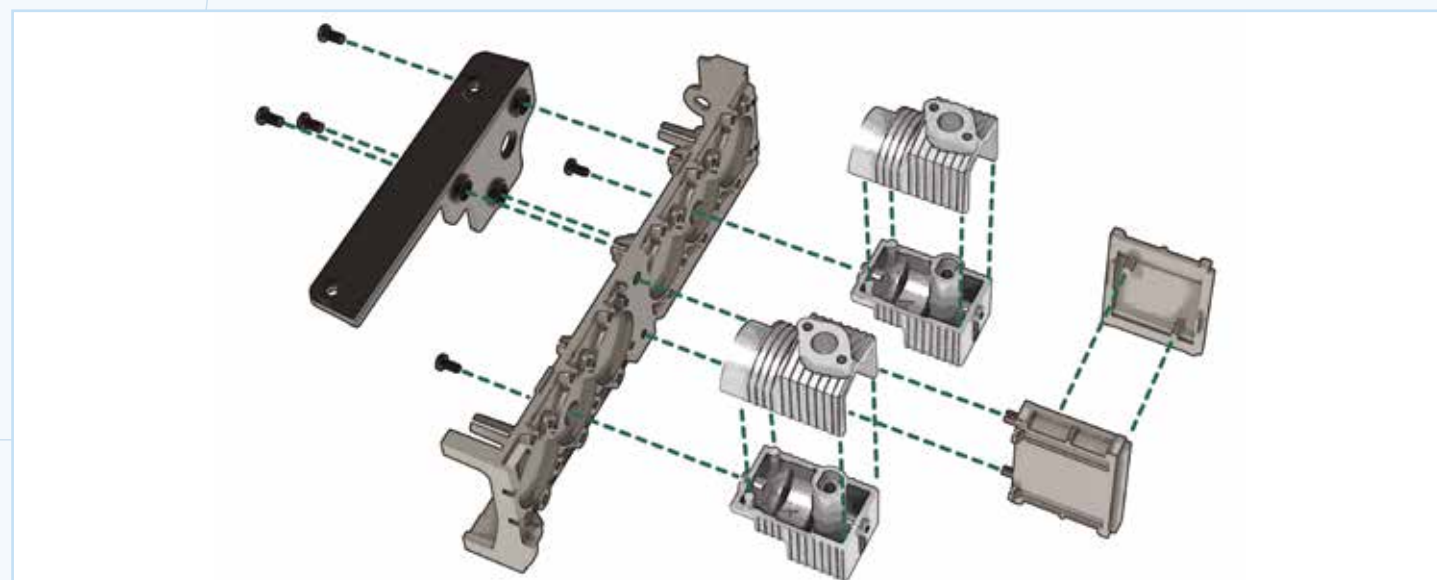
IM M1,7 x3,5mm (x3)

BM M2,0 x4mm (x4)



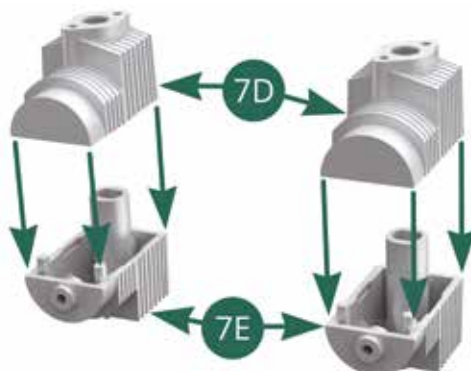
Engine
assembly

ASSEMBLY DIAGRAM

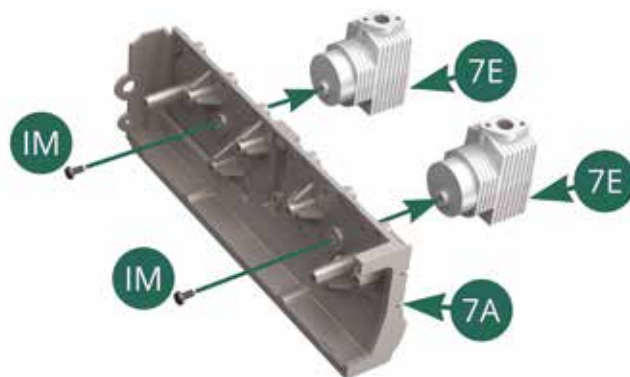


STEP 1

Fit together 7D Cylinder upper and 7E Cylinder lower parts forming two preassembled Cylinders.

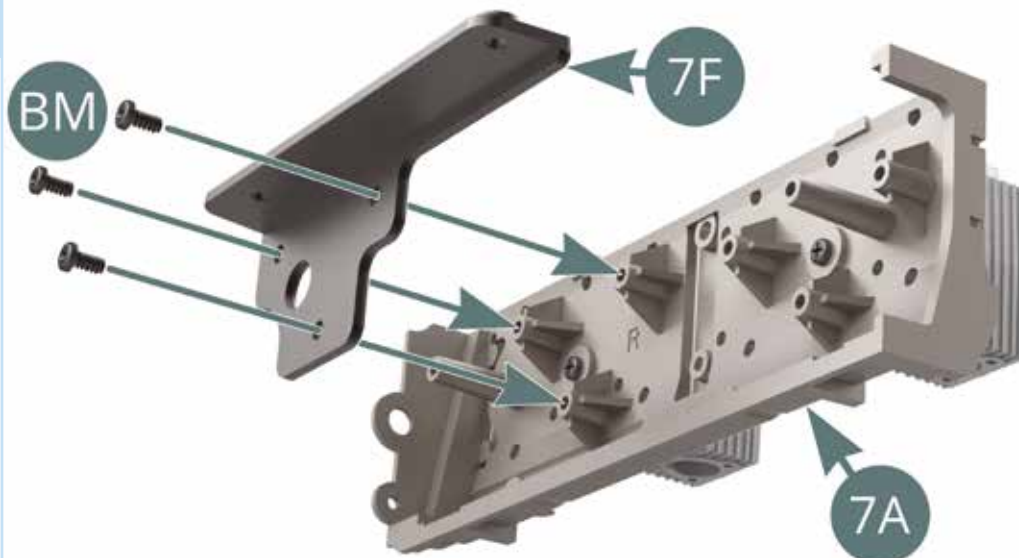


Fit two preassembled Cylinders by their 7E Lower parts to 7A Right Engine Block wall and fix with two IM screws.



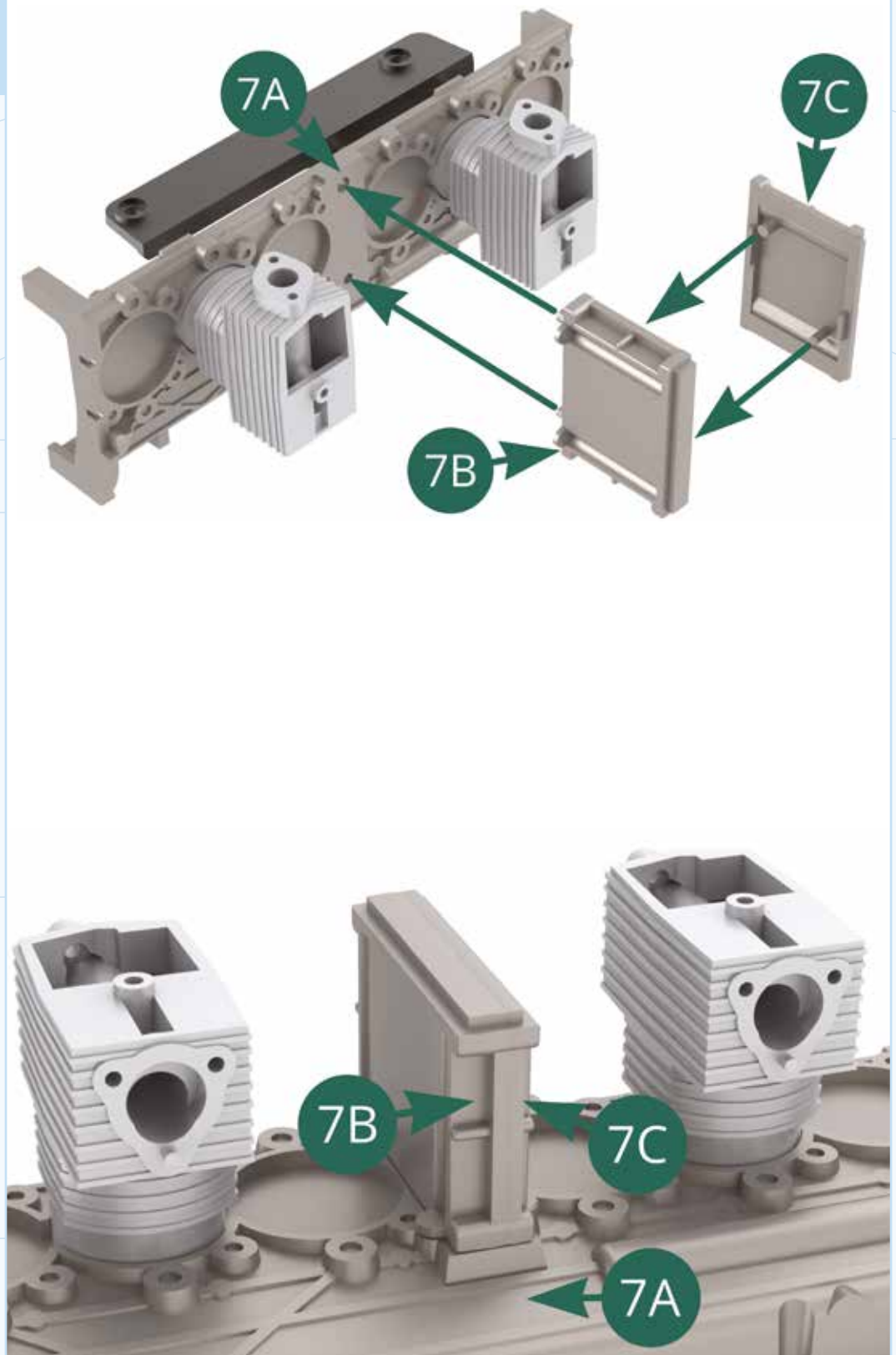
STEP 2

Fit 7F Connection bracket to inner side of 7A Right Engine block wall and fix with three BM screws.



STEP 3

Attach 7C Camshaft drive cover to 7B Camshaft drive housing and fit the latter to 7A Right engine block on its two pins (upper and lower illustrations).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 8

8A Water pump housing

8B Oil pump

8C Oil hose (x 2)

8D Oil filter holder

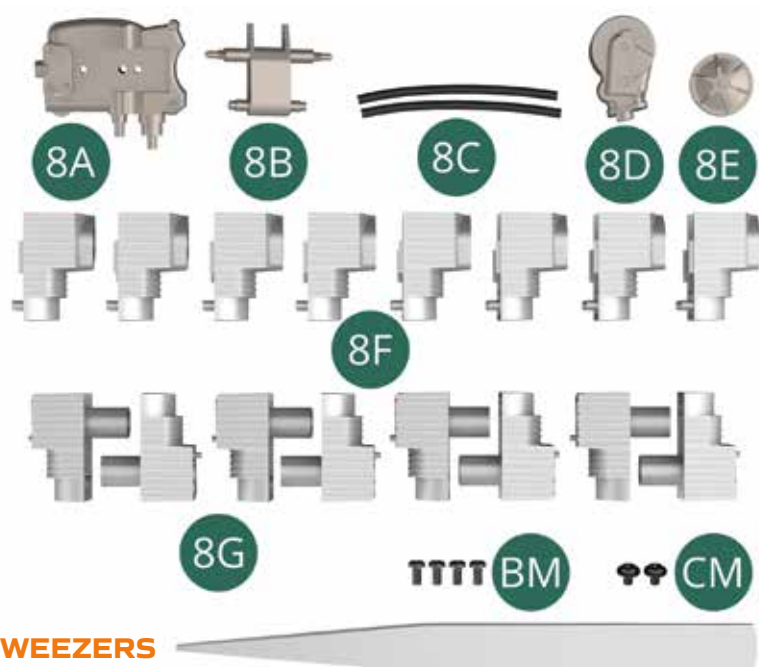
8E Oil filter cover

8F Upper cylinder part (x 8)

8G Lower part of cylinder (x 8)

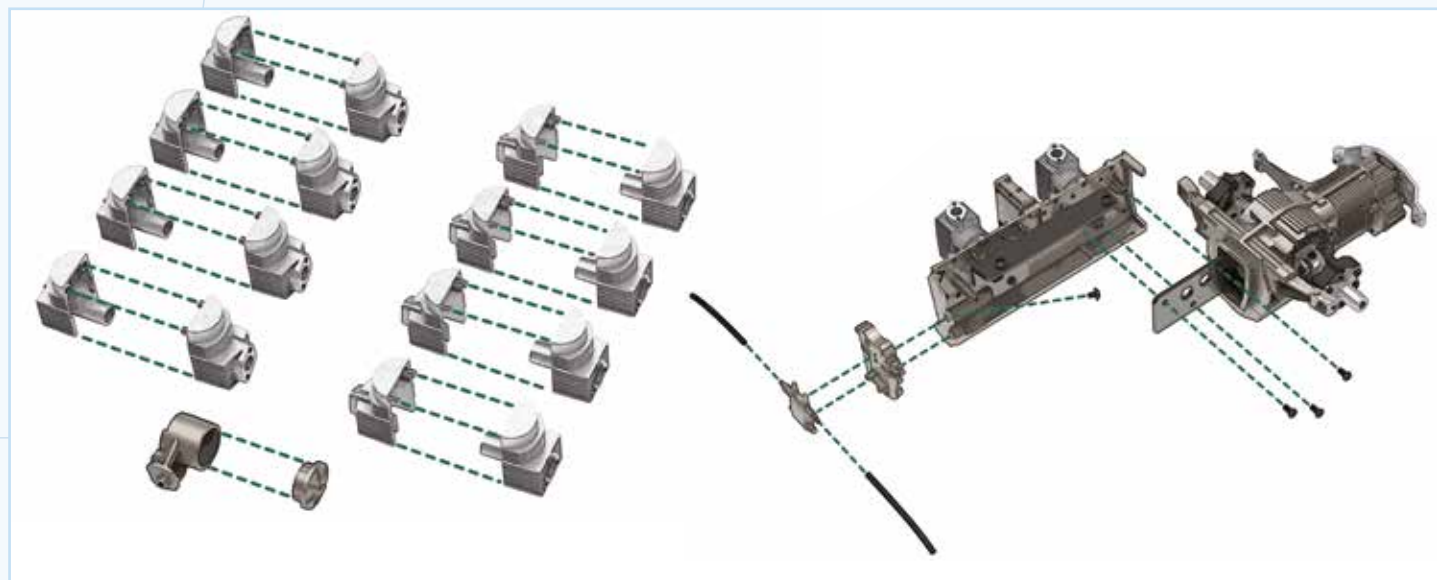
BM Screw M 2.0 x 4 mm (x 4)

CM Screw M 2,0 x 3 x 5 mm (x 2)



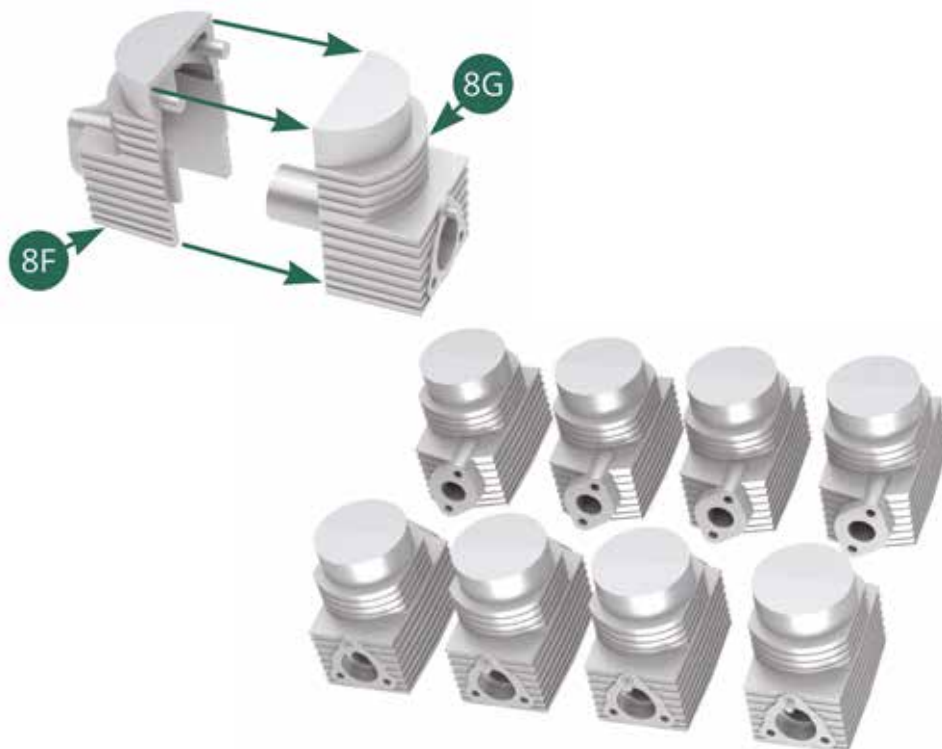
Engine, and engine components assembly
Engine connection with transmission body

ASSEMBLY DIAGRAM



STEP 1

Assemble simultaneously the upper parts 8F and the lower parts 8G to form eight cylinders as in the illustration below.

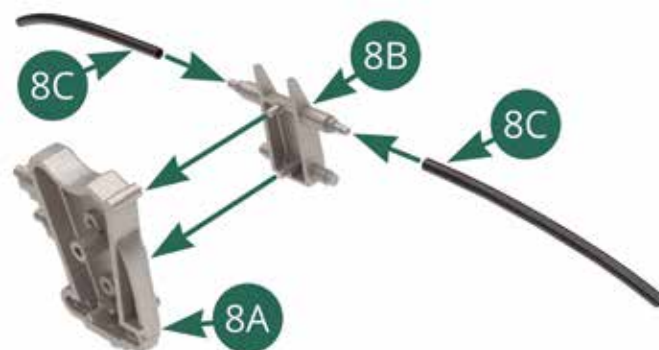


STEP 2

Position the oil filter cover 8E on the support 8D.



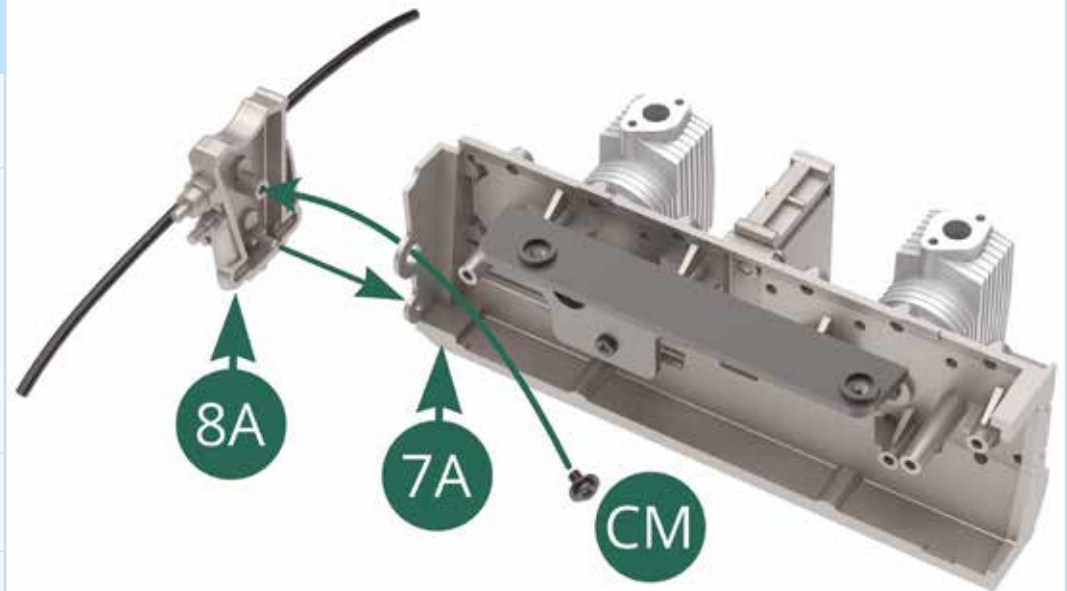
Connect the two oil hoses 8C to the oil pump 8B. Position the oil pump 8B on the water pump housing 8A.



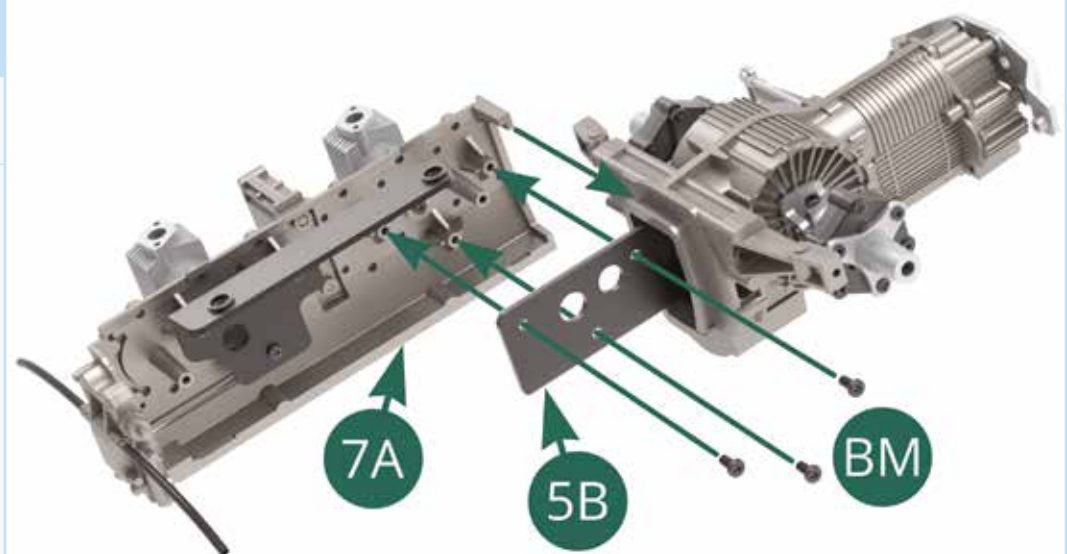


STEP 3

Position the water pump housing 8A at the end of the right engine block 7A and secure it with a CM screw.

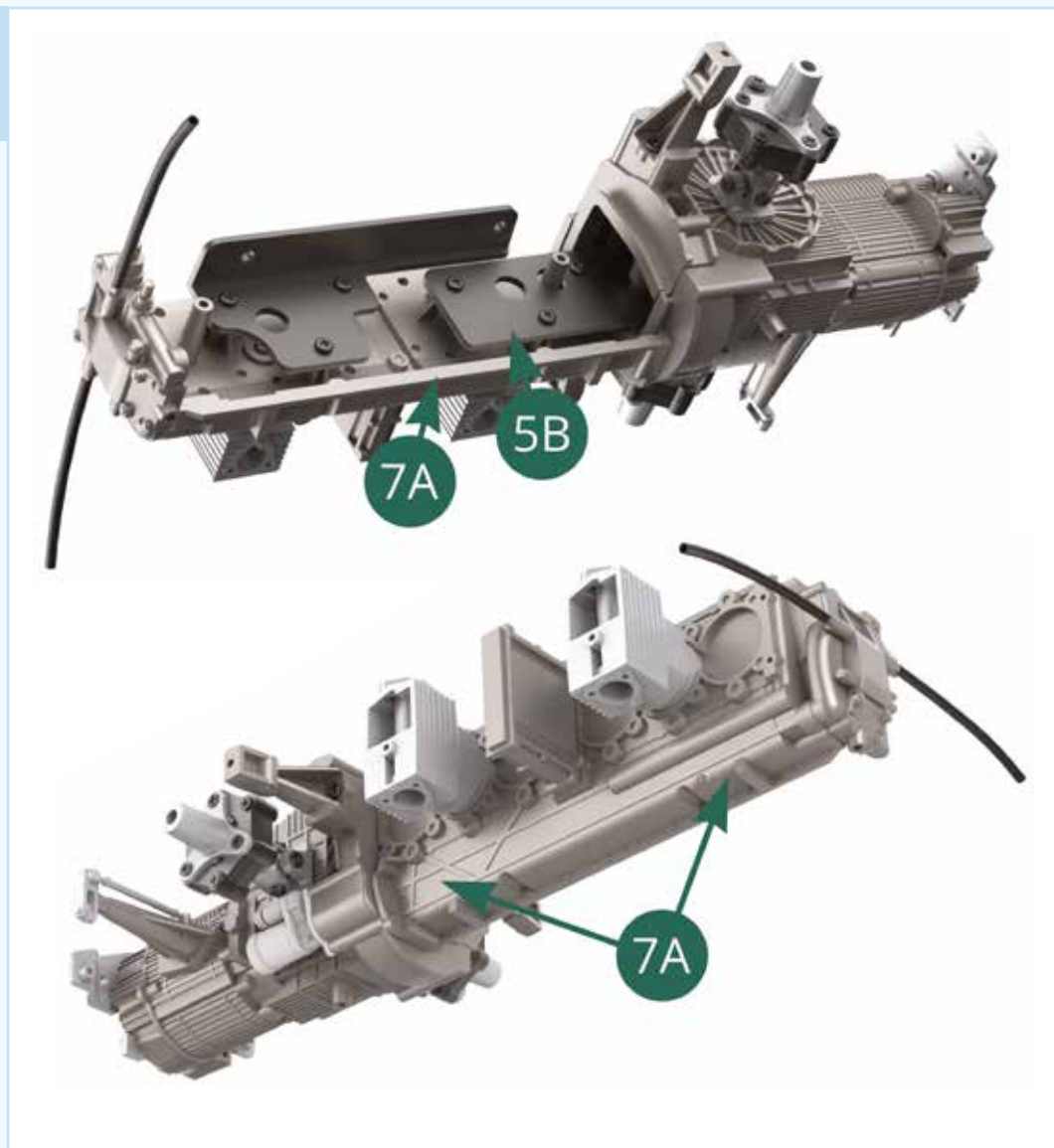


Position the right engine block 7A on the internal support 5B of the assembled transmission and secure it with three BM screws.



STEP 4

Right engine block
mounted
on transmission



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 9

9A Right cylinder head

9B Spark plugs (x 12 + 6 additional)

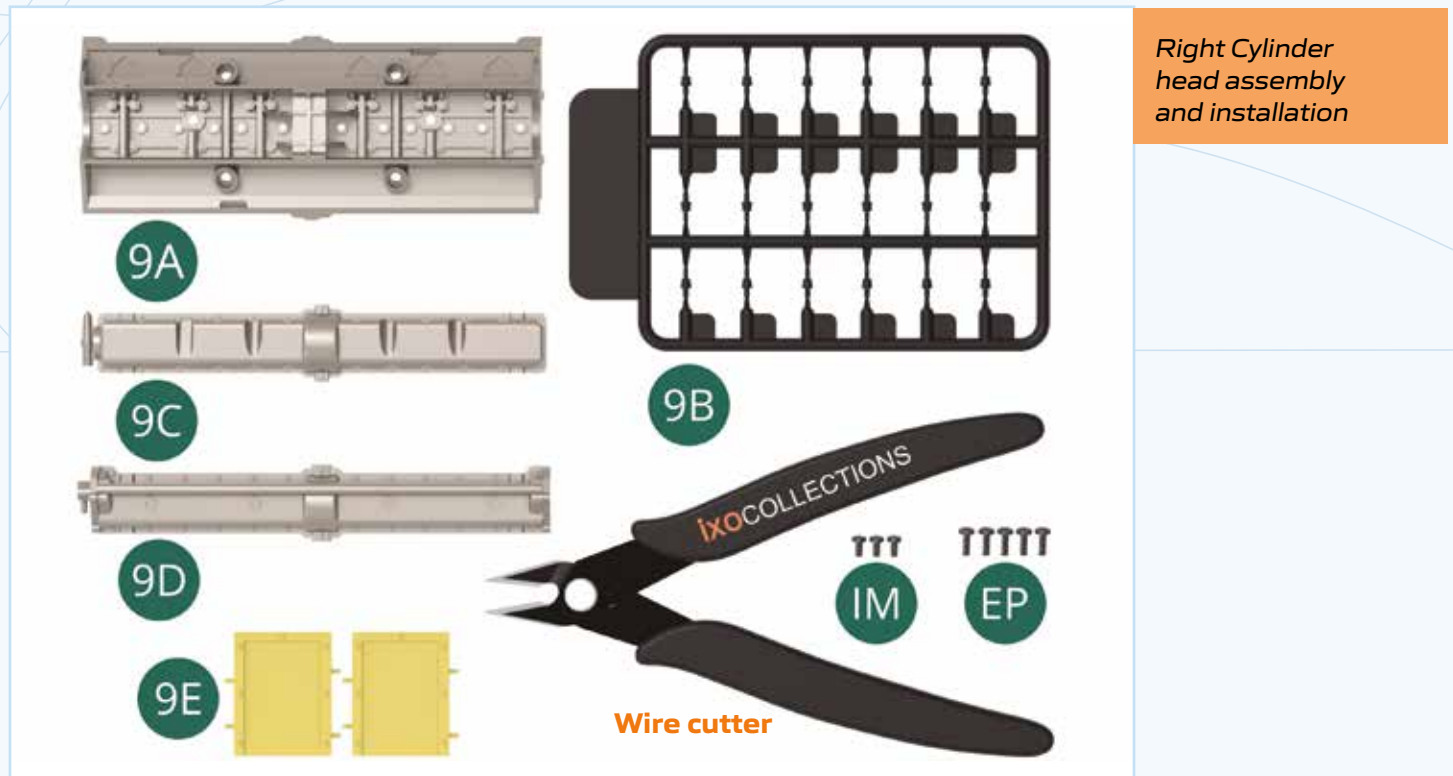
9C Intake valve cover

9D Exhaust valve cover

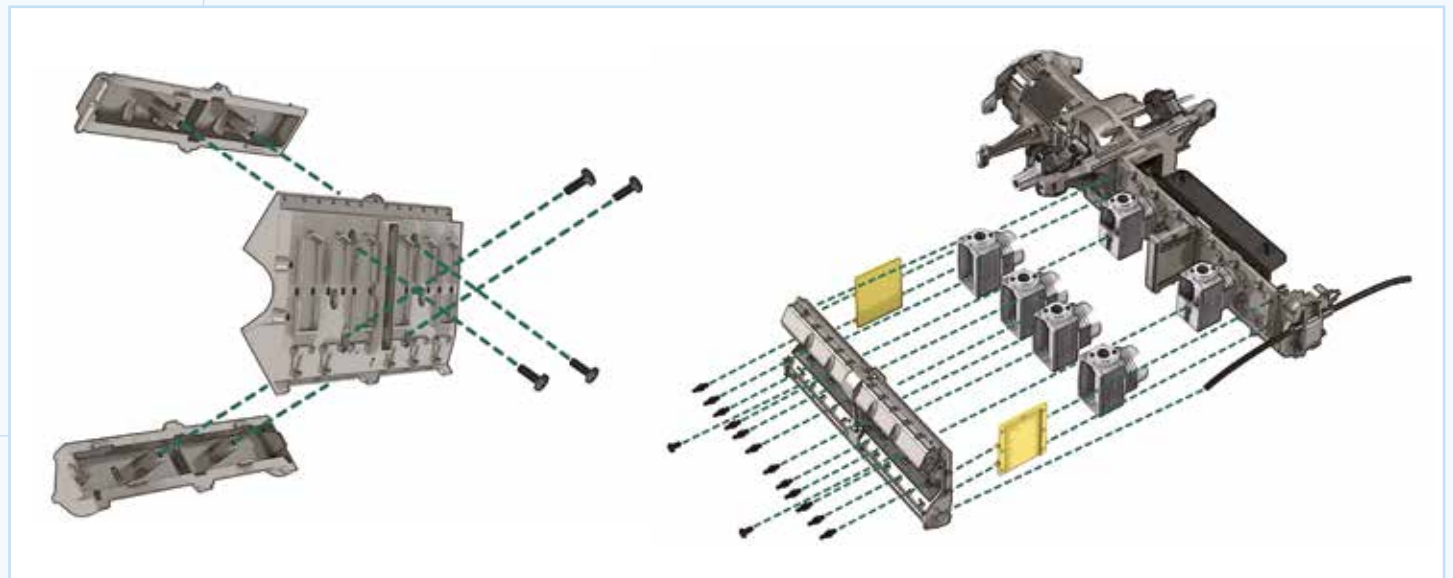
9E Bulkhead (x 2)

IM Screw M 1.7 x 3.5 mm (x 3)

EP Screw M 1.7 x 5 mm (x 5)

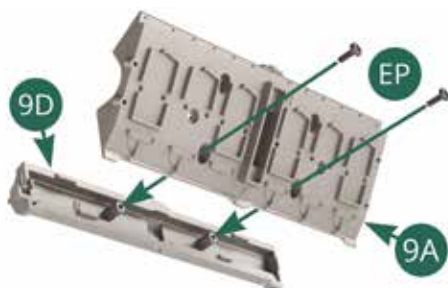


ASSEMBLY DIAGRAM

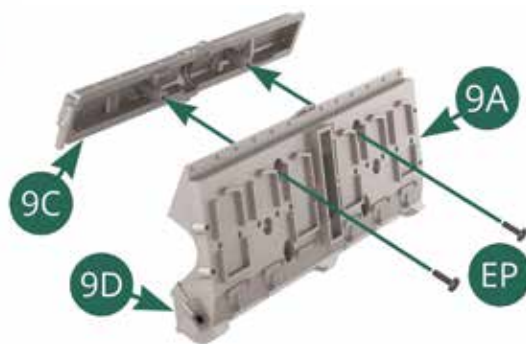


STEP 1

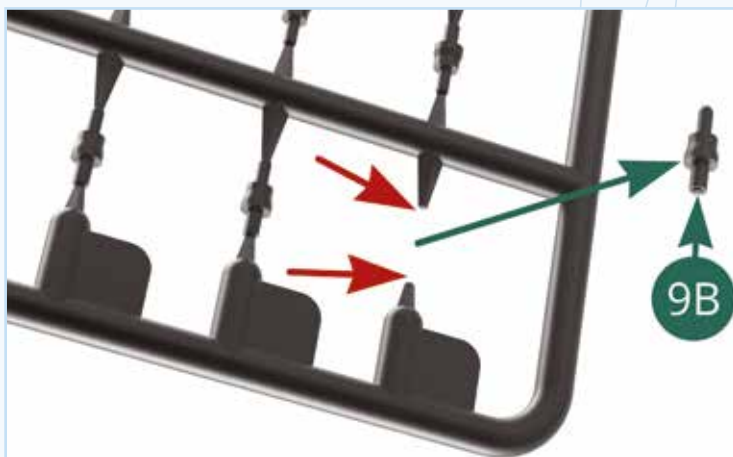
Position the exhaust valve cover 9D on the underside of the right cylinder head 9A and secure it with two EP screws.



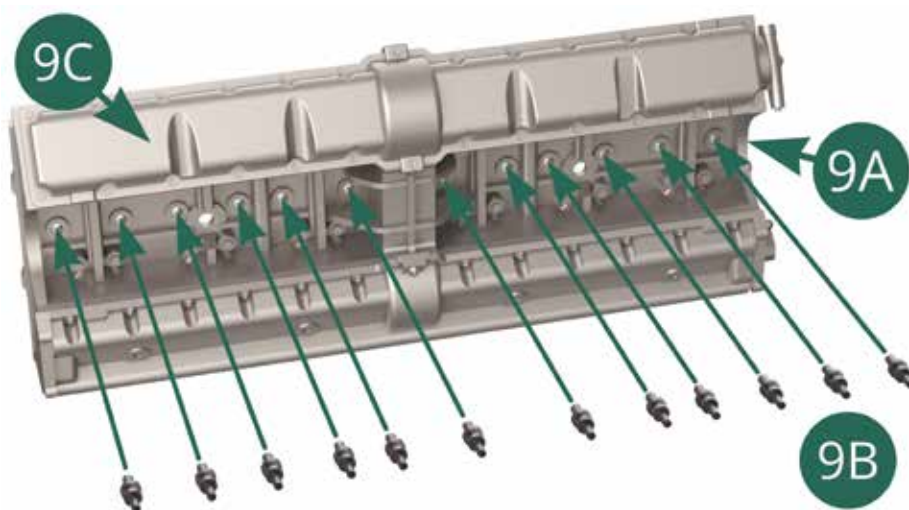
Position the intake valve cover 9C on the upper side of the right cylinder head 9A and secure it with two EP screws.



STEP 2



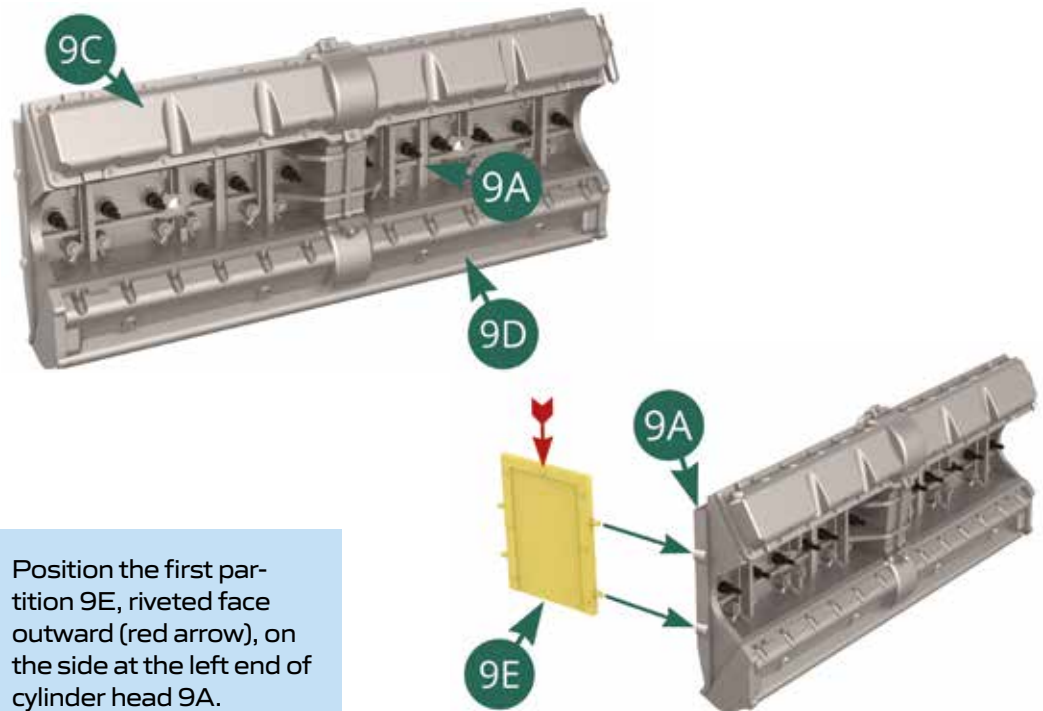
Detach twelve spark plugs 9B from the support using the pliers and tweezers, then position them on the right cylinder head 9A (illustrations below).





STEP 3

9C and 9D valve covers and 9B spark plugs installed on the right cylinder head.

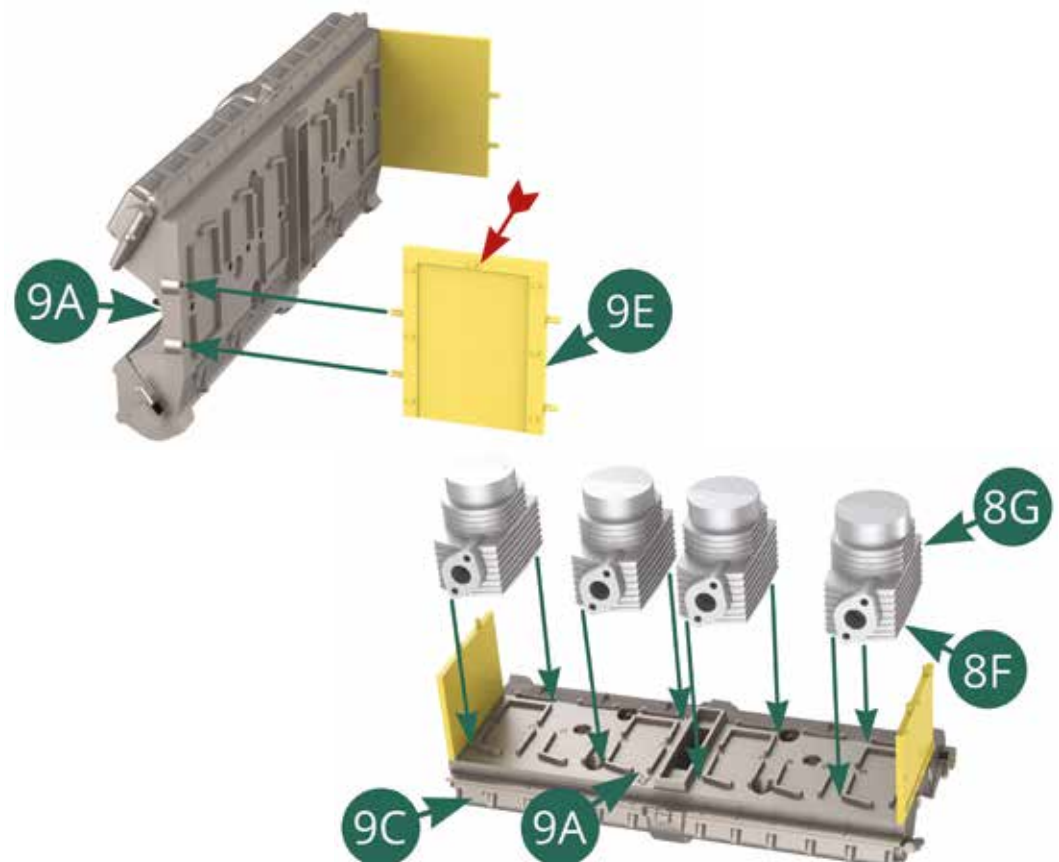


Position the first partition 9E, riveted face outward (red arrow), on the side at the left end of cylinder head 9A.

STEP 4

Position the second bulkhead 9E, riveted face outward (red arrow), on the side at the right end of cylinder head 9A.

Position four cylinders composed of elements 8F and 8G in the guide ribs on the rear wall of the right cylinder head 9A.

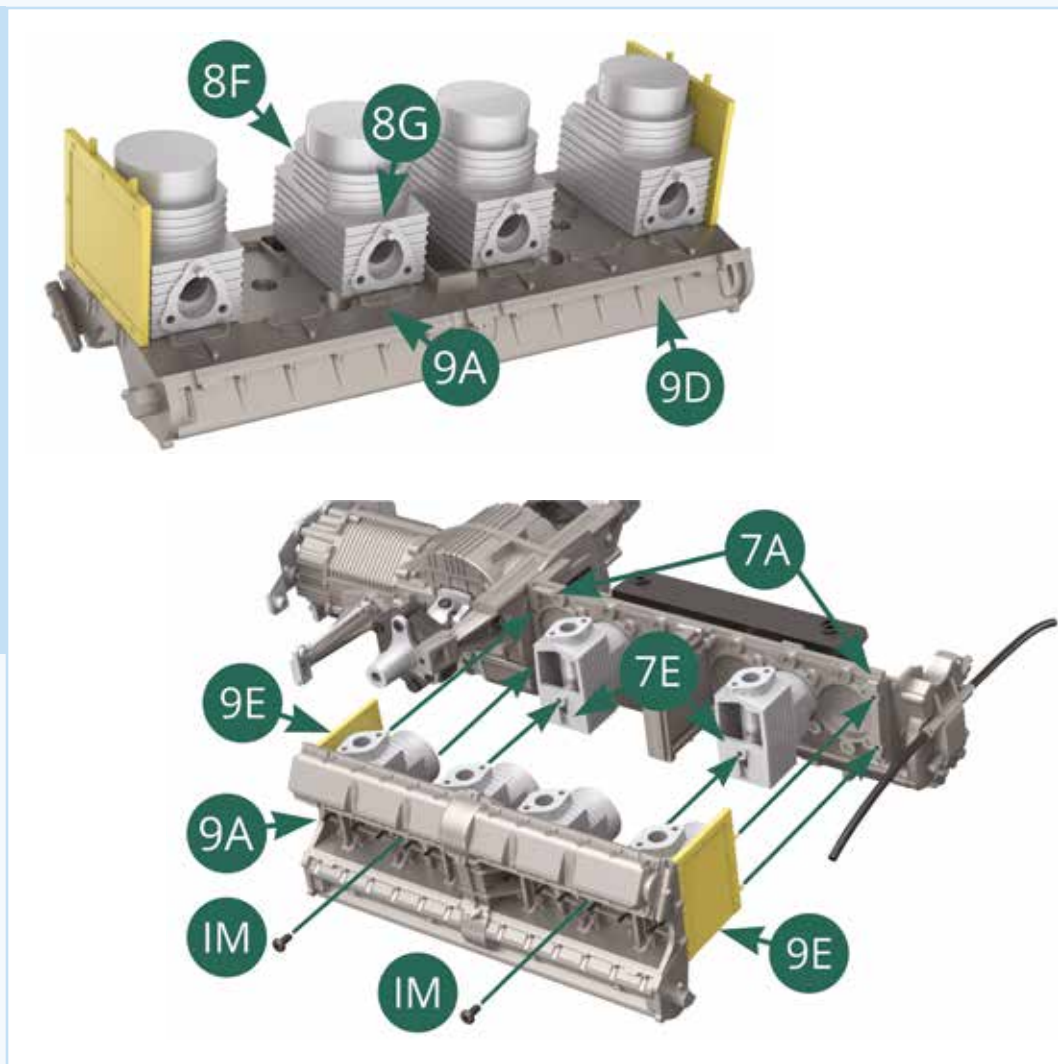


STEP 5

Four preassembled cylinders installed on the rear wall of the right cylinder head 9A.

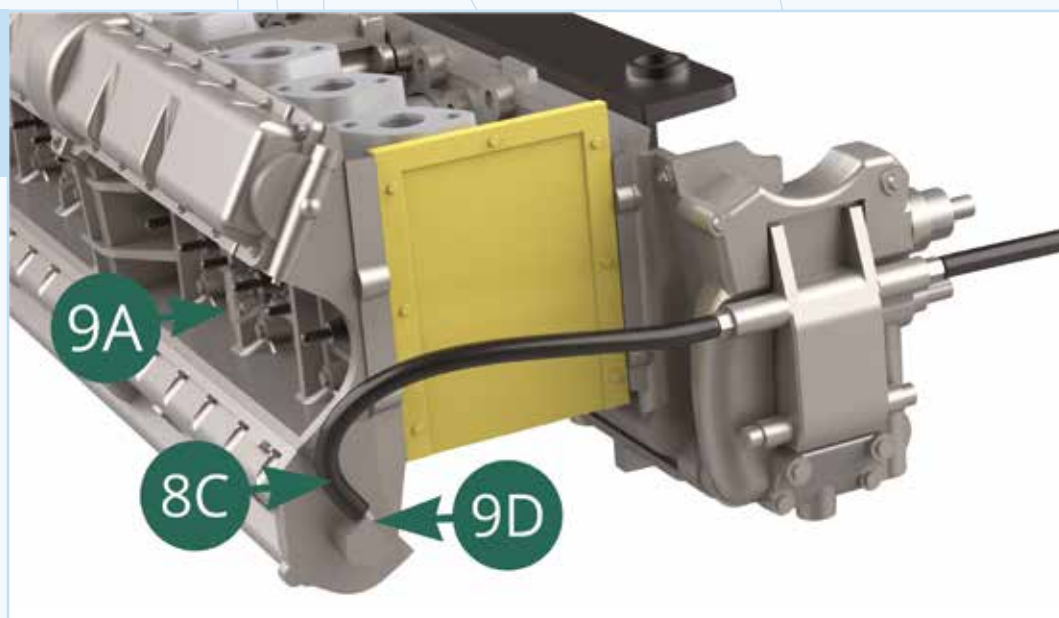
Position the right cylinder head 9A, with its four cylinders and its two partitions 9E, on the right engine block 7A and its two lower cylinder parts 7E, then secure it with two IM screws.

During assembly, keep cylinder head 9A upright so that the four cylinders do not move.

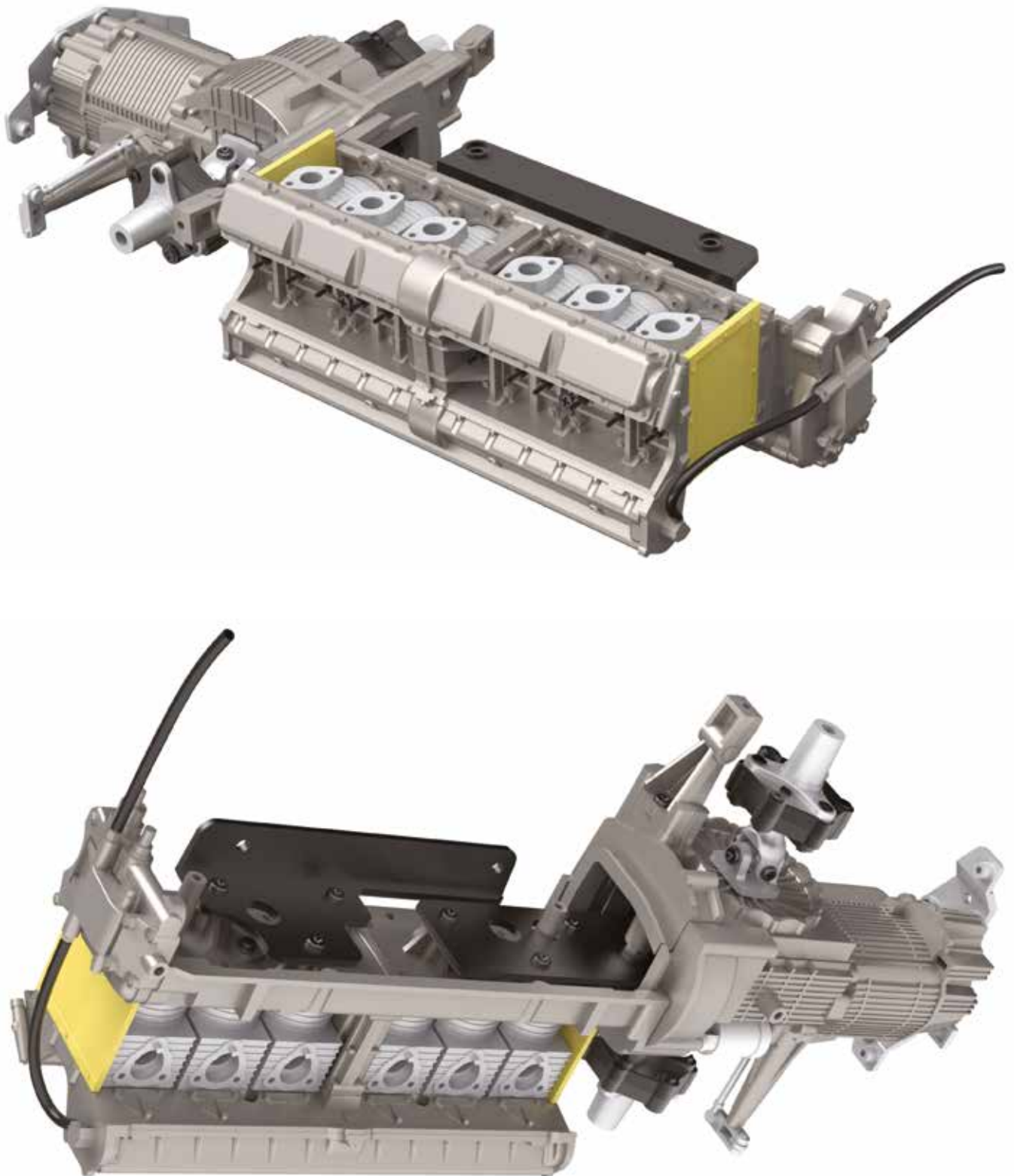


STEP 6

Connect the 8C oil hose to the nozzle located at the end of the 9D exhaust valve cover.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 10

10A Crankcase top

10B Pulley

10C O-ring

10D Generator (x 2)

10E Front cover and axle (x 2)

10F Pulley (x 2)

10G O-ring (x 2)

10H Distributor base (x 2)

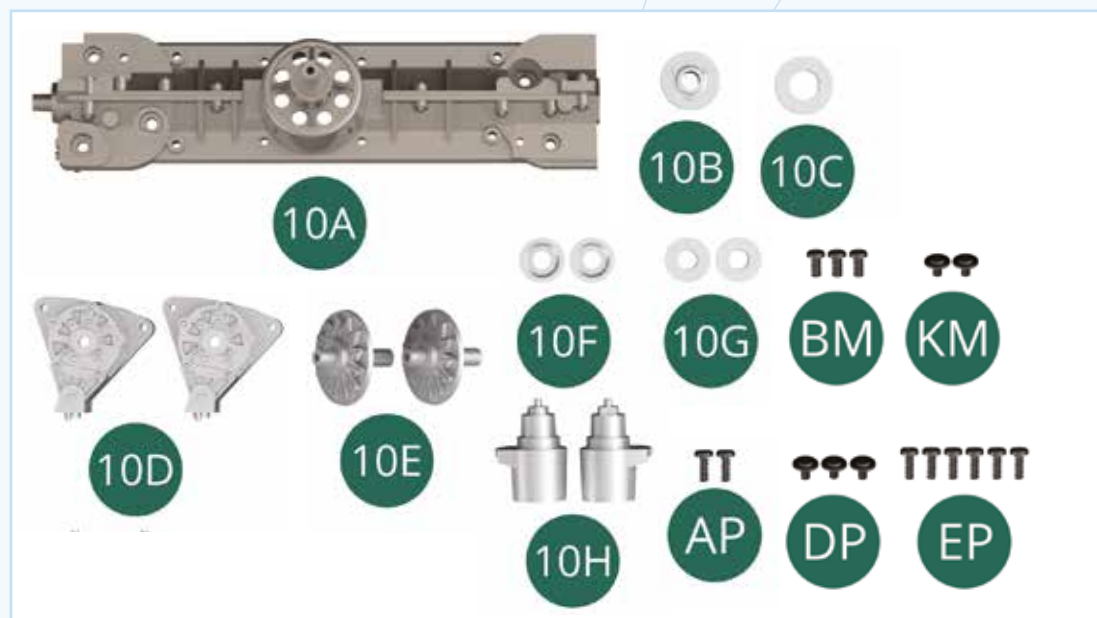
BM Screw M 2.0 x 4 mm (x 3)

KM Screw M 1.7 x 3 x 5 mm (x 2)

DP Screw M 1.7 x 3 x 5 mm (x 3)

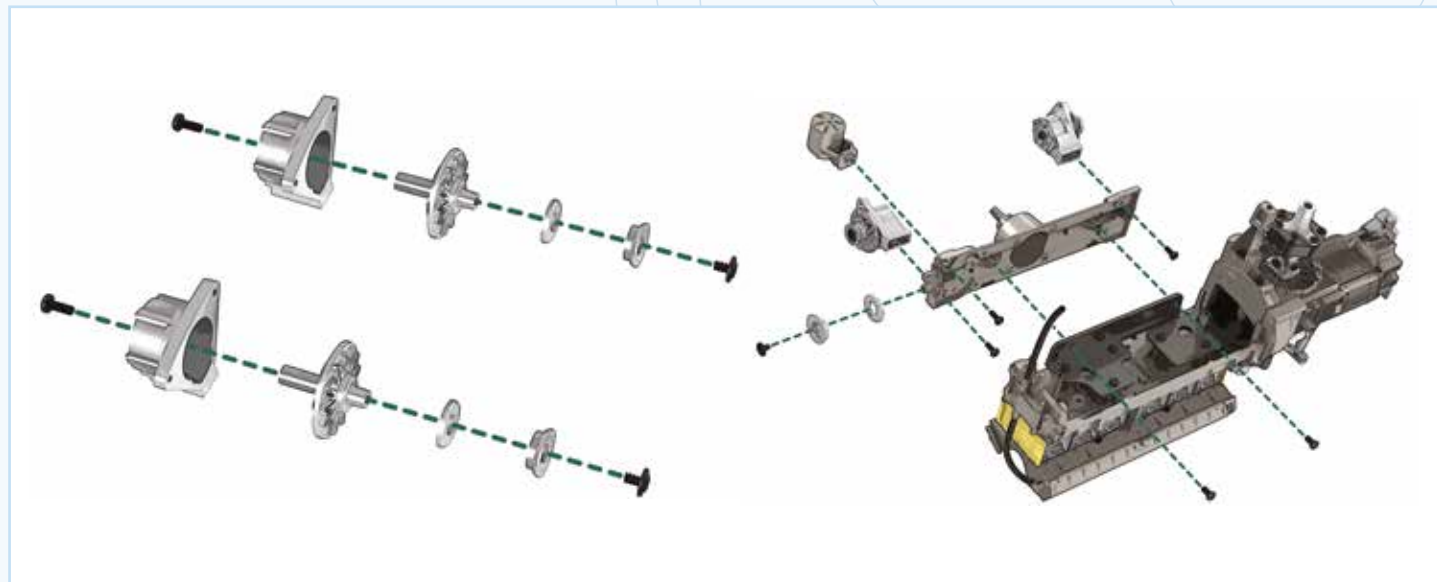
EP Screw M 1.7 x 5 mm (x 5)

AP Screw M 1.7 x 4 mm (x 2)



*Generators,
Crankcase top panel
and Oil Pump
assembly and
installation on the
engine*

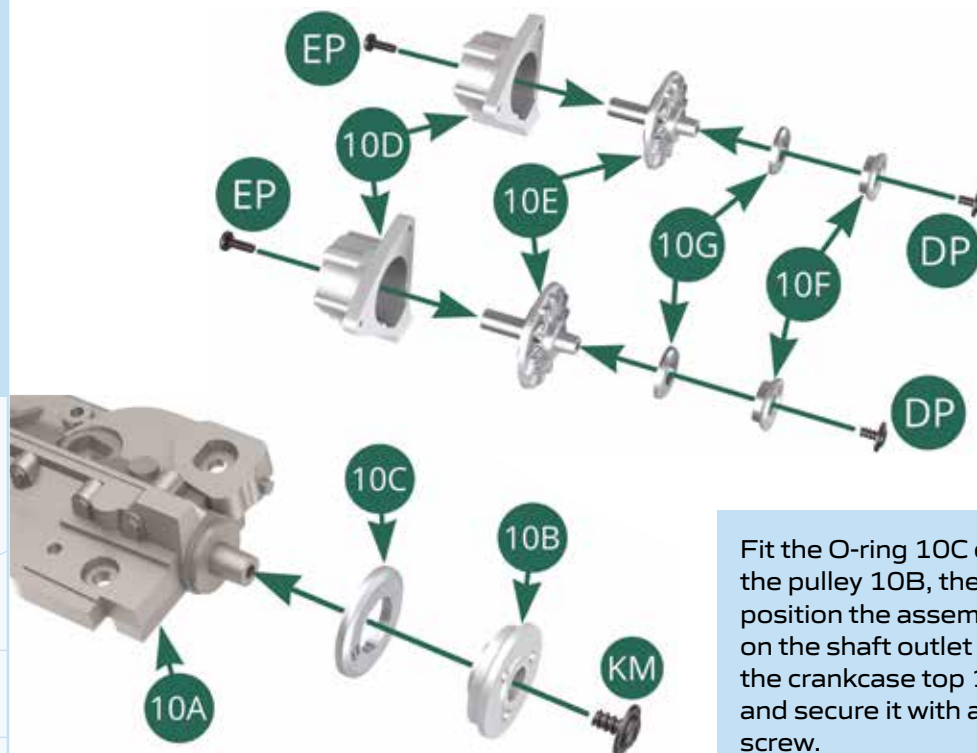
ASSEMBLY DIAGRAM





STEP 1

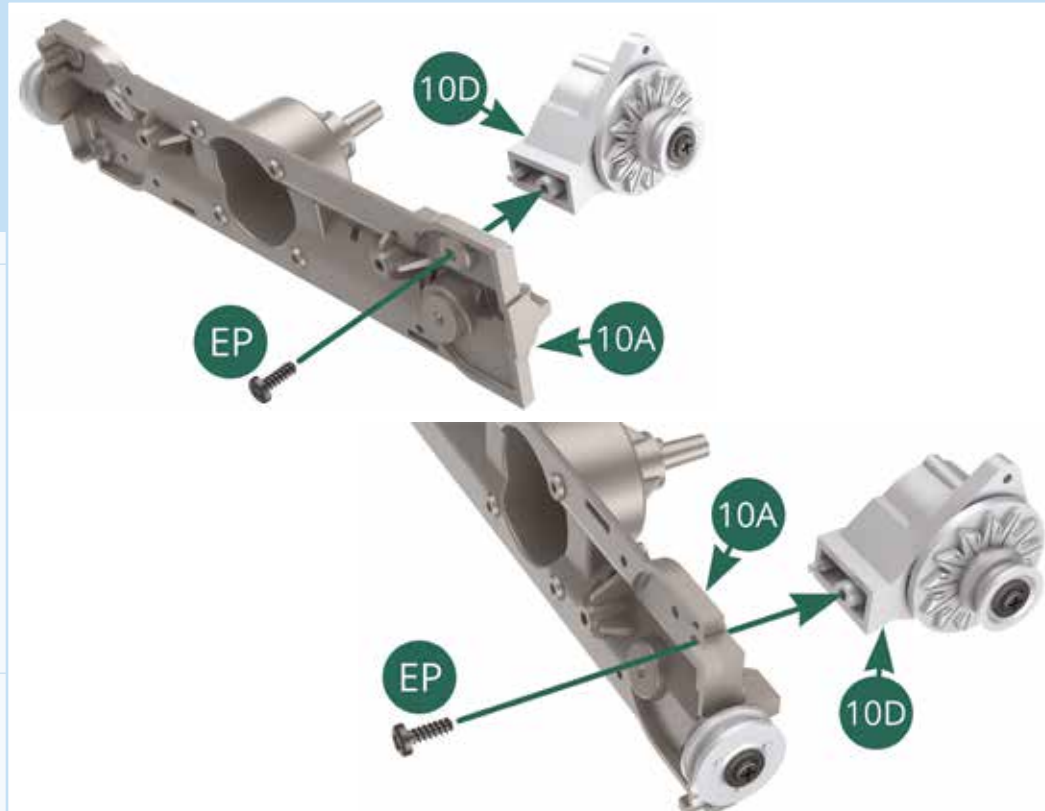
Successively position the O-ring 10G then the pulley 10F on the axis of the front cover 10E and secure them with a DP screw. Position the front cover and the 10E axle on the 10D generator and secure it with an EP screw. Carry out this same assembly a second time.



Fit the O-ring 10C on the pulley 10B, then position the assembly on the shaft outlet of the crankcase top 10A and secure it with a KM screw.

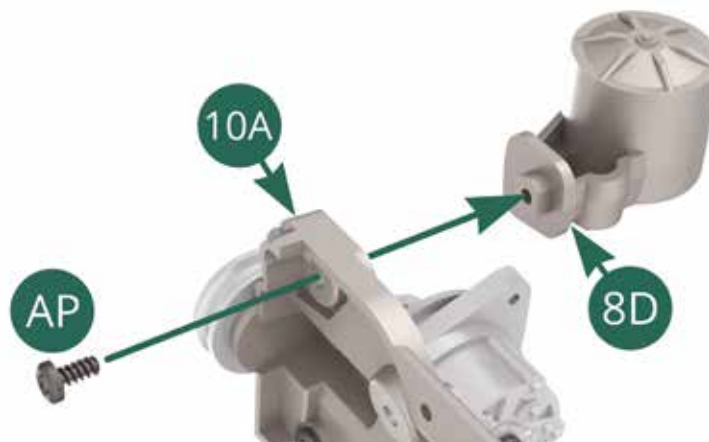
STEP 2

Position the 10D generators at the ends of the 10A crankcase top and secure them with an EP screw (illustrations below).

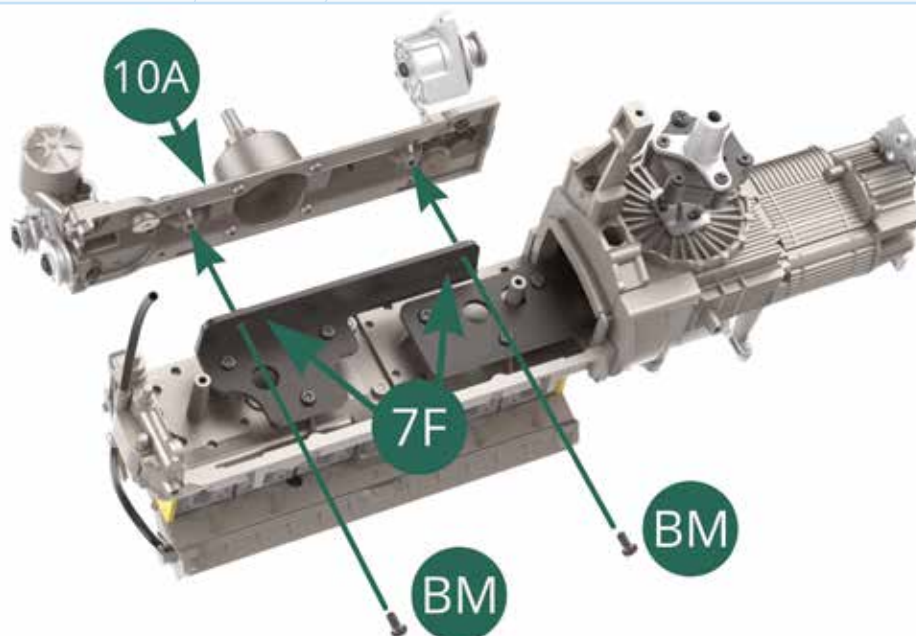


STEP 3

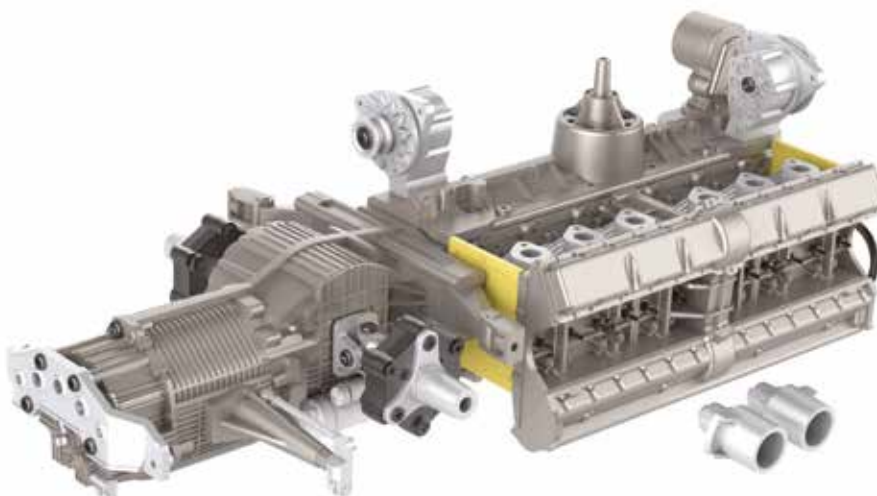
Position the 8D oil filter on top of the 10A crankcase and secure it with an AP screw.



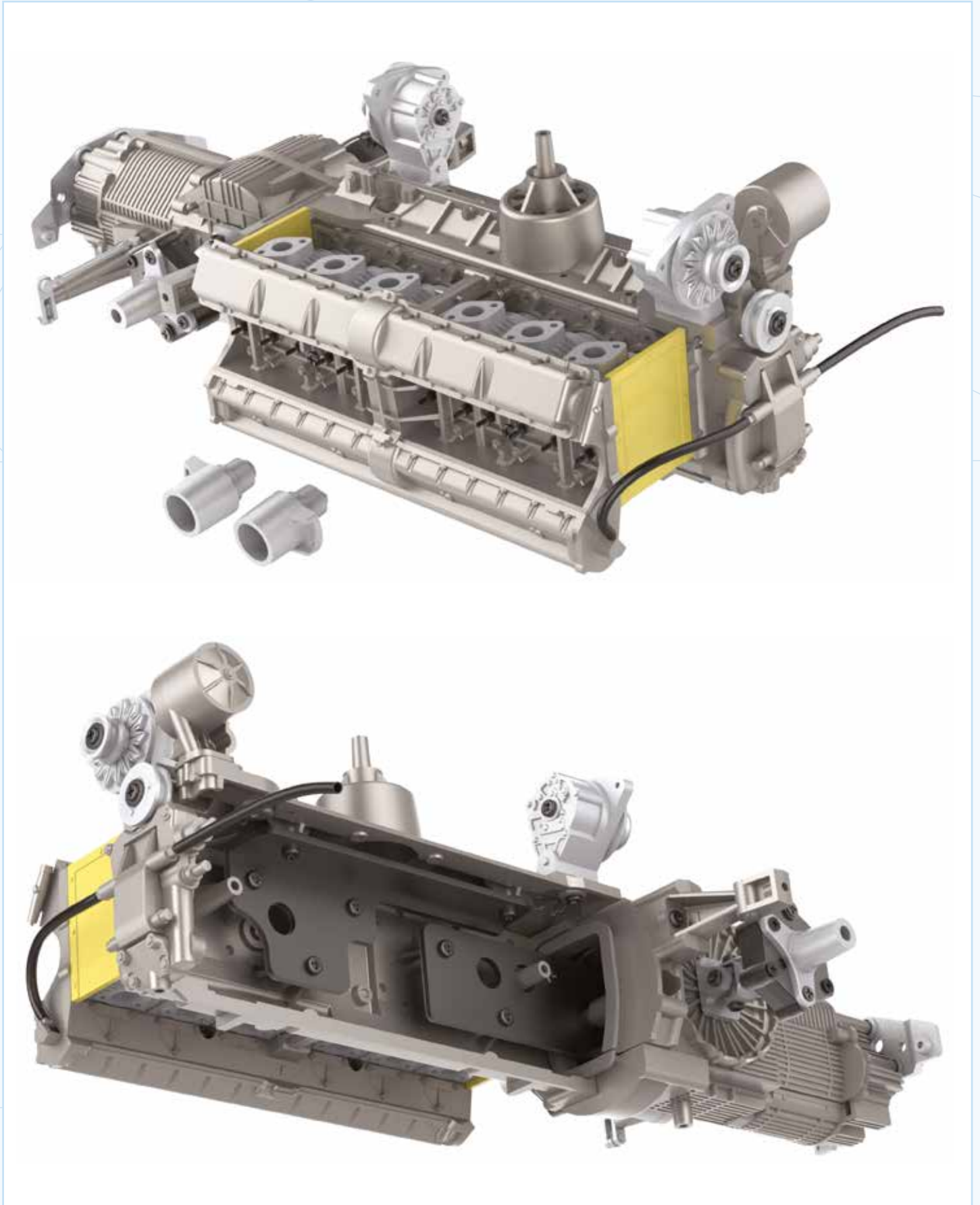
Position the engine casing top 10A on the linkage support 7F and secure it with two BM screws.



GENERAL VIEW



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 11

11A Left engine block

11B Transmission box

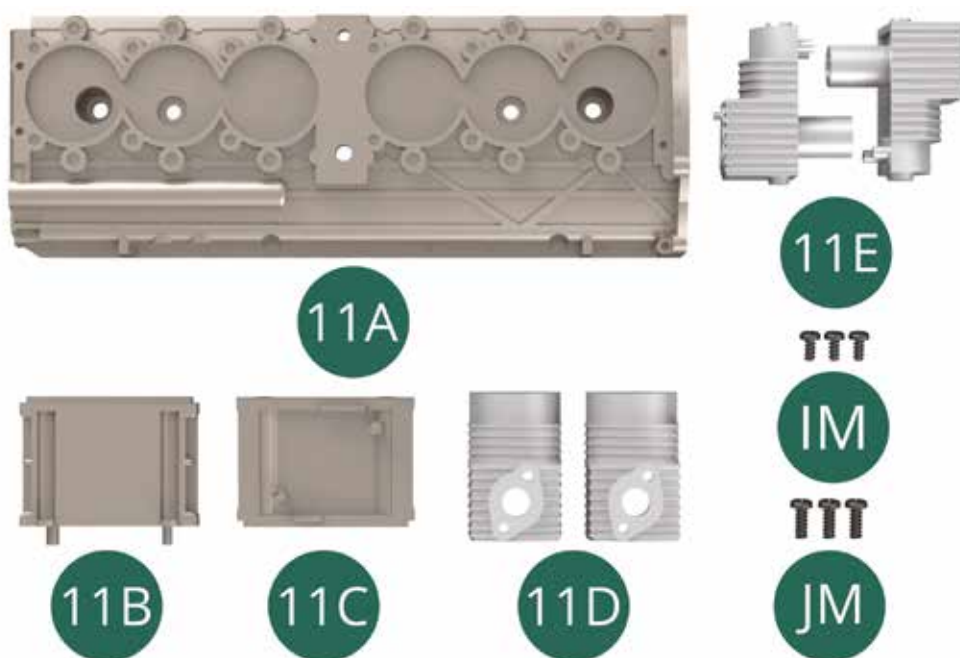
11C Transmission housing cover

11D Upper part of cylinder (x 2)

11E Lower part of cylinder (x 2)

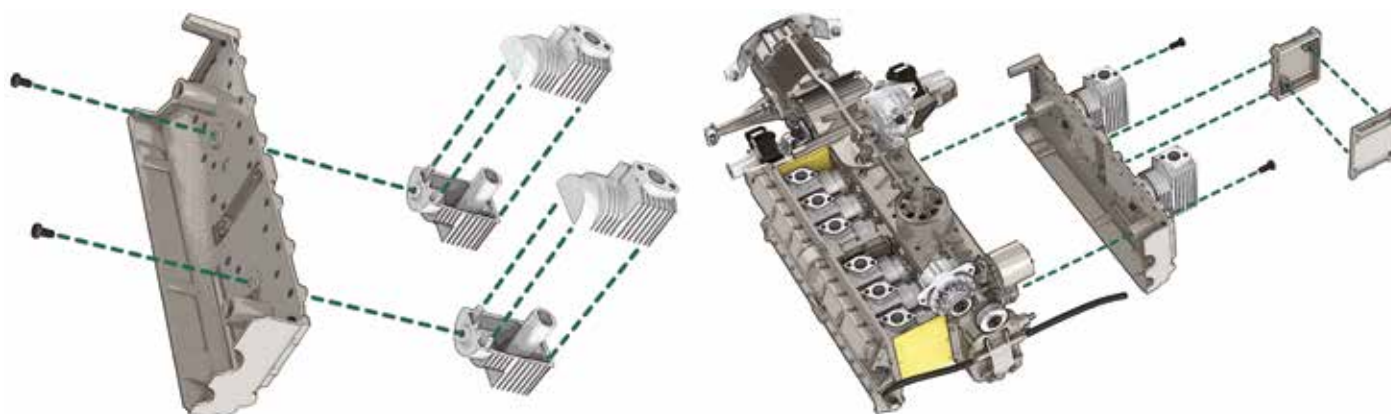
IM Screw M 1.7 x 3.5 mm (x 3)

JM Screw M 2,0 x 5 mm (x 3)



Left engine block assembly

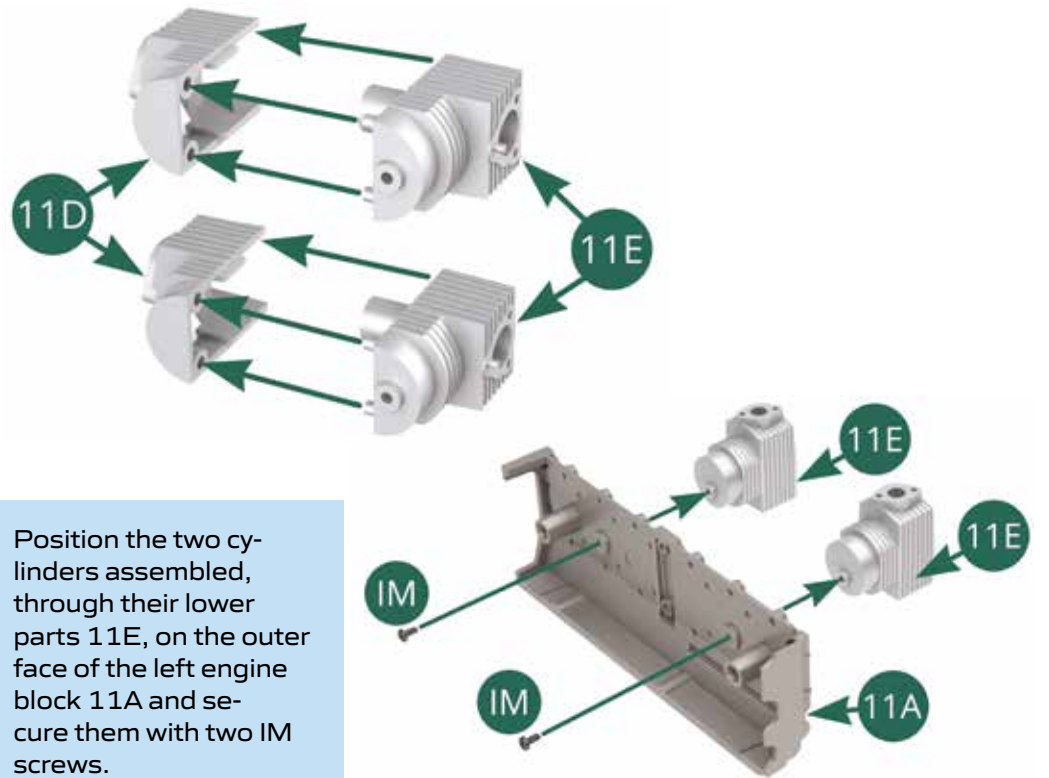
ASSEMBLY DIAGRAM





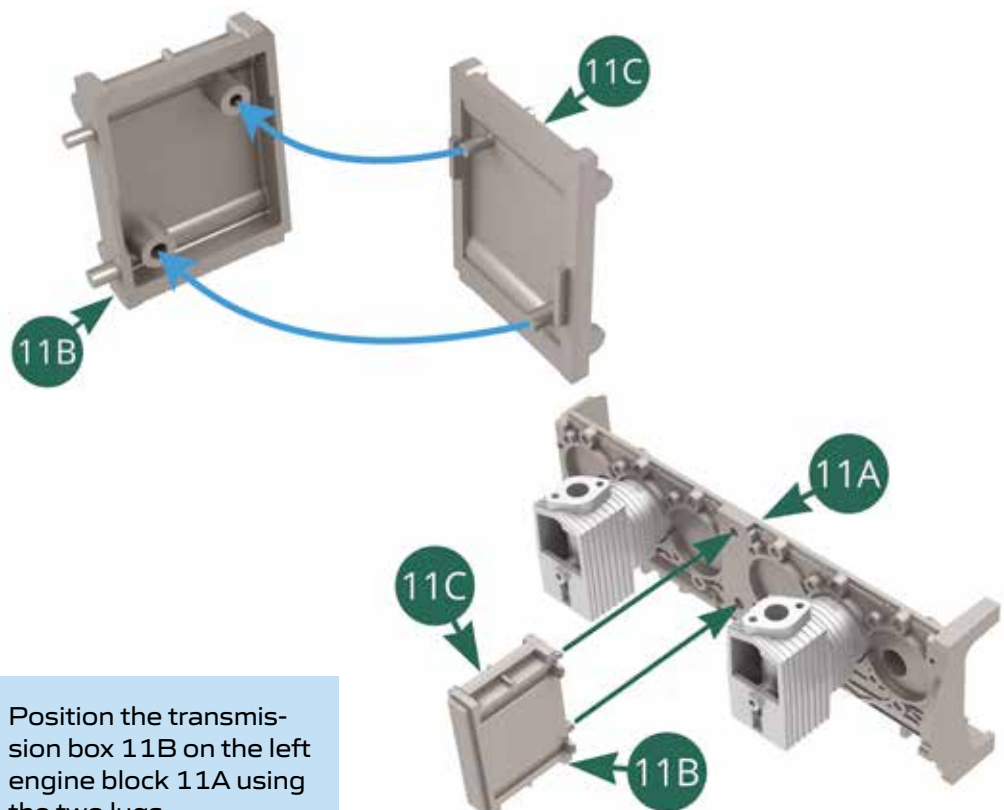
STEP 1

Assemble simultaneously the upper parts 11D and the lower parts 11E to form two cylinders.



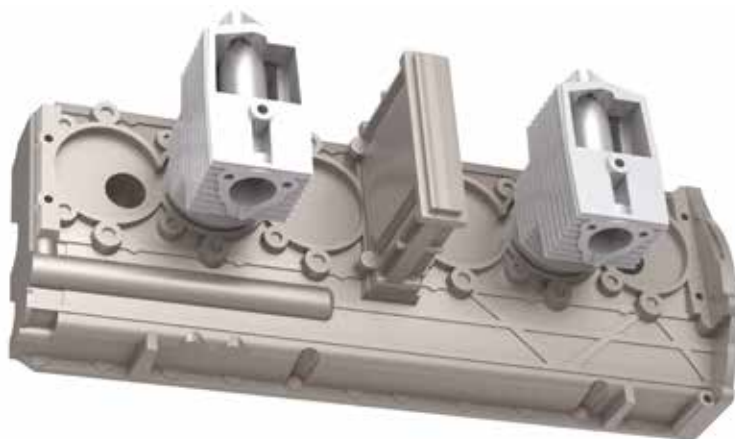
STEP 2

Position the transmission housing cover 11C on the transmission housing 11B.

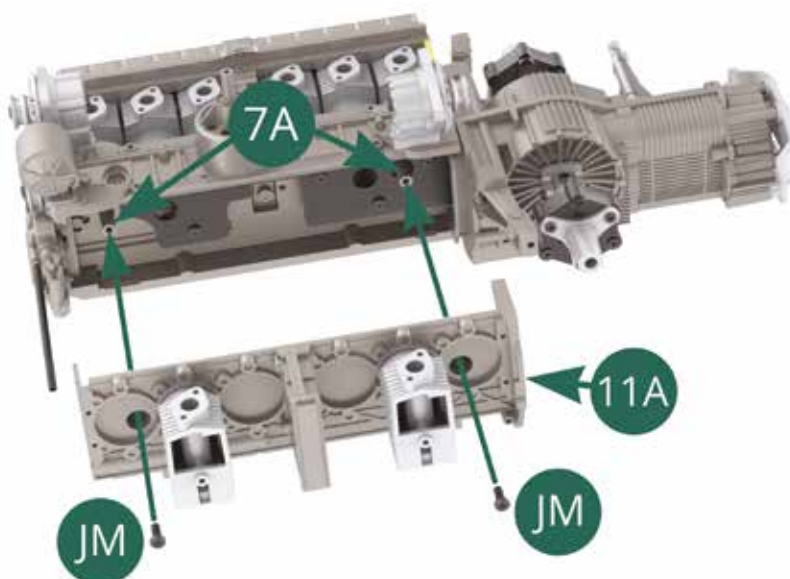


STEP 3

Preassembled left engine block



Position the left engine block 11A on the right engine block 7A and secure it with two JM screws.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 12

12A Intake valve cover

12B Main gear

12C Compressor

12D Side cover (x 2)

12E Compressor housing

12F Secondary pinion
(note the four rivets on the side)

12G Compressor base

12H Inspection hatch

12I Compressor outer body

12J Connector

12K Toothed belt

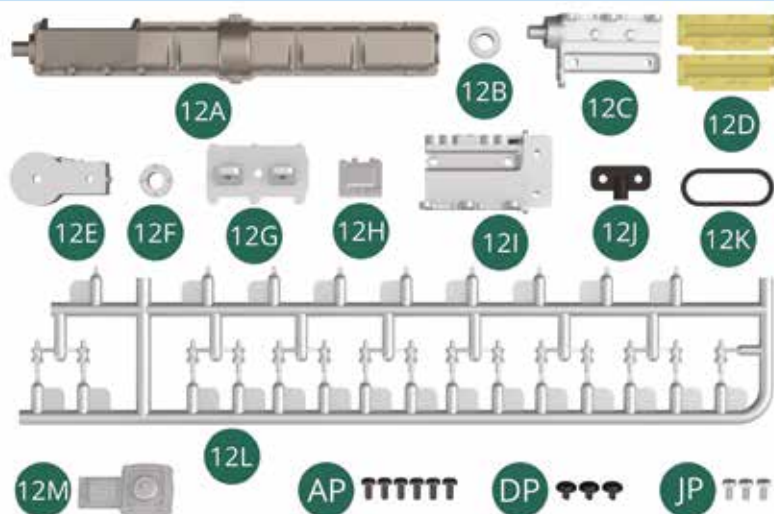
12L Injector nozzle (x 15)

12M Housing cover

AP Screw M 1.7 x 4 mm (x 6)

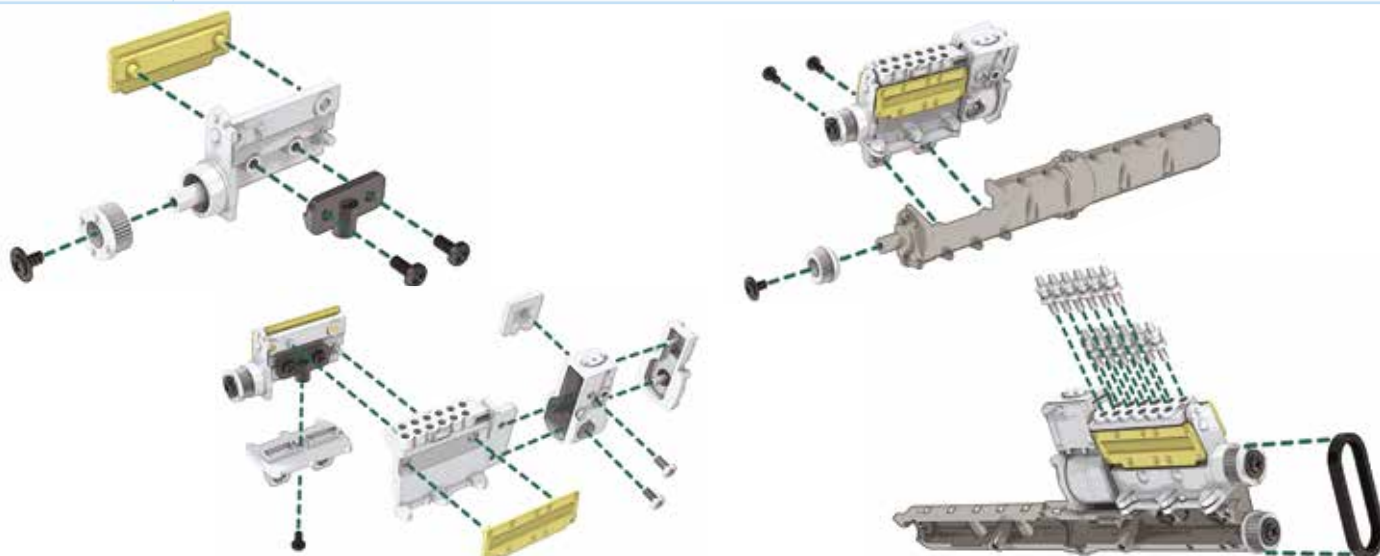
DP Screw M 1.7 x 3 x 5 mm (x 3)

JP Screw M 1.7 x 4 mm (x 3, silver)



*Gas Booster and
its drive assembly
and mounting*

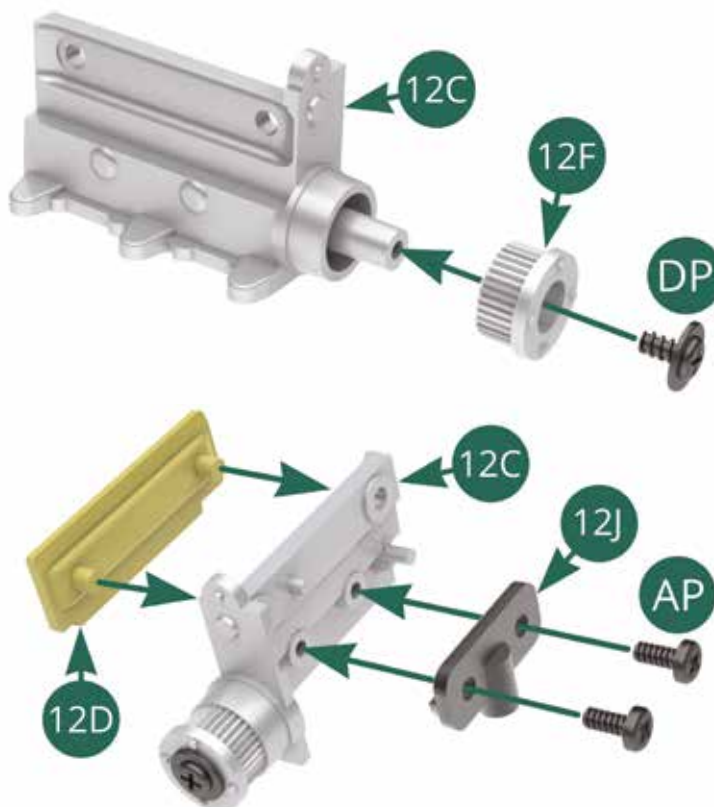
ASSEMBLY DIAGRAM



STEP 1

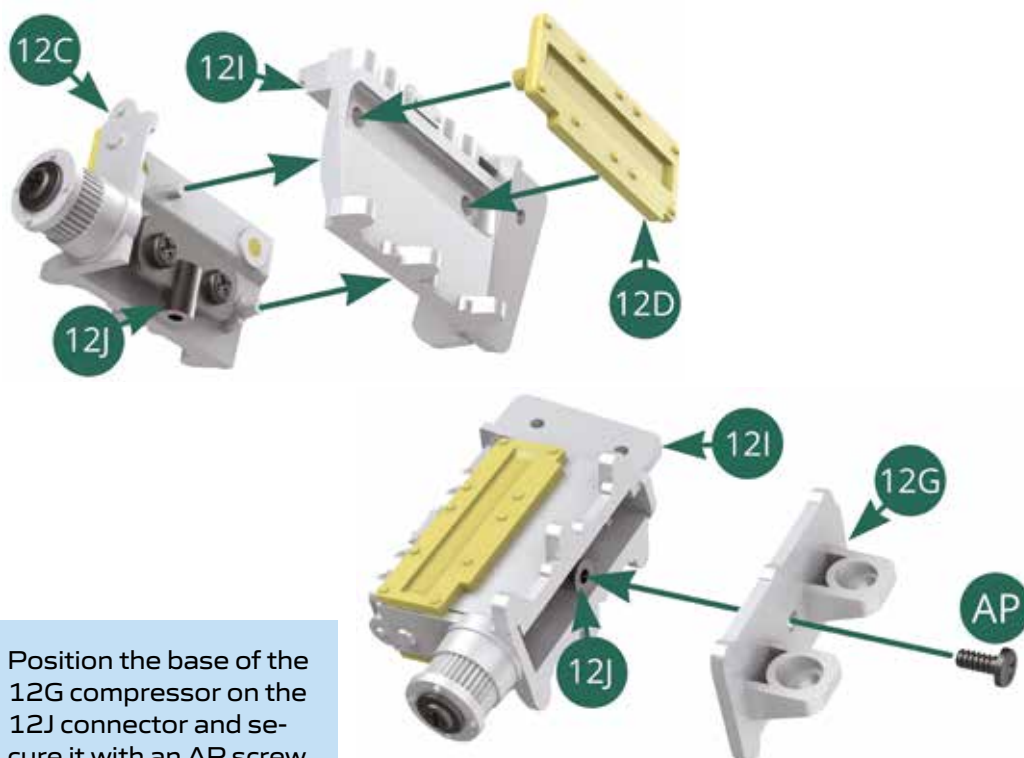
Position the secondary gear 12F on the axis of the compressor 12C and secure it with a DP screw.

Position connector 12J on compressor 12C and secure it with two AP screws. Position the side cover 12D on the compressor 12C.



STEP 2

Position the outer body of compressor 12I on compressor 12C. Position the side cover 12D on the outer body of the compressor 12I.

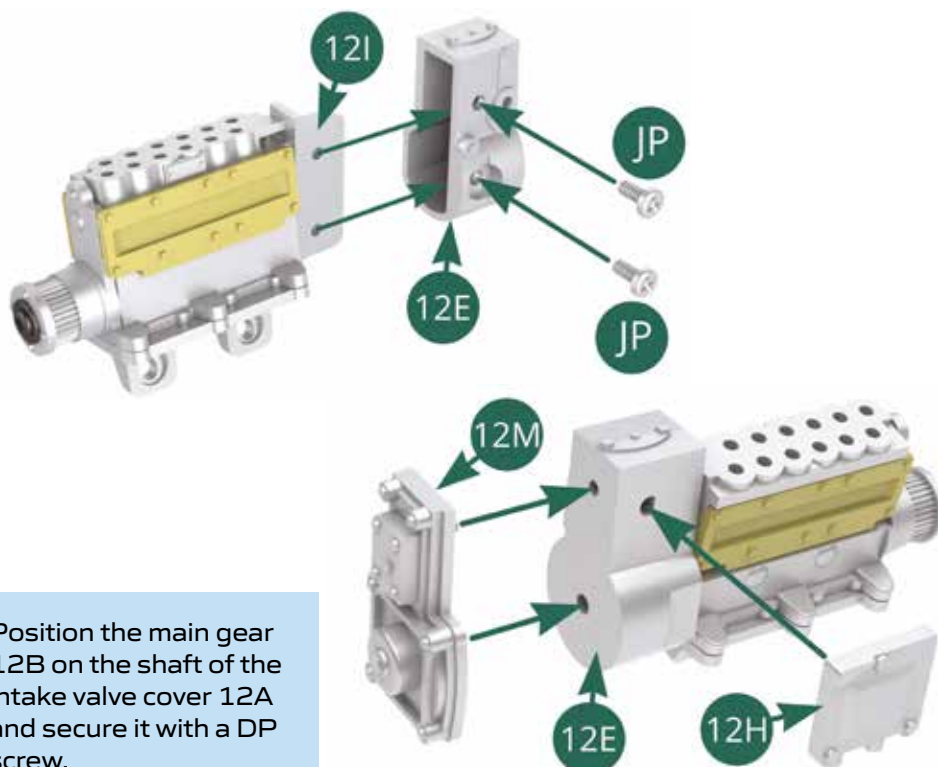


Position the base of the 12G compressor on the 12J connector and secure it with an AP screw.



STEP 3

Position the compressor housing 12E on the outer body of the compressor 12I and secure it with two silver JP screws.

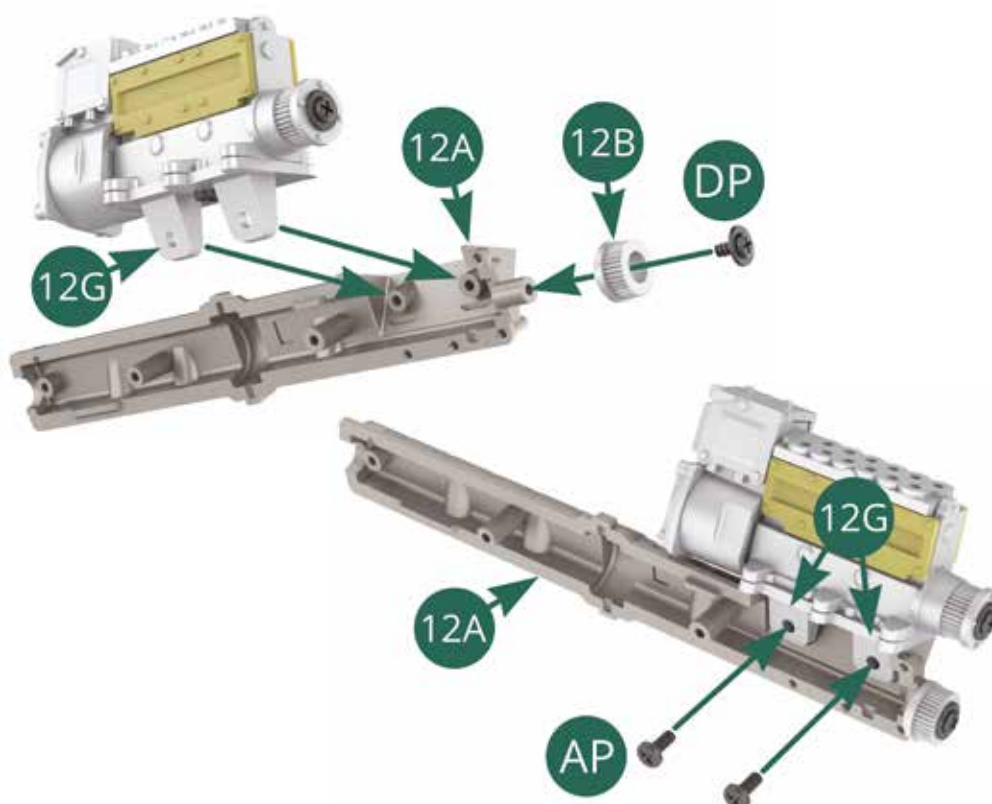


Position the main gear 12B on the shaft of the intake valve cover 12A and secure it with a DP screw.

STEP 4

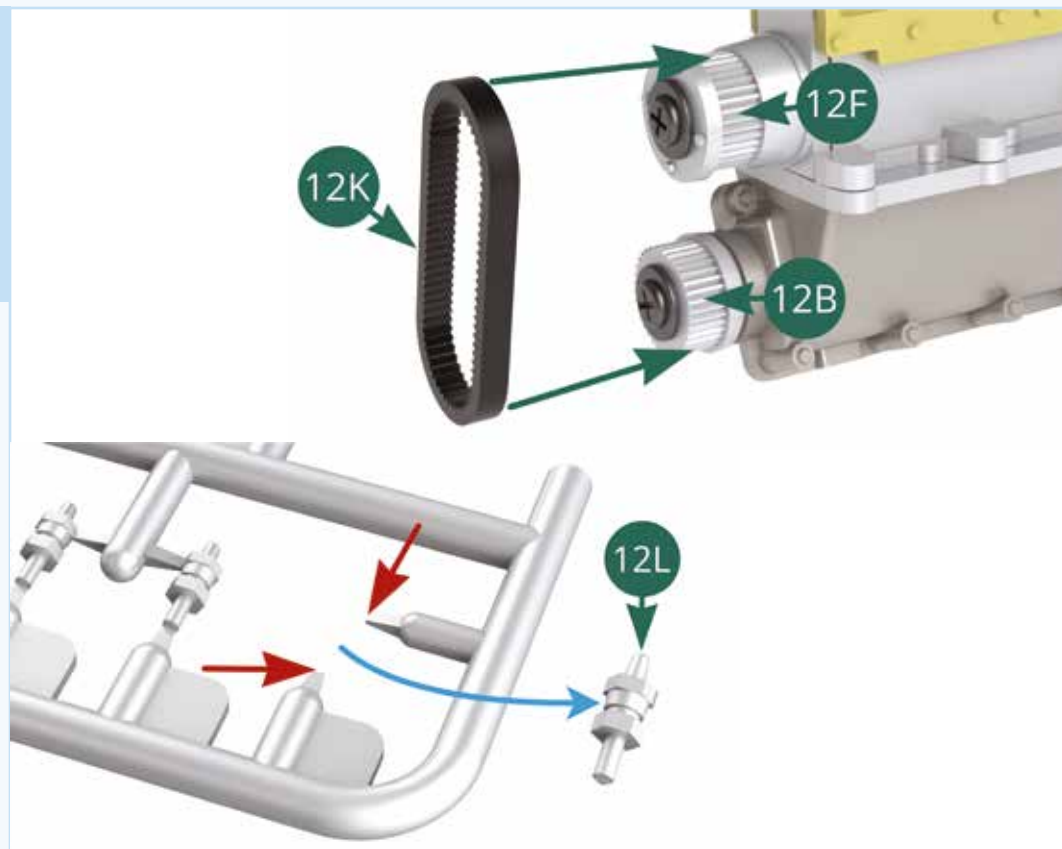
Positionner le pignon principal 12B sur l'axe du couvercle de soupapes d'admission 12A et le fixer avec une vis DP.

Position the base of the compressor 12G on the intake valve cover 12A and secure it with two AP screws (illustrations below).



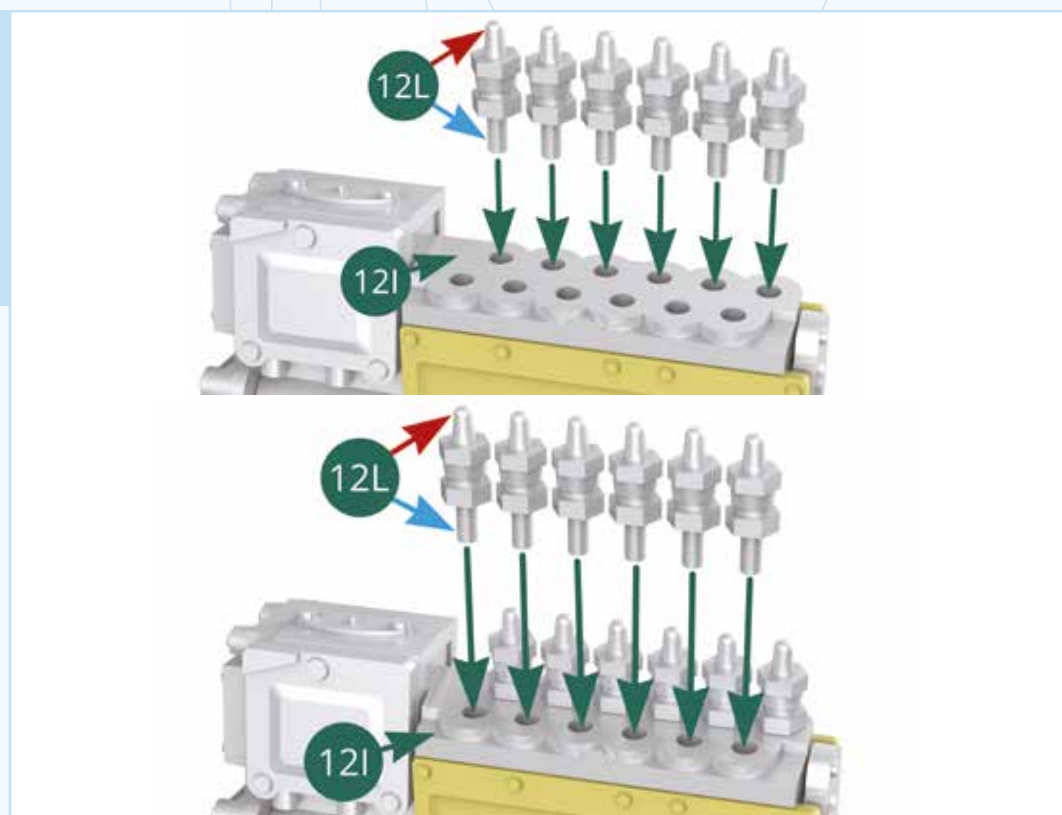
STEP 5

Position the toothed belt around the secondary pinion 12F and the main pinion 12B. Carefully detach twelve 12L injector nozzles from the holder using the pliers (red arrows).

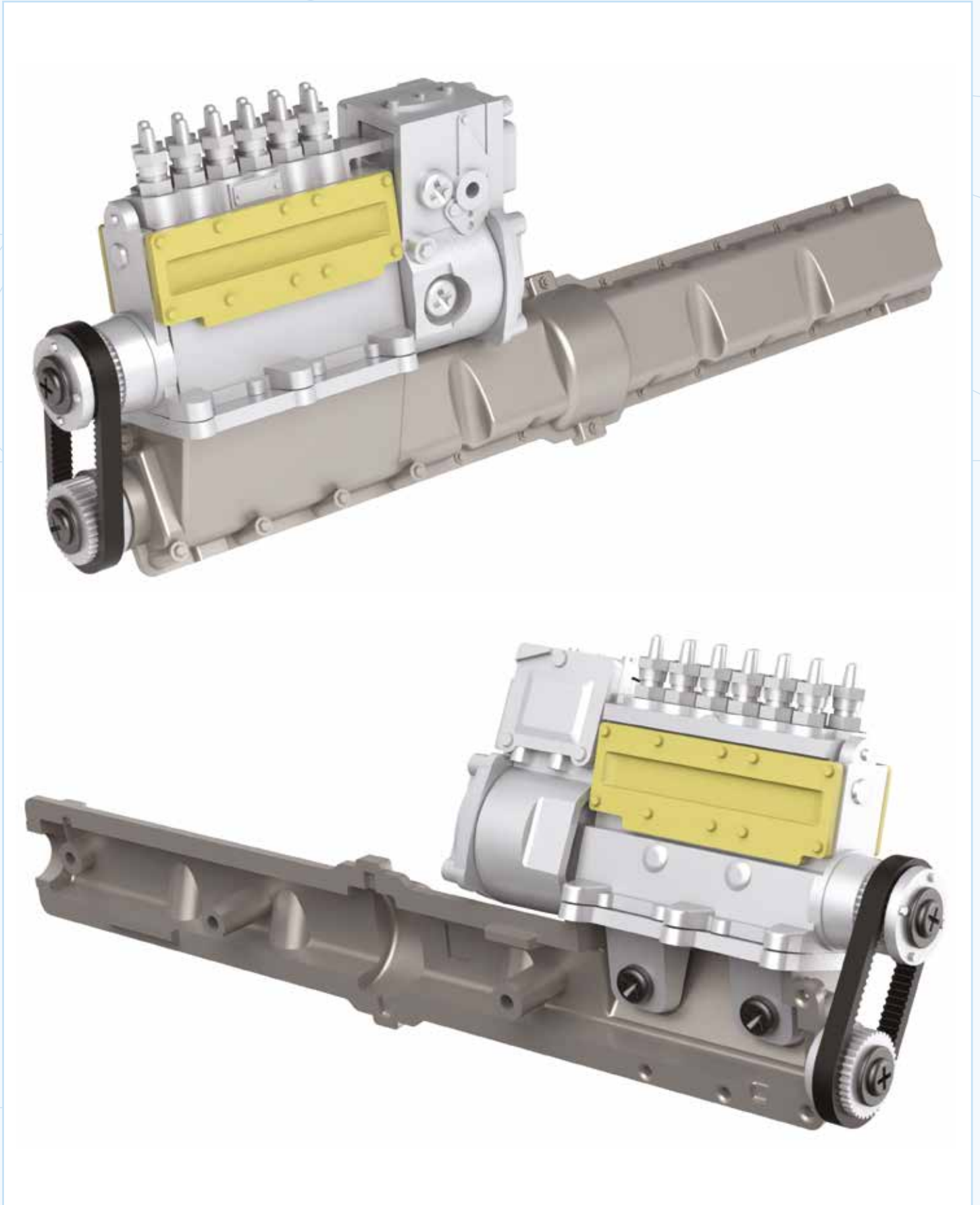


STEP 6

Position one by one, in two rows, the twelve 12L injector nozzles on the outer body of the 12I compressor. Mark the correct direction of assembly of the nozzles (red and blue arrows).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 13

13A Left cylinder head

13B Spark plugs (x 12 + 6 additional)

13C Exhaust valve cover

13D Partition (x 2)

13E Outer pulley

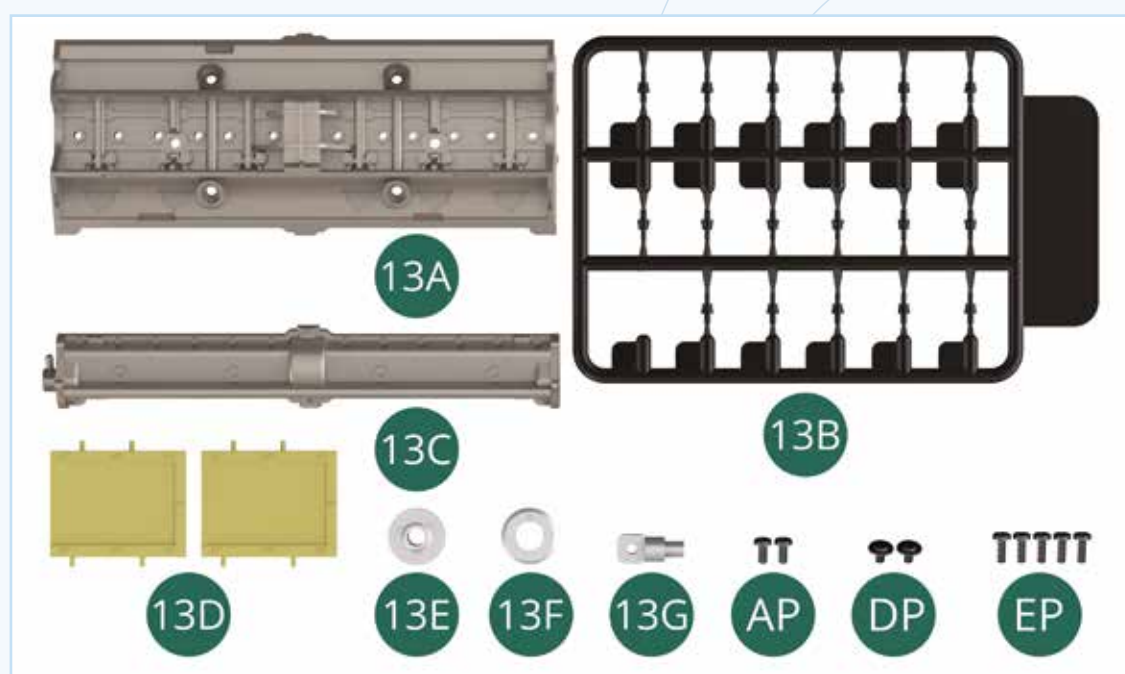
13F Inner pulley

13G Pulley shaft

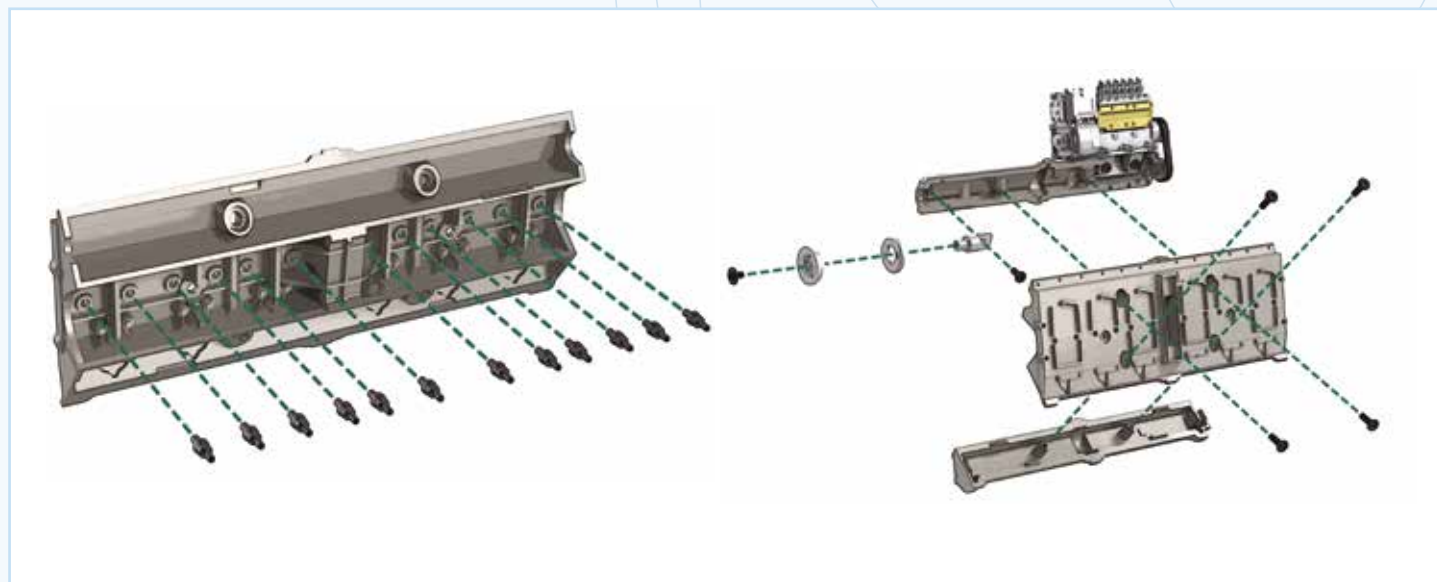
AP Screw M 1.7 x 4 mm (x 2)

DP Screw M 1.7 x 3 x 5 mm (x 2)

EP Screw M 1.7 x 5 mm (x 5)



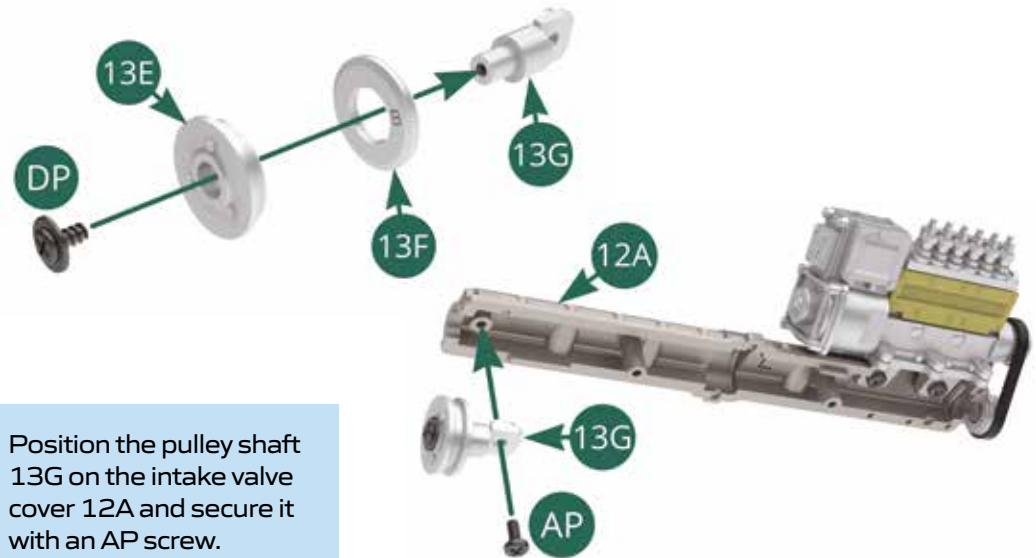
ASSEMBLY DIAGRAM





STEP 1

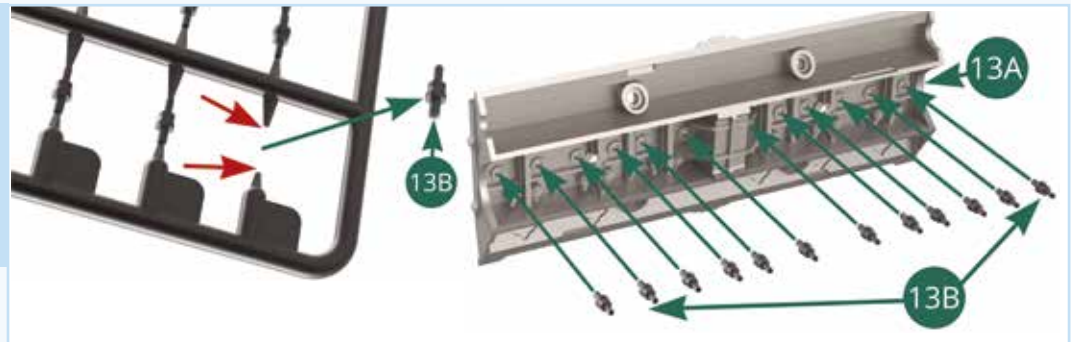
Position the inner 13F and outer 13E pulleys on axis 13G and secure them with a DP screw.



Position the pulley shaft 13G on the intake valve cover 12A and secure it with an AP screw.

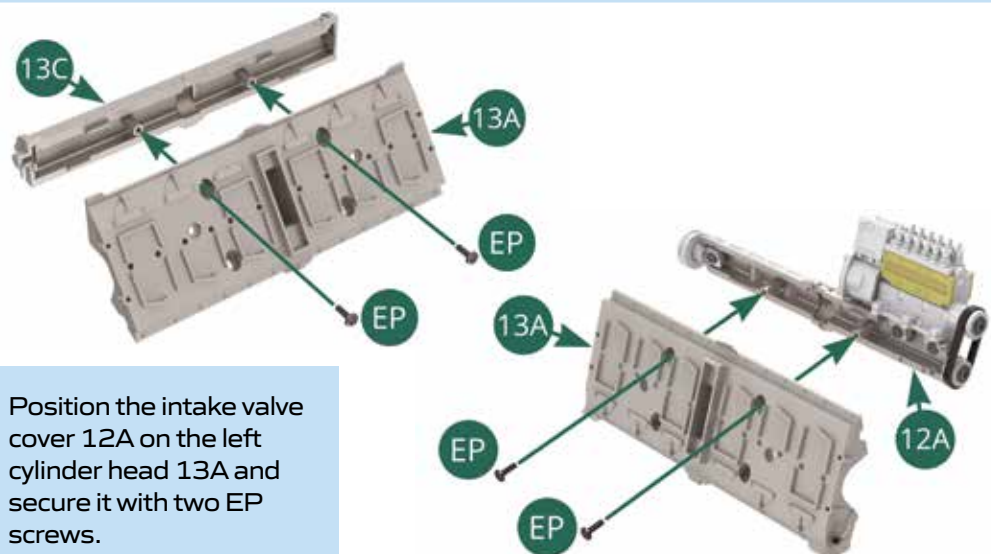
STEP 2

Detach twelve spark plugs 13B from the support using the pliers and tweezers, then position them on the left cylinder head 13A (illustrations opposite).



STEP 3

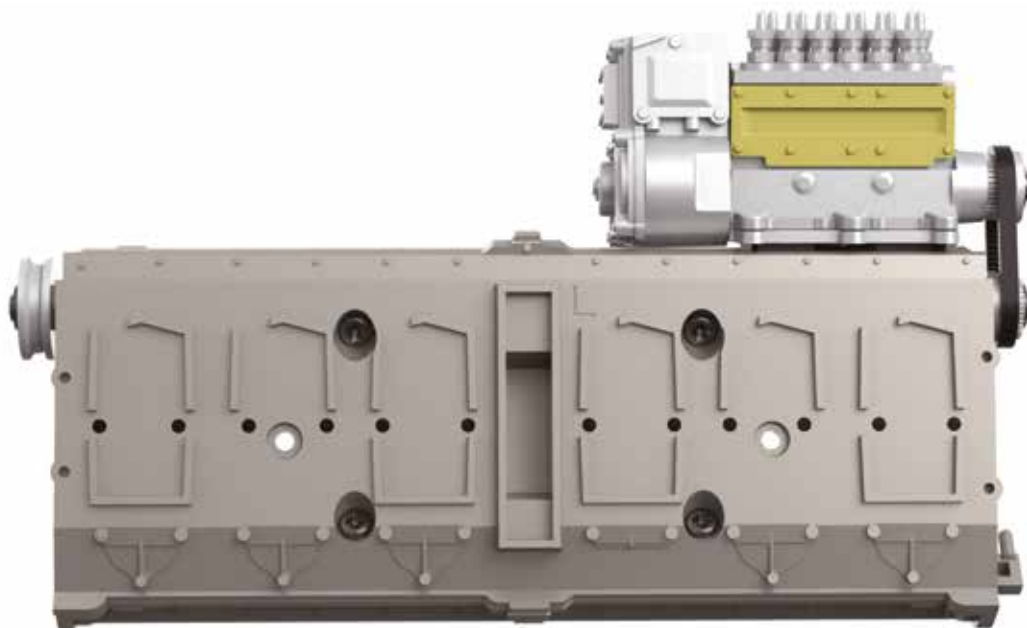
Position the exhaust valve cover 13C on the left cylinder head 13A and secure it with two EP screws.



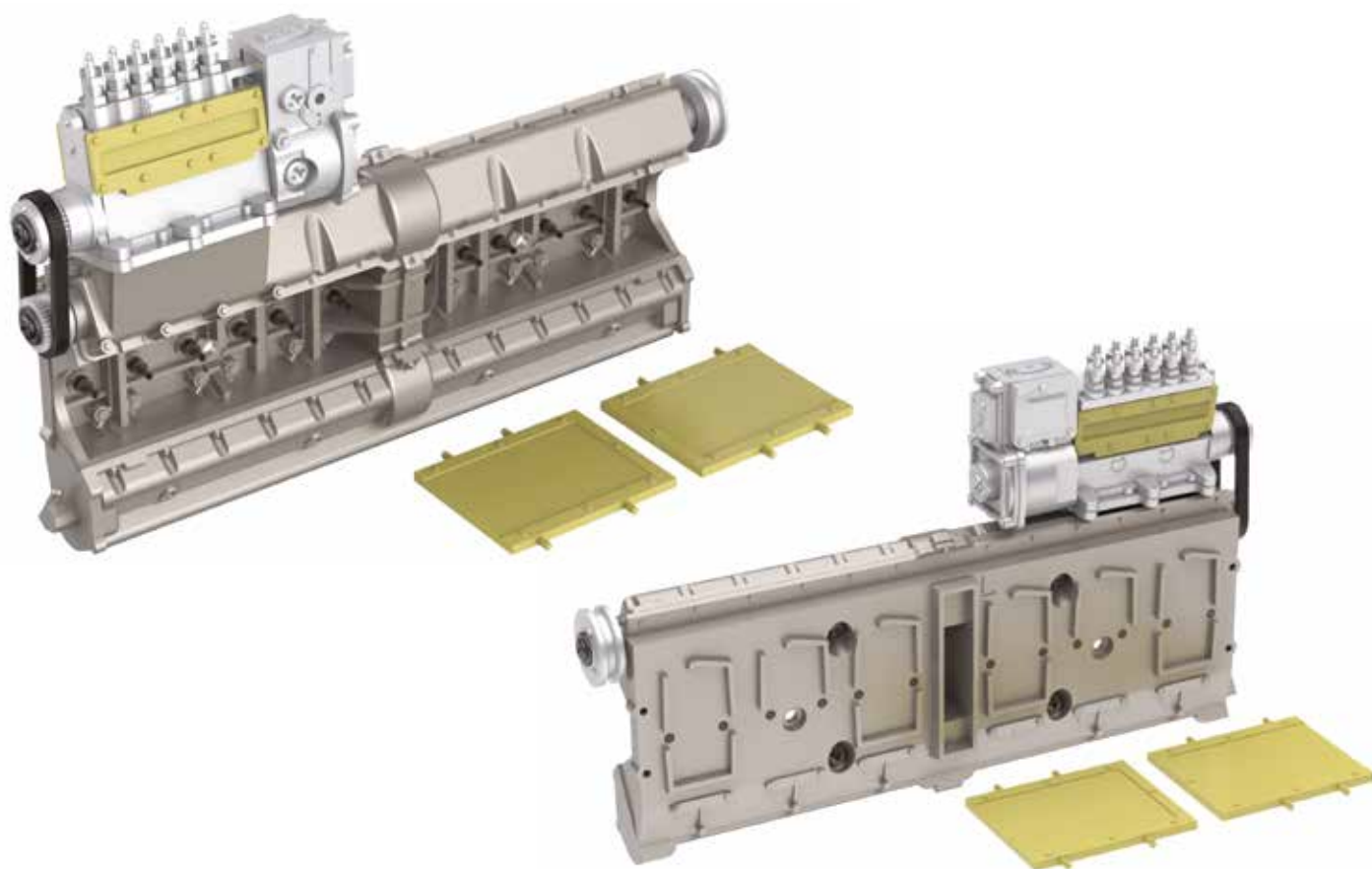
Position the intake valve cover 12A on the left cylinder head 13A and secure it with two EP screws.

STEP 4

*Preassembly of the left
cylinder head*



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 14

14A Top of the air cooling chamber

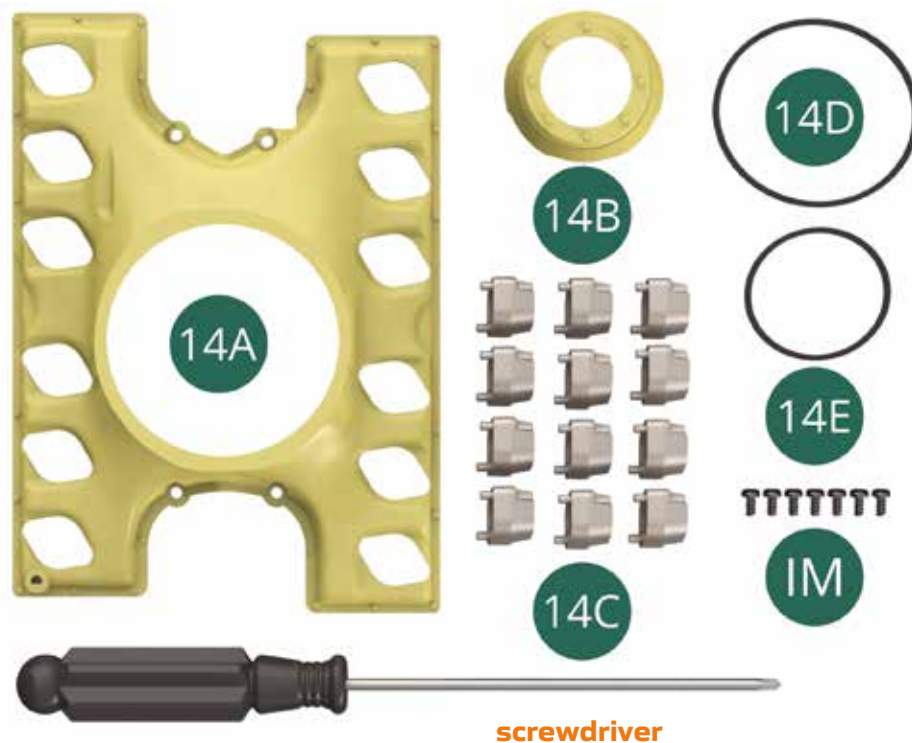
14B Upper air flow guide

14C Air intake bracket (x 12)

14D Main generator belt

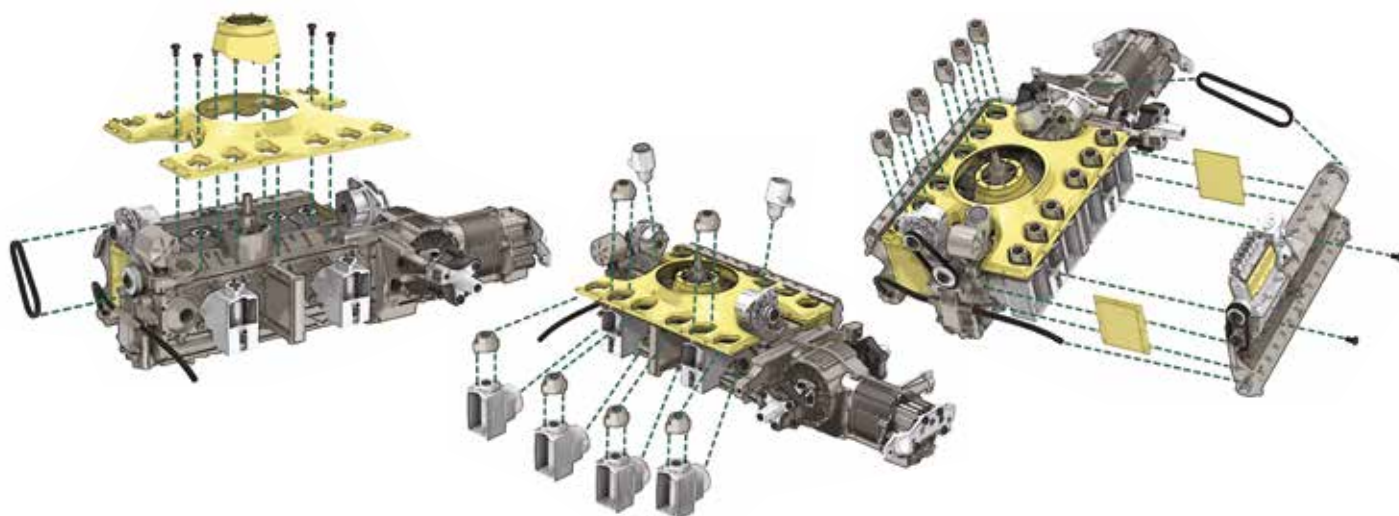
14E Secondary generator belt

IM Screw M 1.7 x 3.5 mm (x 7)



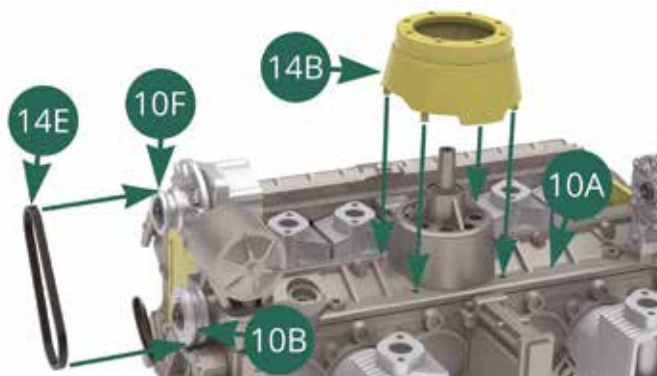
Air cooling chamber top, generators belts and Left cylinder head installation on engine

ASSEMBLY DIAGRAM

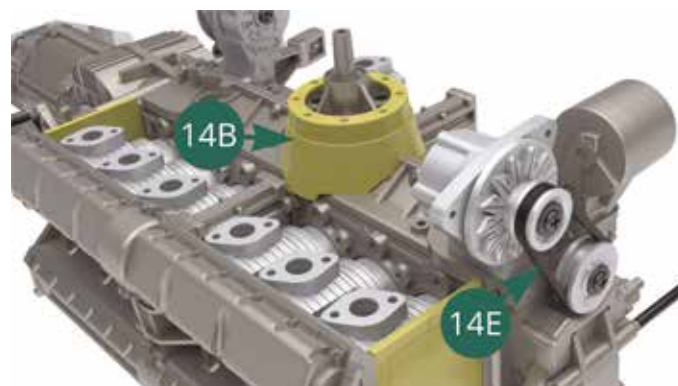


STEP 1

Position the upper air flow guide 14B on top of the Crankcase top 10A.

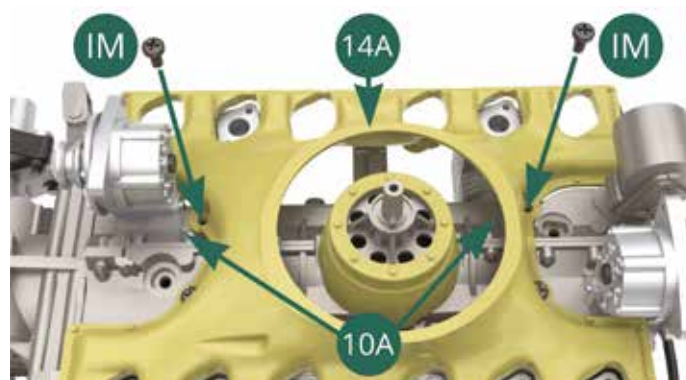
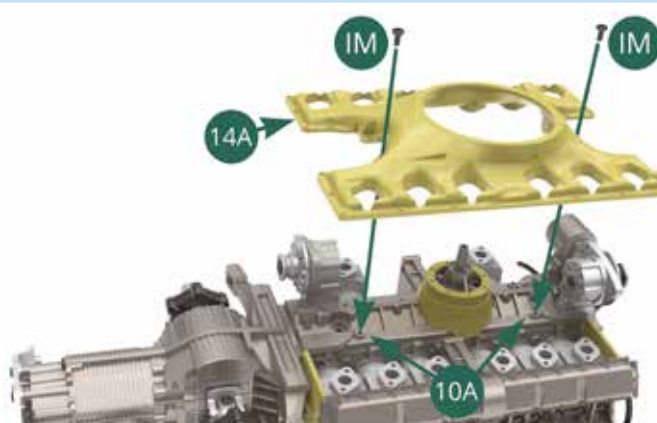


Position the secondary generator belt 14E on the pulleys 10F and 10B (illustrations above and opposite).



STEP 2

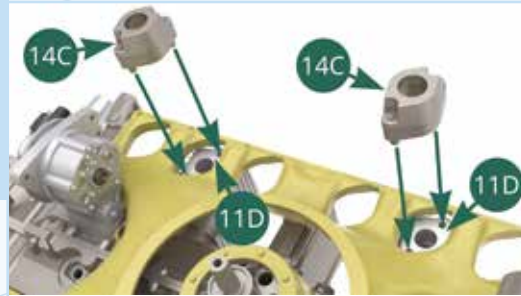
Position the top of the air cooling chamber 14A on the top of the Crankcase top 10A and secure it with four IM screws (illustrations opposite and below).





STEP 3

Position two 14C air intake brackets on the upper cylinder parts 11D on the left side of the engine.

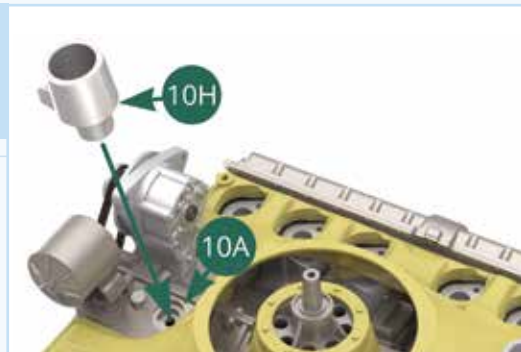


Position a 10H distributor base on top of the 10A crankcase.



STEP 4

Position another 10H distributor base on top of the 10A crankcase.

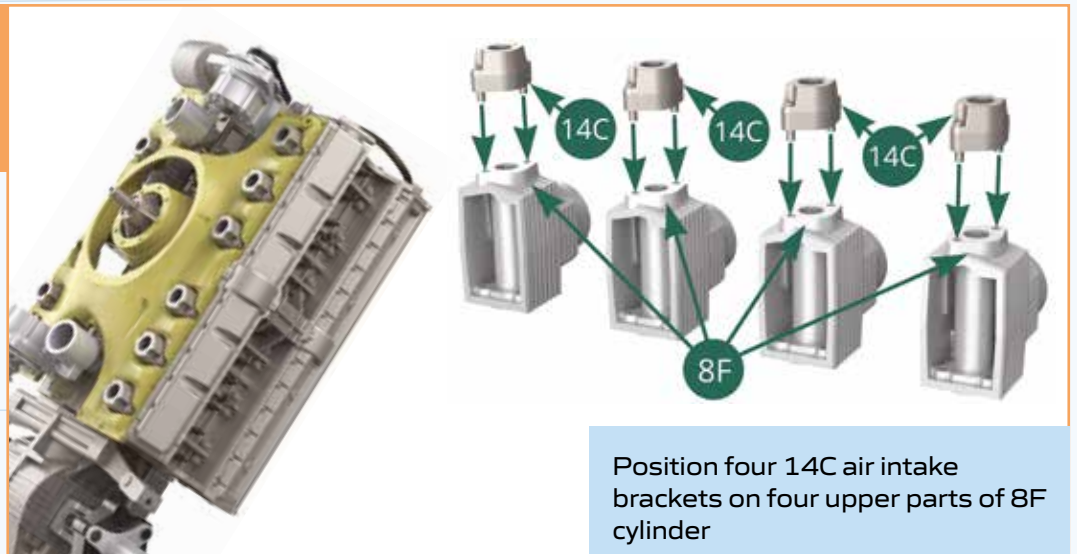


Position six 14C air intake brackets on the upper cylinder parts 8F (x 4) and 7D (x 2) on the right side of the engine.



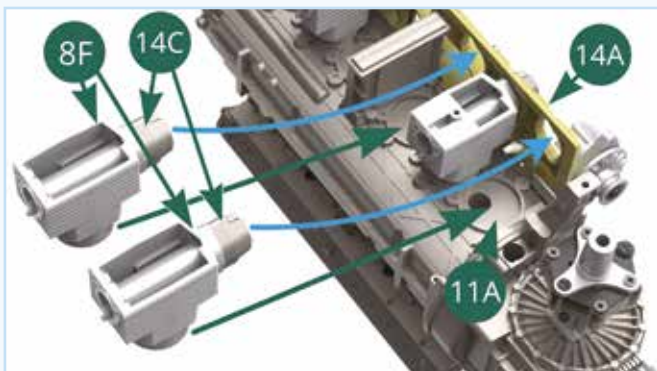
STEP 5

Six 14C air intake brackets installed on the right side of the engine

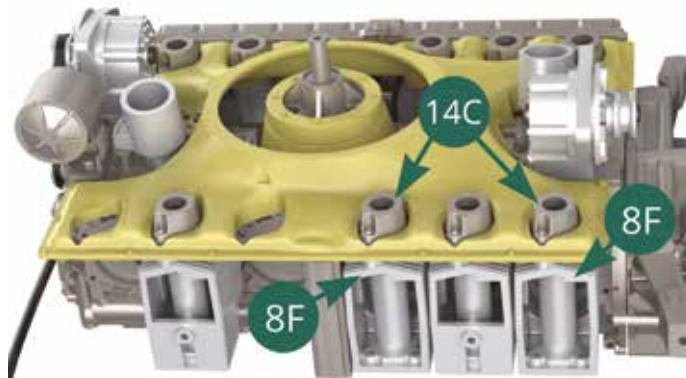


Position four 14C air intake brackets on four upper parts of 8F cylinder

STEP 6

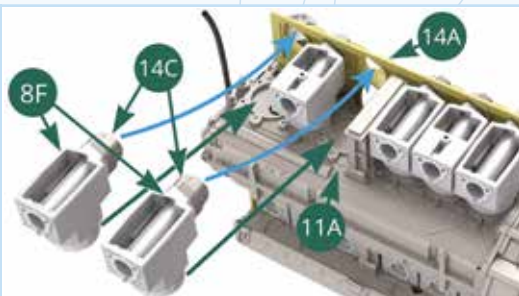


Position two upper cylinder parts 8F on the left engine block 11A by passing the two air intake supports 14C through the openings provided on the top of the air cooling chamber 14A, as indicated by the blue arrows. (illustrations above and opposite).



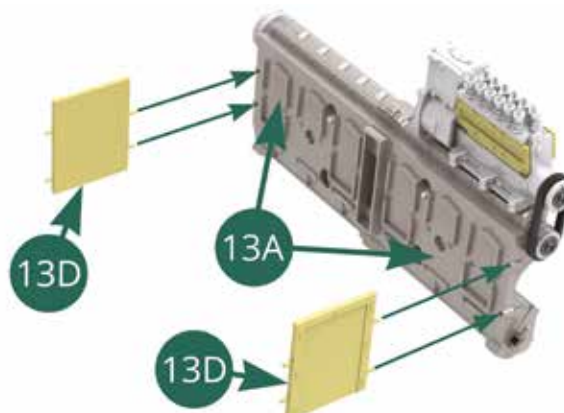
STEP 7

Position two other upper cylinder parts 8F on the left engine block 11A by passing the two air intake brackets 14C in the openings provided on the top of the air cooling chamber 14A as indicated by the blue arrows (illustrations opposite).



STEP 8

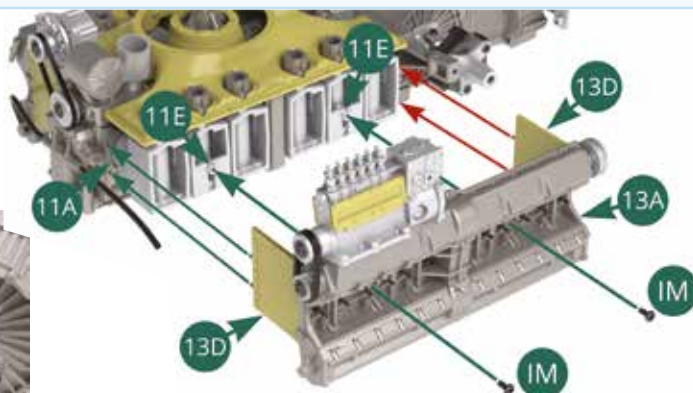
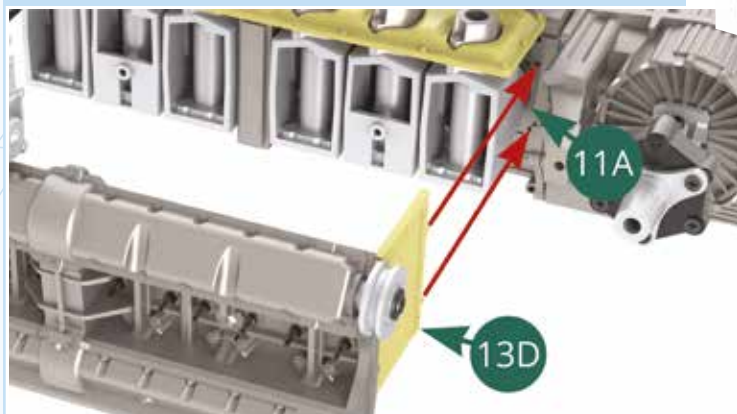
Position the two partitions 13D, riveted face outwards, at the ends of the cylinder head 13A.





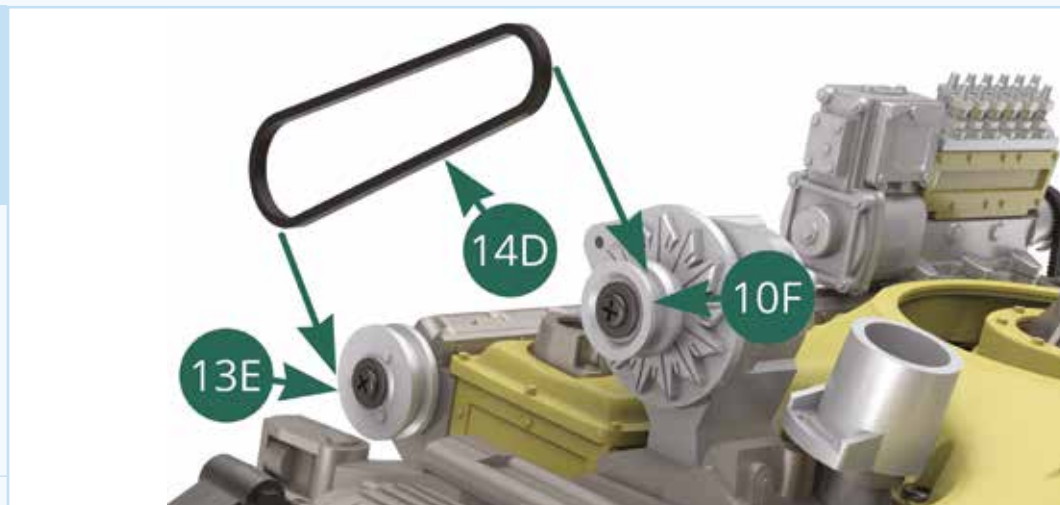
STEP 9

Position the left cylinder head 13A on the lower part of cylinder 11E making sure that the two partitions 13D are correctly positioned on the left engine block 11A, then fix the assembly with two IM screws (illustrations opposite and below).



STEP 10

Position the generator main belt 14D on the pulleys 10F and 13E (illustrations opposite and below).

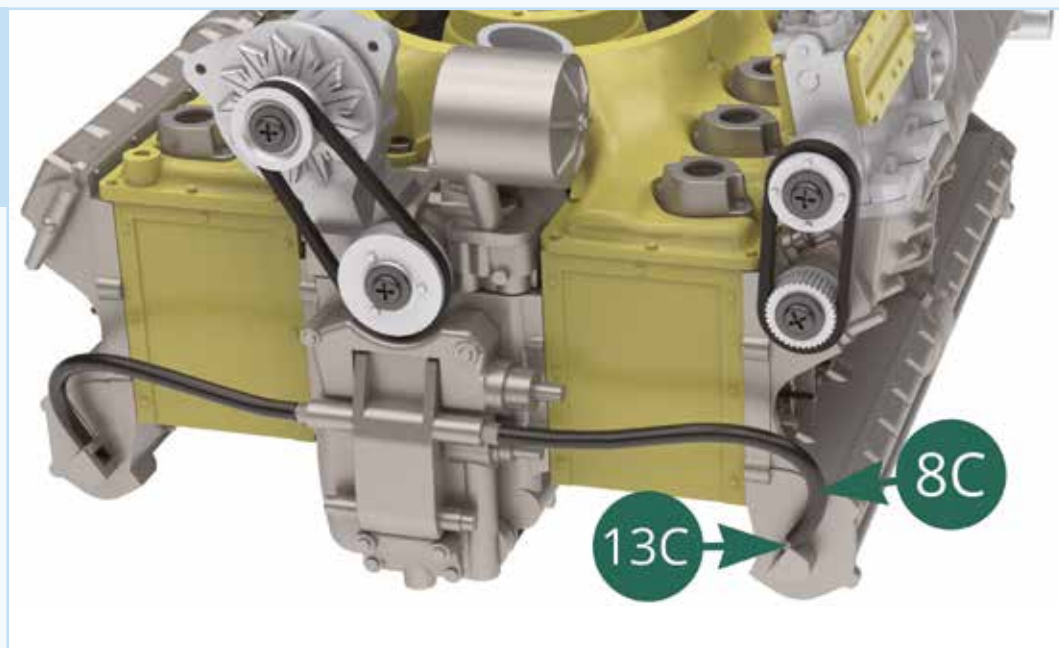


14D generator main belt installed

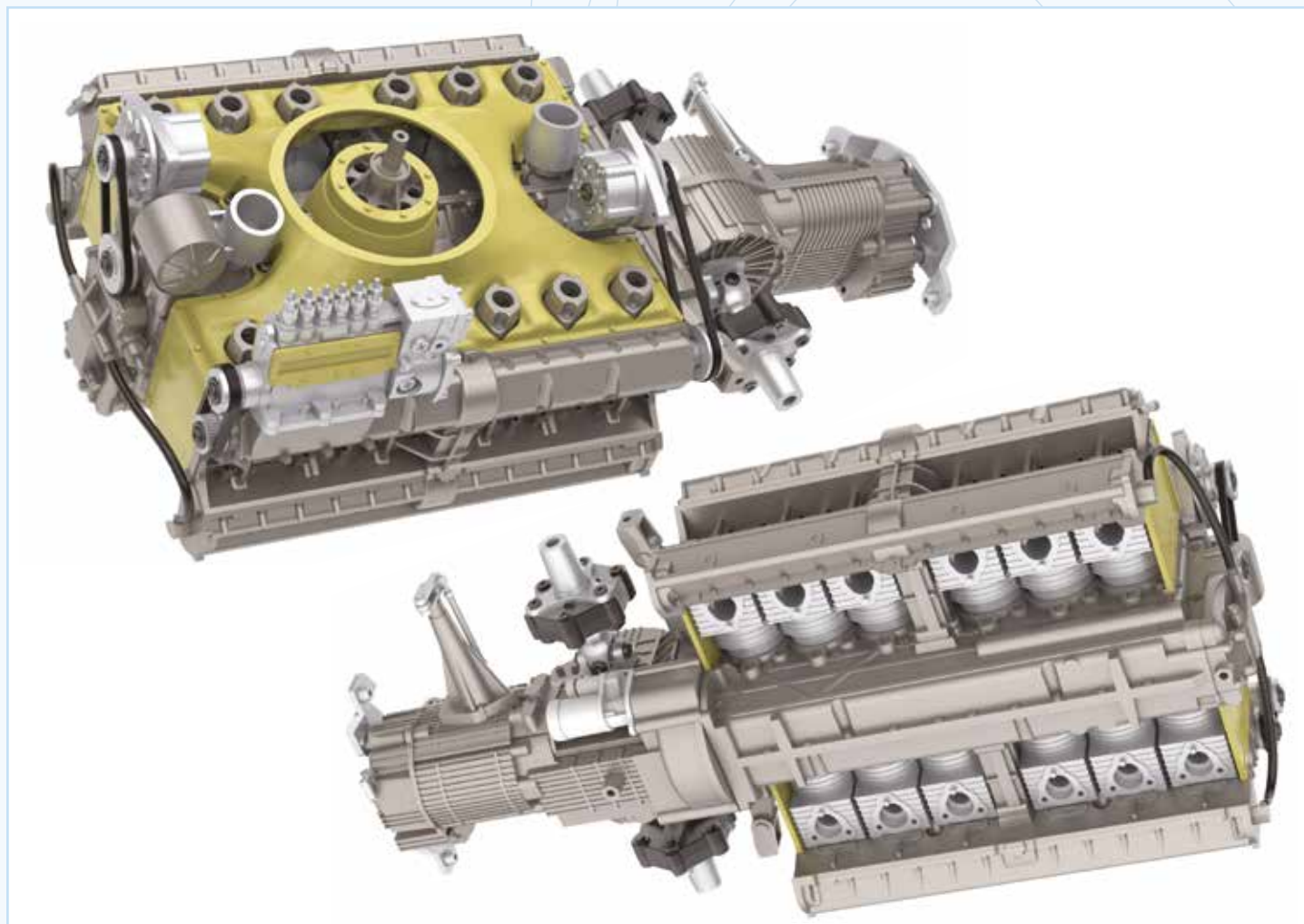


STEP 11

Connect the free end of the 8C oil hose to the nozzle located at the end of the 13C exhaust valve cover.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 15

15A Intake trumpet base top

15B Intake trumpet base bottom

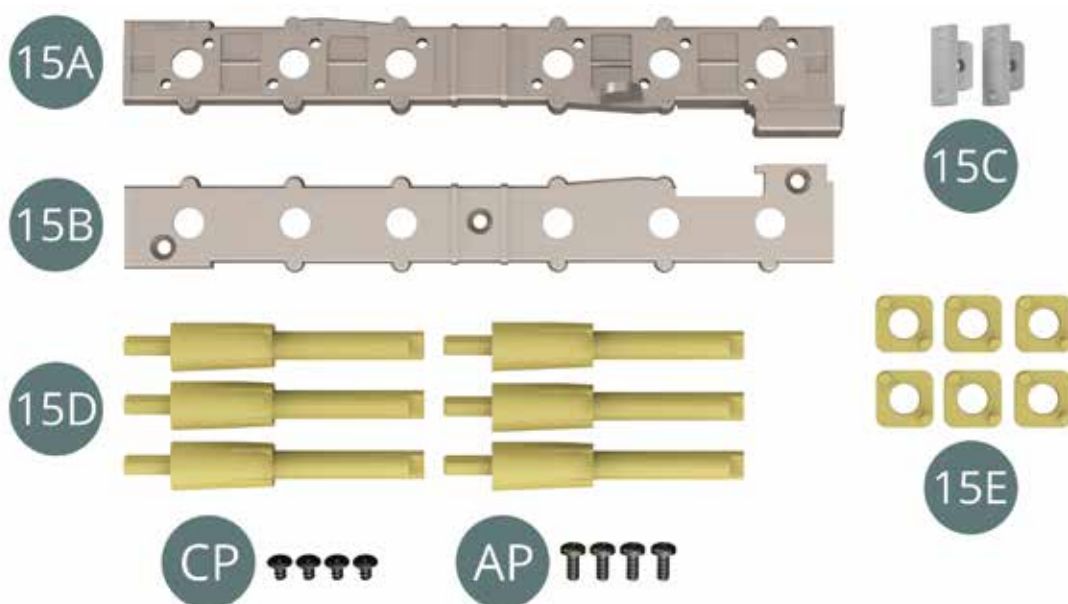
15C End cover (x2)

15D Intake trumpet (x6)

15E Intake trumpet flange (x6)

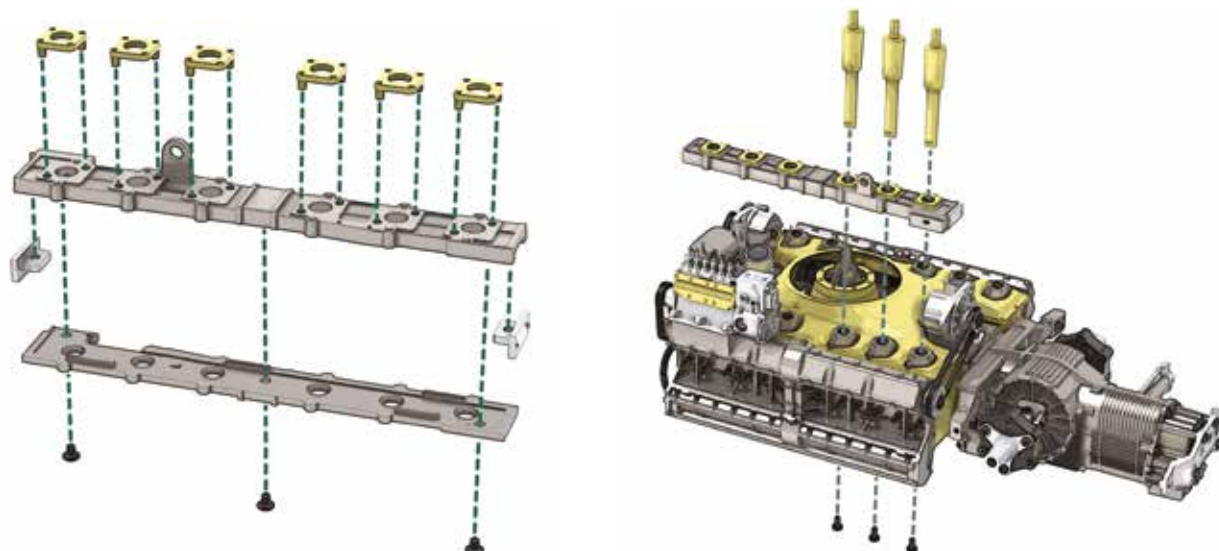
CP M1,7 x3x3mm (x4 , flat head)

AP M1,7 x4mm (x4)



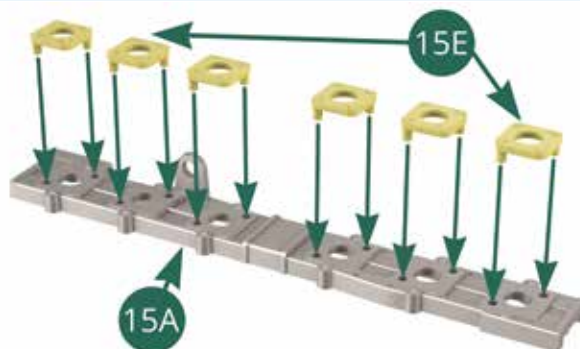
Left side Intake trumpets installation on the engine

ASSEMBLY DIAGRAM



STEP 1

Position the six 15E inlet flanges on the top of the 15A intake trumpet support.

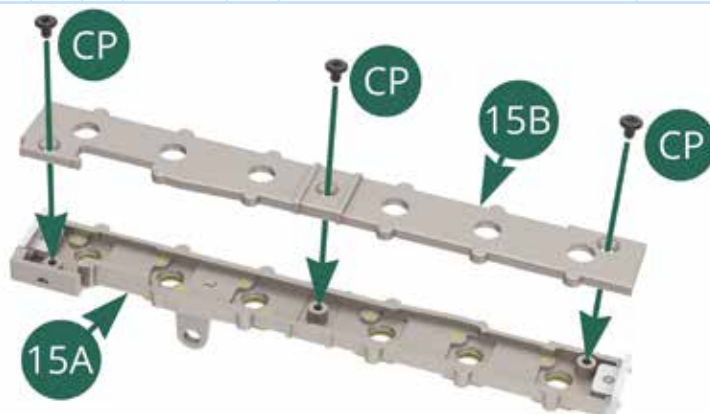


Position the two 15C covers at the ends of the 15A intake trumpet support top.



STEP 2

Position the inlet trumpet support underside 15B on the support top 15A and secure with three CP screws.



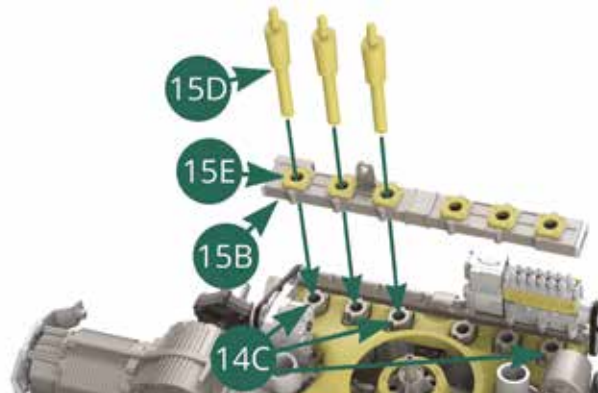
Preassembly of the intake trumpet holder





STEP 3

Position the 15B mission trumpet holder over the six 14C air intake brackets. Place three 15D inlet trumpets into the three corresponding 14C holders by passing them through their respective three 15E flanges.

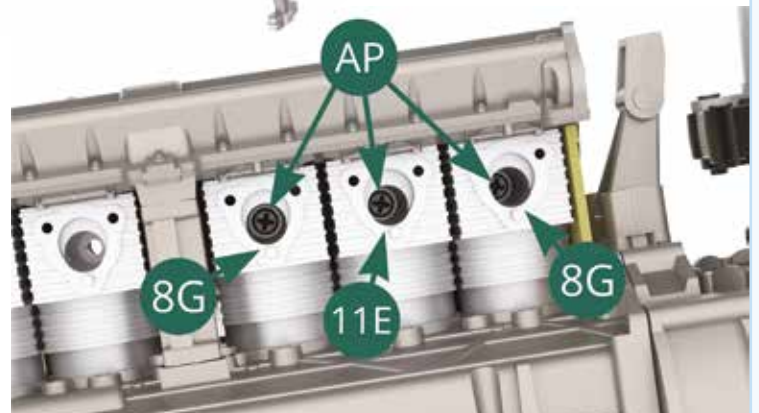
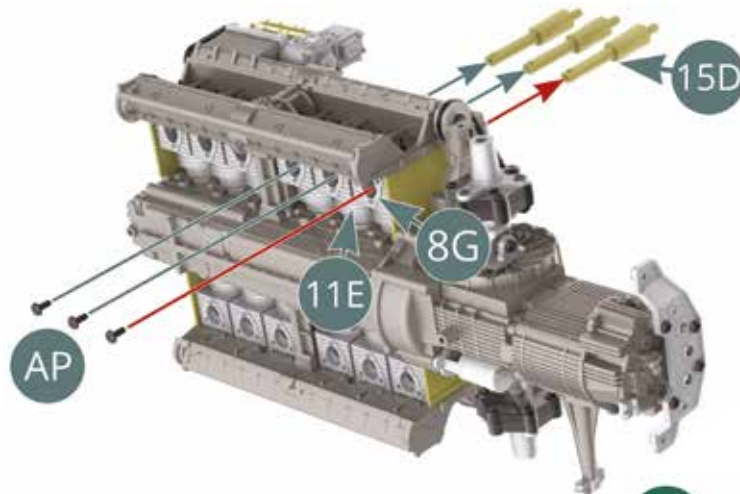


Check the correct orientation towards the outside of the holes on the 15D trumpets (red arrows in the illustrations opposite).

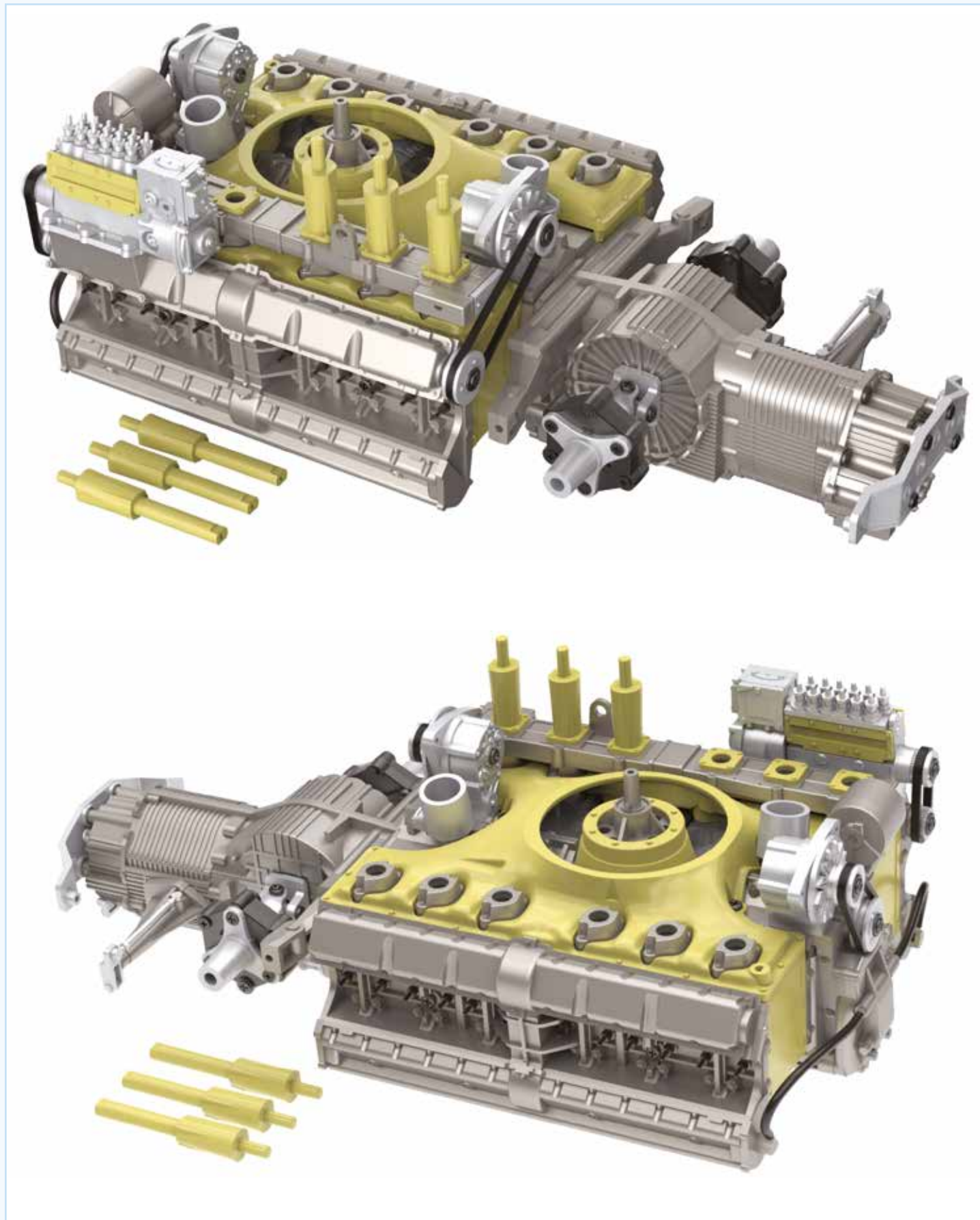


STEP 4

Attach three 15D intake trumpets to the 11E (x 1) and 8G (x 2) cylinder lower parts with three AP screws. Start with the 8G indicated by the red arrow (illustrations opposite and below).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 16

16A Intake trumpet support top

16B Admission trumpet support underside

16C End cover (x 2)

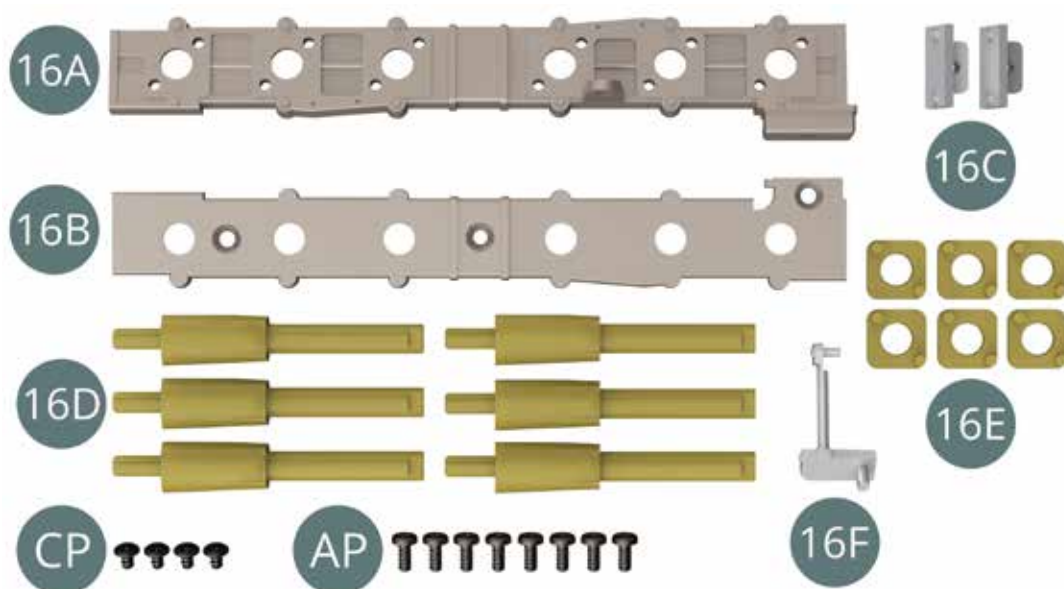
16D Admission Trumpet (x 6)

16E Inlet flange (x 6)

16F Generator support arm

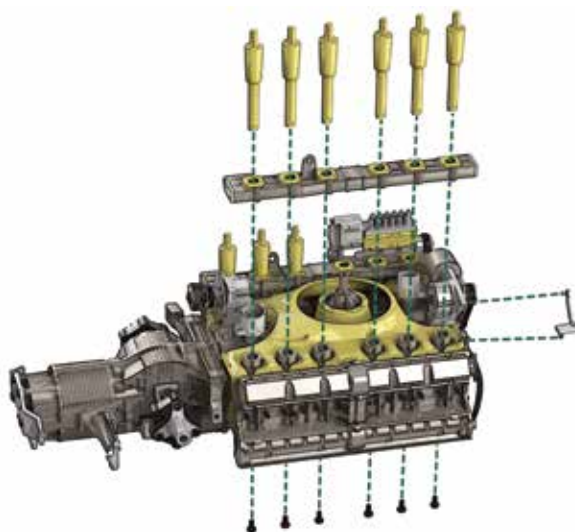
CP Screw M 1.7 x 3 x 3 mm (x 4, flat head)

AP Screw M 1.7 x 4 mm (x 8)



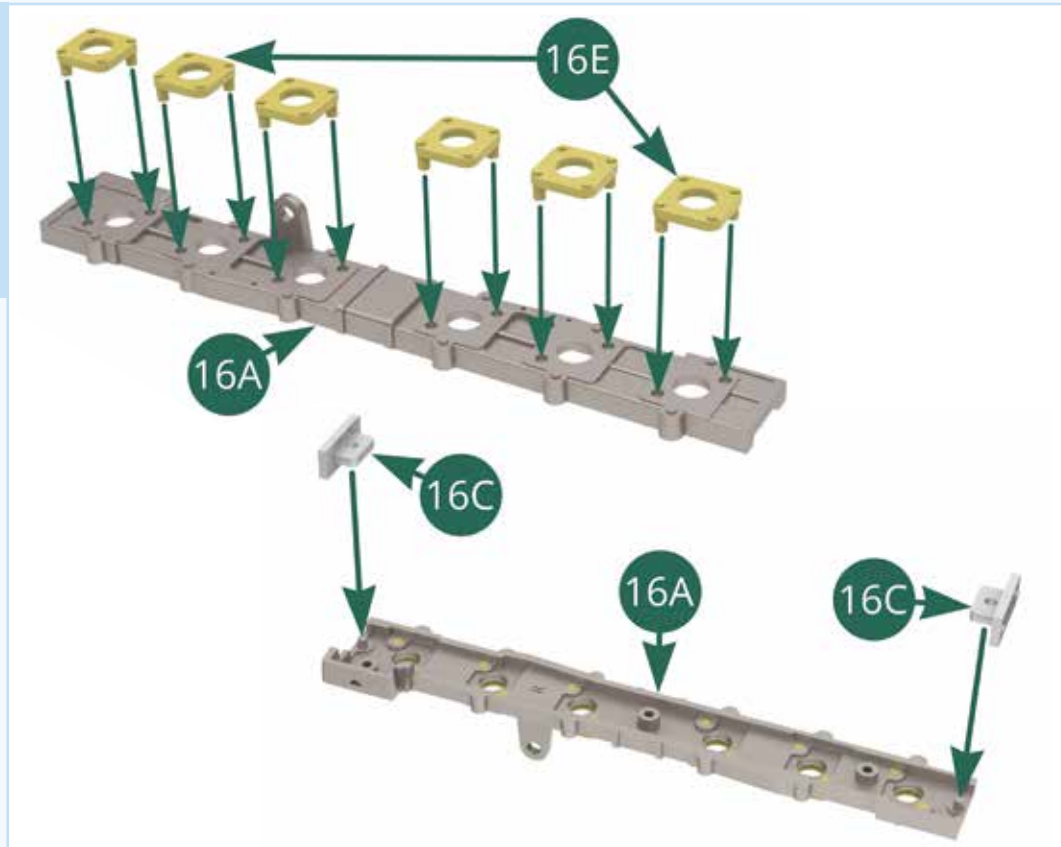
*Right side Intake
trumpets installation
on the engine*

ASSEMBLY DIAGRAM



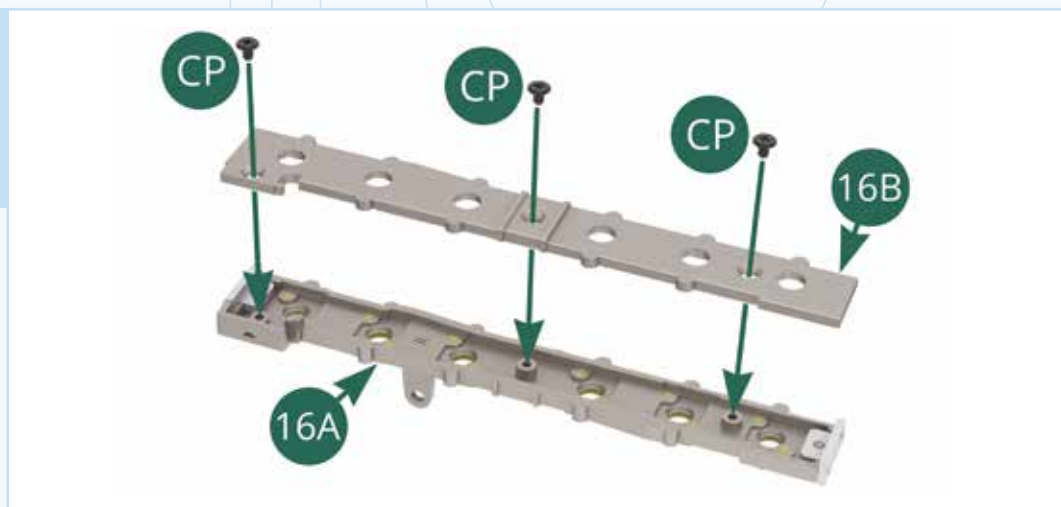
STEP 1

Position the six 16E intake flanges on the top of the 16A intake trumpet support. Position the two 16C covers at the ends of the 16A inlet trumpet support top.



STEP 2

Position the inlet trumpet support underside 16B on the support top 16A and secure with three CP screws.



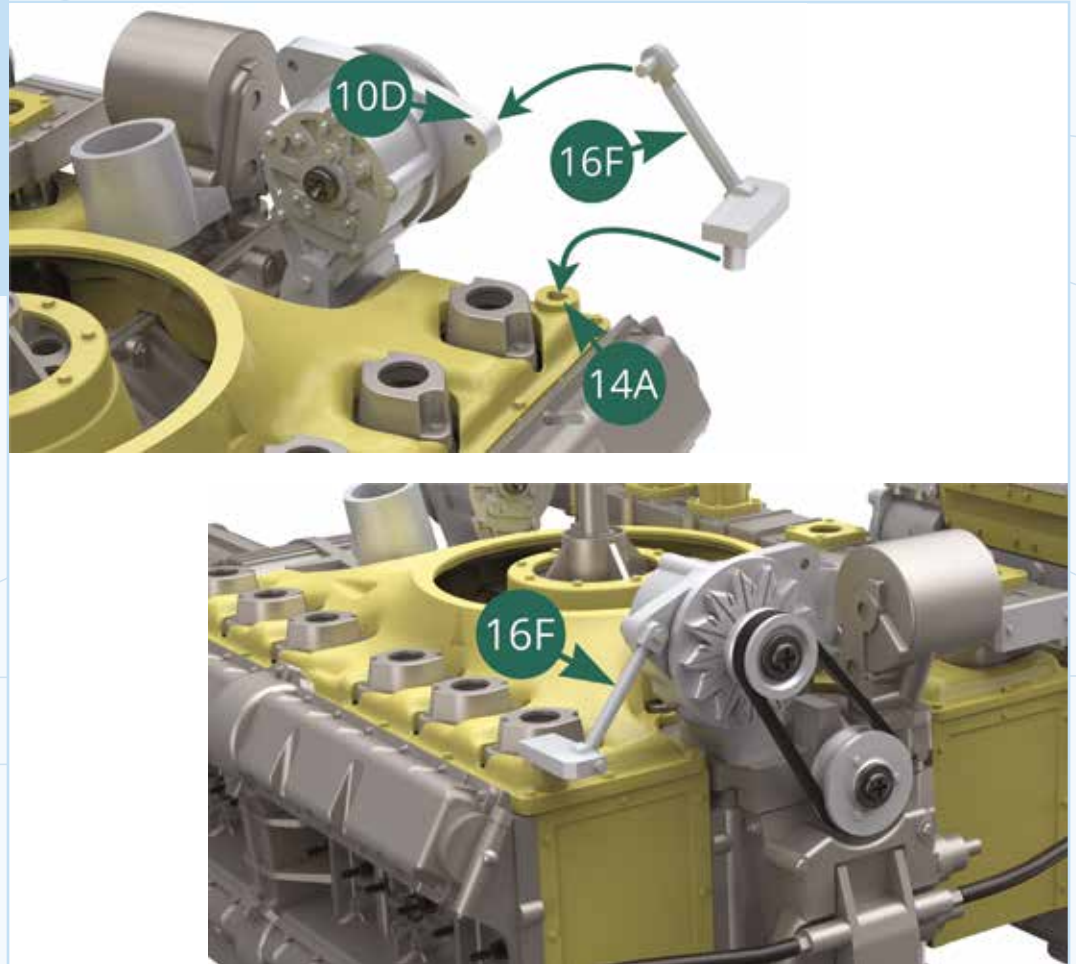
Preassembly of the intake trumpet holder





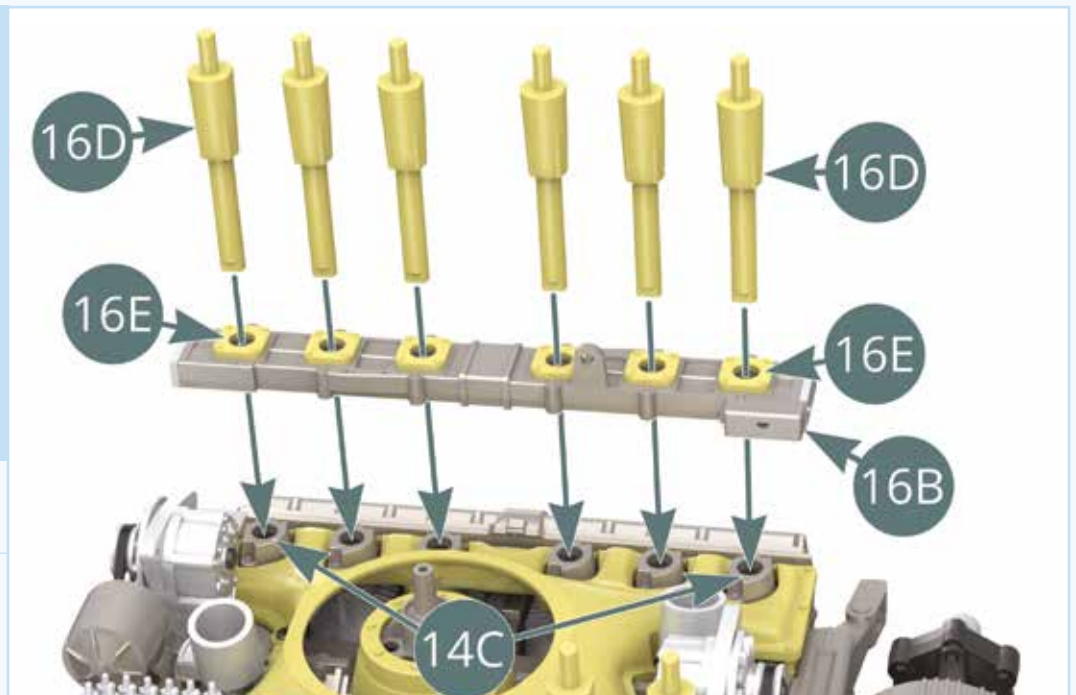
STEP 3

Position the support arm 16F on the bracket of the generator 10D and at the corner of the top of the air cooling chamber 14A (illustrations opposite and below).



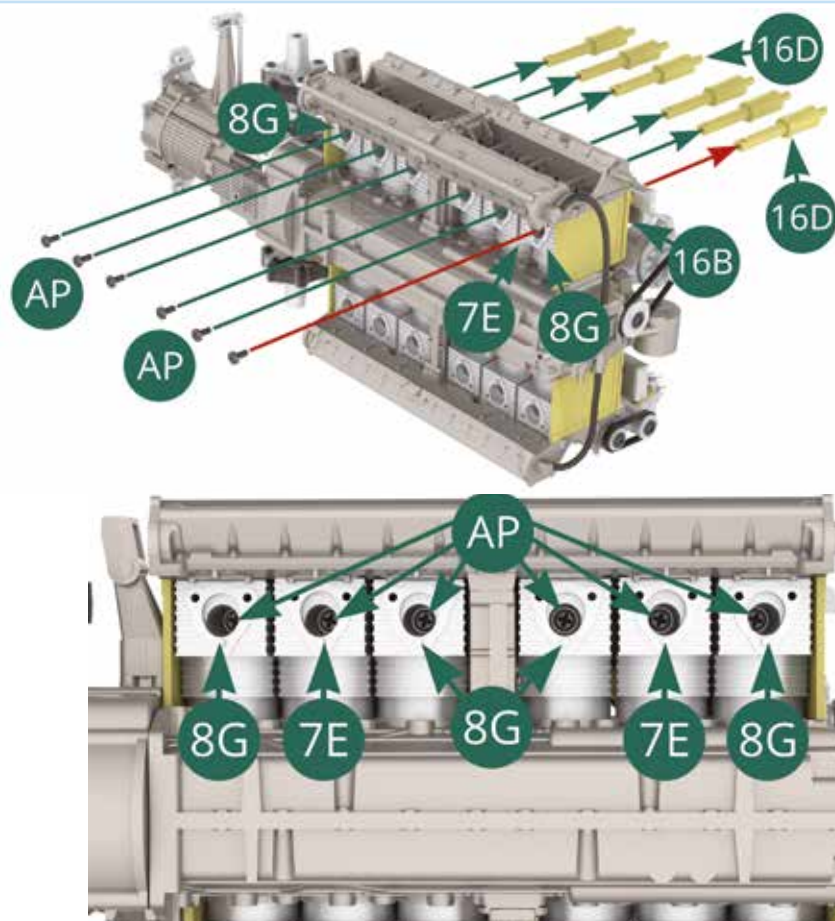
STEP 4

Position the 16B intake trumpet bracket over the six 14C air intake brackets. Place six 16D intake trumpets into the corresponding six 14C holders by passing them through their respective six 16E flanges. Check the correct orientation towards the inside of the holes on the 16D trumpets (red arrows).



STEP 5

Secure the 16D intake trumpets to the 8G (x 4) and 7E (x 2) cylinder lower parts with six AP screws. Start with the 8G indicated by the red arrow (illustrations opposite and below).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 17

17A Return spring (x2)

17B Generator strut (x 6)

17C Control rod (x 2)

17D Rocker axle (x 2)

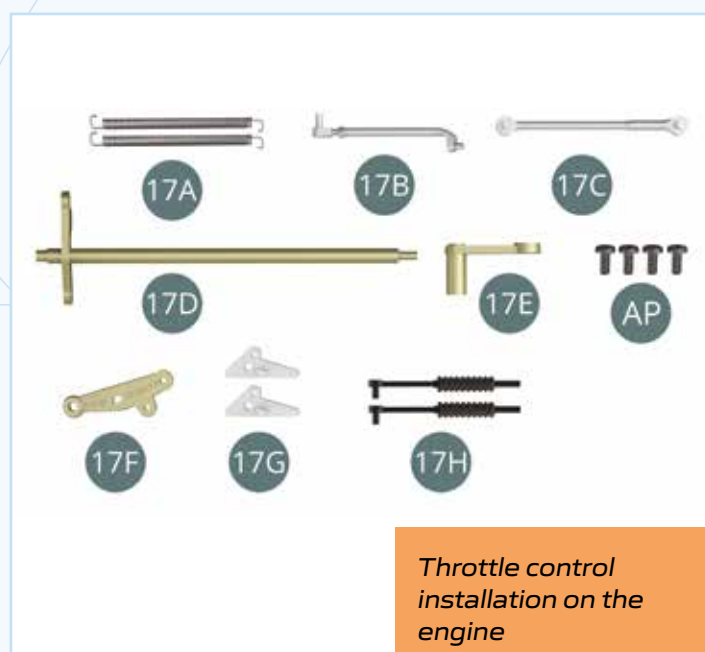
17E Control lever

17F Rocker

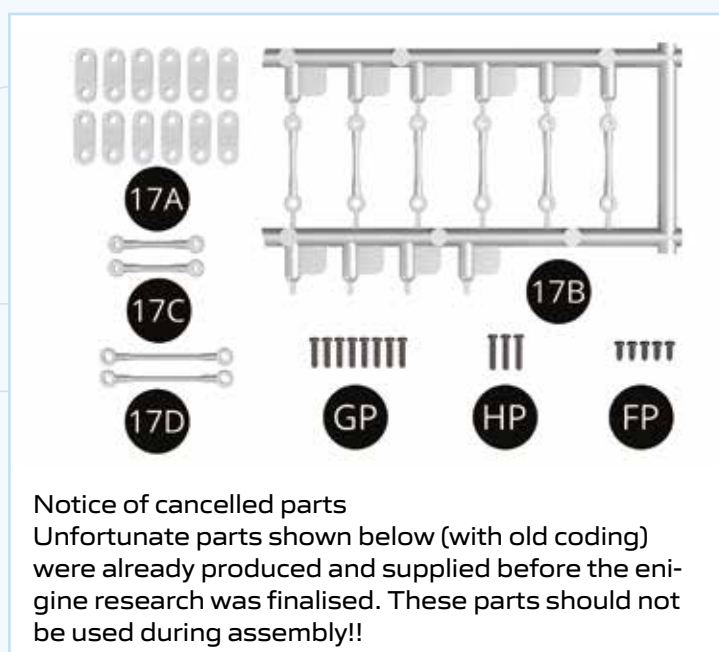
17G Bracket (x2)

17H Damper (x2)

AP Vis M 1,7 x 4 mm (x 4)

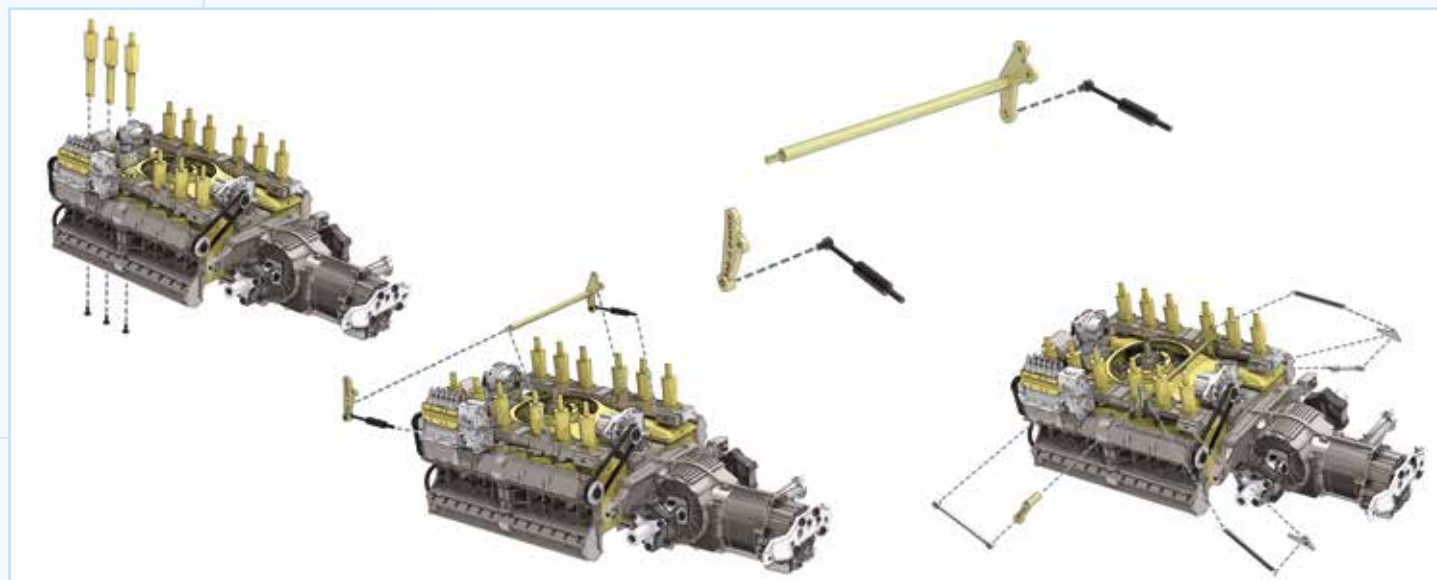


*Throttle control
installation on the
engine*



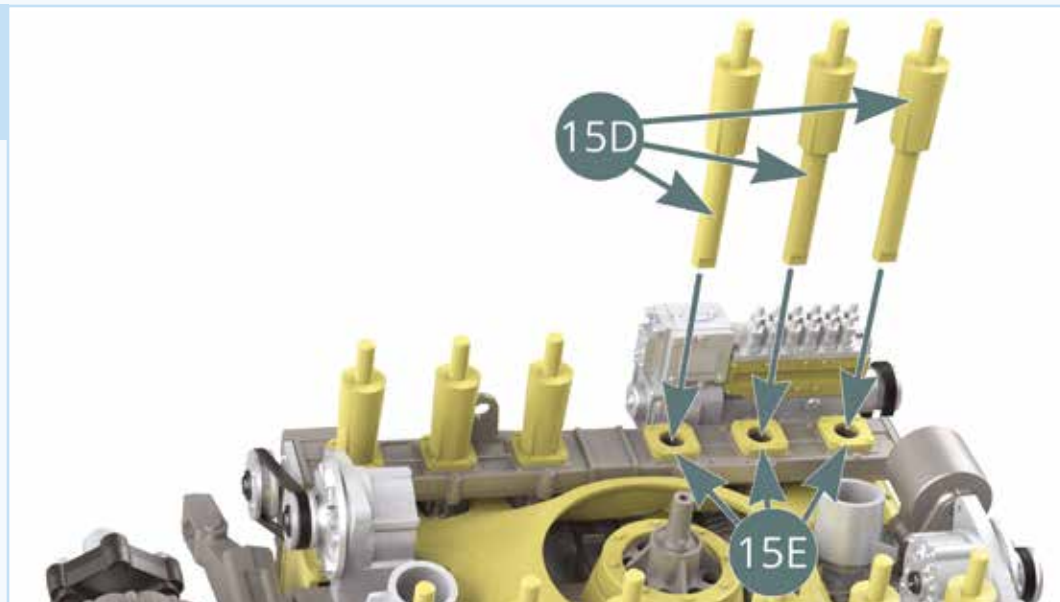
Notice of cancelled parts
Unfortunate parts shown below (with old coding)
were already produced and supplied before the en-
gine research was finalised. These parts should not
be used during assembly!!

ASSEMBLY DIAGRAM



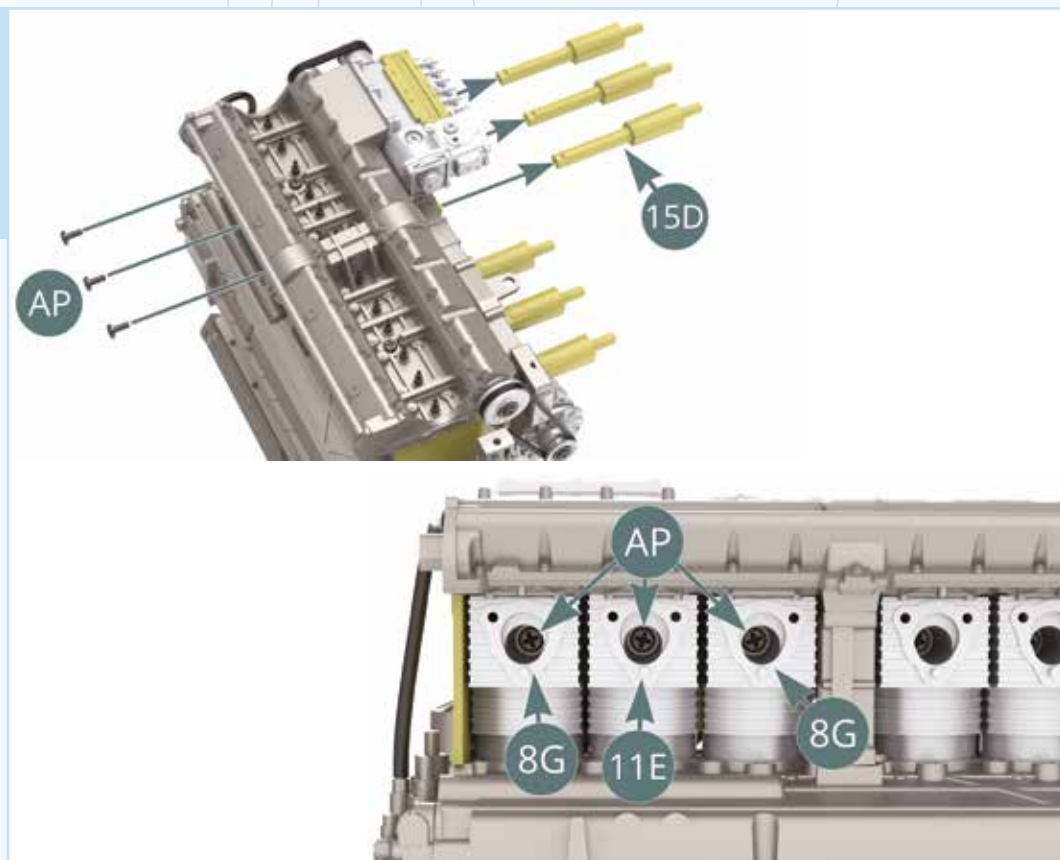
STEP 1

Fit three 15D Intake trumpets into three 15E Intake trumpet flanges.



STEP 2

Fix three 15D Intake trumpets to 11E and 8G Cylinder lower parts with three AP screws (top and bottom illustrations).





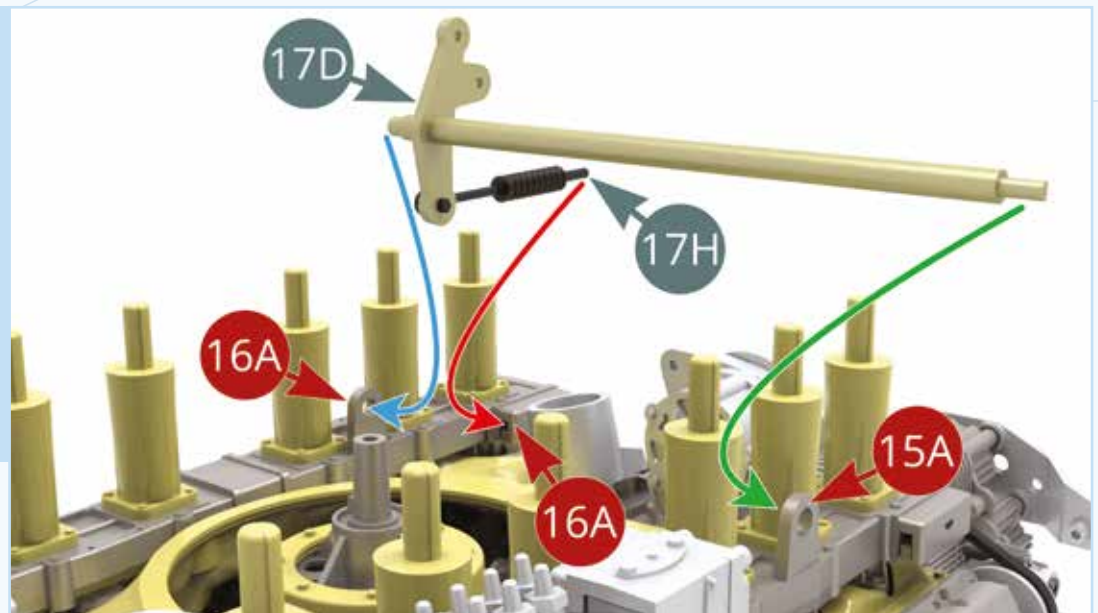
STEP 3

Fit 17H Damper to 17D Rocker axle.



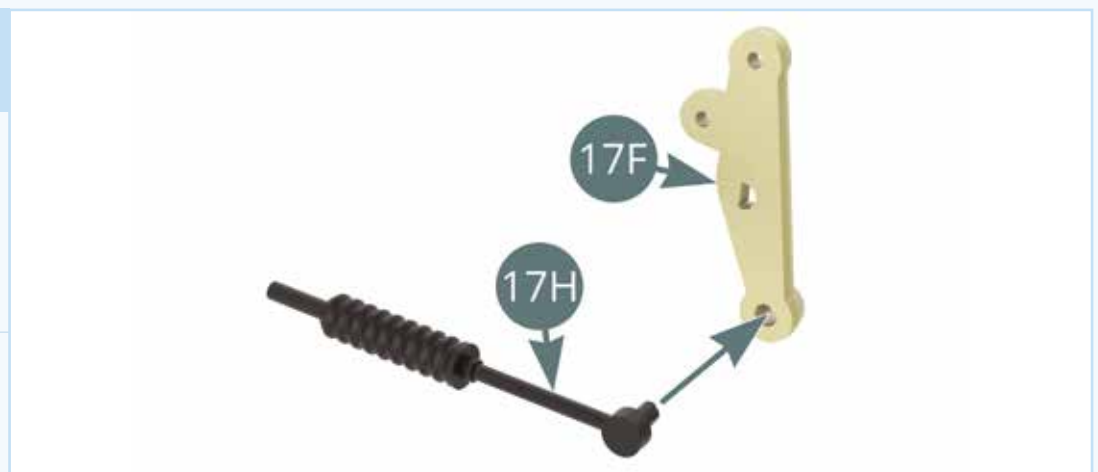
STEP 4

Start fitting 17D Rocker axle by passing its free end into 15A Intake trumpet base eye plate (green arrow) and 17H Damper into 16A Intake trumpet base (red arrow). Finish 17D Rocker axle installation by fitting its rocker end into 16A Intake trumpet base eye plate (blue arrow).



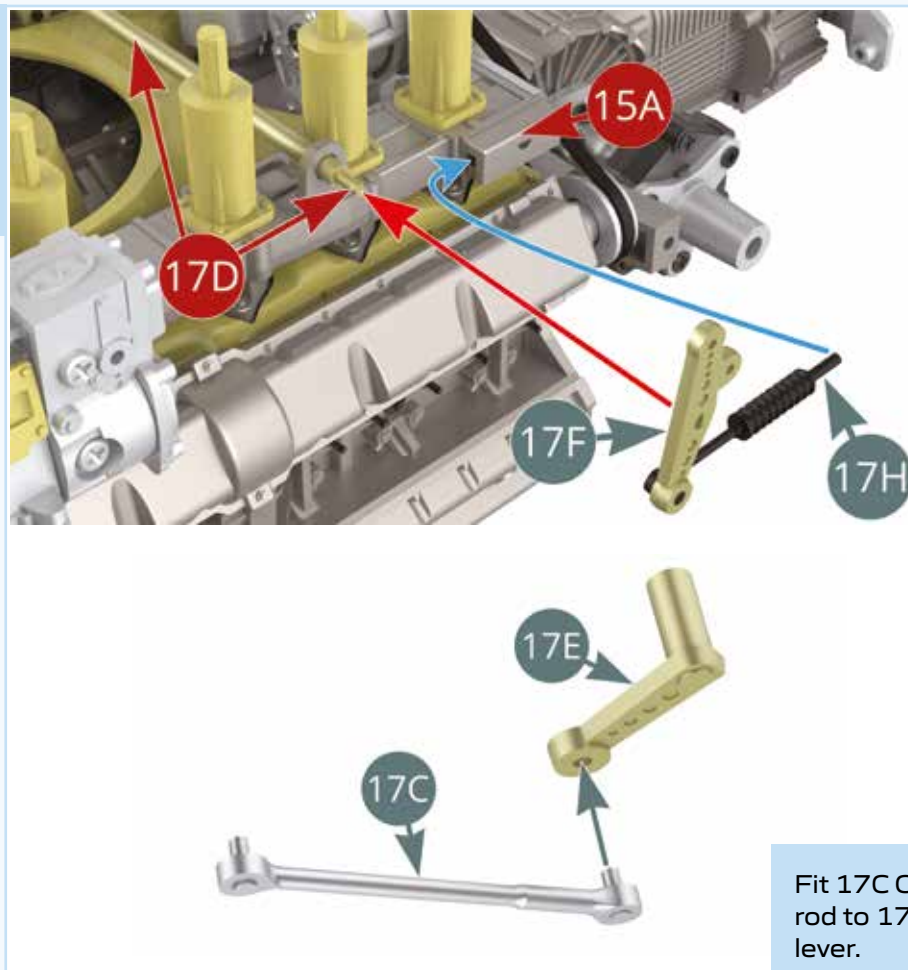
STEP 5

Fit 17H Damper to 17F Rocker.



STEP 6

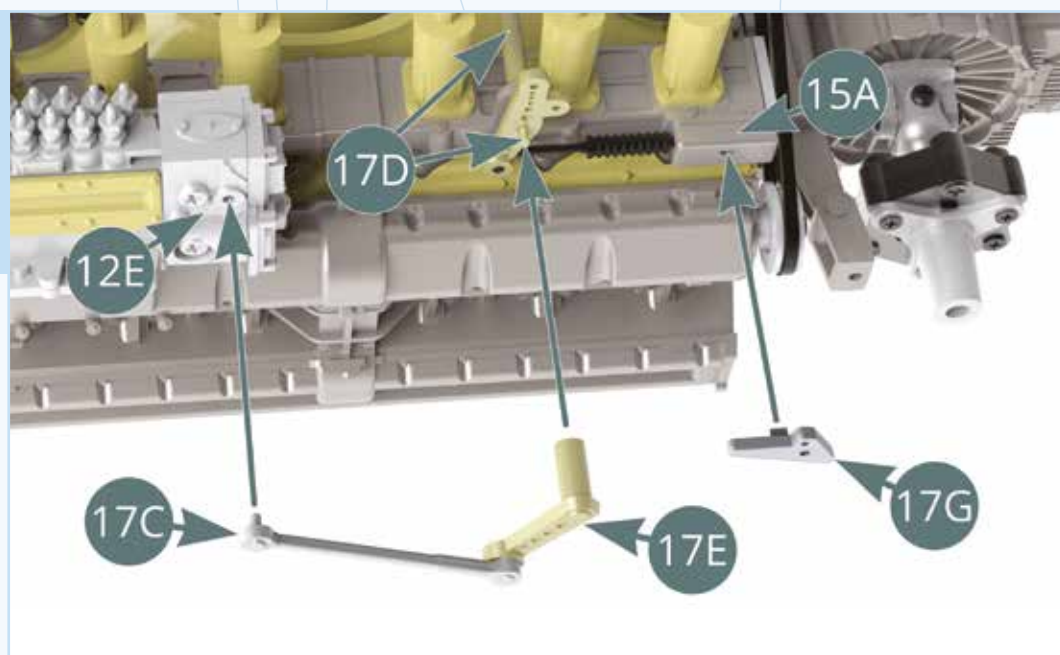
Fit 17H Damper into 15A Intake trumpet base (blue arrow) and 17F Rocker to 17D Rocker axle (red arrow).



Fit 17C Control rod to 17E Control lever.

STEP 7

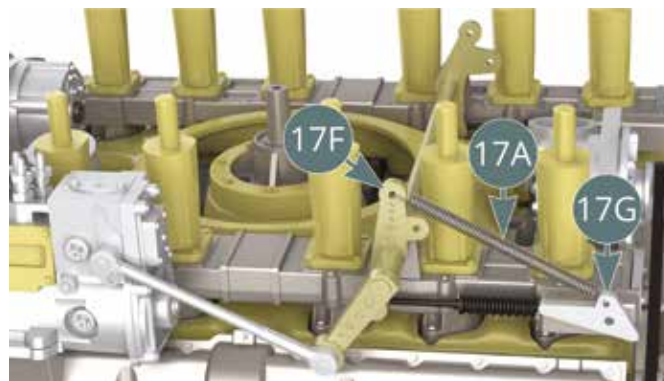
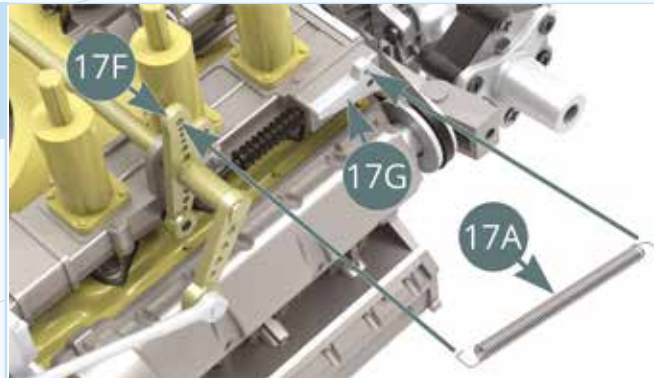
Fit 17E Control lever to 17D Rocker axle end, and 17C Control rod to 12E Bosch injector pump. Fit 17G Bracket to 15A Intake trumpet base.





STEP 8

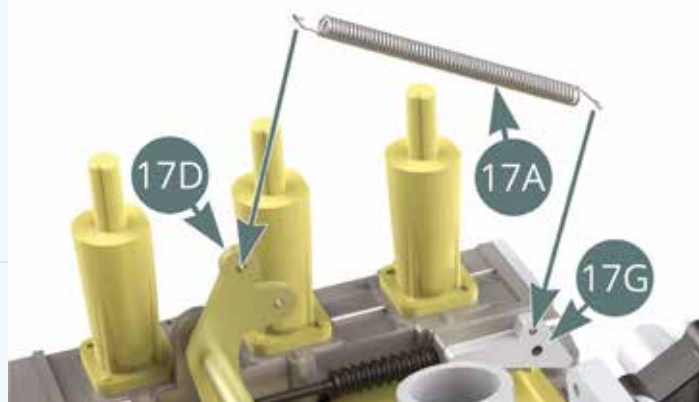
Fit 17A Return spring between 17G Bracket and 17F Rocker.



17A Return spring is installed between 17G Bracket and 17F Rocker.

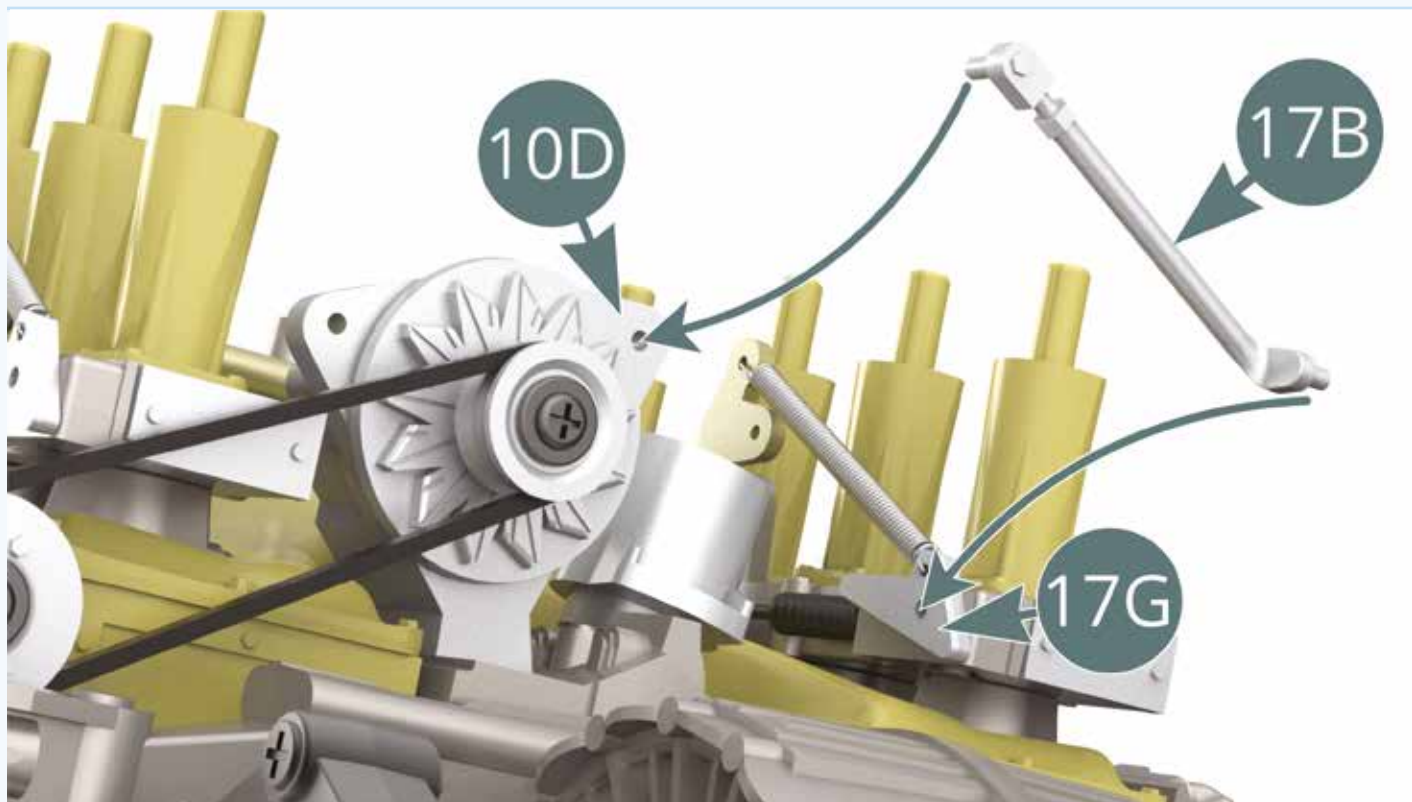
STEP 9

Fit 17G Bracket to 16A Intake trumpet base.

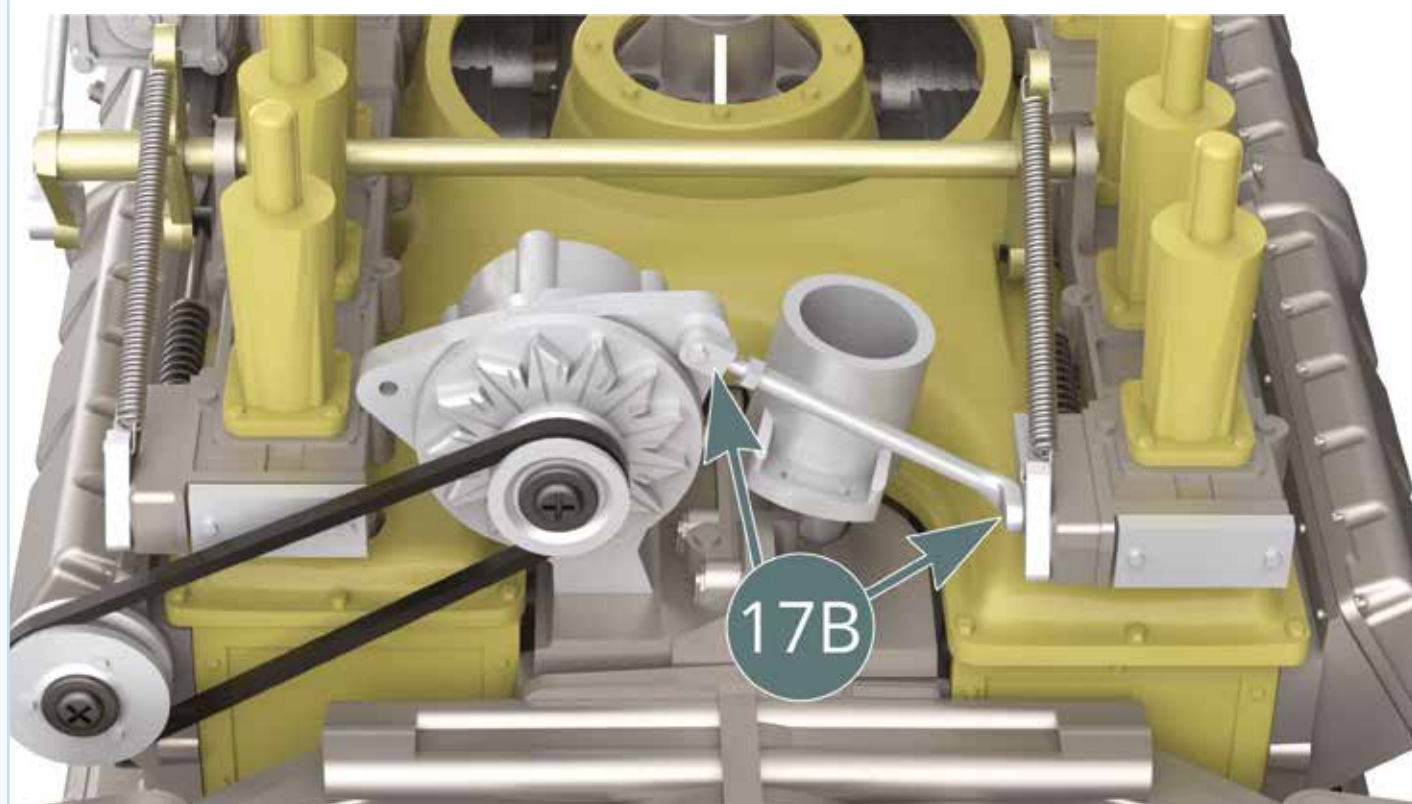


Fit 17A Return spring between 17G Bracket and 17D Rocker axle.

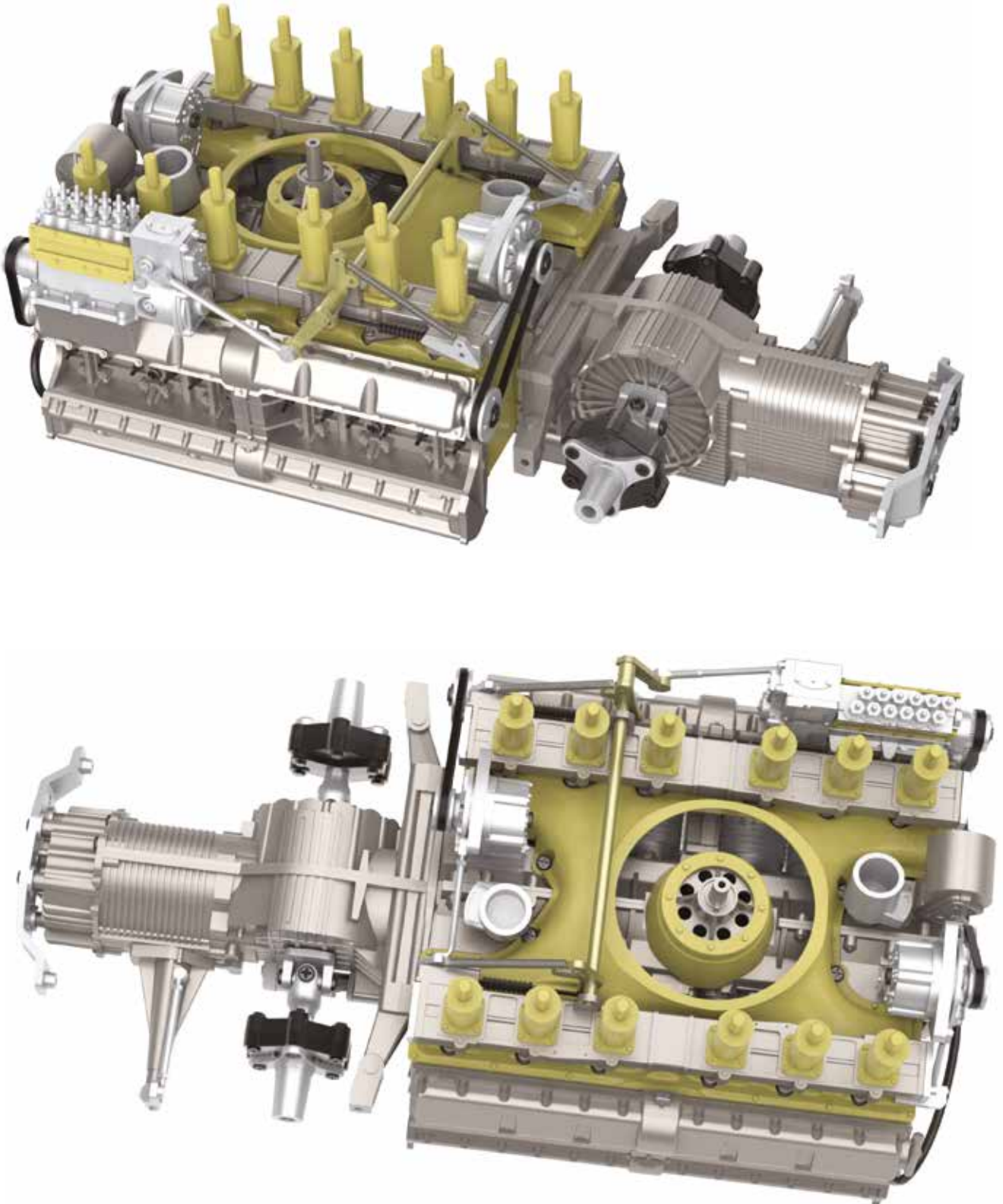
STEP 10



Fit 17B Generator strut between 17G Bracket and 10D Generator (upper and lower illustrations).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 18

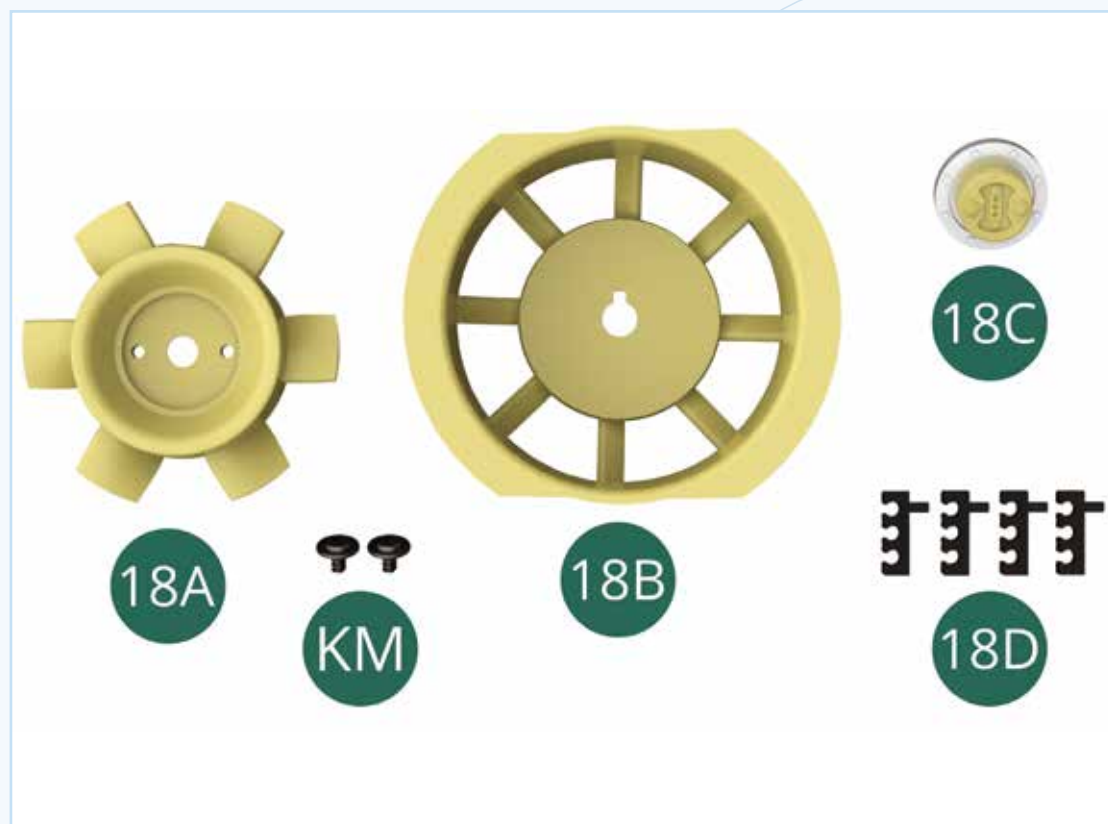
18A Fan

18B Fan housing

18C Hub cover

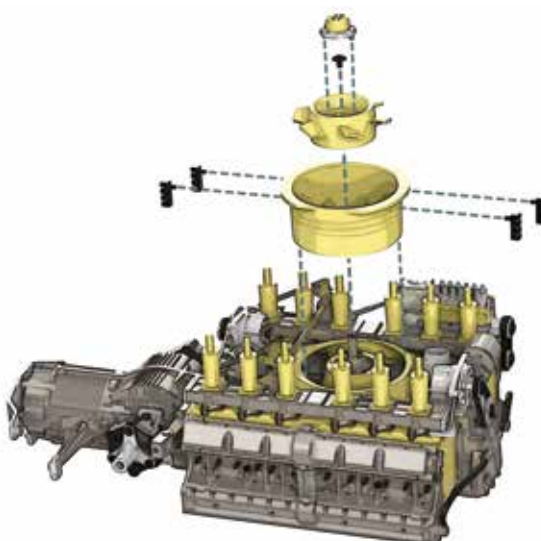
18D Fuel line guide (x4)

KM M1,7 x3x5mm (x2)



Cooler fan installation on the engine

ASSEMBLY DIAGRAM





STEP 1

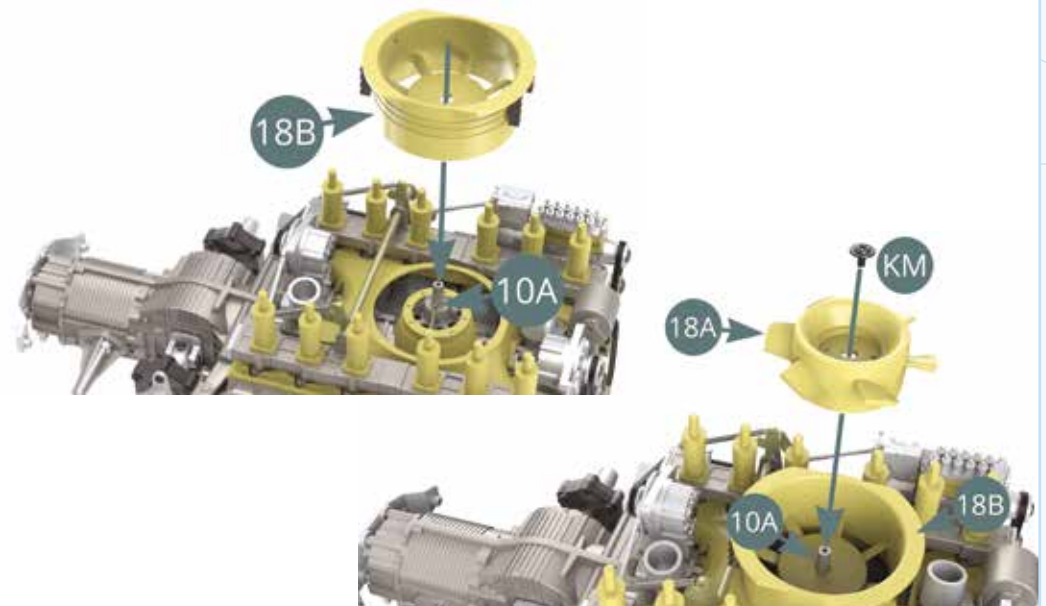
Fit two 18D Fuel line guides to one side of 18B Fan housing and two more to its opposite side (top and bottom illustrations).



STEP 2

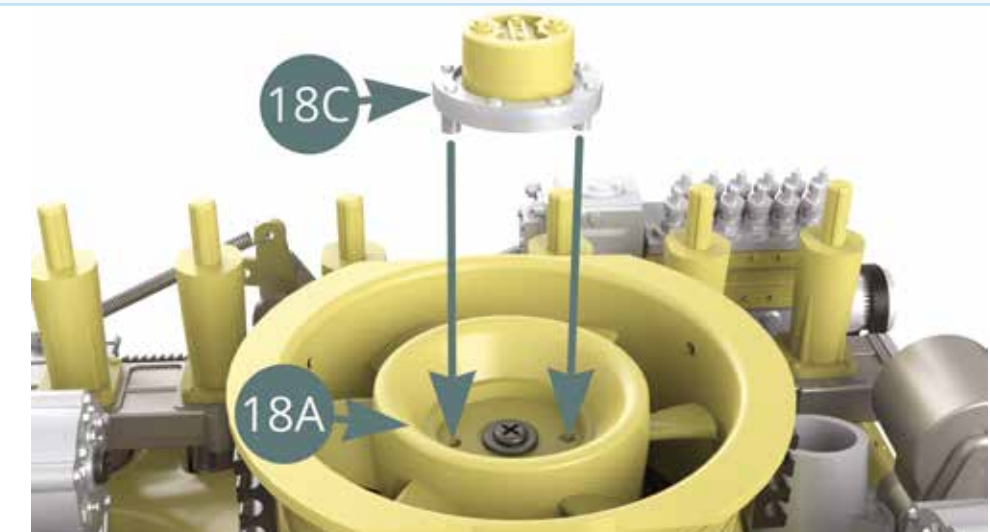
Fit 18B Fan housing to 10A Crankcase top panel stub axle.

Fit 18A Fan to 10A Crankcase top panel stub axle and fix with KM screw.

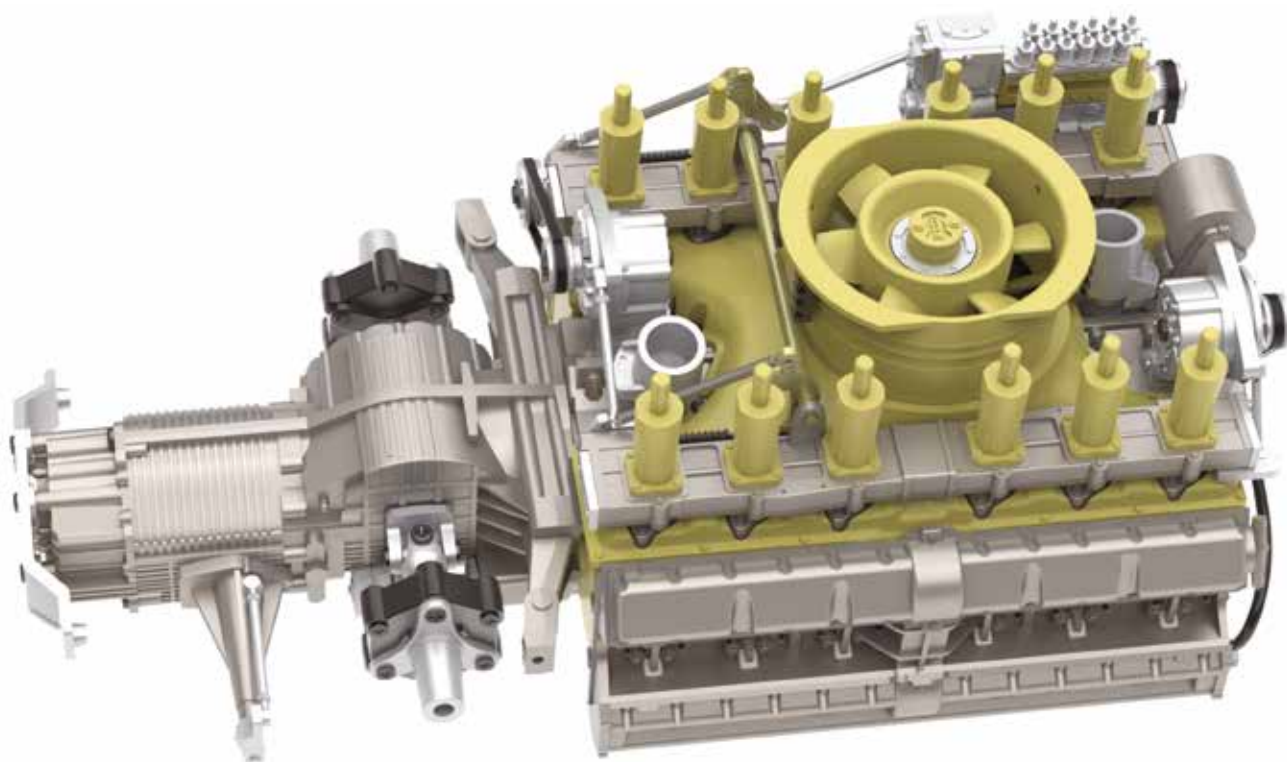
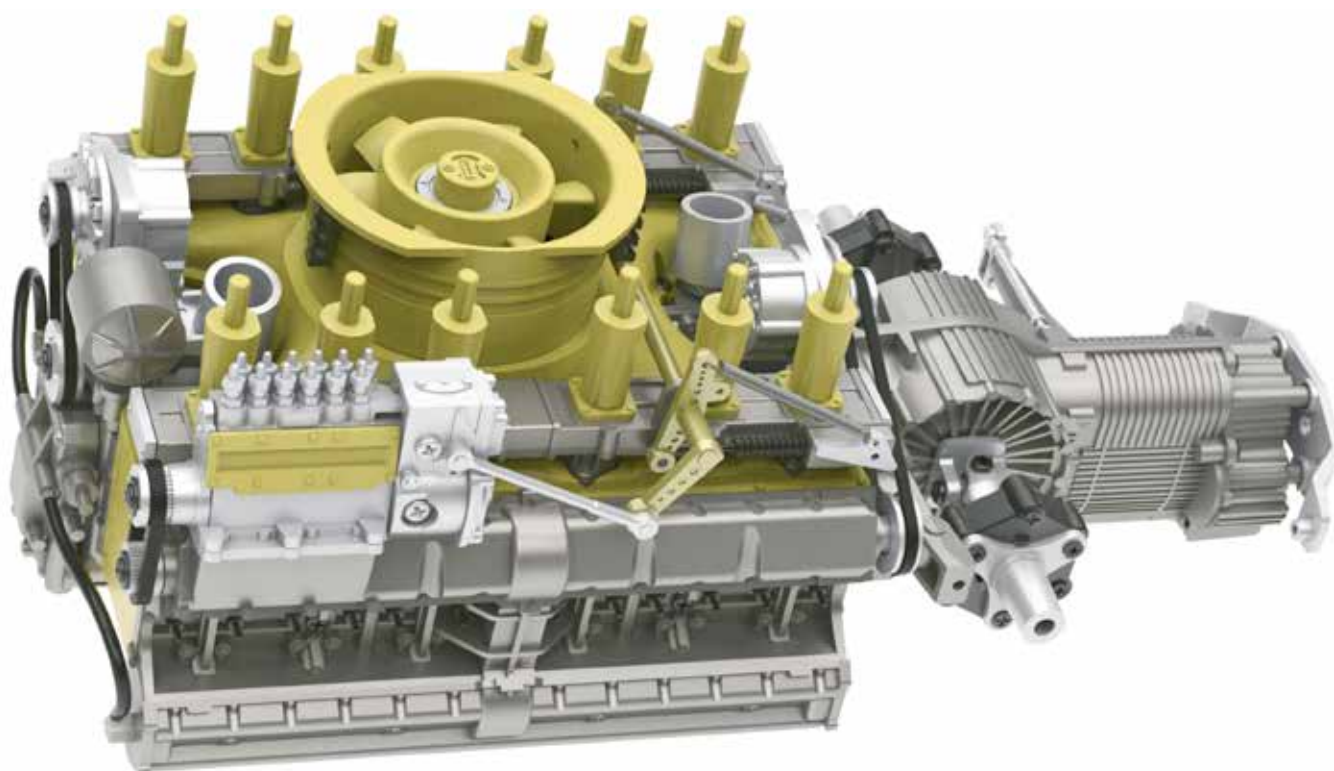


STEP 3

Fit 18C Hub cover to 18A Fan.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 19

19A Flange (x6)

19B Exhaust pipe

19C Exhaust pipe

19D Exhaust pipe

19E Exhaust pipe

19F Exhaust pipe

19G Exhaust pipe

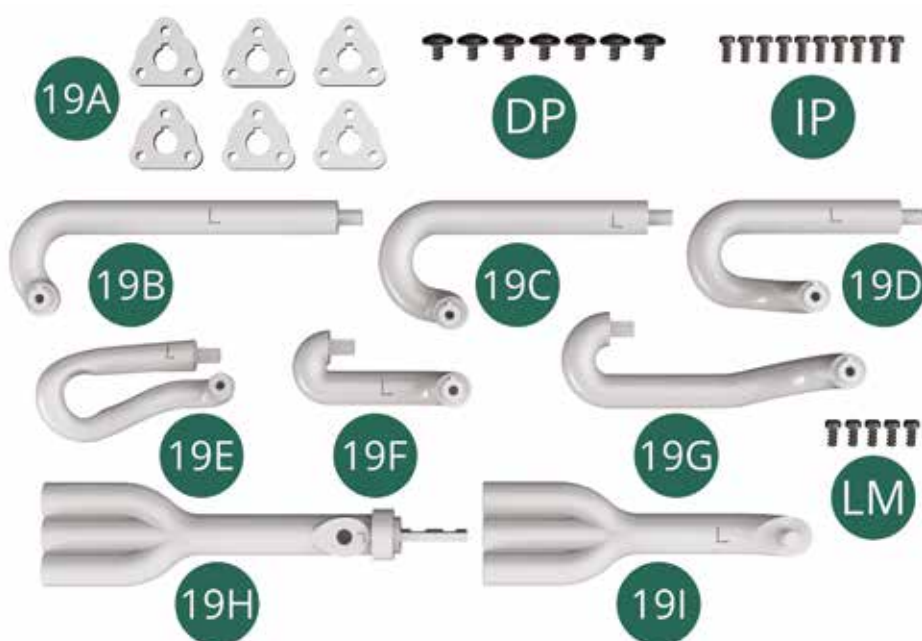
19H Exhaust manifold

19I Exhaust manifold

DP M1,7 x3x5mm (x7)

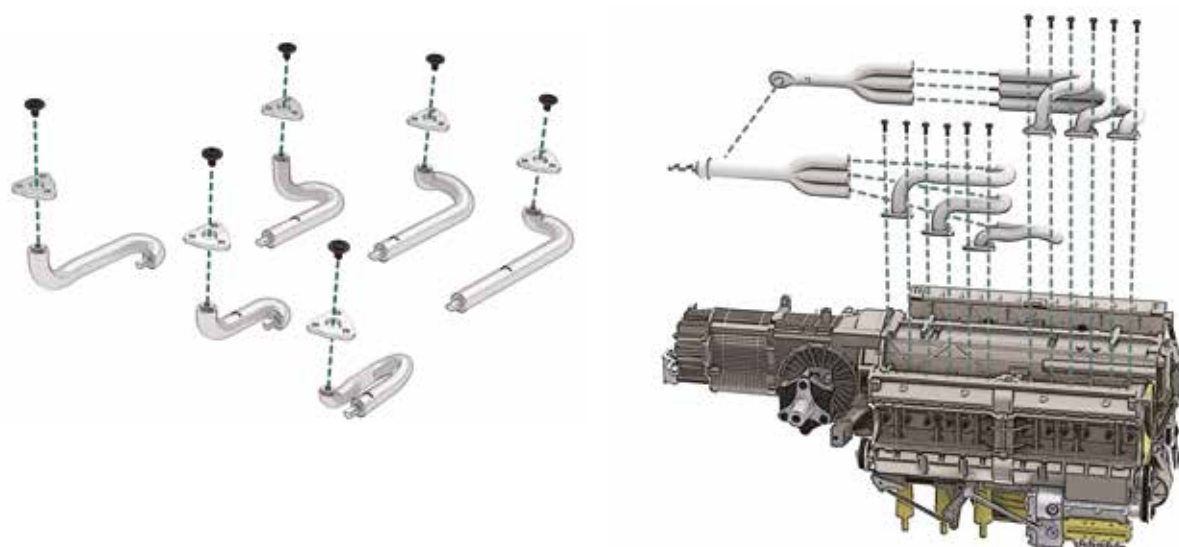
IP M1,5 x3mm (x10)

LM M1,5 x3mm (x5)



Left exhaust manifold installation on the engine

ASSEMBLY DIAGRAM



STEP 1

Fit six 19A Flanges consecutively on 19B, 19C, 19D, 19E, 19F and 19G Exhaust pipes and fix with six DP screws (upper and lower illustrations).



STEP 2

Fit 19A Flange of 19B Exhaust pipe to 8G Cylinder and fix with two IP screws.

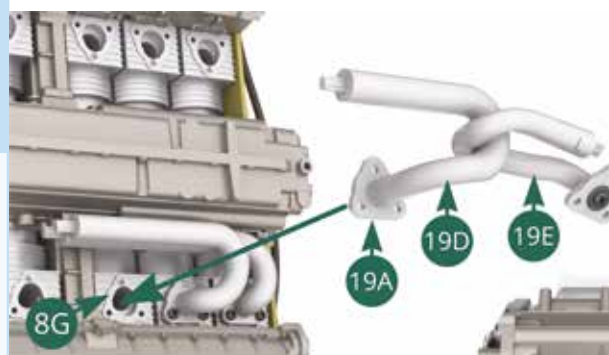


Fit 19A Flange of 19C Exhaust pipe to 11E Cylinder and fix with two LM screws.



STEP 3

Hook 19E Exhaust pipe to 19D Exhaust pipe and fit the latter's 19A Flange to 8G Cylinder.



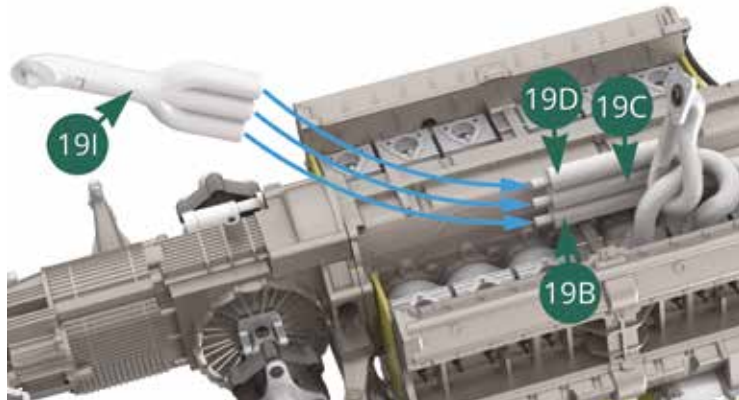
Fix 19A Flange of 19D Exhaust pipe to 8G Cylinder with two IP screws.





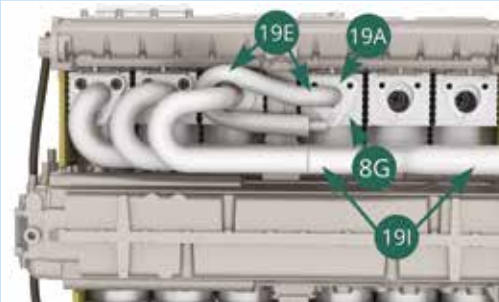
STEP 4

Fit 19I Exhaust manifold to connecting pins of 19B, 19C and 19D Exhaust pipes.



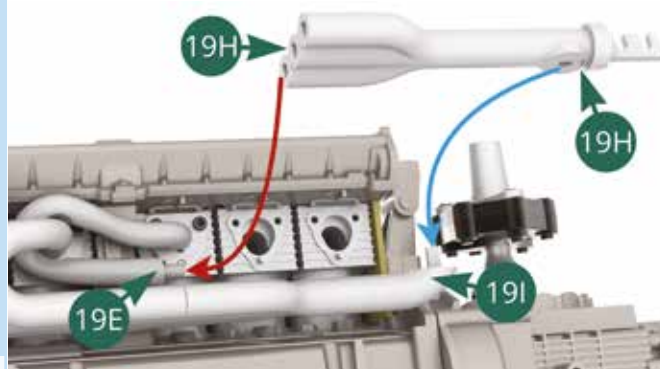
STEP 5

Fit 19A Flange of 19E Exhaust pipe to 8G Cylinder and fix with two IP screws (upper and lower illustrations).



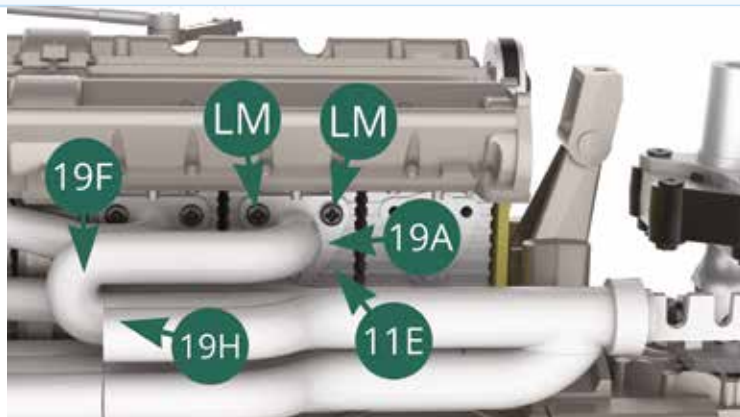
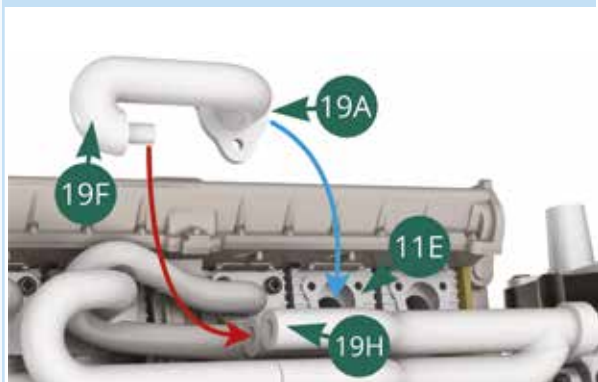
STEP 6

Fit 19H Exhaust manifold lower socket to 19E Exhaust pipe pin (red arrow) and then fit 19H Exhaust manifold other extremity socket to 19I Exhaust manifold pin (blue arrow), referring to top and bottom illustrations.



STEP 7

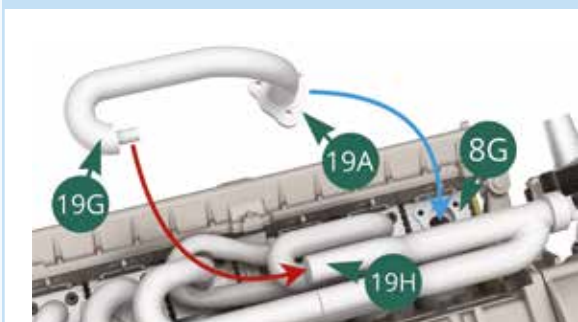
Fit 19F Exhaust pipe pin to middle socket of 19H Exhaust manifold (red arrow), aligning at the same time 19A Flange to 11E Cylinder (blue arrow).



Fix 19A Flange of 19F exhaust pipe to 11E Cylinder with two LM screws.

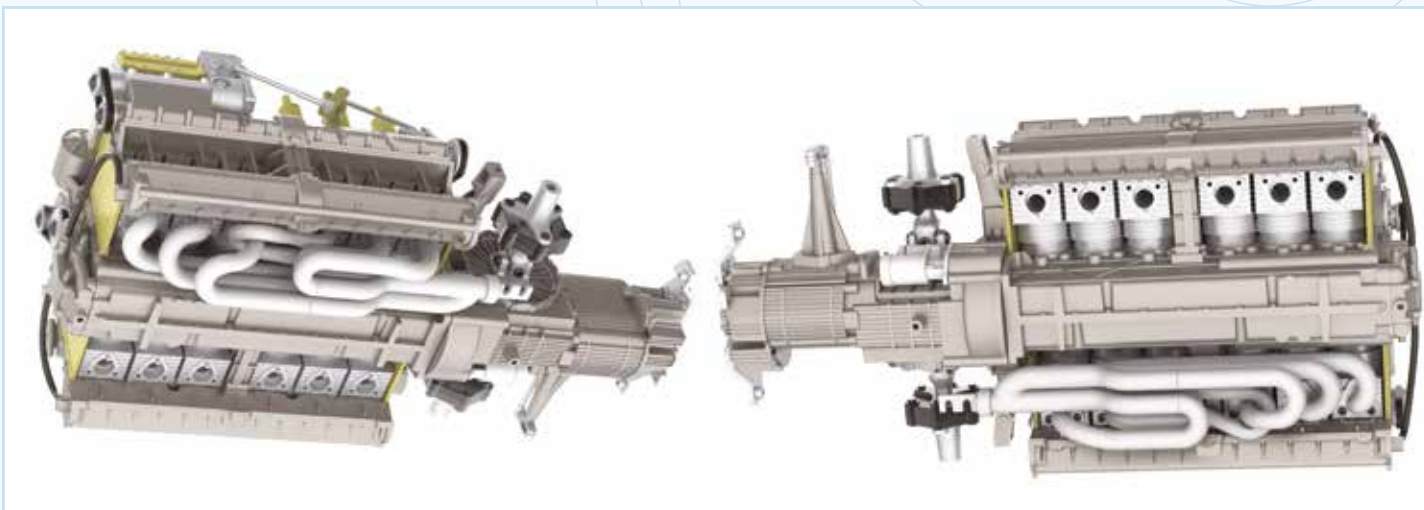
STEP 8

Fit 19G Exhaust pipe pin to top socket of 19H Exhaust manifold (red arrow), aligning at the same time 19A Flange to 8G Cylinder (blue arrow).



Fix 19A Flange of 19G exhaust pipe to 8G Cylinder with two IP screws.

GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 20

20A Flange (x 6)

20B Exhaust pipe

20C Exhaust pipe

20D Exhaust pipe

20E Exhaust pipe

20F Exhaust pipe

20G Exhaust pipe

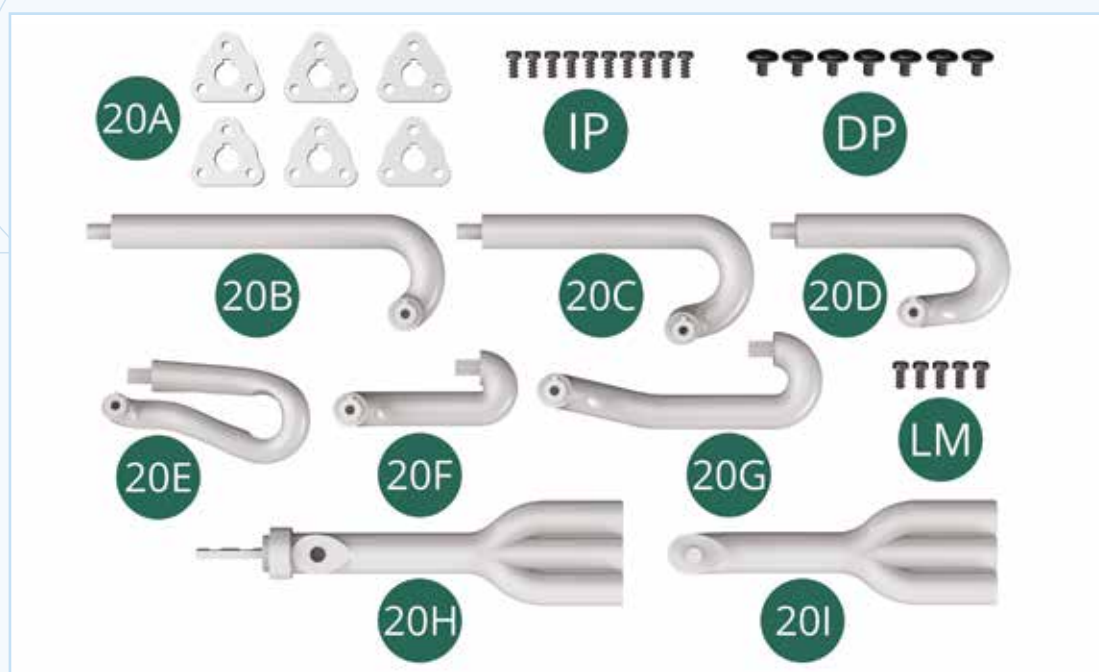
20H Exhaust manifold

20I Exhaust manifold

DP Screw M 1.7 x 3 x 5 mm (x 7)

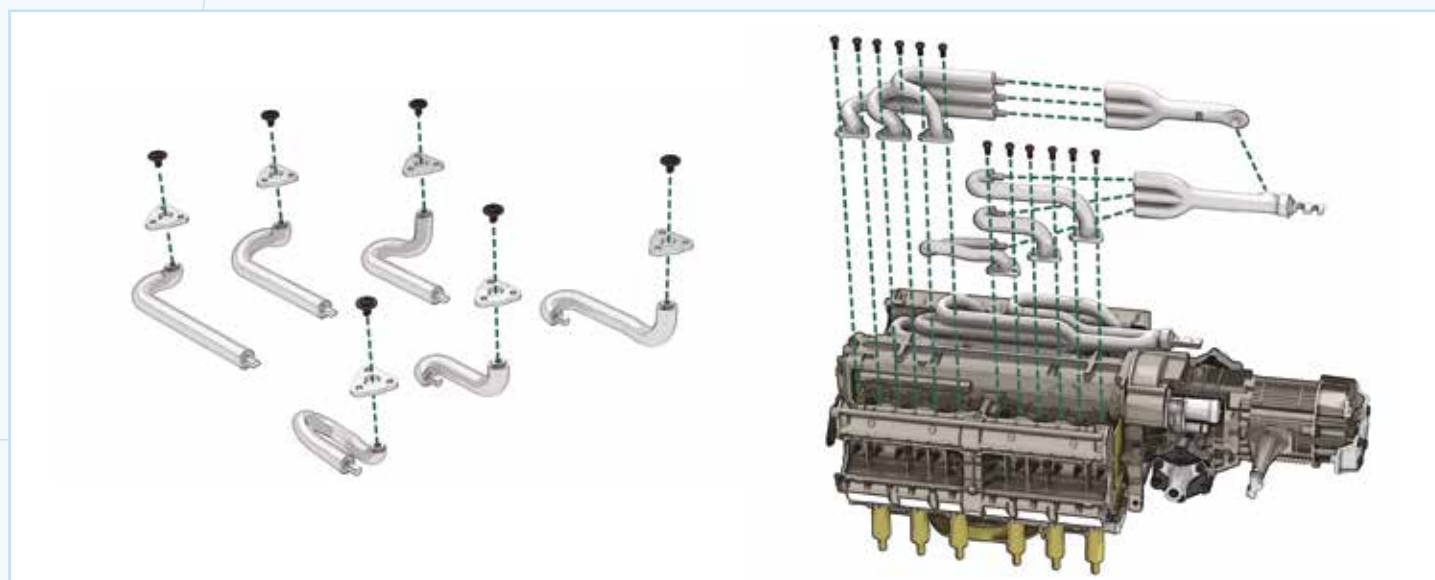
IP Screw M 1.5 x 3 mm (x 10)

LM Screw M 1.5 x 3 mm (x 5)



Right exhaust manifold installation on the engine

ASSEMBLY DIAGRAM



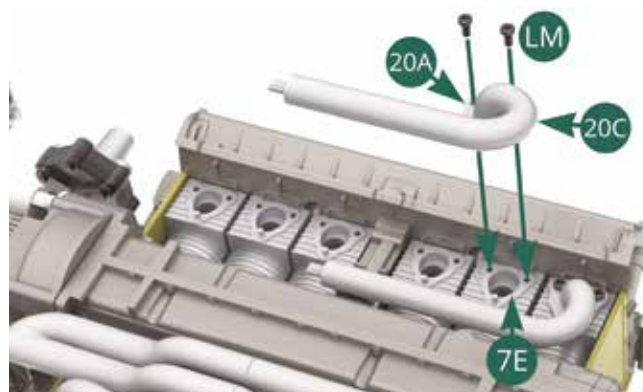
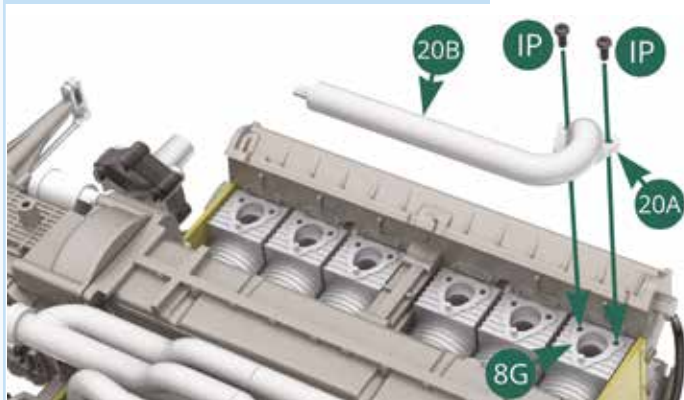
STEP 1

Fit six 20A Flanges consecutively on 20B, 20C, 20D, 20E, 20F and 20G Exhaust pipes and fix with six DP screws (upper and lower illustrations).



STEP 2

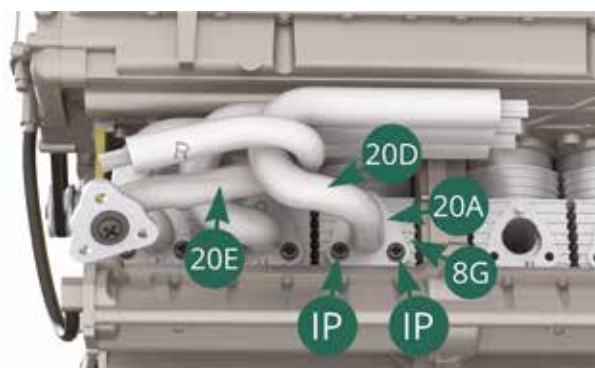
Fit 20A Flange of 20B Exhaust pipe to 8G Cylinder and fix with two IP screws.



Fit 20A Flange of 20C Exhaust pipe to 7E Cylinder and fix with two LM screws.

STEP 3

Hook 20E Exhaust pipe to 20D Exhaust pipe and fit the latter's 20A Flange to 8G Cylinder.

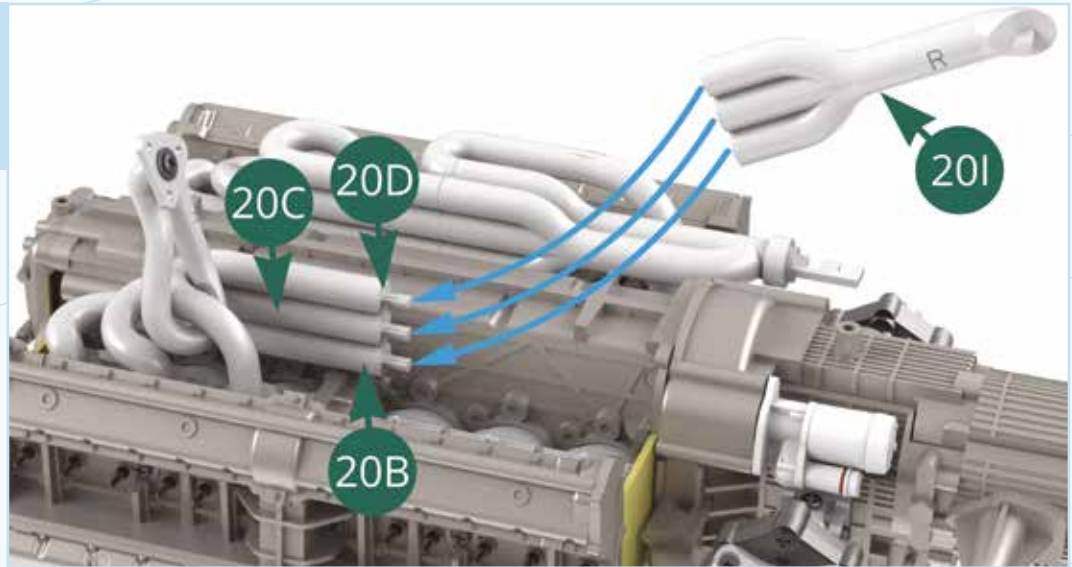


Fix 20A Flange of 20D Exhaust pipe to 8G Cylinder with two IP screws.



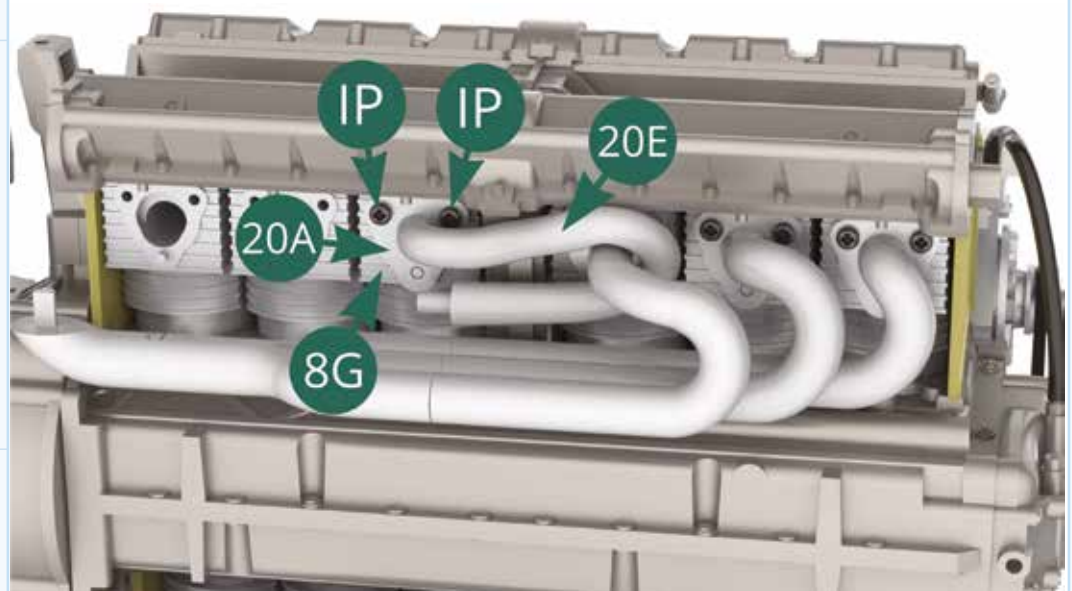
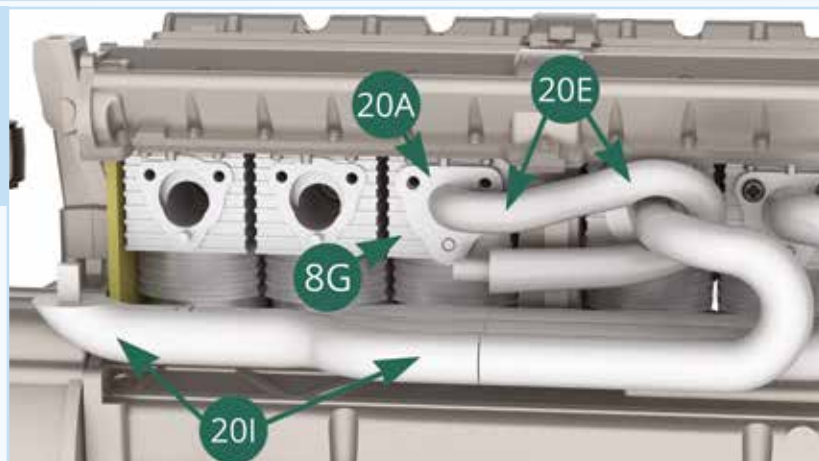
STEP 4

Fit 20I Exhaust manifold to connecting pins of 20B, 20C and 20D Exhaust pipes.



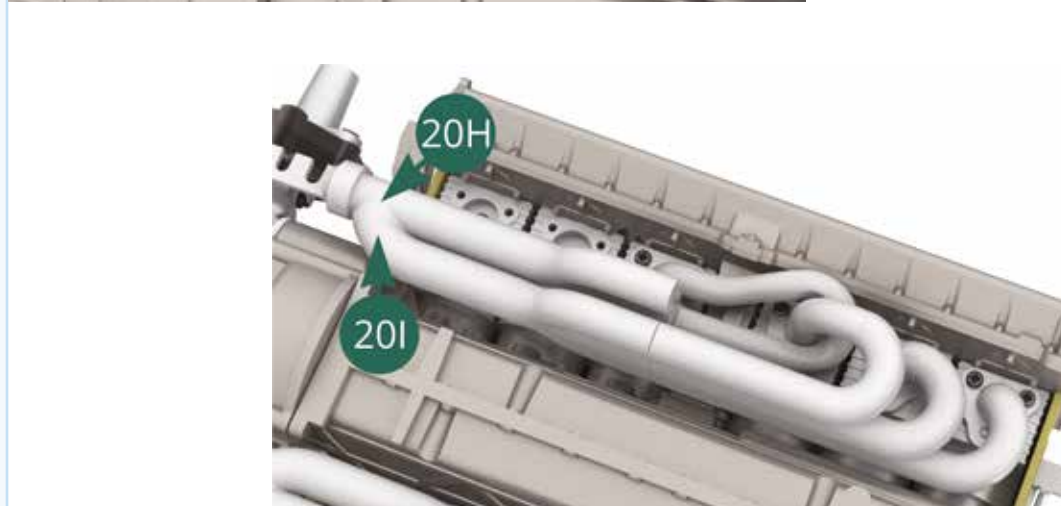
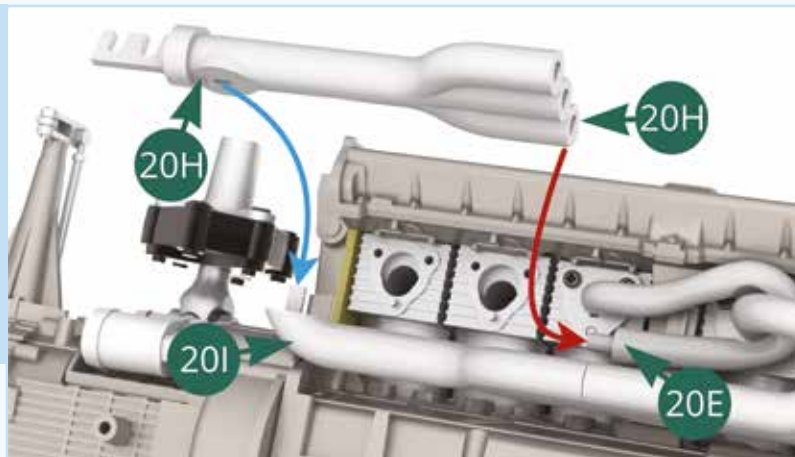
STEP 5

Fit 20A Flange of 20E Exhaust pipe to 8G Cylinder and fix with two IP screws (upper and lower illustrations).



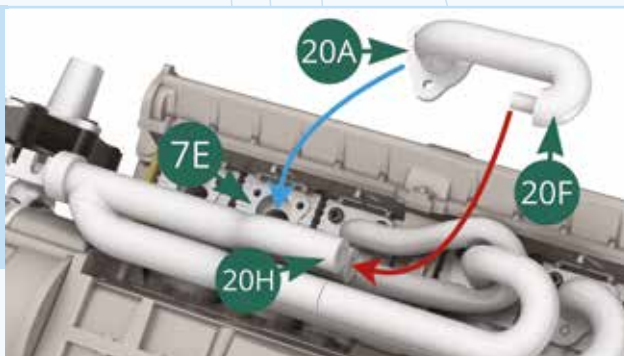
STEP 6

Fit 20H Exhaust manifold lower socket to 20E Exhaust pipe pin (red arrow) and then fit 20H Exhaust manifold other extremity socket to 20I Exhaust manifold pin (blue arrow), referring to top and bottom illustrations.

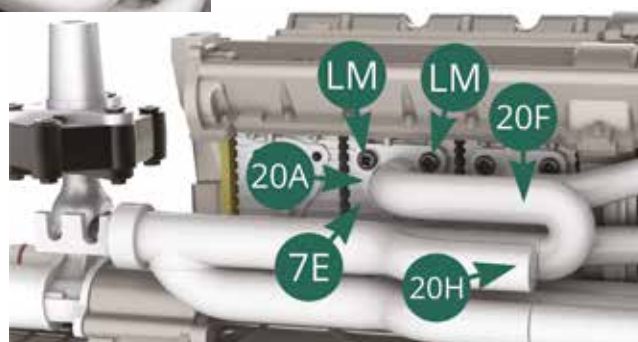


STEP 7

Fit 20F Exhaust pipe pin to middle socket of 20H Exhaust manifold (red arrow), aligning at the same time 20A Flange to 7E Cylinder (blue arrow).



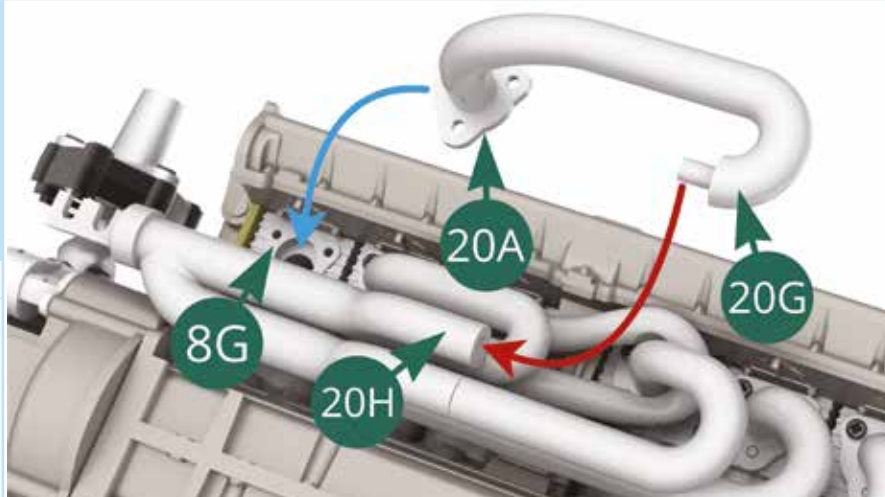
Fix 20A Flange of 20F exhaust pipe to 7E Cylinder with two LM screws.





STEP 8

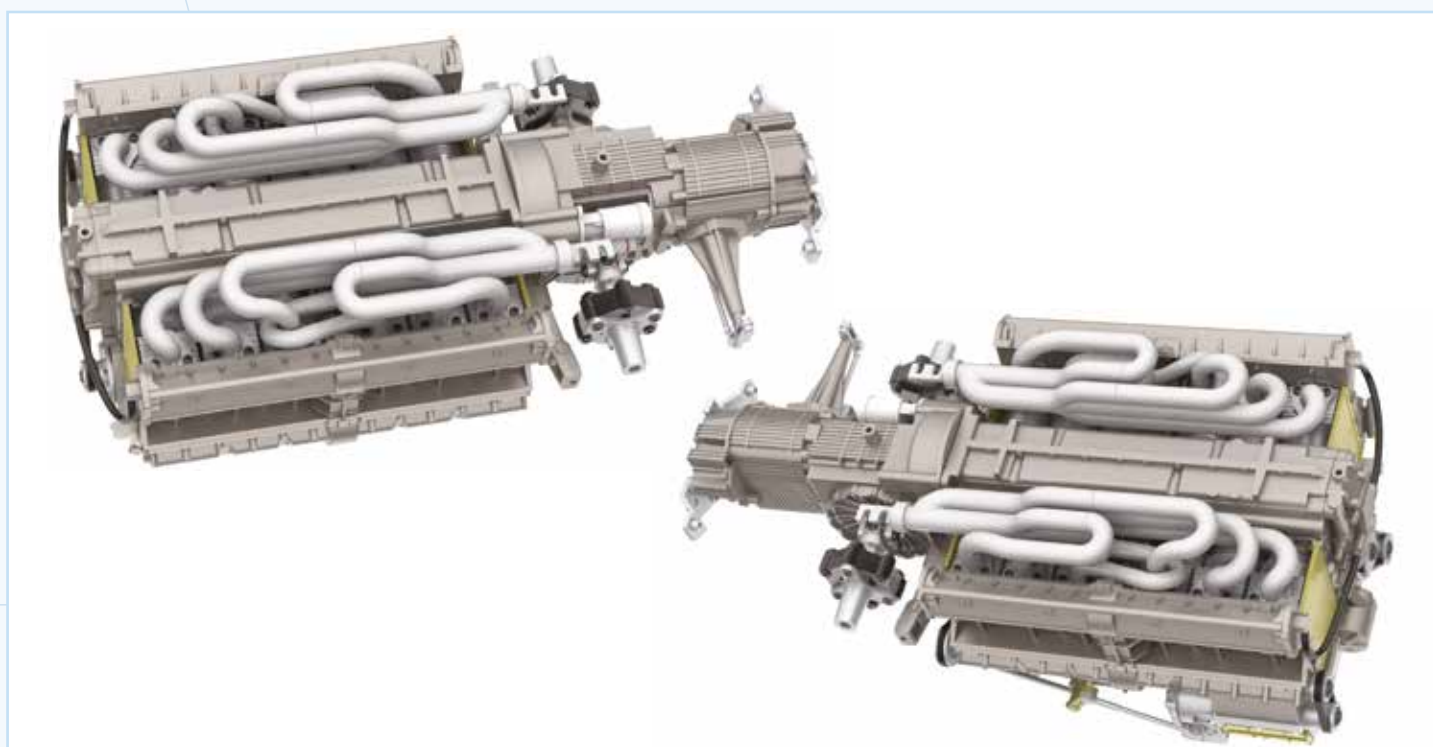
Fit 20G Exhaust pipe pin to top socket of 20H Exhaust manifold (red arrow), aligning at the same time 20A Flange to 8G Cylinder (blue arrow).



Fix 20A Flange of 20G Exhaust pipe to 8G Cylinder with two IP screws.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 21

21A Left upper exhaust pipe

21B Left lower exhaust pipe

21C Exhaust pipe end bracket (x2)

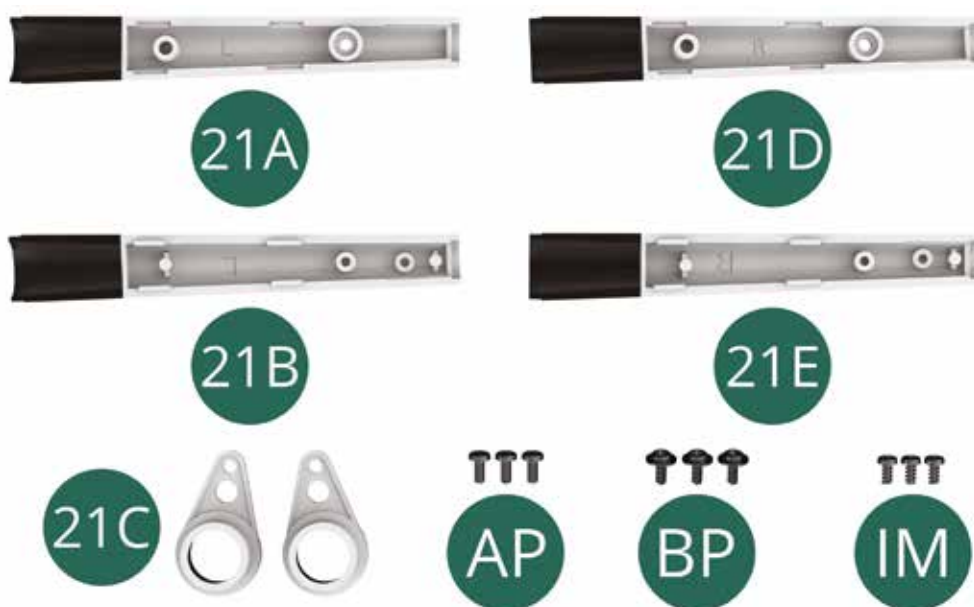
21D Right upper exhaust pipe

21E Right lower exhaust pipe

AP M1,7 x4mm (x3)

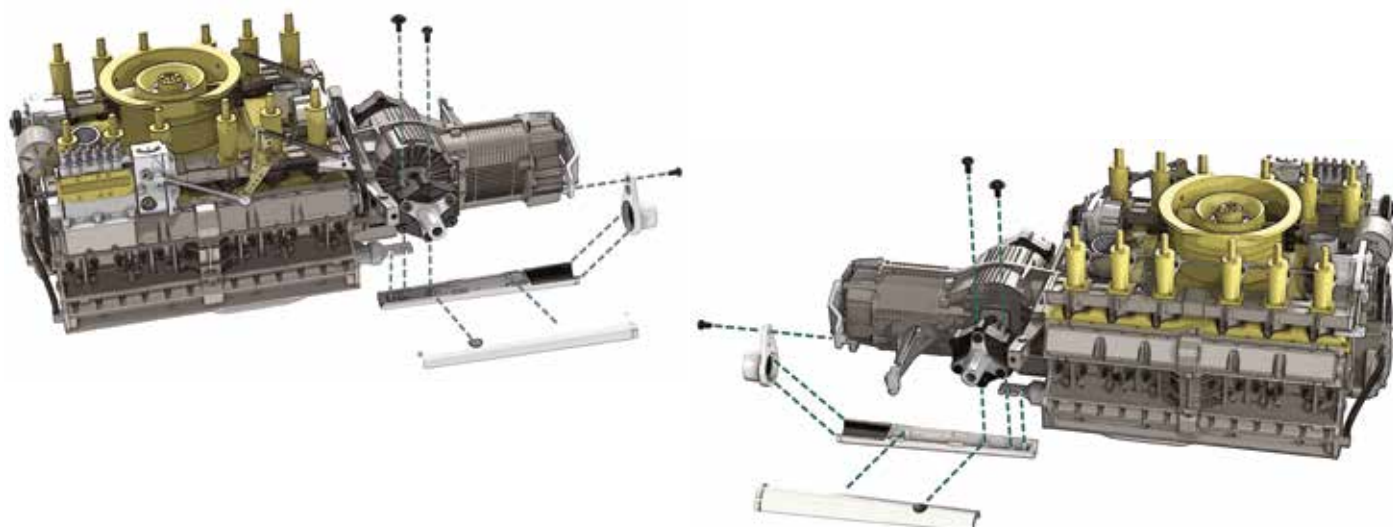
BP M1,7 x4x5mm (x3)

IM M1,7 x3,5mm (x3)



Exhaust pipes installation on the engine

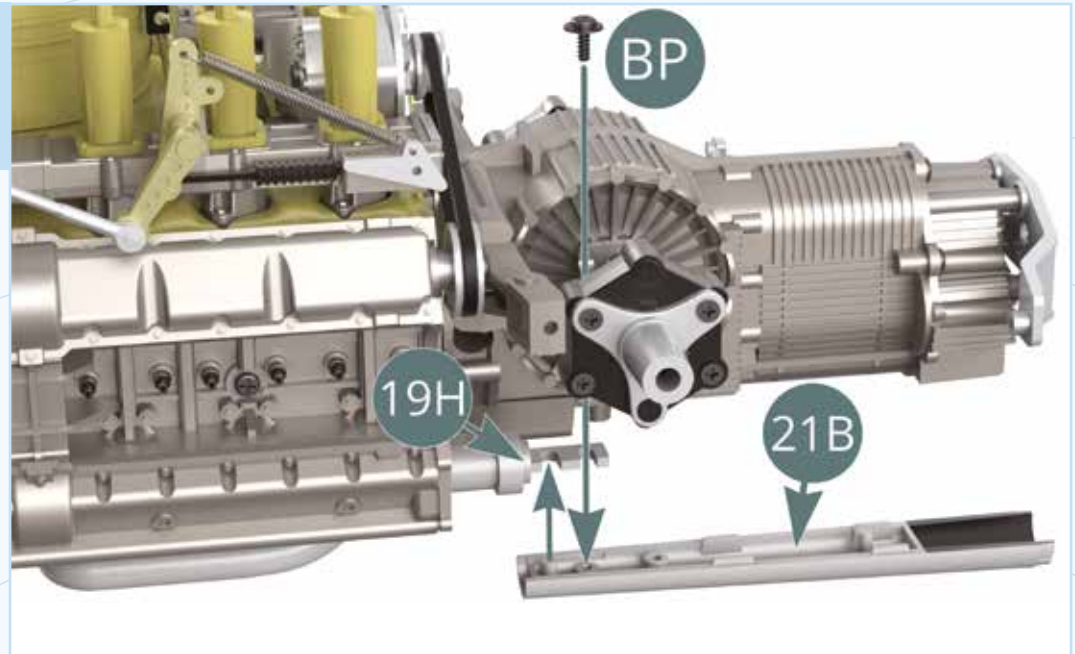
ASSEMBLY DIAGRAM





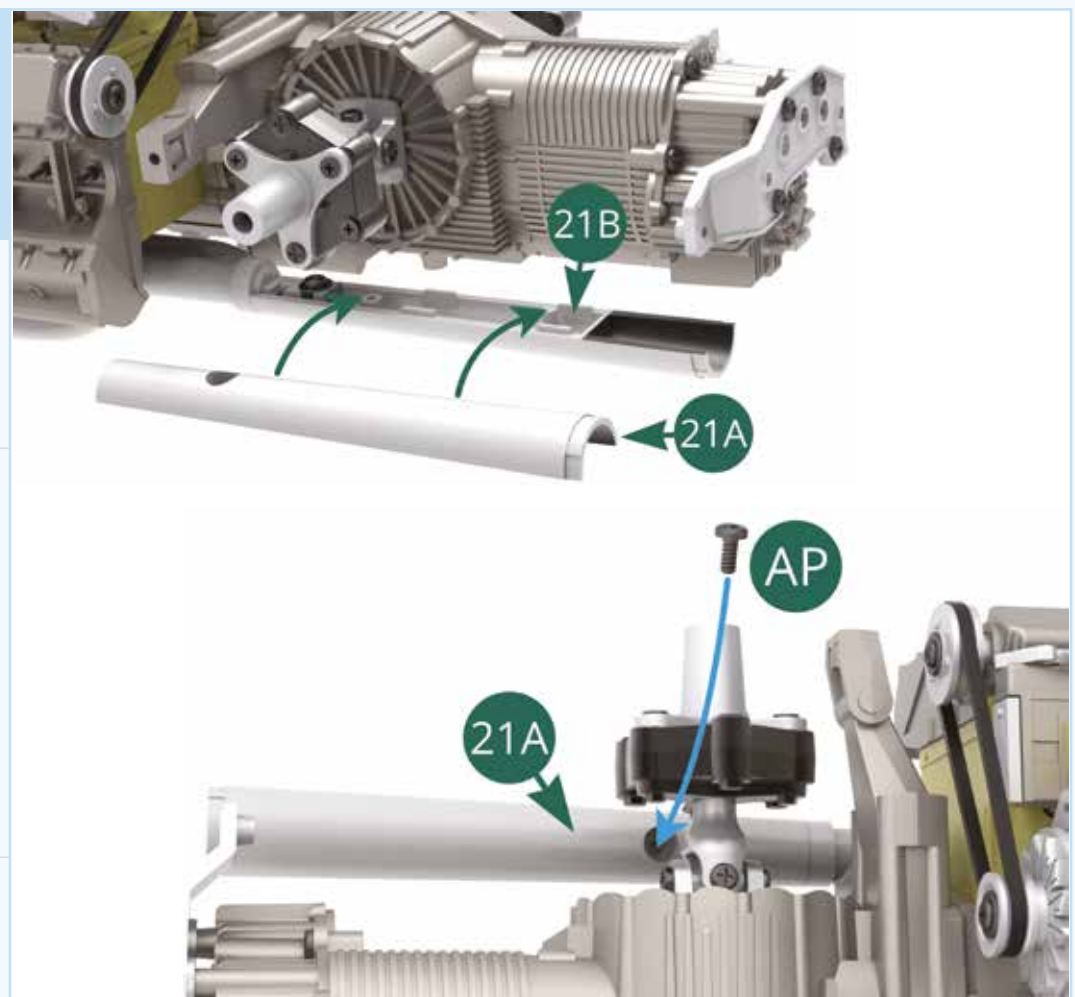
STEP 1

Fit 21B Left lower exhaust pipe to 19H Exhaust manifold and fix with BP screw.



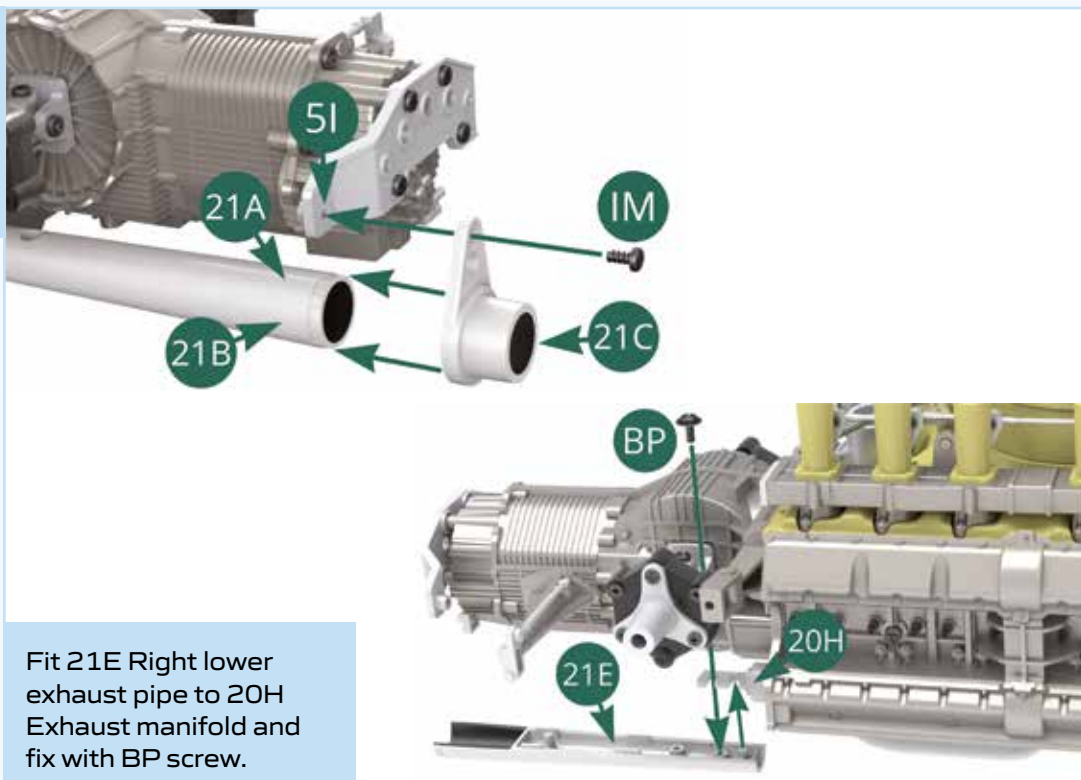
STEP 2

Fit 21A Left upper exhaust pipe on top of 21B Left lower exhaust pipe, and fix with AP screw (upper and lower illustrations).



STEP 3

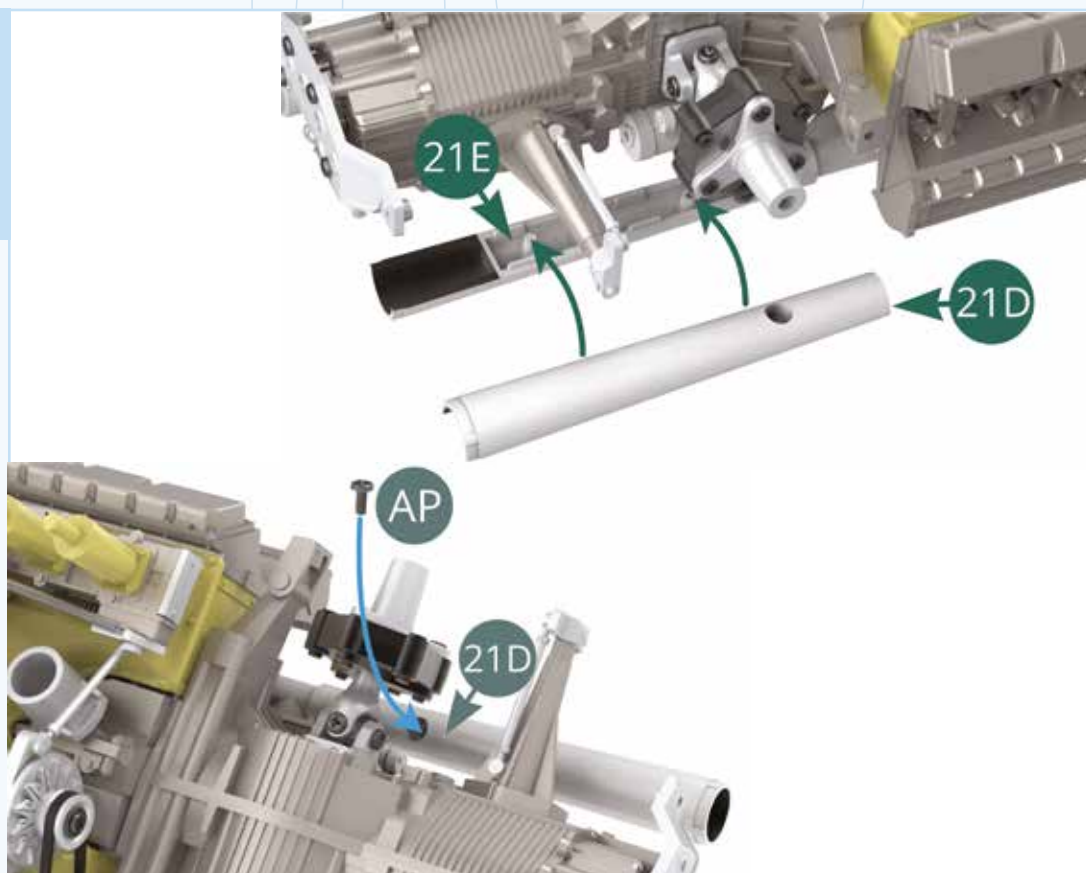
Align and fit 21C Exhaust pipe end bracket to 21A, 21B Exhaust pipe and 5I Exhaust pipe holder, and fix to the latter with IM screw.



Fit 21E Right lower exhaust pipe to 20H Exhaust manifold and fix with BP screw.

STEP 4

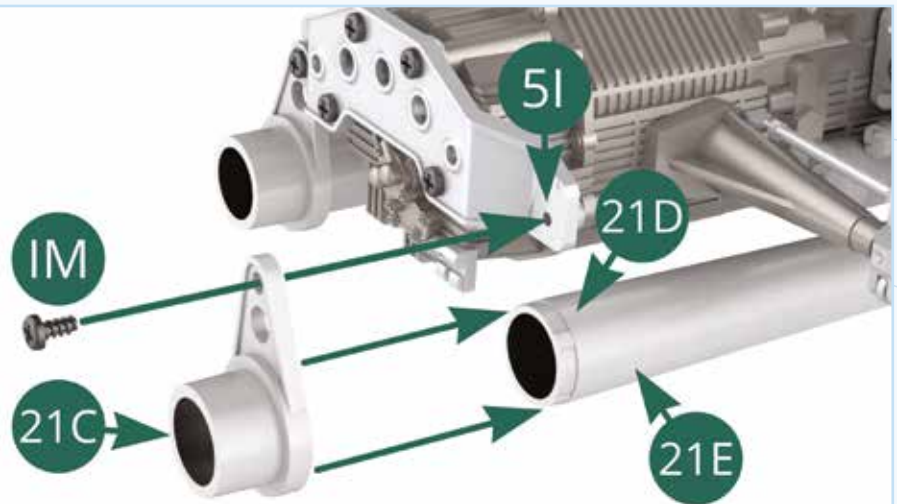
Fit 21D Right upper exhaust pipe on top of 21E Right lower exhaust pipe, and fix with AP screw (upper and lower illustrations).



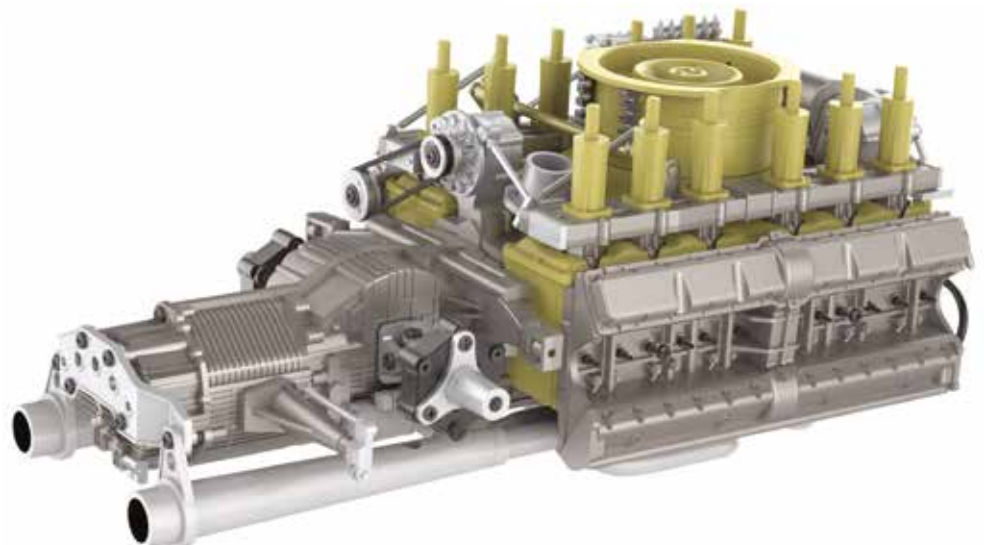


STEP 5

Align and fit 21C Exhaust pipe end bracket to 21D, 21E Exhaust pipe and 5I Exhaust pipe holder, and fix to the latter with IM screw.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 22

22A Ignition distributor

22B Distributor cover

22C Ignition wire plugs (x18)

22D Ignition wire (x12)

AP M1,7 x4mm (x2)



22A



22B



AP



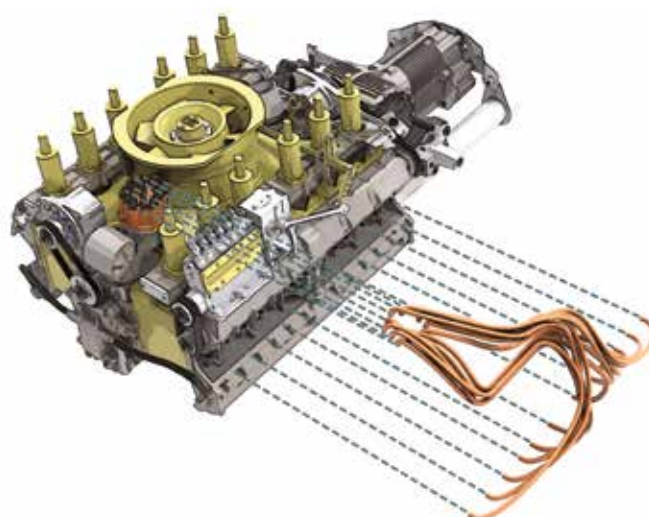
22C



22D

Left side Ignition wires and Ignition distributor installation on the engine

ASSEMBLY DIAGRAM



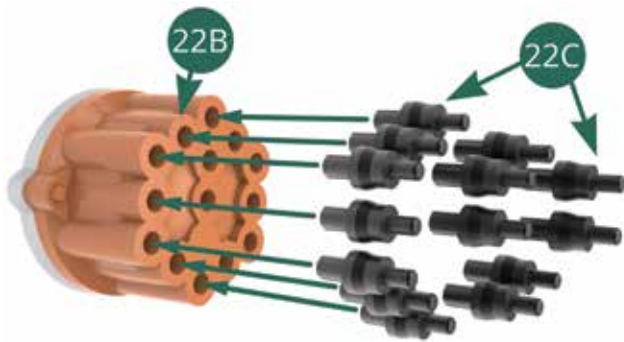


STEP 1

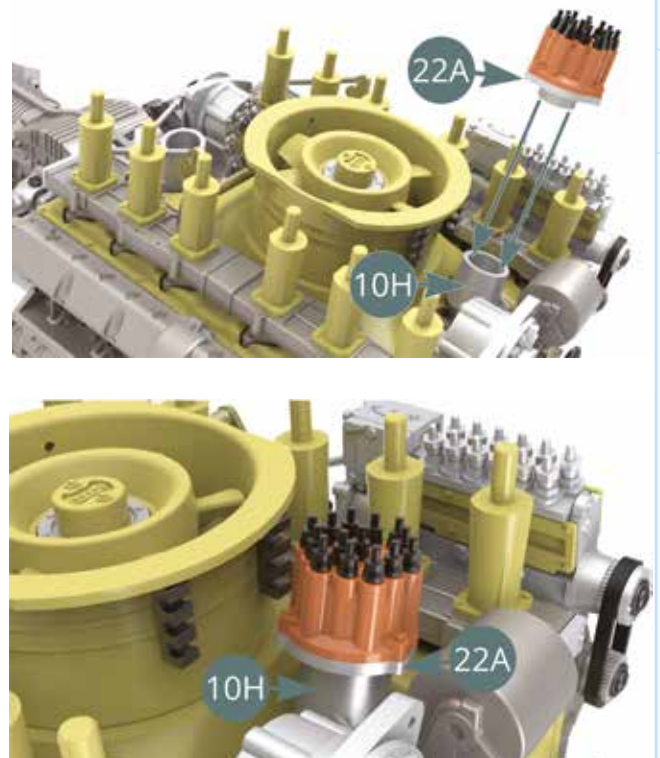
Fit 22B Distributor cover to 22A Ignition distributor and fix with AP screw. Nip off fourteen 22C Ignition wire plugs from the molded fret.



STEP 2

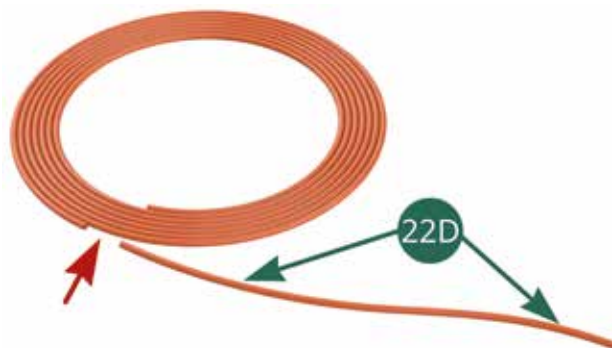


Fit fourteen 22C Ignition wire plugs to 22B Distributor cover. Fit 22A Ignition distributor to 10H Distributor base, note its orientation when fitted on next illustration.



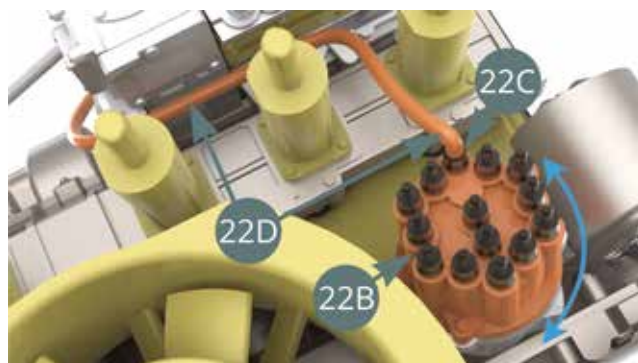
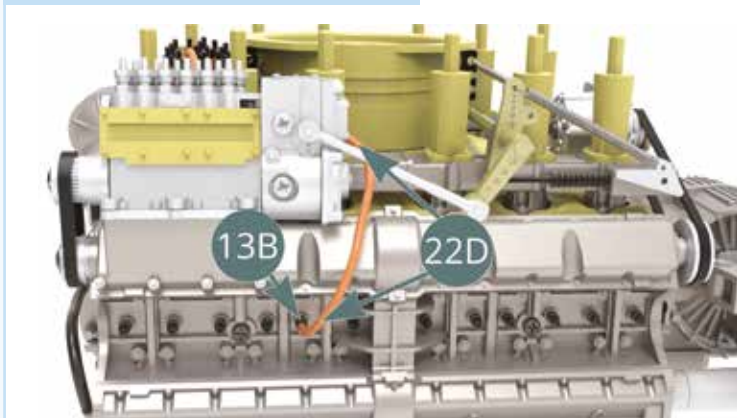
STEP 3

Cut first 22D Ignition wire 100mm long from the Ignition wire roll.



STEP 4

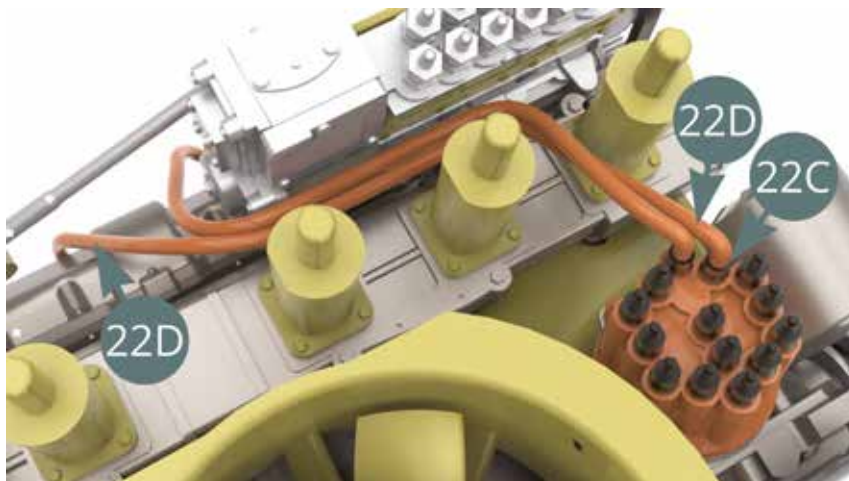
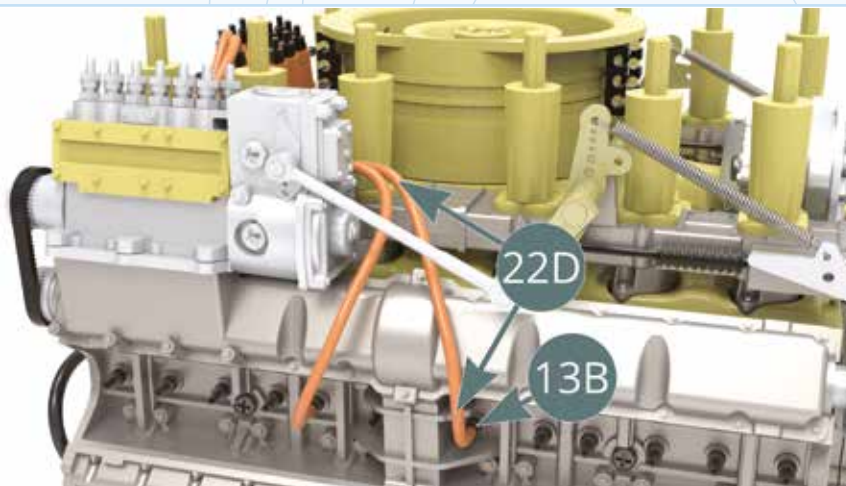
Fit first 22D Ignition wire to 13B Spark plug (upper illustration) , then lead and fit to 22C Ignition wire plug (lower illustration).



Turn 22B distributor cover (blue arrow) to match its below illustrated position.

STEP 5

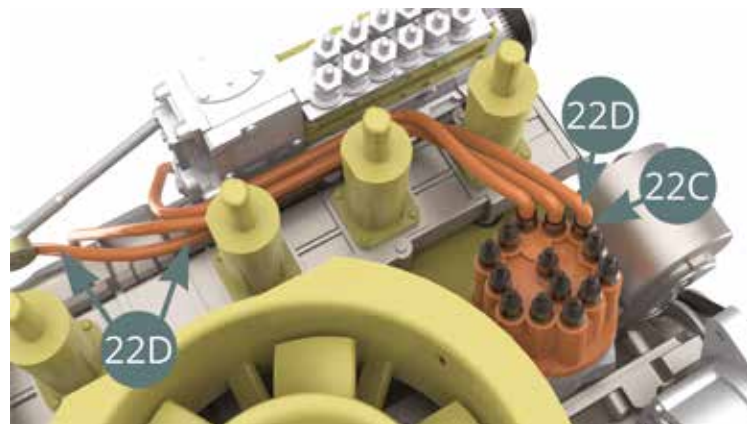
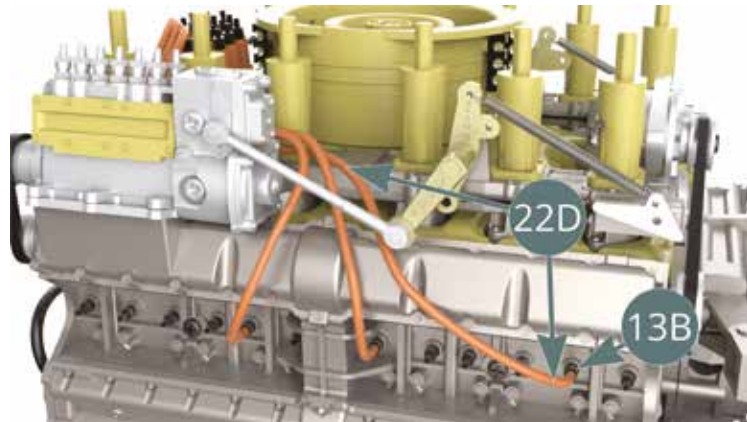
Cut second 22D Ignition wire 100mm long from the Ignition wire roll and fit it to next 13B Spark plug (upper illustration) , then lead and fit to 22C Ignition wire plug (lower illustration).





STEP 6

Cut third 22D Ignition wire 120mm long from the Ignition wire roll and fit it to next 13B Spark plug (upper illustration) , then lead and fit to 22C Ignition wire plug (lower illustration).



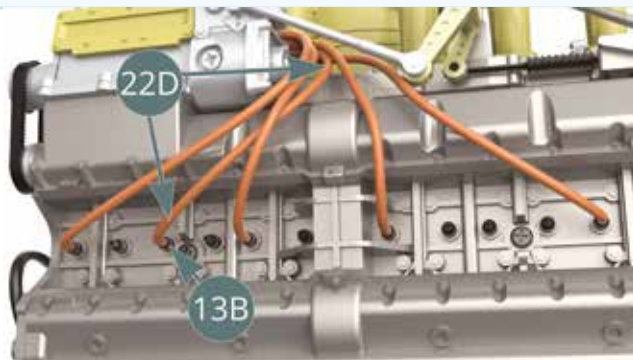
STEP 7

Cut fourth 22D Ignition wire 125mm long from the Ignition wire roll and fit it to next 13B Spark plug (upper illustration), then lead and fit to 22C Ignition wire plug (lower illustration).



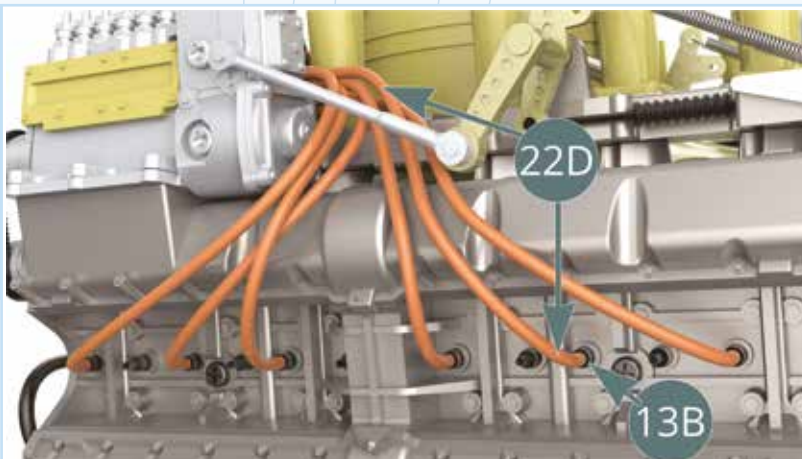
STEP 8

Cut fifth 22D Ignition wire 120mm long from the Ignition wire roll and fit it to next 13B Spark plug (upper illustration), then lead and fit to 22C Ignition wire plug (lower illustration).



STEP 9

Cut sixth 22D Ignition wire 120mm long from the Ignition wire roll and fit it to next 13B Spark plug (upper illustration), then lead and fit to 22C Ignition wire plug (lower illustration).





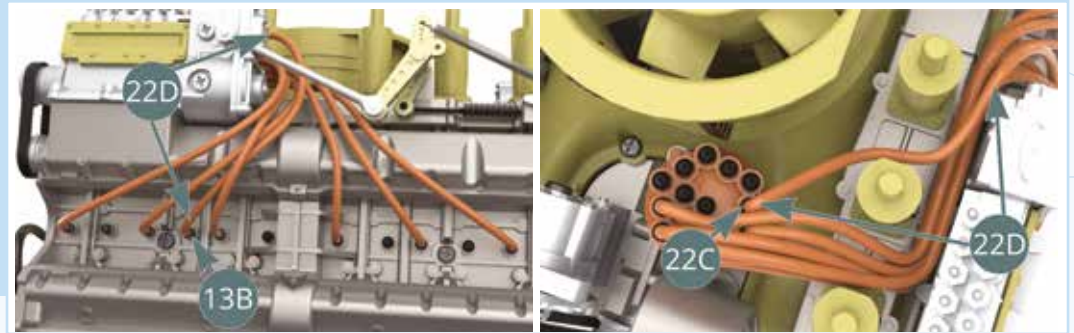
STEP 10

First six 22D Ignition wires are attached to the engine



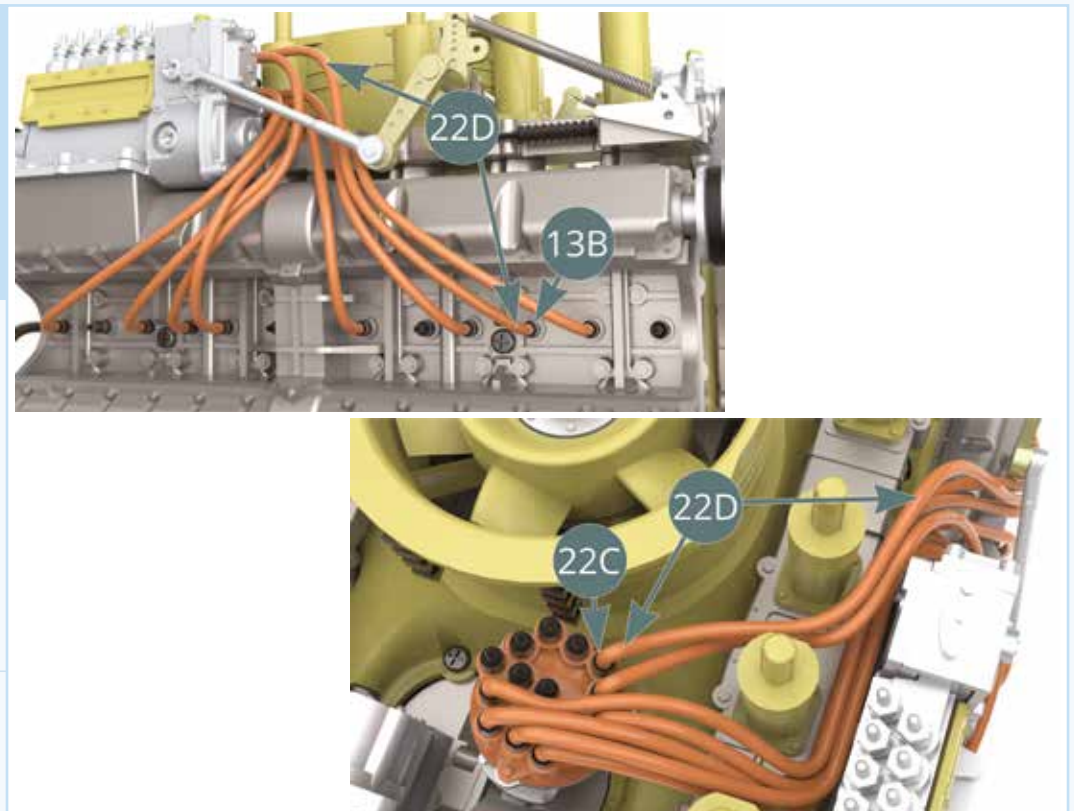
STEP 11

Cut seventh 22D Ignition wire 100mm long from the Ignition wire roll and fit it to next 13B Spark plug (first illustration), then lead and fit to 22C Ignition wire plug (second illustration).



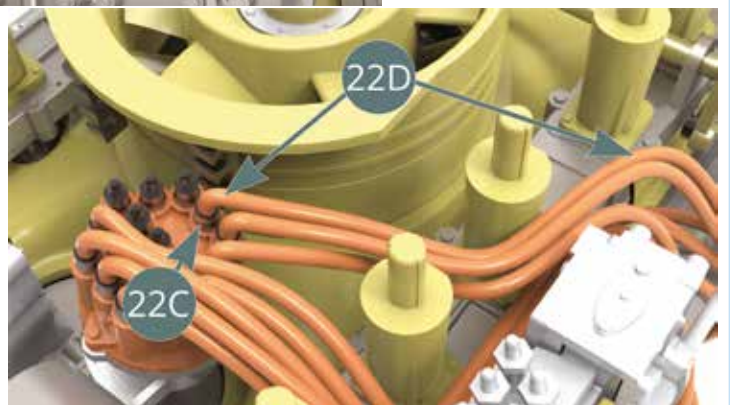
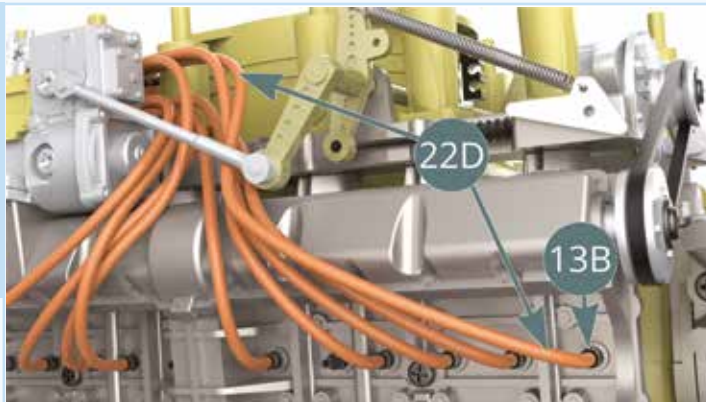
STEP 12

Cut eighth 22D Ignition wire 105mm long from the Ignition wire roll and fit it to next 13B Spark plug (upper illustration), then lead and fit to 22C Ignition wire plug (lower illustration).



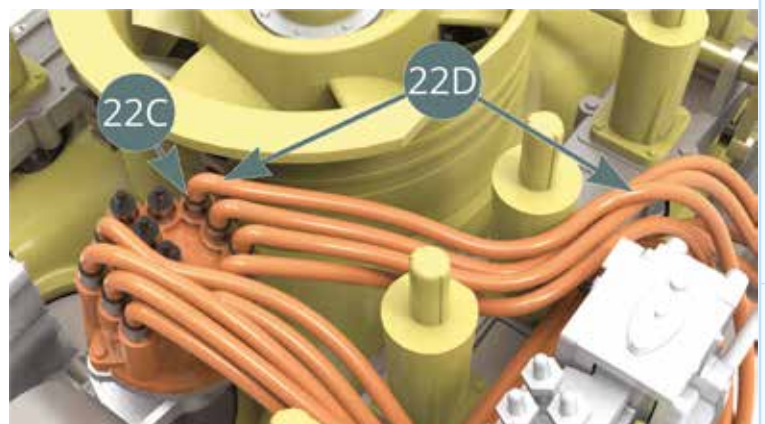
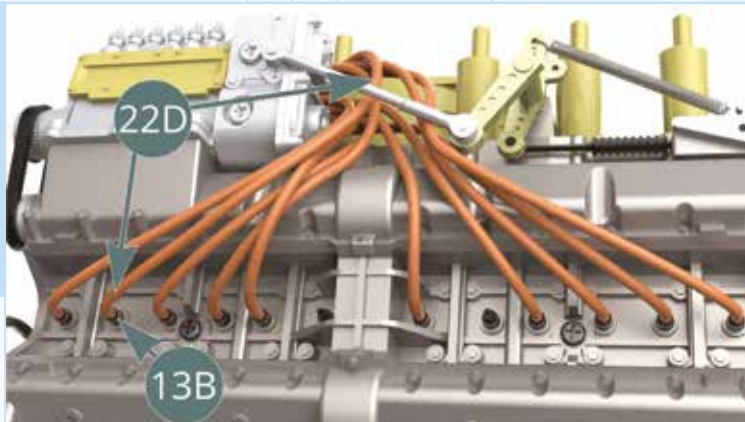
STEP 13

Cut ninth 22D Ignition wire 120mm long from the Ignition wire roll and fit it to next 13B Spark plug (upper illustration), then lead and fit to 22C Ignition wire plug (lower illustration).



STEP 14

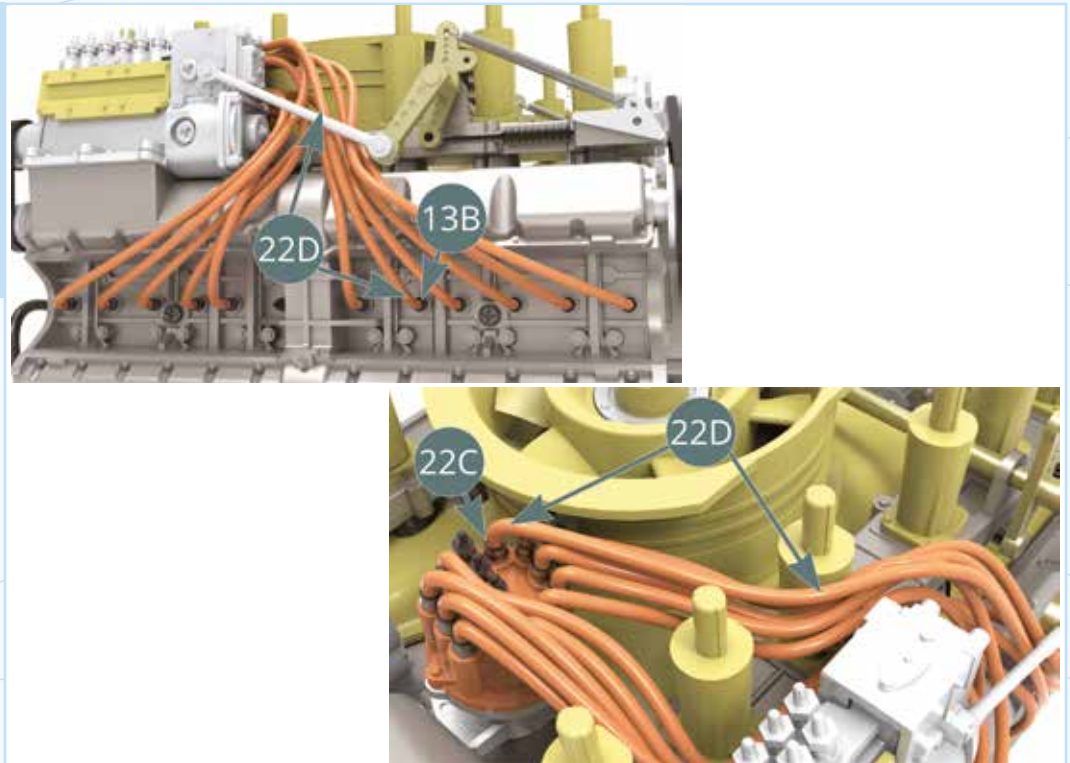
Cut tenth 22D Ignition wire 115mm long from the Ignition wire roll and fit it to next 13B Spark plug (upper illustration), then lead and fit to 22C Ignition wire plug (lower illustration).





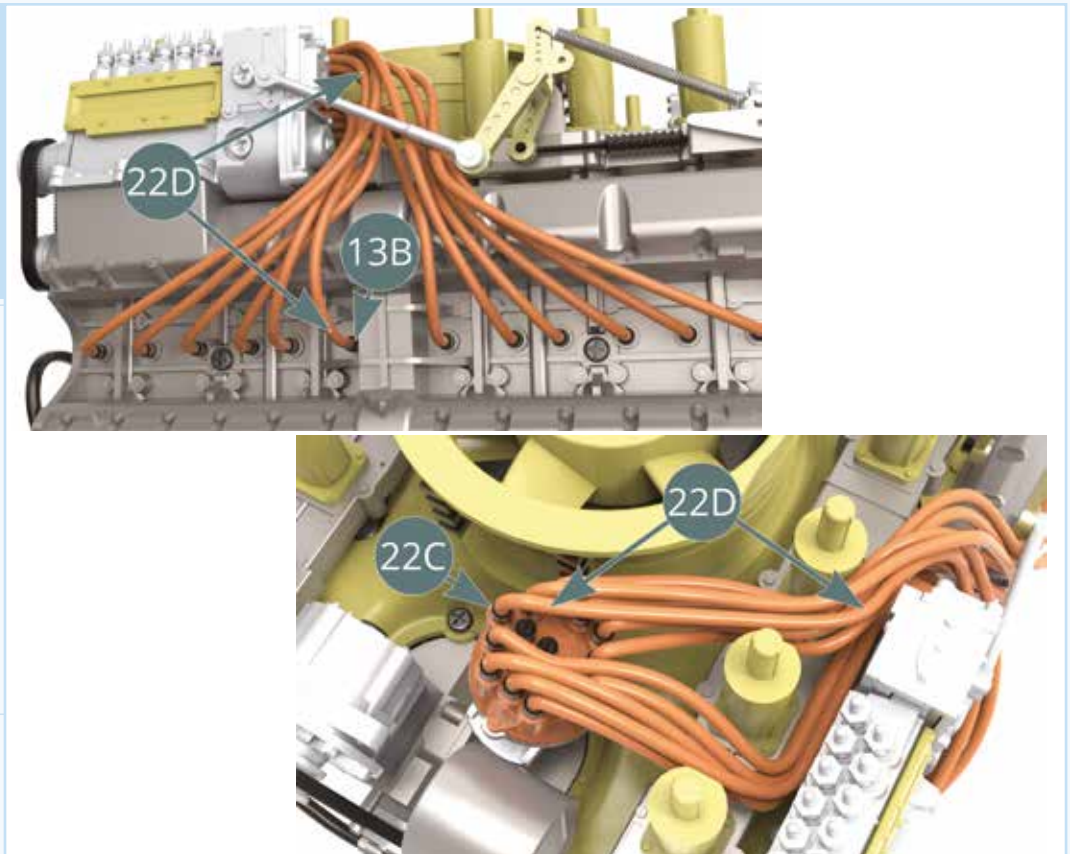
STEP 15

Cut eleventh 22D Ignition wire 105mm long from the Ignition wire roll and fit it to next 13B Spark plug (upper illustration), then lead and fit to 22C Ignition wire plug (lower illustration).

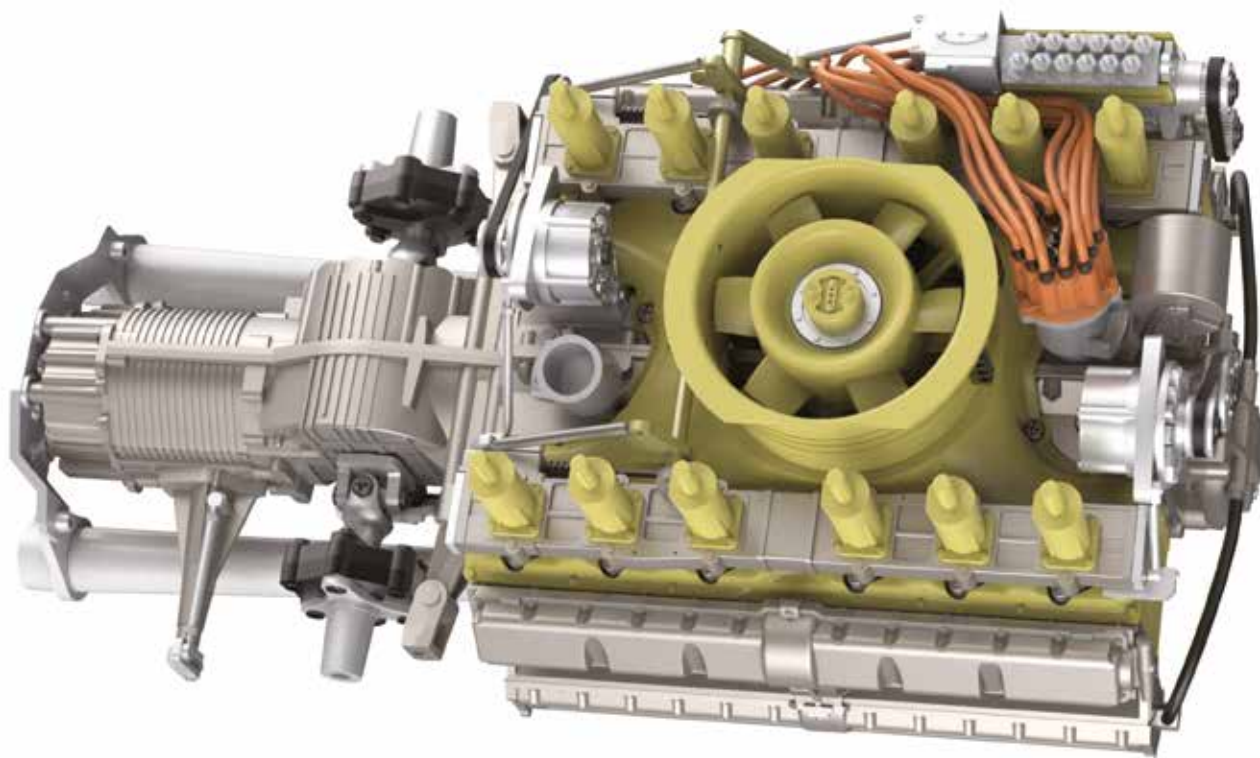
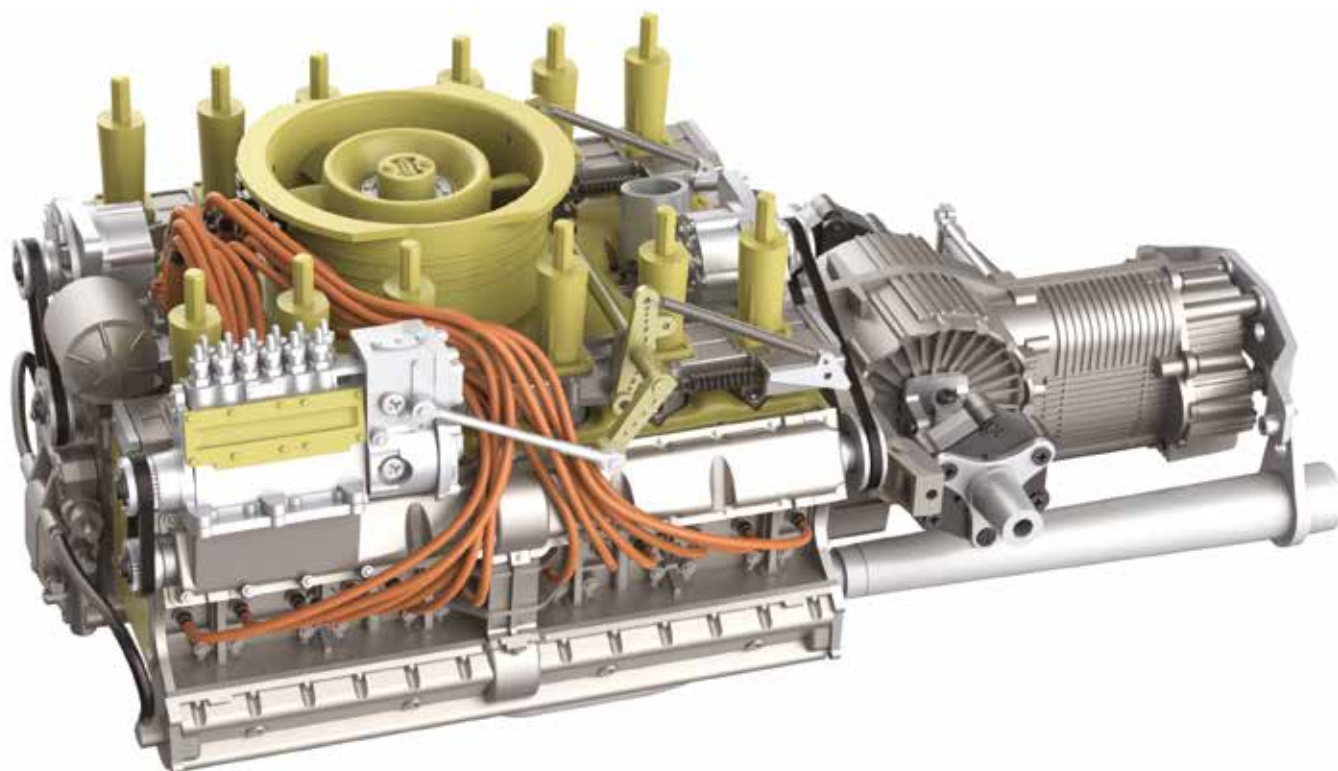


STEP 16

Cut twelveth 22D Ignition wire 105mm long from the Ignition wire roll and fit it to next 13B Spark plug (upper illustration), then lead and fit to 22C Ignition wire plug (lower illustration).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 23

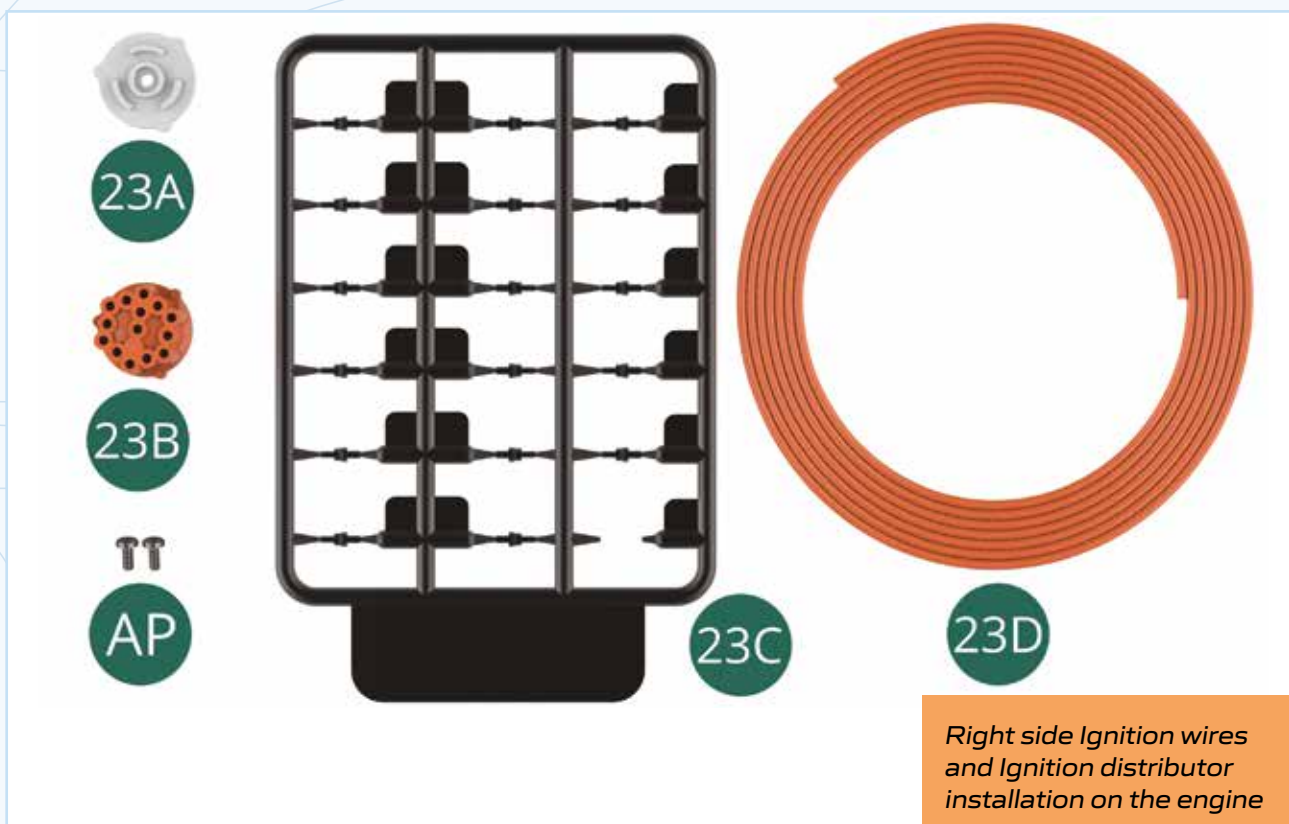
23A Ignition distributor

23B Distributor cover

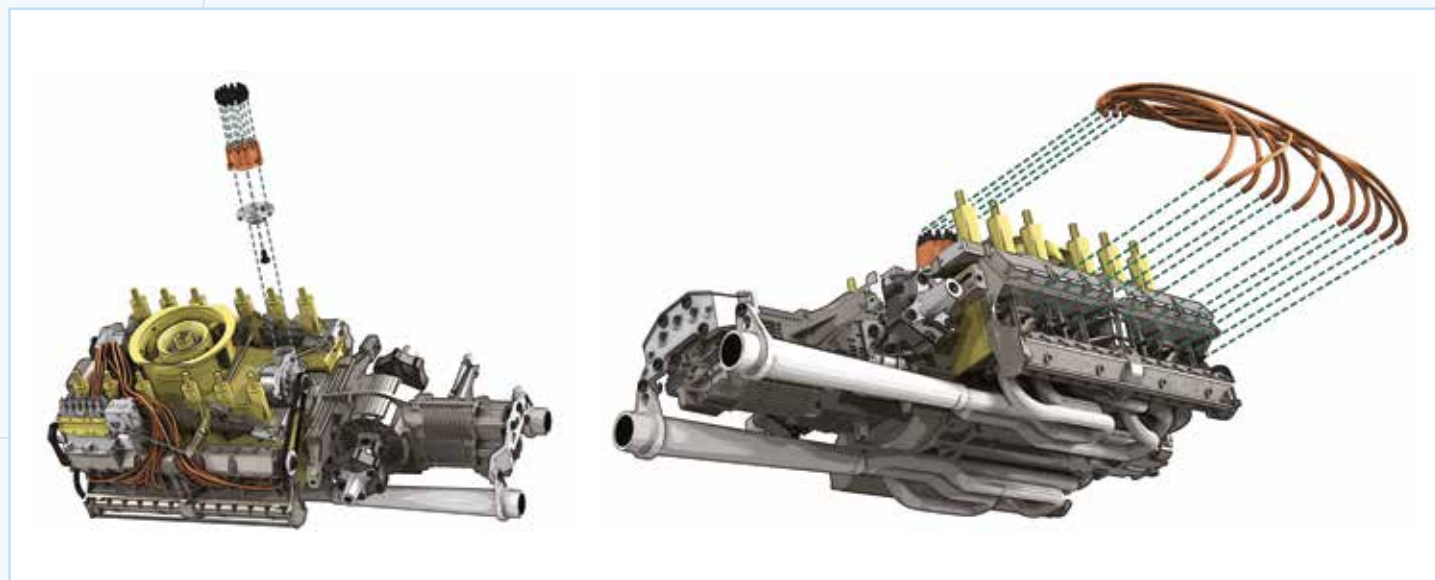
23C Ignition wire plugs (x17)

23D Ignition wire (x12)

AP M1,7 x4mm (x2)



ASSEMBLY DIAGRAM



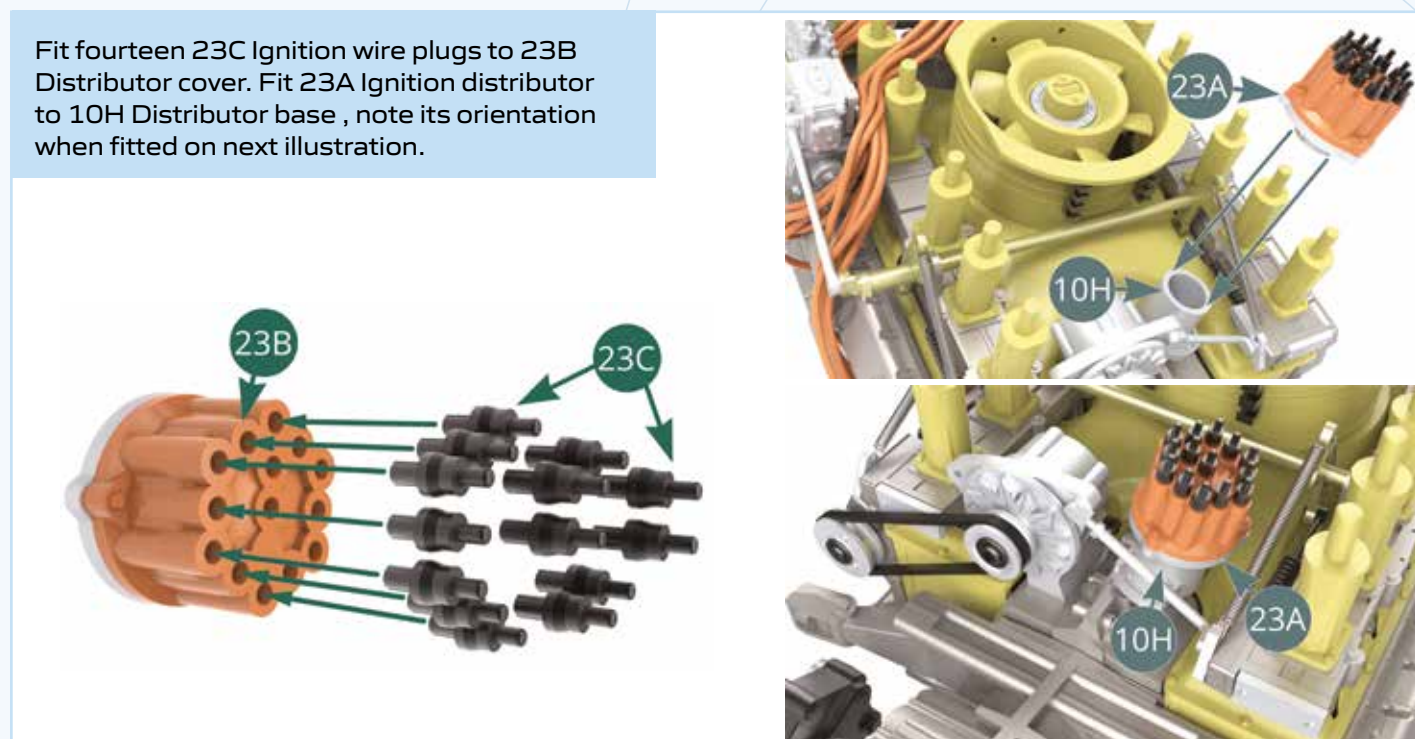
STEP 1

Fit 23B Distributor cover to 23A Ignition distributor and fix with AP screw. Nip off fourteen 23C Ignition wire plugs from the molded fret.



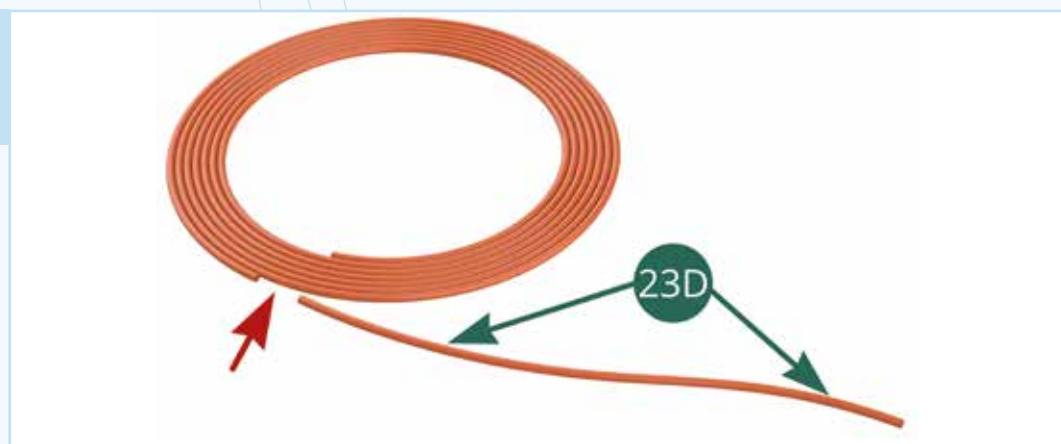
STEP 2

Fit fourteen 23C Ignition wire plugs to 23B Distributor cover. Fit 23A Ignition distributor to 10H Distributor base, note its orientation when fitted on next illustration.



STEP 3

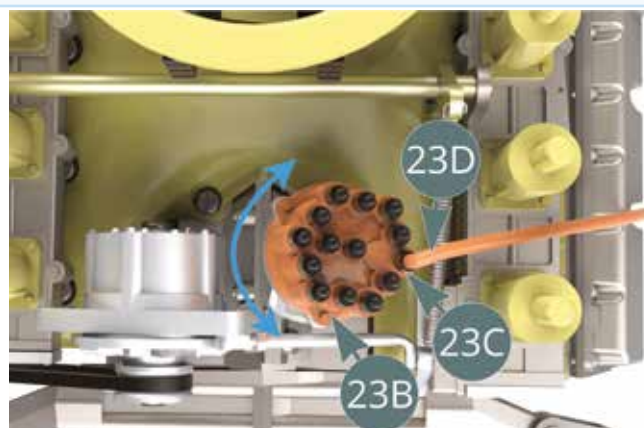
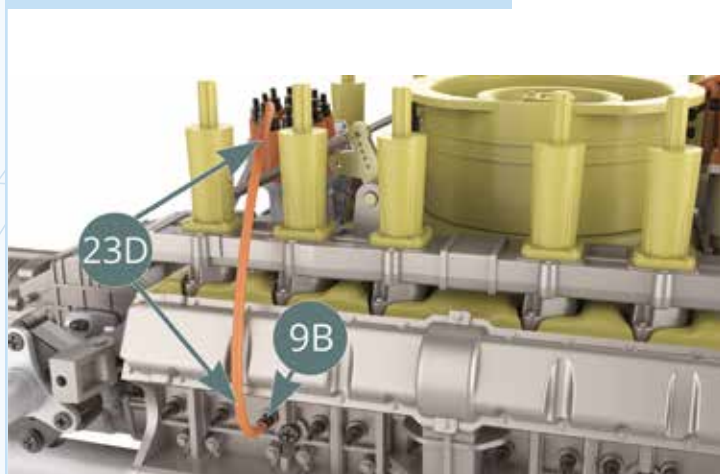
Cut first 23D Ignition wire 75mm long from the Ignition wire roll.





STEP 4

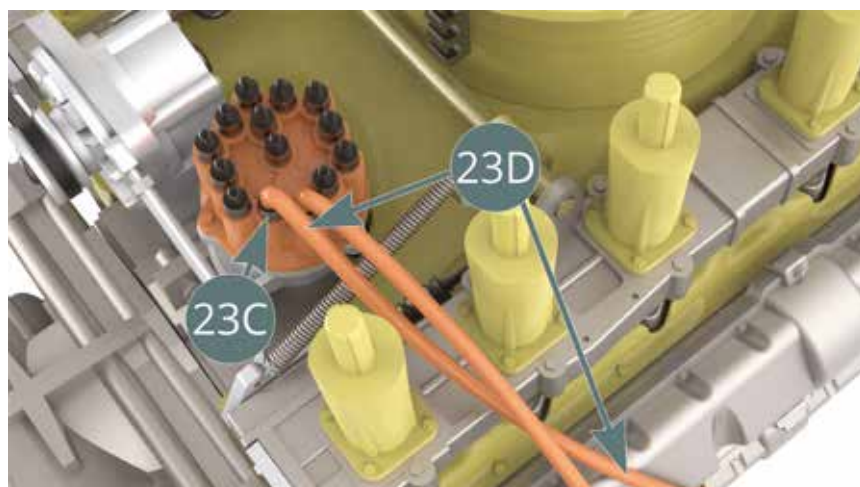
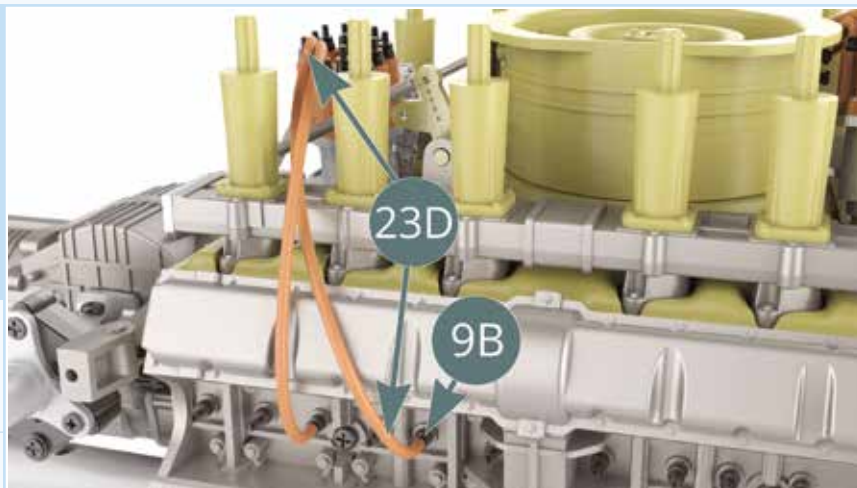
Fit first 23D Ignition wire to 9B Spark plug (upper illustration), then lead and fit to 23C Ignition wire plug (lower illustration).



Turn 23B distributor cover (blue arrow) to match its below illustrated position.

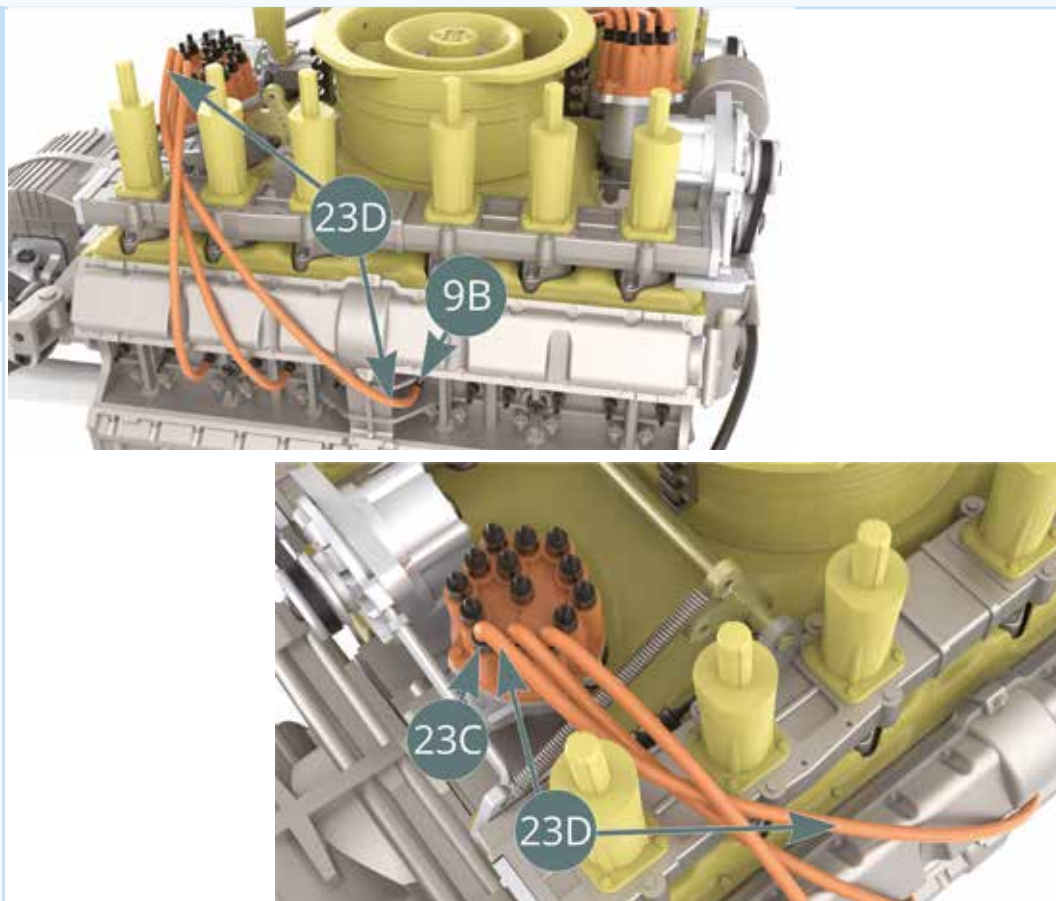
STEP 5

Cut second 23D Ignition wire 82 mm long from the Ignition wire roll and fit it to next 9B Spark plug (upper illustration), then lead and fit to 23C Ignition wire plug (lower illustration).



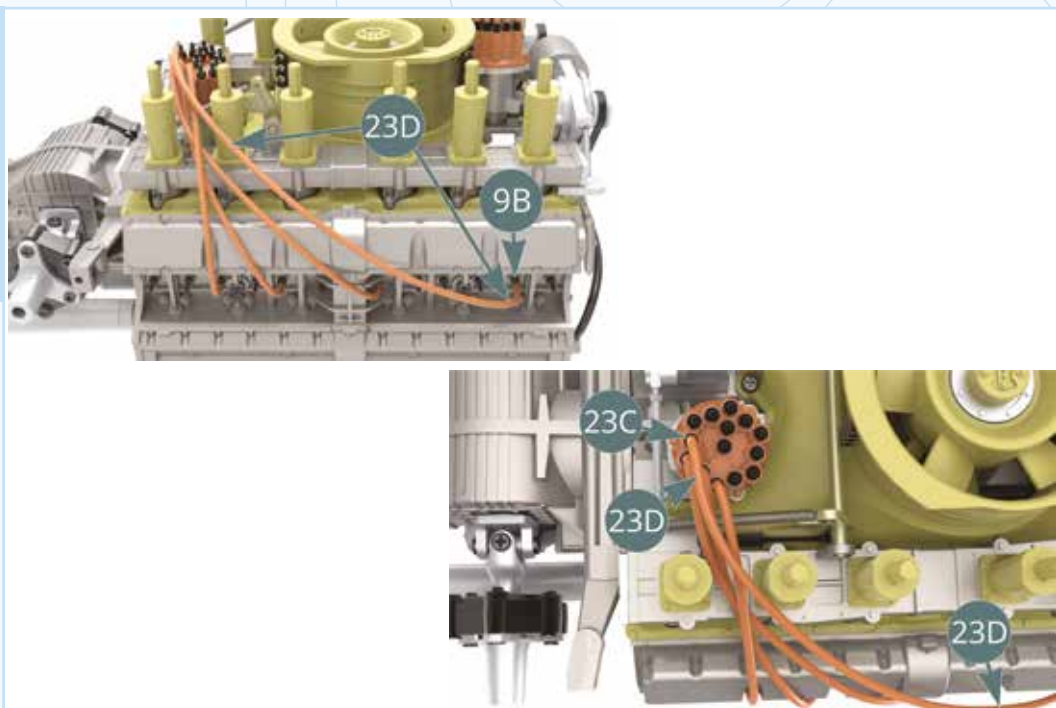
STEP 6

Cut third 23D Ignition wire 98 mm long from the Ignition wire roll and fit it to next 9B Spark plug (upper illustration), then lead and fit to 23C Ignition wire plug (lower illustration).



STEP 7

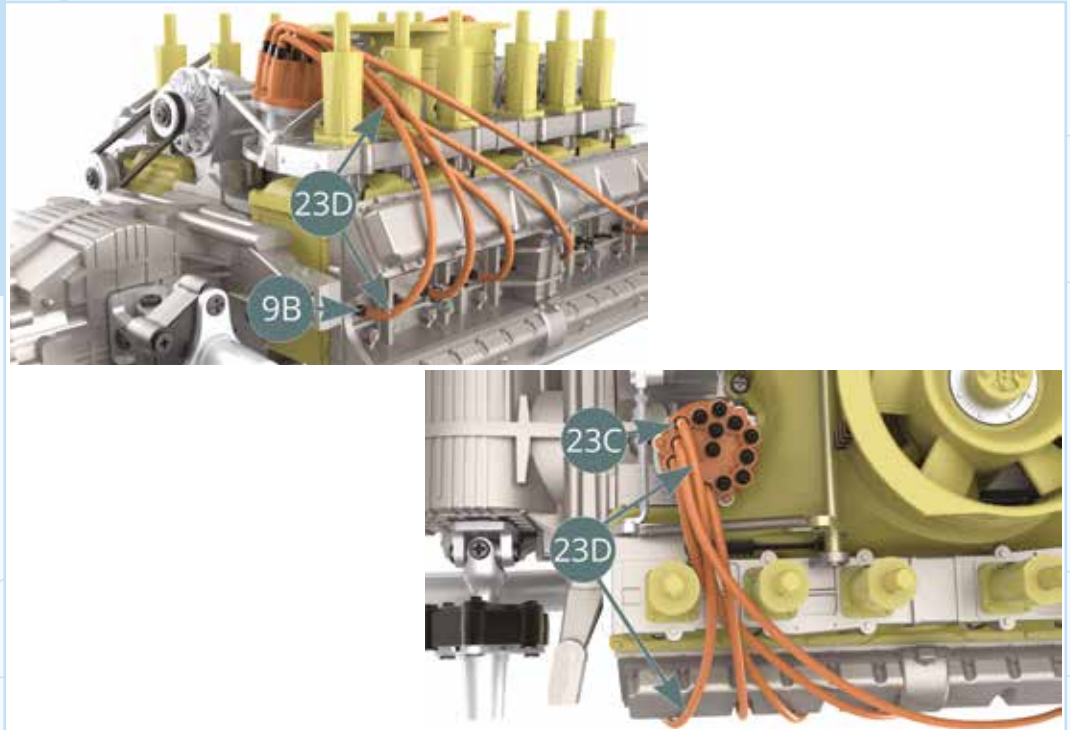
Cut fourth 23D Ignition wire 120 mm long from the Ignition wire roll and fit it to next 9B Spark plug (upper illustration), then lead and fit to 23C Ignition wire plug (lower illustration).





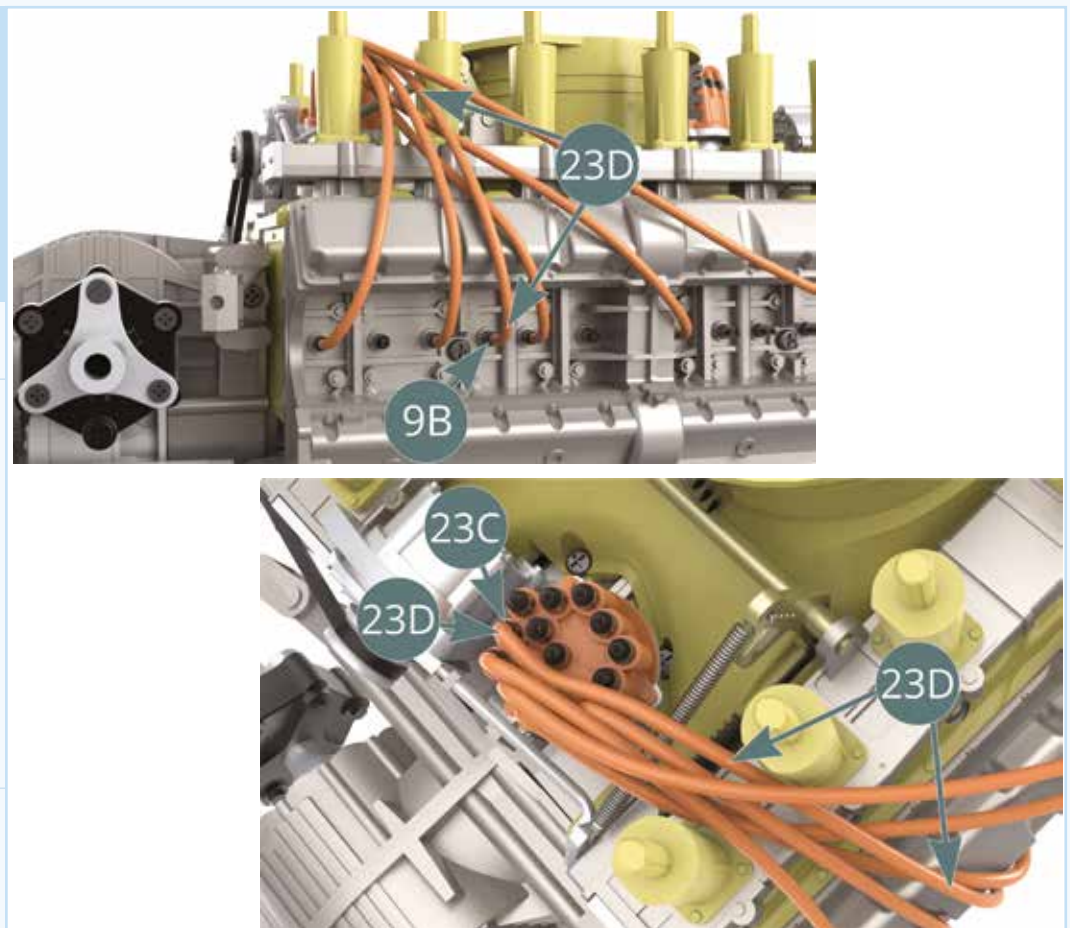
STEP 8

Cut fifth 23D Ignition wire 85mm long from the Ignition wire roll and fit it to next 9B Spark plug (upper illustration), then lead and fit to 23C Ignition wire plug (lower illustration).



STEP 9

Cut sixth 23D Ignition wire 90 mm long from the Ignition wire roll and fit it to next 9B Spark plug (upper illustration), then lead and fit to 23C Ignition wire plug (lower illustration).



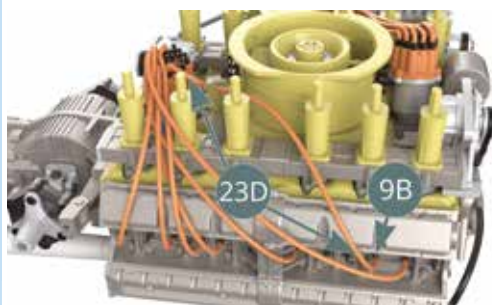
STEP 10

First six 23D Ignition wires are attached to the right side of the engine



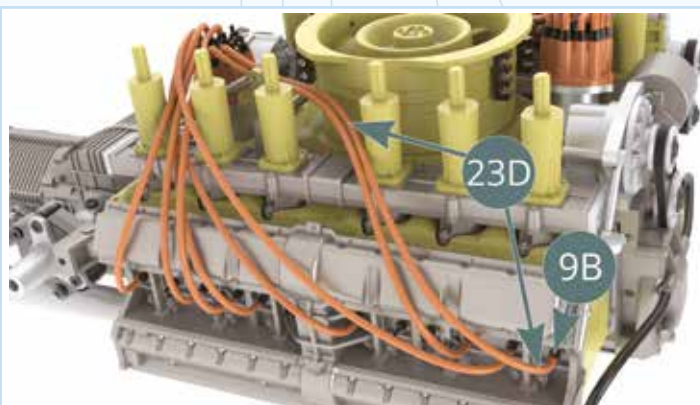
STEP 11

Cut seventh 23D Ignition wire 105mm long from the Ignition wire roll and fit it to next 9B Spark plug (first illustration), then lead and fit to 23C Ignition wire plug (second illustration).



STEP 12

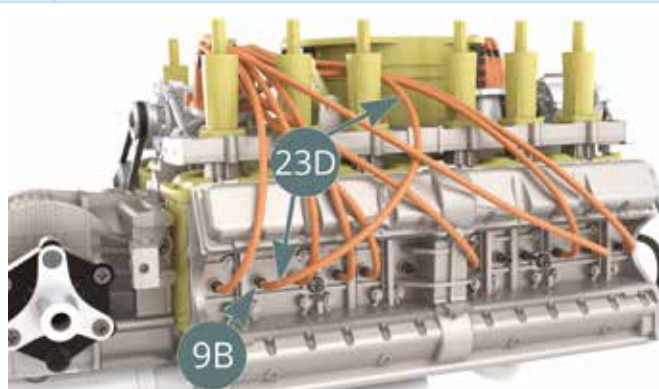
Cut eighth 23D Ignition wire 115 mm long from the Ignition wire roll and fit it to next 9B Spark plug (upper illustration), then lead and fit to 23C Ignition wire plug (lower illustration).





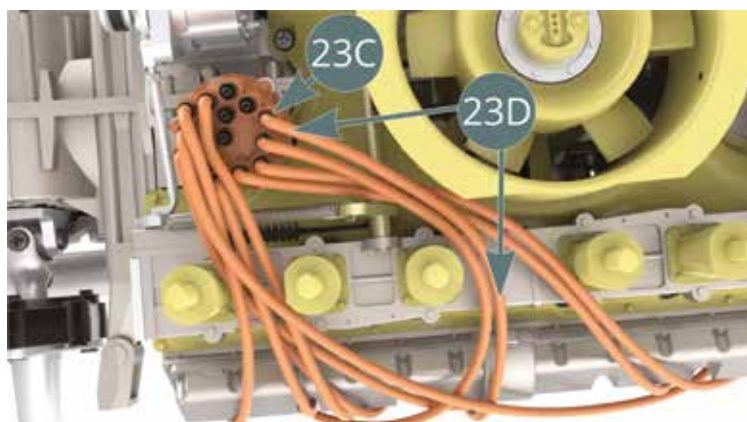
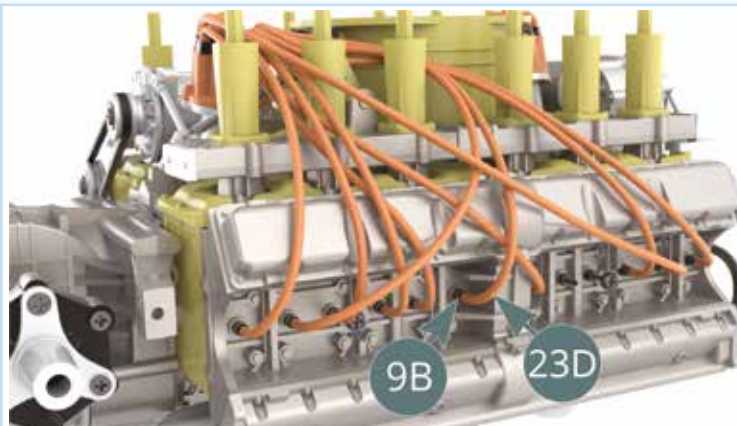
STEP 13

Cut ninth 23D Ignition wire 105mm long from the Ignition wire roll and fit it to next 9B Spark plug (upper illustration), then lead and fit to 23C Ignition wire plug (lower illustration).



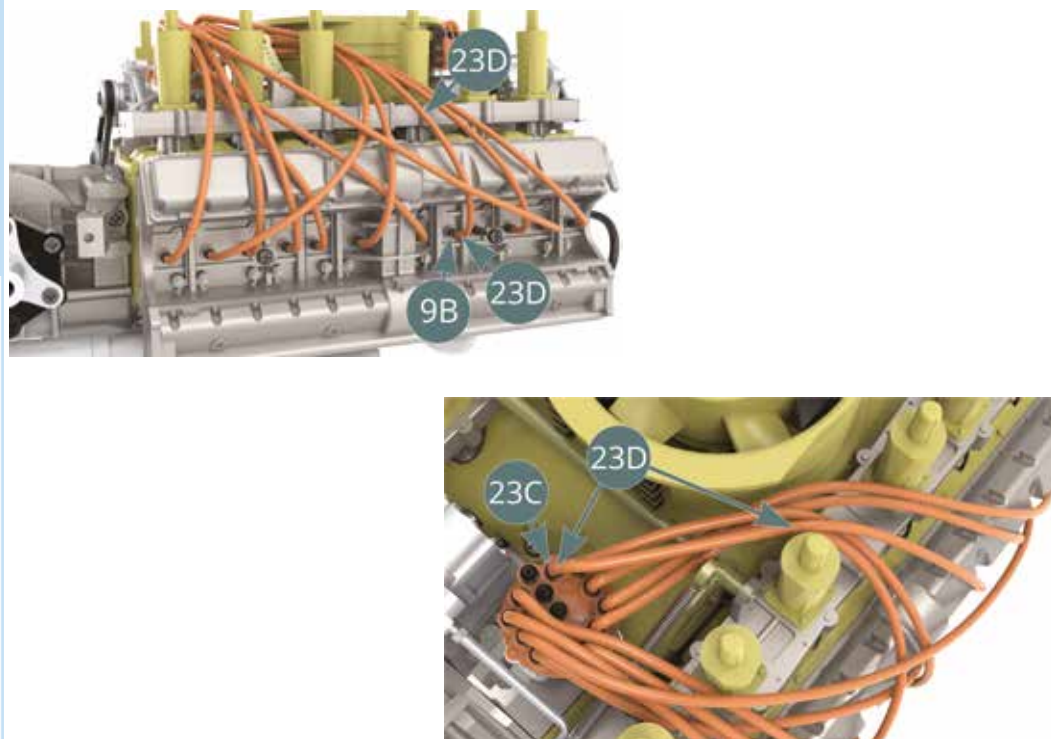
STEP 14

Cut tenth 23D Ignition wire 95 mm long from the Ignition wire roll and fit it to next 9B Spark plug (upper illustration), then lead and fit to 23C Ignition wire plug (lower illustration).



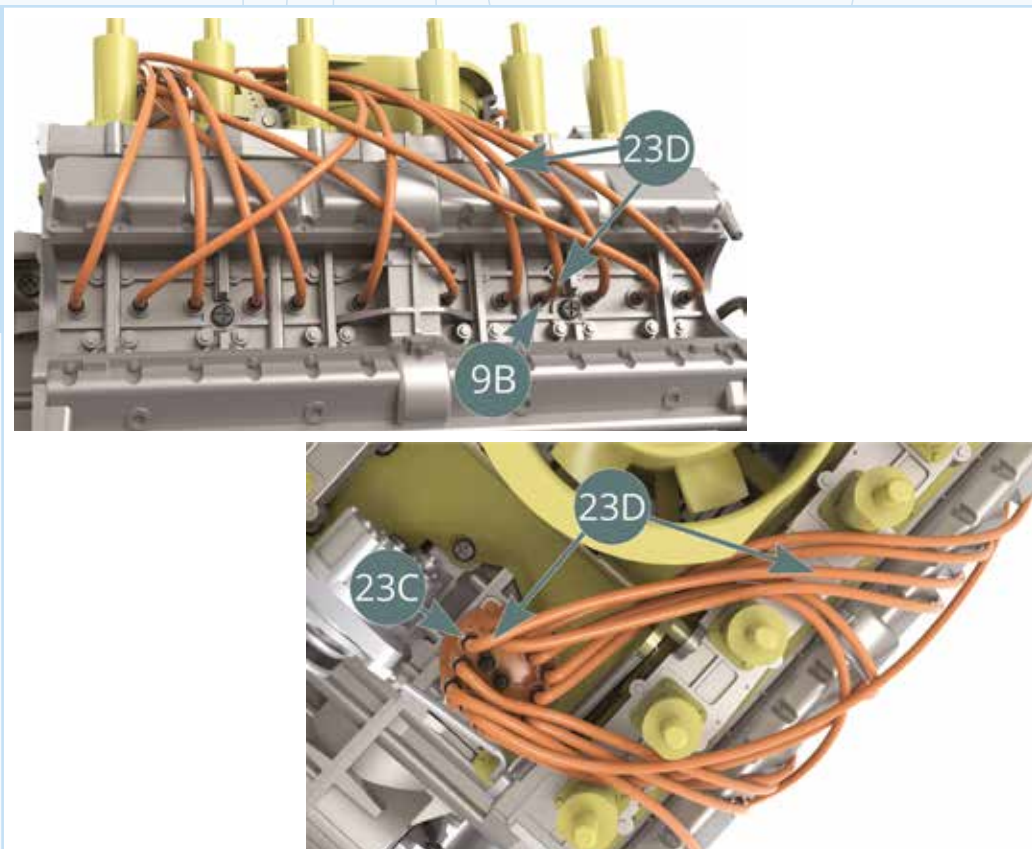
STEP 15

Cut eleventh 23D Ignition wire 105 mm long from the Ignition wire roll and fit it to next 9B Spark plug (upper illustration) , then lead and fit to 23C Ignition wire plug (lower illustration).



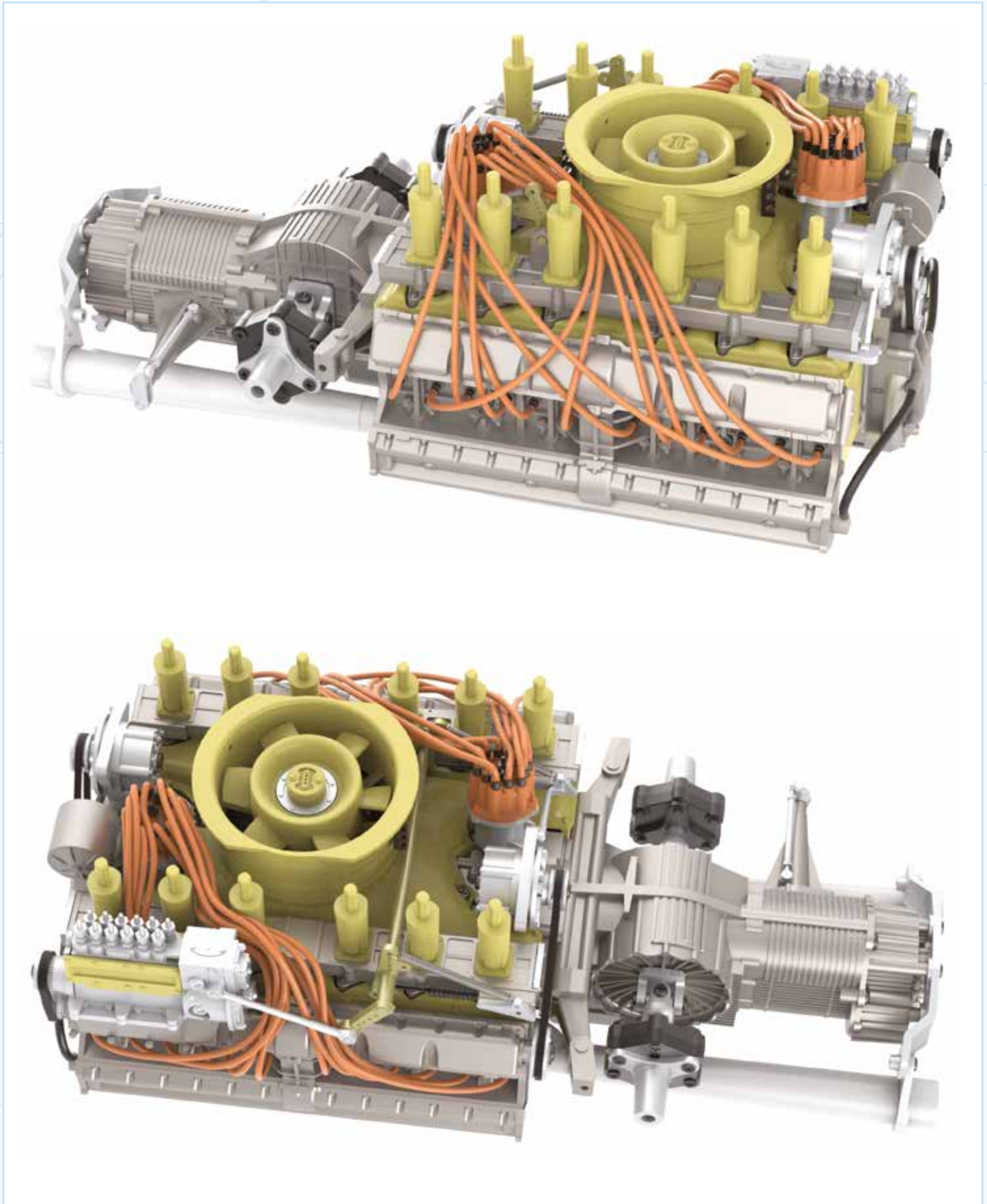
STEP 16

Cut twelveth 23D Ignition wire 110mm long from the Ignition wire roll and fit it to next 9B Spark plug (upper illustration) , then lead and fit to 23C Ignition wire plug (lower illustration).





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 24

24A V-frame

24B Collar link

24C Brake fluid reservoir

24D Brake fluid reservoir

24E Cap (x 2)

24F Support

24G Brake Fluid Hose (x 2)

24H Windshield washer reservoir

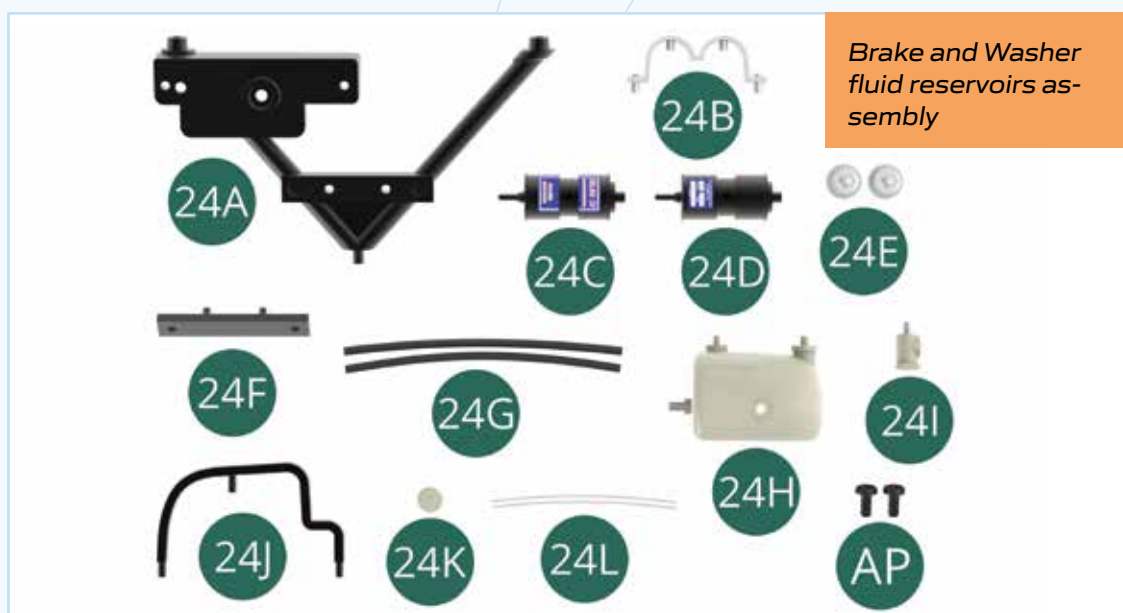
24I Windshield washer pump

24J Clip

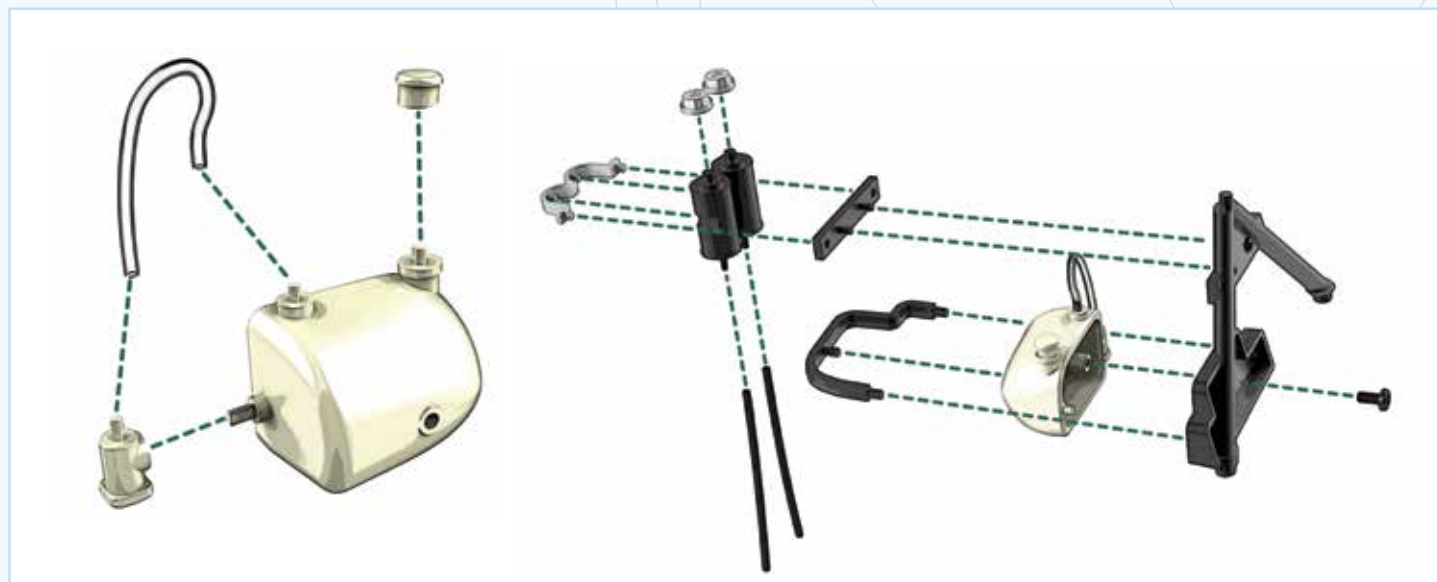
24K Cap

24L Windshield washer fluid hose

AP Screw M 1.7 x 4 mm (x 2)



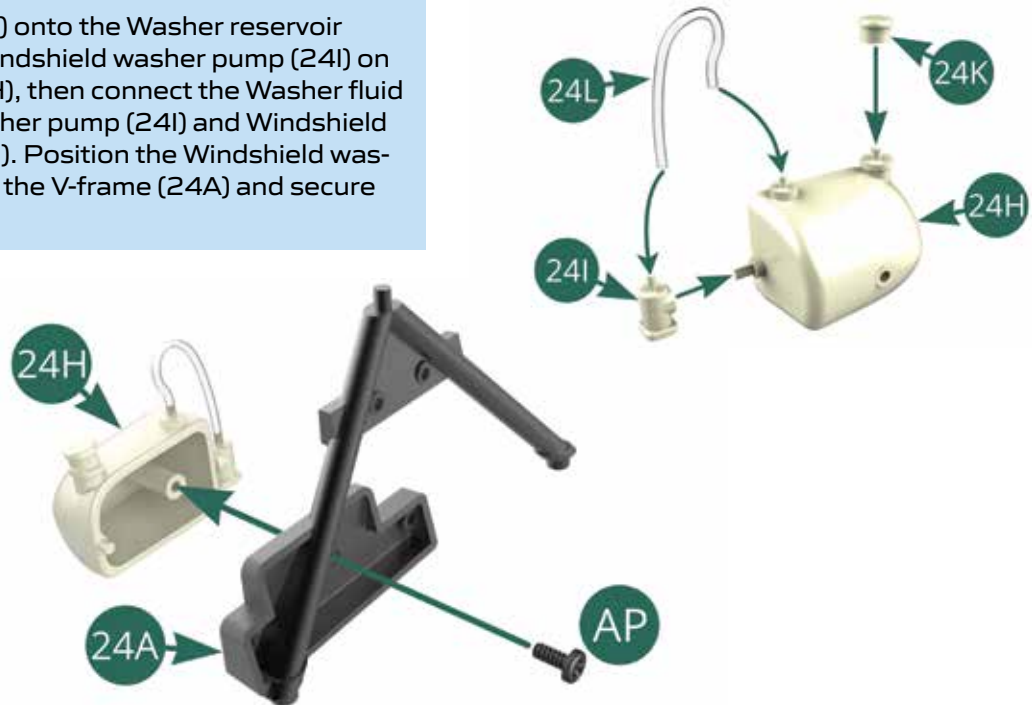
ASSEMBLY DIAGRAM





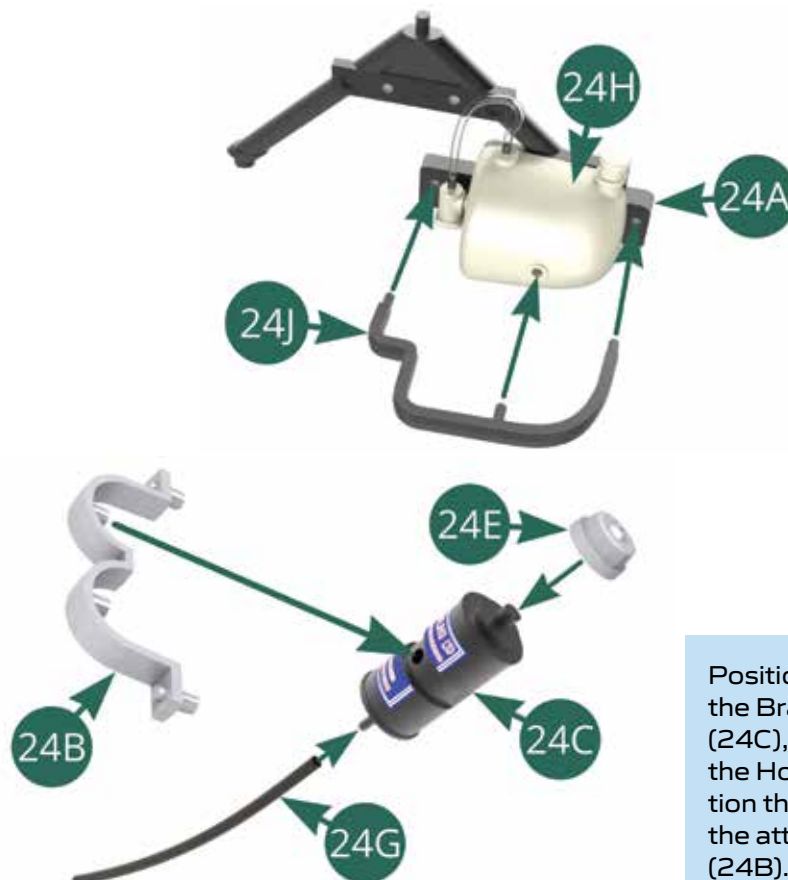
STEP 1

Position the Cap (24K) onto the Washer reservoir (24H). Position the Windshield washer pump (24I) on Washer reservoir (24H), then connect the Washer fluid hose (24L) to the Washer pump (24I) and Windshield washer reservoir (24H). Position the Windshield washer reservoir (24H) on the V-frame (24A) and secure with an AP screw.



STEP 2

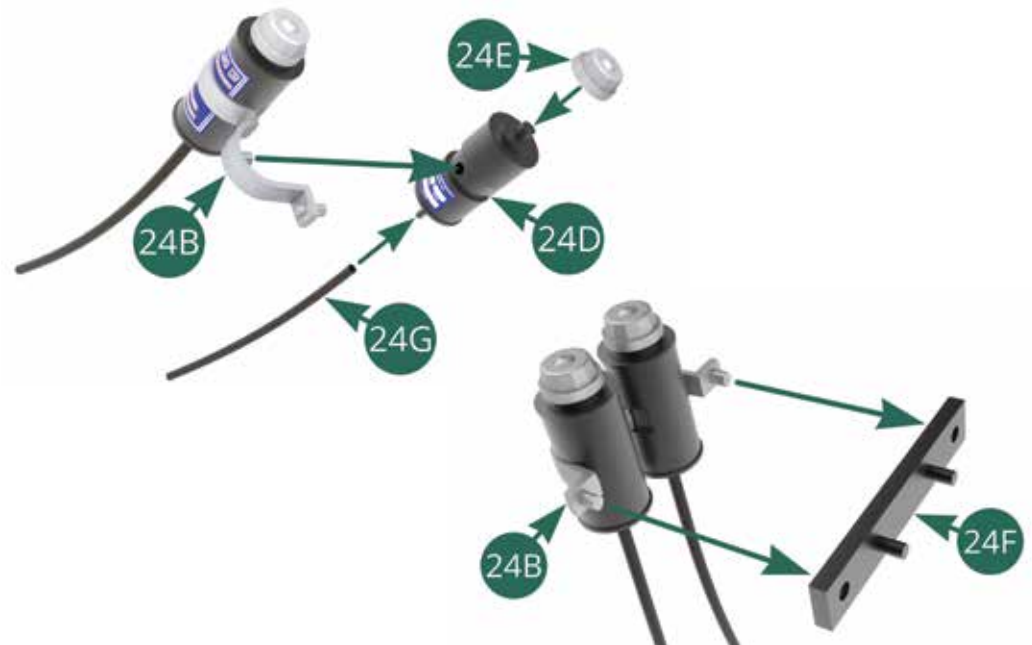
Position the Clip (24J) on the V-frame (24A) and on the Windshield washer reservoir (24H).



Position Cap (24E) on the Brake fluid reservoir (24C), then connect the Hose (24G). Position the Tank (24C) on the attachment Collar (24B).

STEP 3

Position the Cap (24E) on the Brake fluid tank (24D), then connect the Fluid hose (24G). Position Brake fluid reservoir (24C) on Clamp (24B).



Position Clamp (24B) on Support (24F).

STEP 4

Position Support (24F) on the V-frame (24A) – illustrations below.



GENERAL VIEW





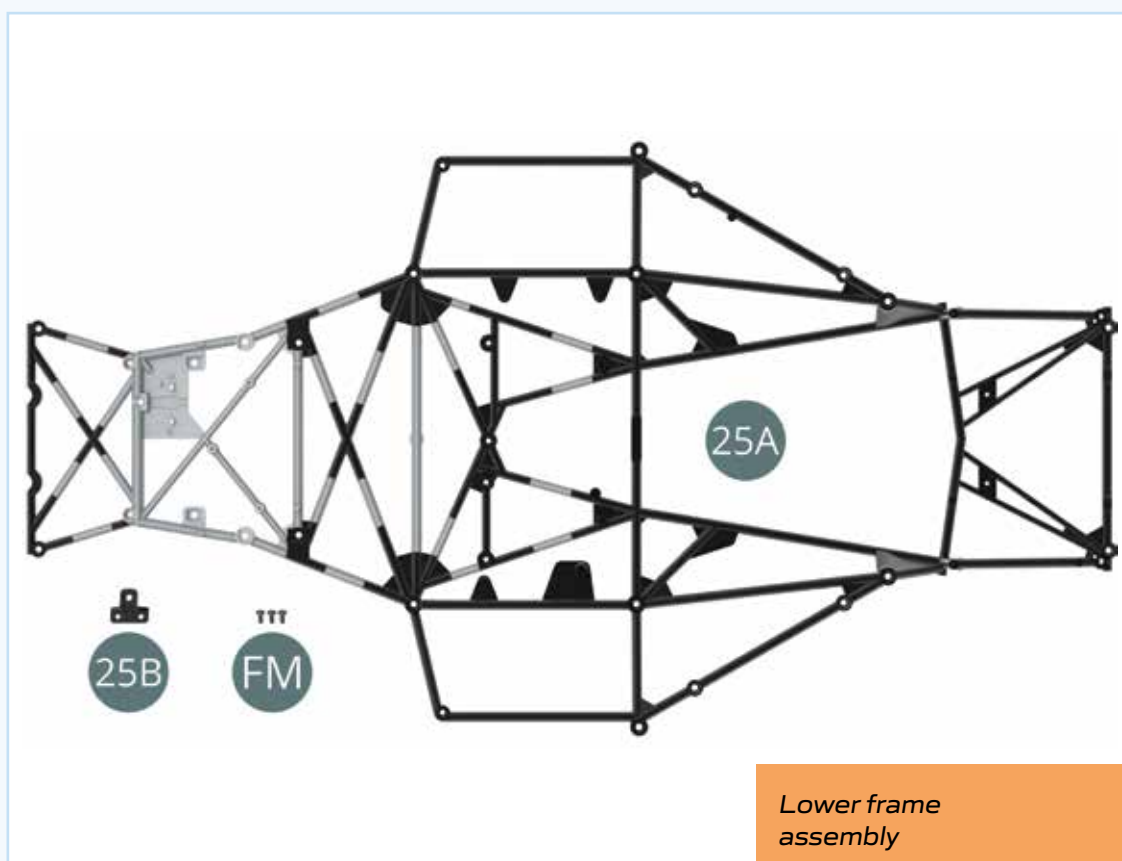
Assembly guide

PARTS OF THE ISSUE 25

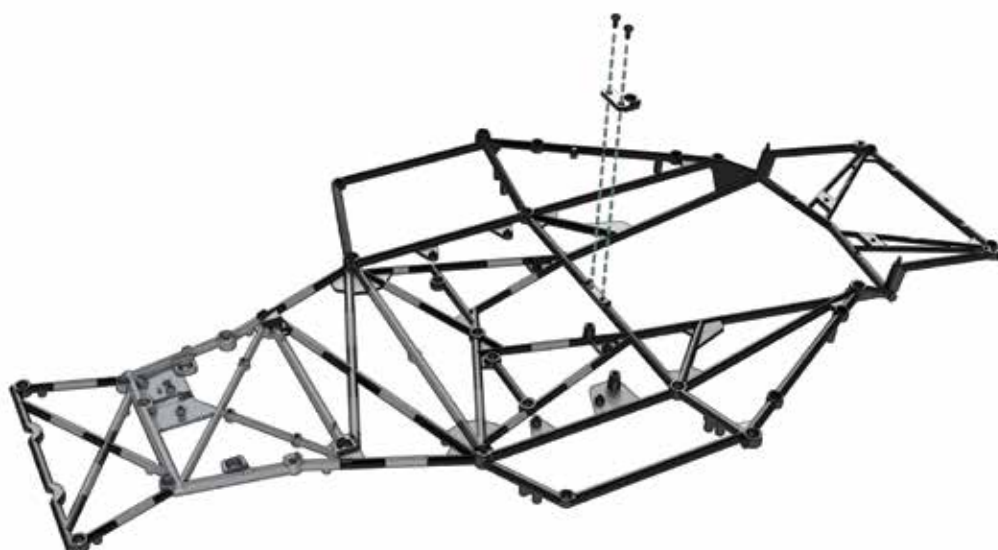
25A Lower frame

FM Screw M 1.7 x 4 mm (x 3)

25B Front engine mount



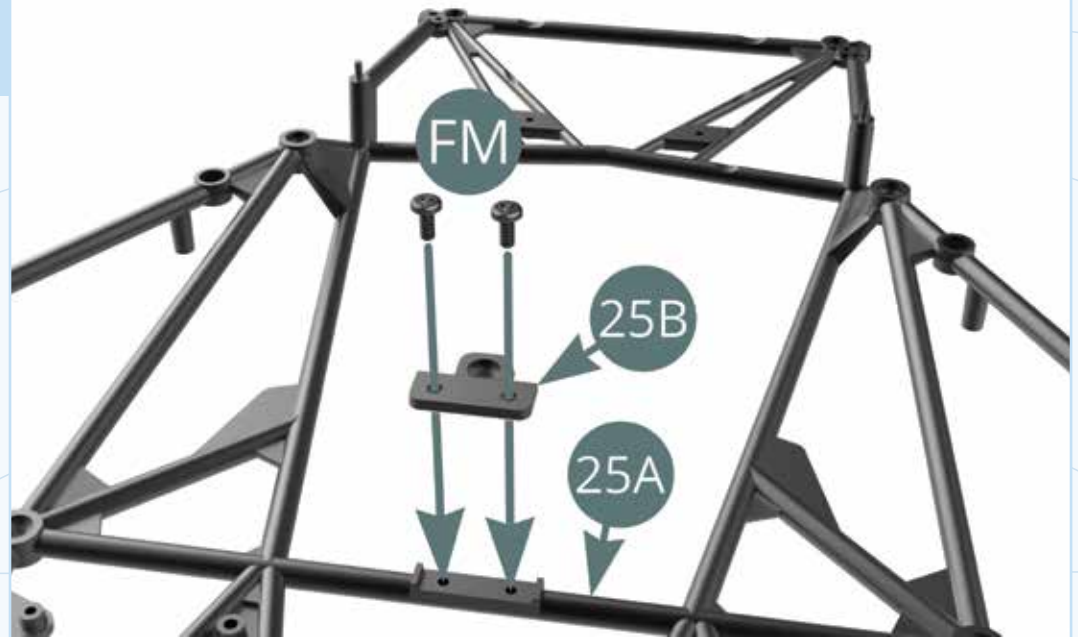
ASSEMBLY DIAGRAM



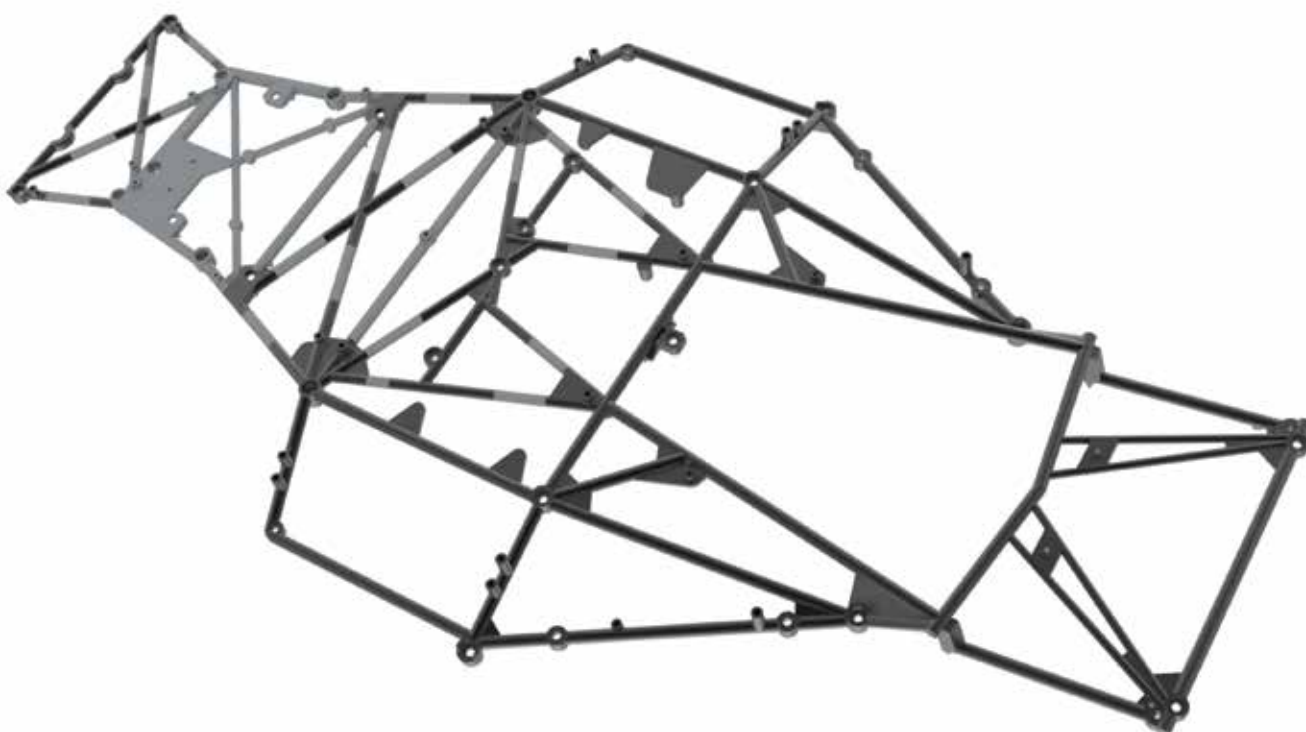


STEP 1

Position the front engine mount 25B on the lower frame 25A and fix it with two FM screws (illustration opposite).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 26

26A Footrest

26B Rod

26C Bottom bracket

26D Throttle pedal

26E Clutch pedal

26F Brake pedal

26G Pedal bracket

26H Master cylinder

26I Tappet (x 2)

26J Clutch cable

26K Brake light switch cable

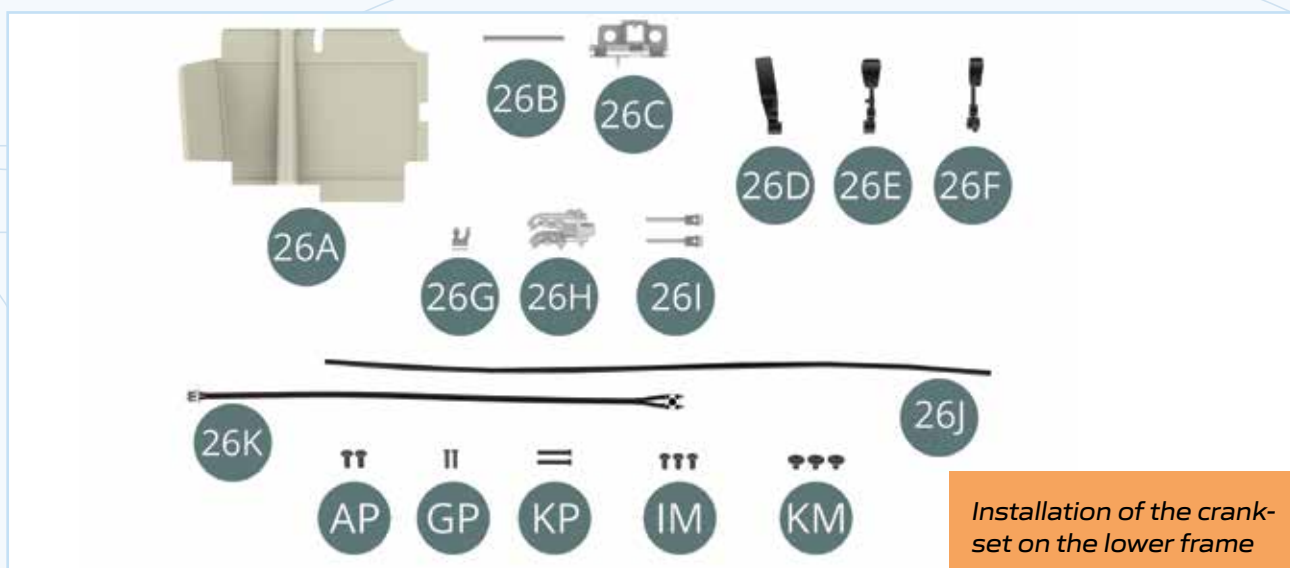
AP Screw M 1.7 x 4 mm (x 2)

GP Screw M 1.2 x 5 mm (x 2)

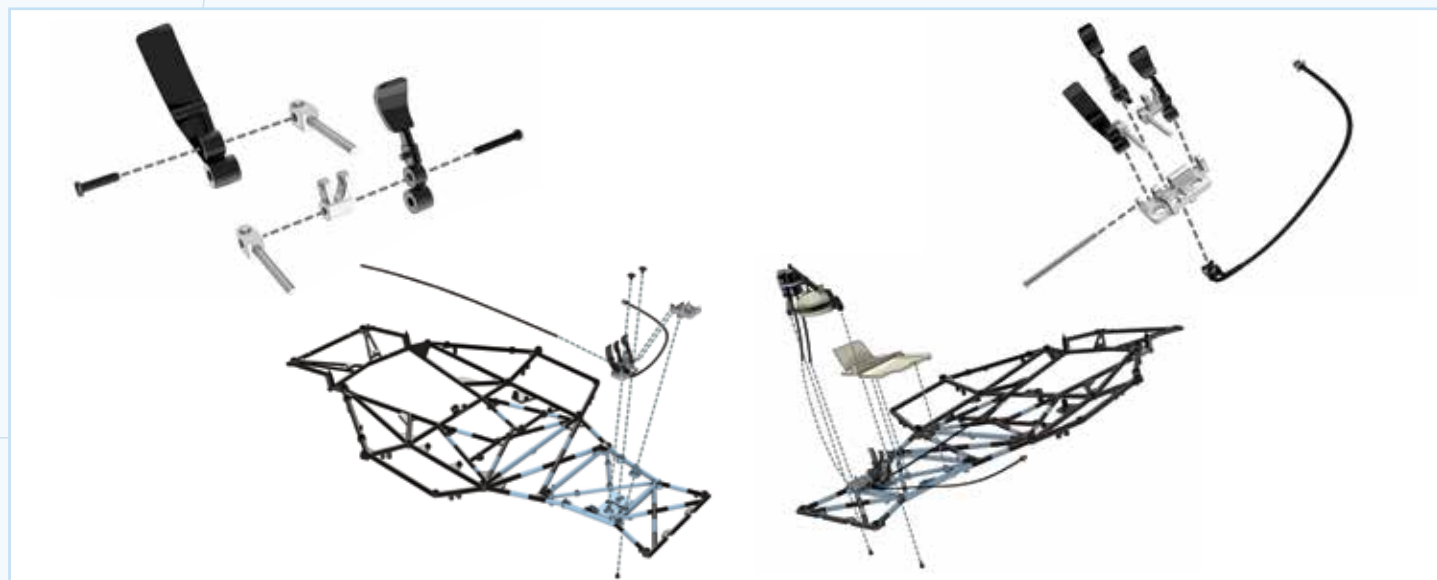
KP Screw M 1.2 x 9.5 mm (x 2)

IM Screw M 1.7 x 3.5 mm (x 3)

KM Screw M 1.7 x 3 x 5 mm (x 3)

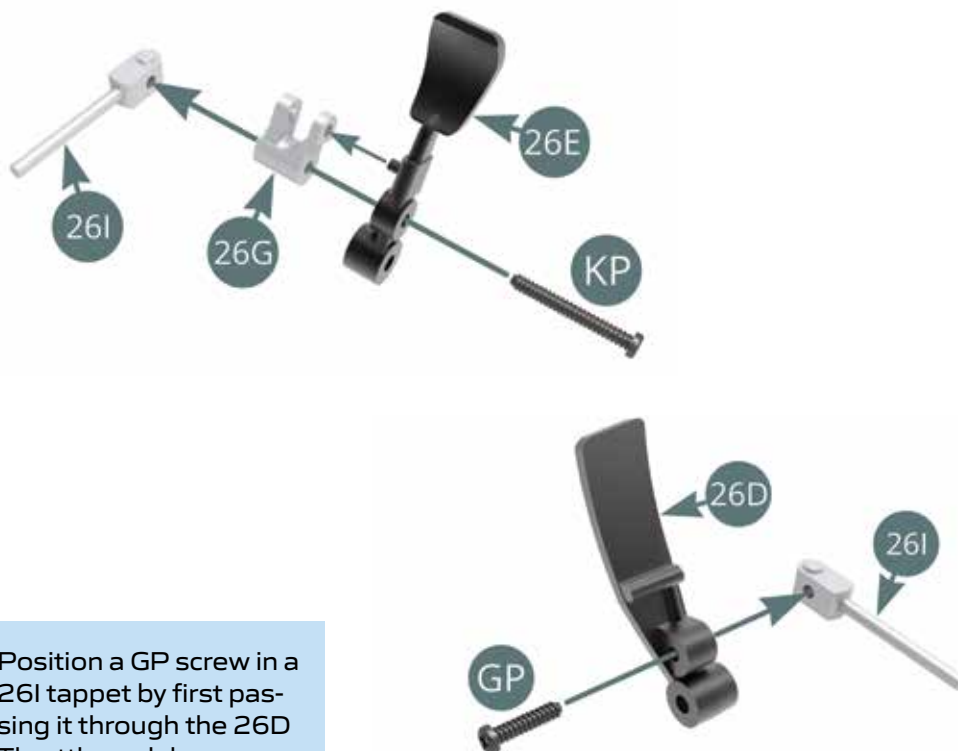


ASSEMBLY DIAGRAM



STEP 1

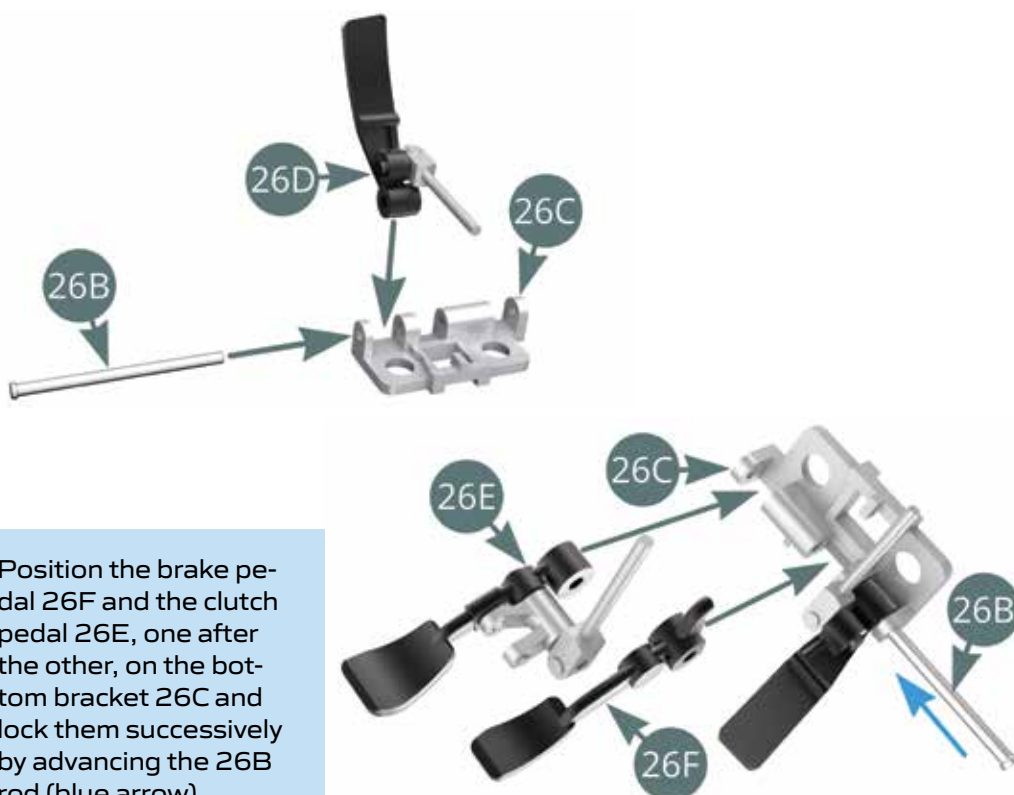
Position a KP screw in a 26I tappet by first passing it through the 26E clutch pedal and then the 26G bracket.



Position a GP screw in a 26I tappet by first passing it through the 26D Throttle pedal.

STEP 2

Position the throttle pedal 26D on the pedal bracket 26C and lock it with the 26B rod.

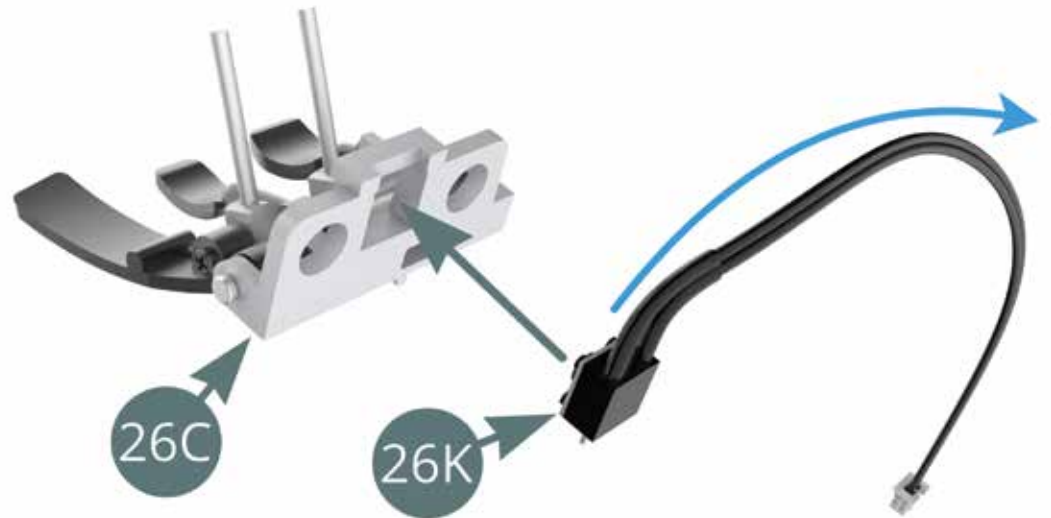


Position the brake pedal 26F and the clutch pedal 26E, one after the other, on the bottom bracket 26C and lock them successively by advancing the 26B rod (blue arrow).



STEP 3

Fold the 26K brake light switch cable to the side (blue arrow) and position the switch into the slot provided under the 26C bottom bracket.



Pedal assembly



STEP 4

Position the 26C bottom bracket on the 25A lower frame and secure it with two KM screws.

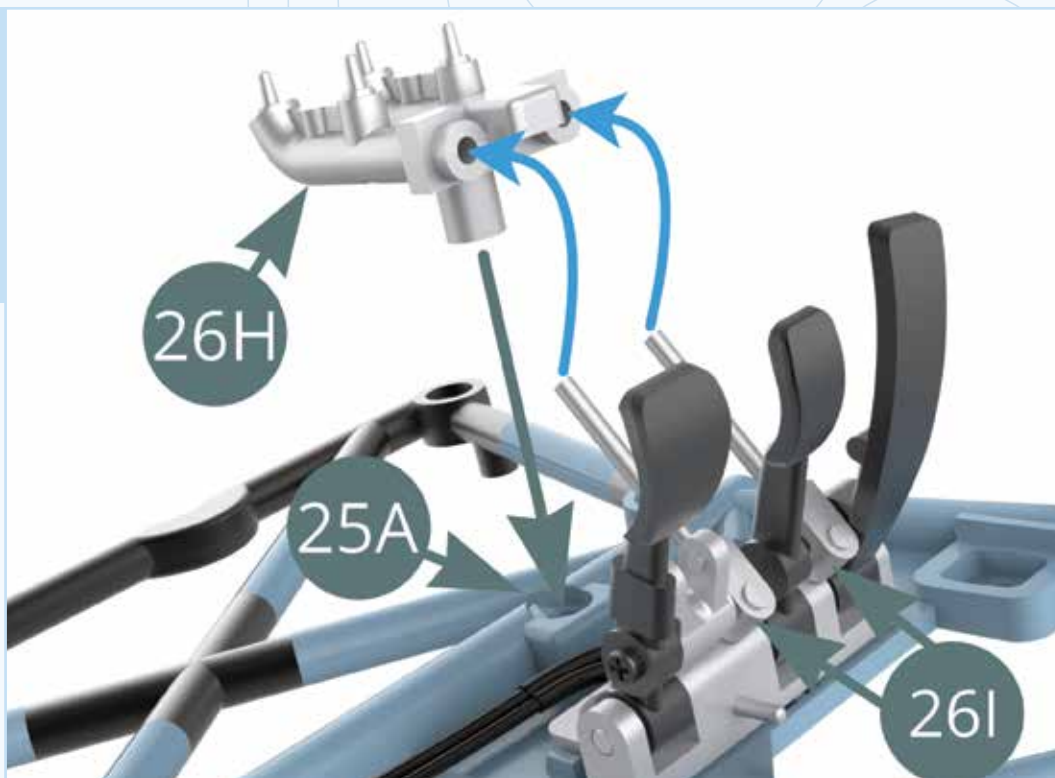


Crankset installed on the frame



STEP 5

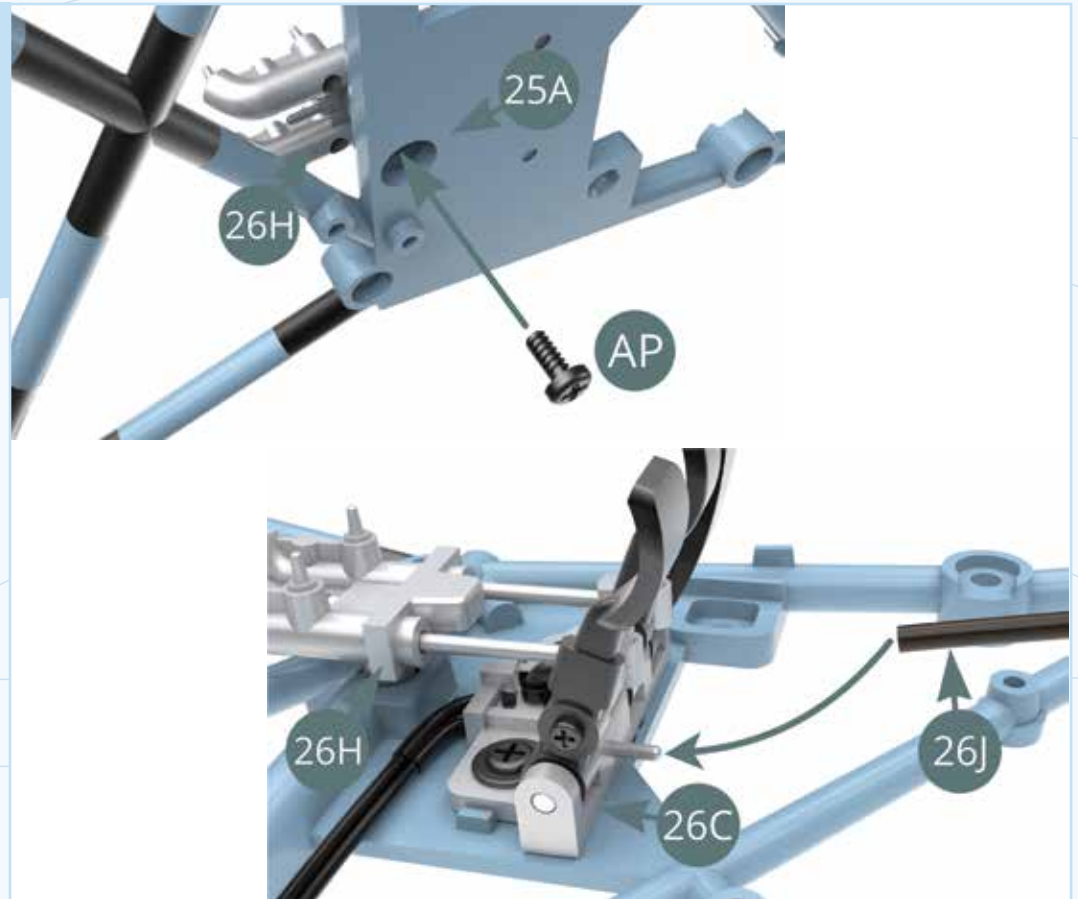
Position the master cylinders 26H on the lower frame 25A and, at the same time, insert the two 26I tappets into their respective master cylinder housings 26H (blue arrow).





STEP 6

Attach the master cylinders 26H to the lower frame 25A with an AP screw.
Position the clutch cable 26J on the nozzle at the rear of the bottom bracket 26C.



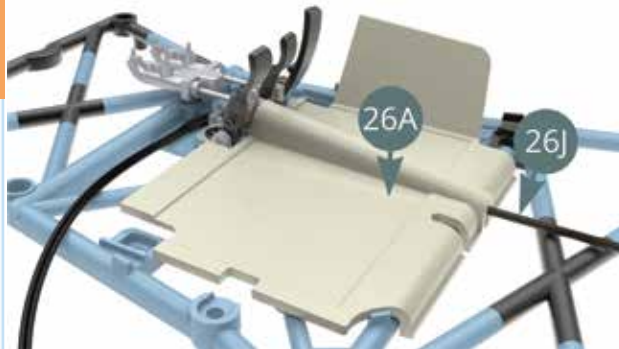
STEP 7

Position the footrest 26A on the lower frame 25A using the three lugs provided. Pass the clutch cable 26J through the slot indicated by the green arrow (see illustrations opposite).

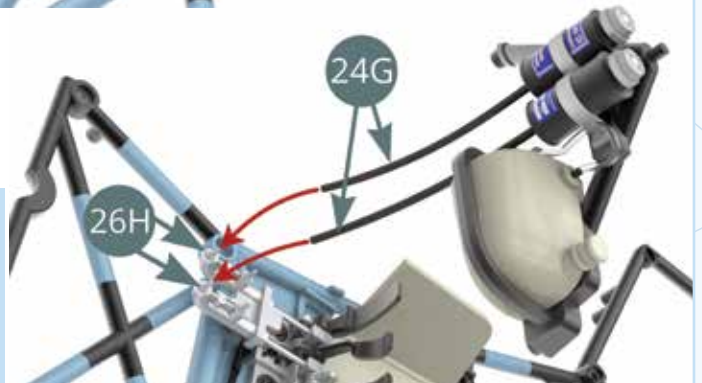


STEP 8

Footrest 26A installed
on the chassis

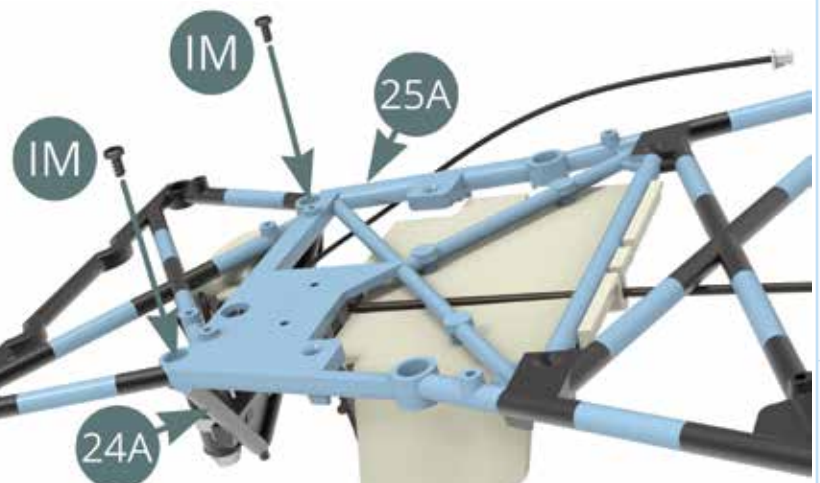
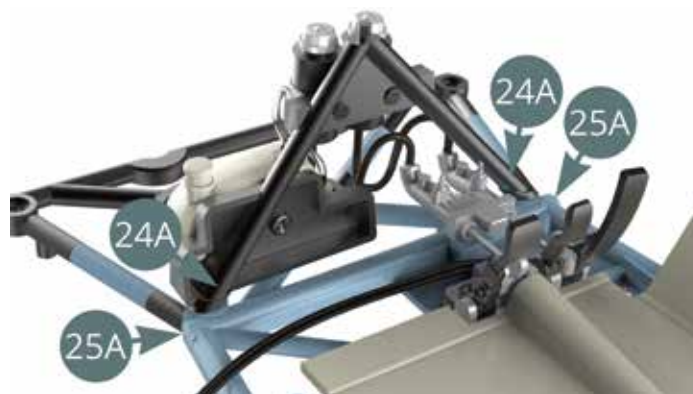


Position the 24G brake
fluid hose nozzles on the
front of the 26H master
cylinders (continued on
the following illustration).

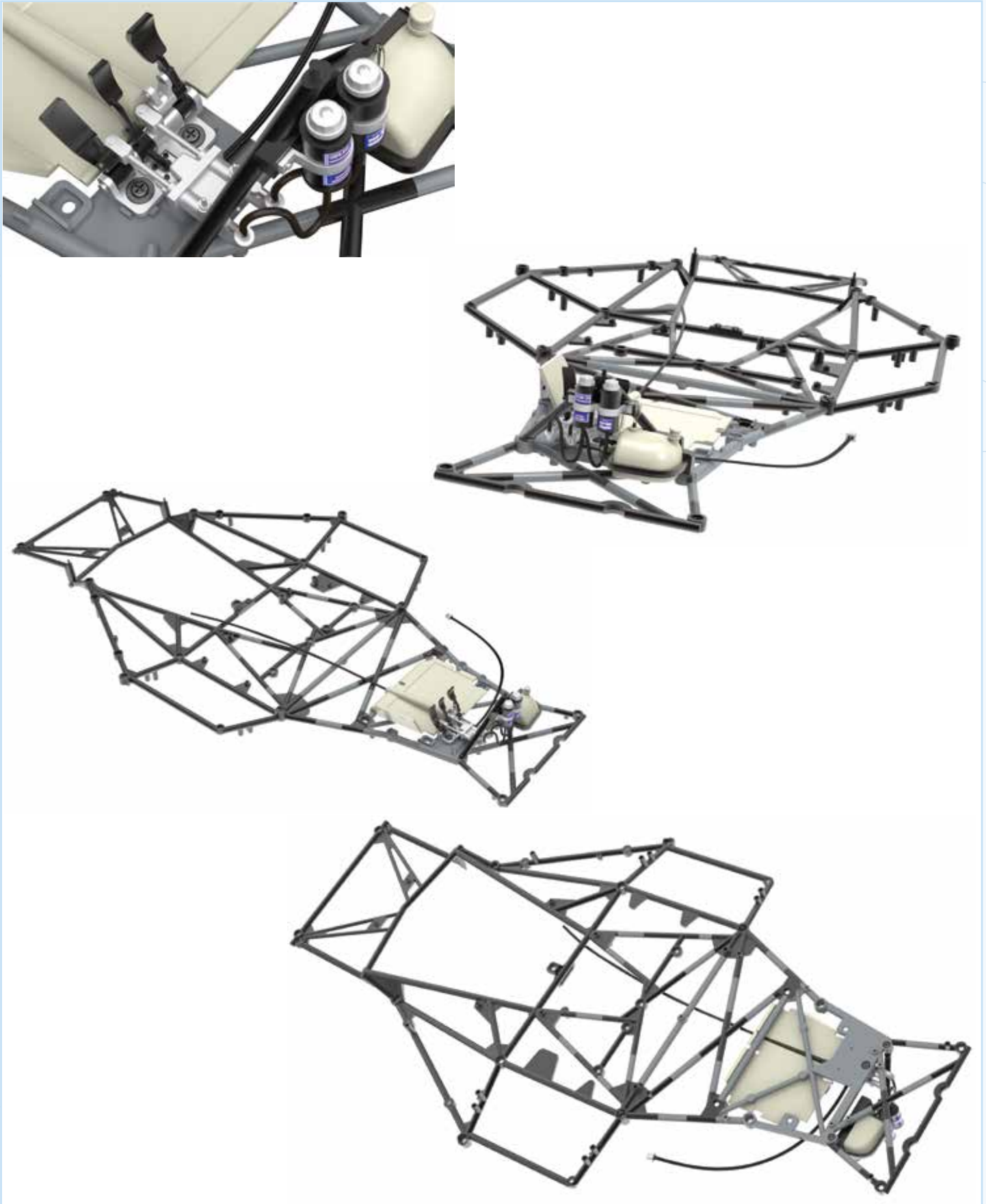


STEP 9

Continue by positioning
the 24A V frame on the
lower frame 25A, then
fix it from below with
two IM screws (illustra-
tions opposite).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 27

27A Dashboard Frame

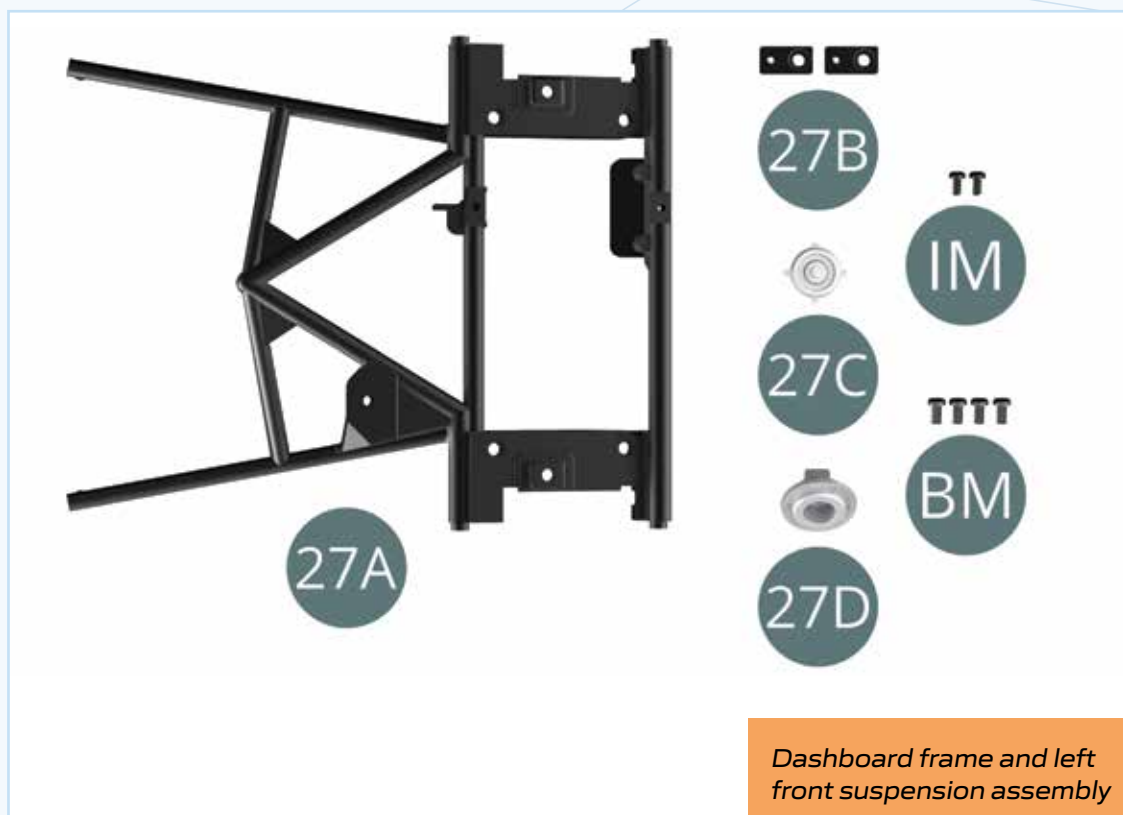
27B Bracket (x 2)

27C Windscreen wiper control

27D Horn

IM Screw M 1.7 x 3.5 mm (x 2)

BM Screw M 2 x 4 mm (x 4)



ASSEMBLY DIAGRAM





STEP 1

Position the 27C wiper control and 27D horn on the 27A dashboard frame and secure the horn with an IM screw.

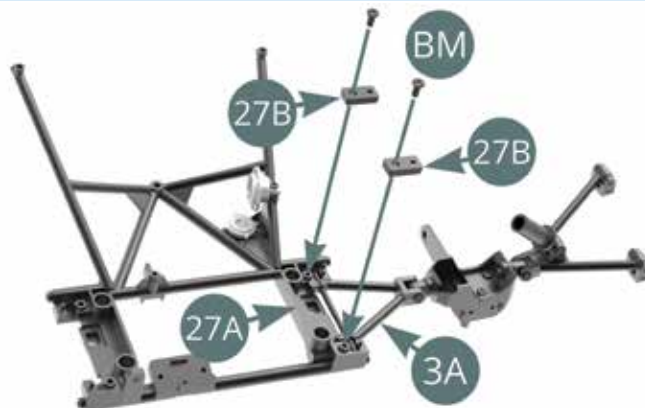


Position the upper swing arm 3A on the dashboard frame 27A.

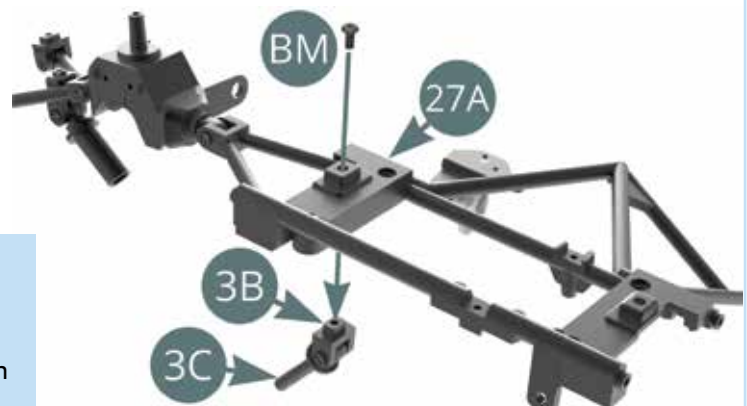


STEP 2

Attach the upper swingarm 3A to the dashboard frame 27A using the brackets 27B and two BM screws.



Position the 3B shock bracket and 3C piston on the 27A dashboard frame, and secure it with a BM screw.



GENERAL VIEW



View of the left front suspension in its future mounting position



Assembly guide

PARTS OF THE ISSUE 28

28A Attachment

28B Support

28C Support

28D Attachment

28E Fire extinguisher pull

AP Screw M 1.7 x 4 mm (x 3)

IM Screw M 1.7 x 3.5 mm (x 5)



28A



28B



28C



28D



28E



AP



IM

Installation of the steering wheel on the dashboard frame

ASSEMBLY DIAGRAM



STEP 1

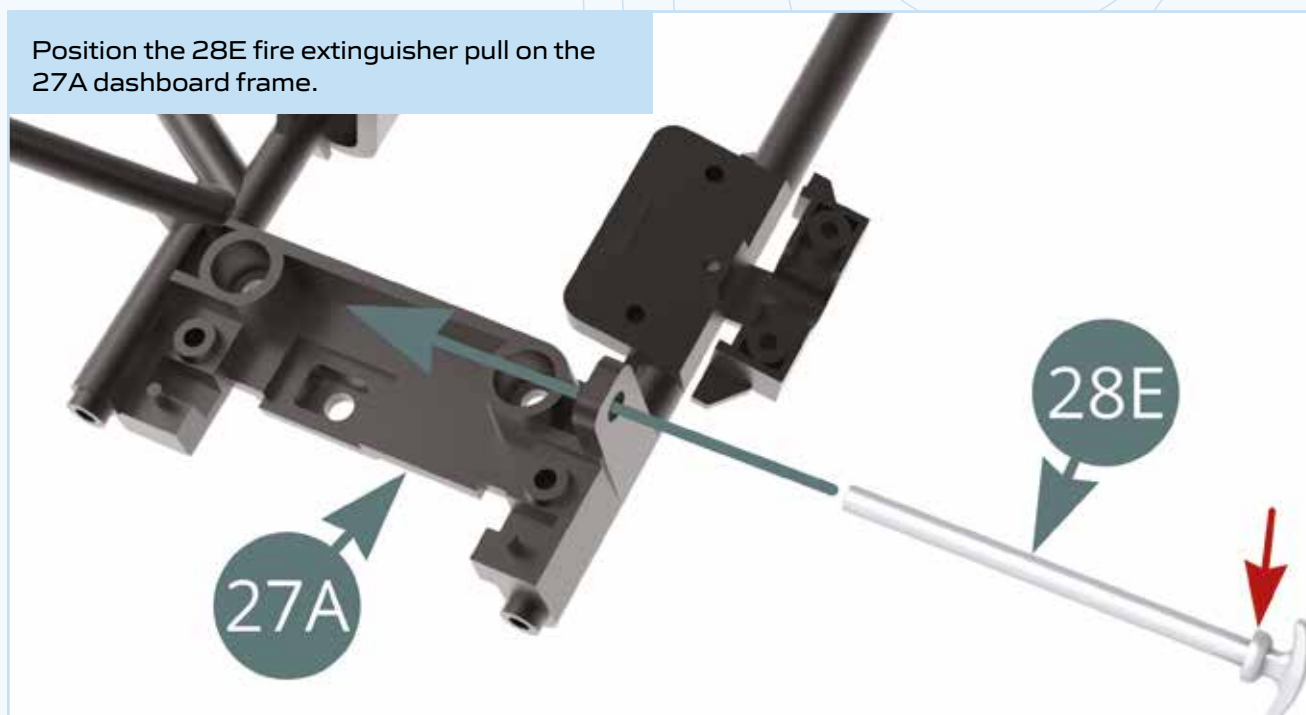
Position the 28B support on the 27A dashboard frame and secure it with an IM screw.



Position the 28C support on the 27A dashboard frame and secure it with an IM screw.

STEP 2

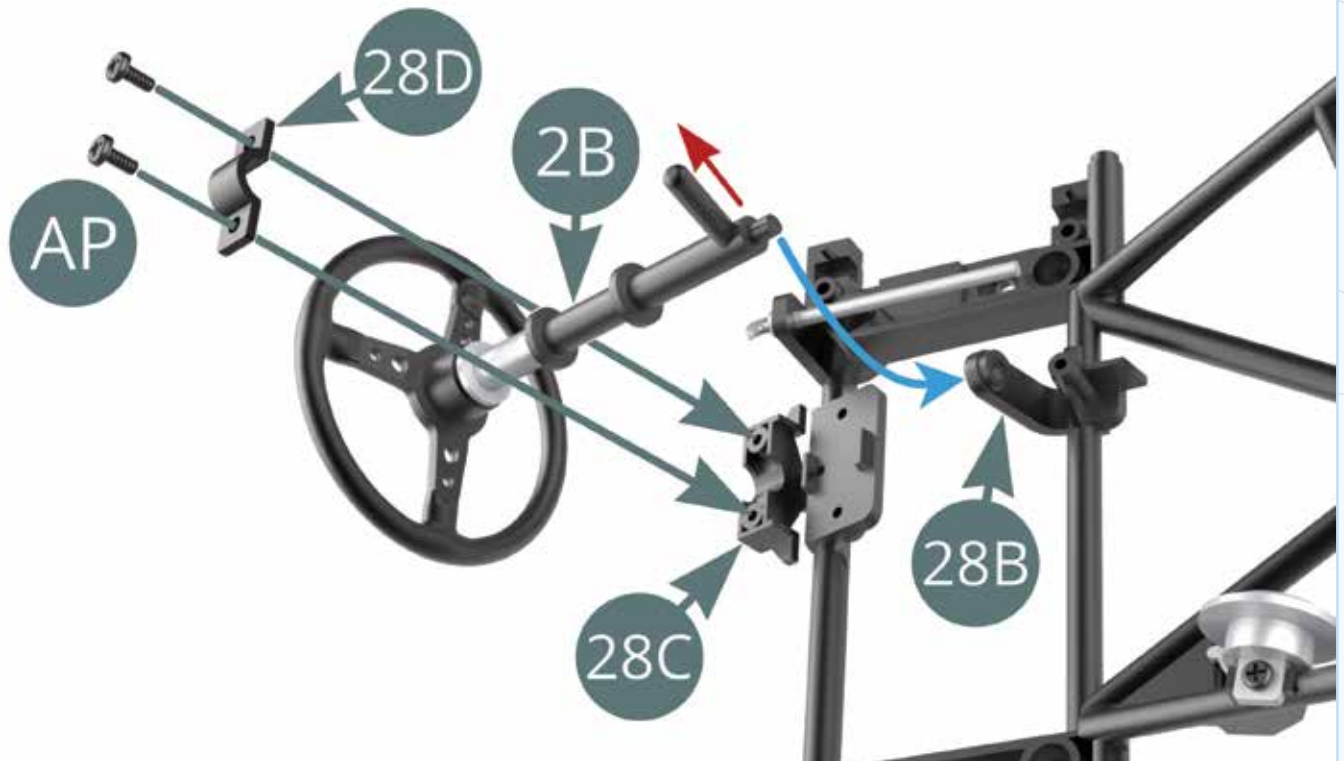
Position the 28E fire extinguisher pull on the 27A dashboard frame.





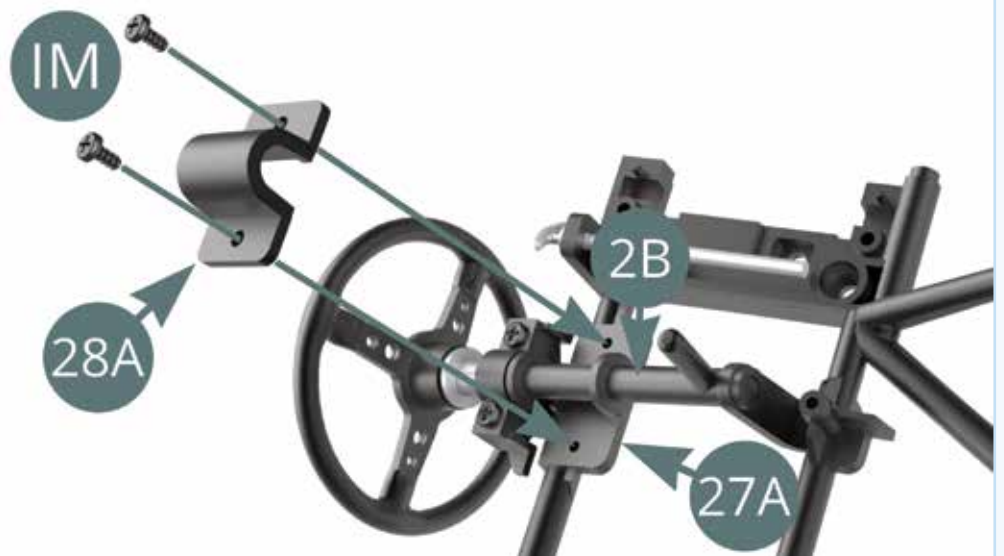
STEP 3

Position the end of 2B steering column on 28B support (blue arrow) and secure it to support 28C using attachment 28D and two AP screws. Check the orientation of the axle at the end of steering column 2B (red arrow).

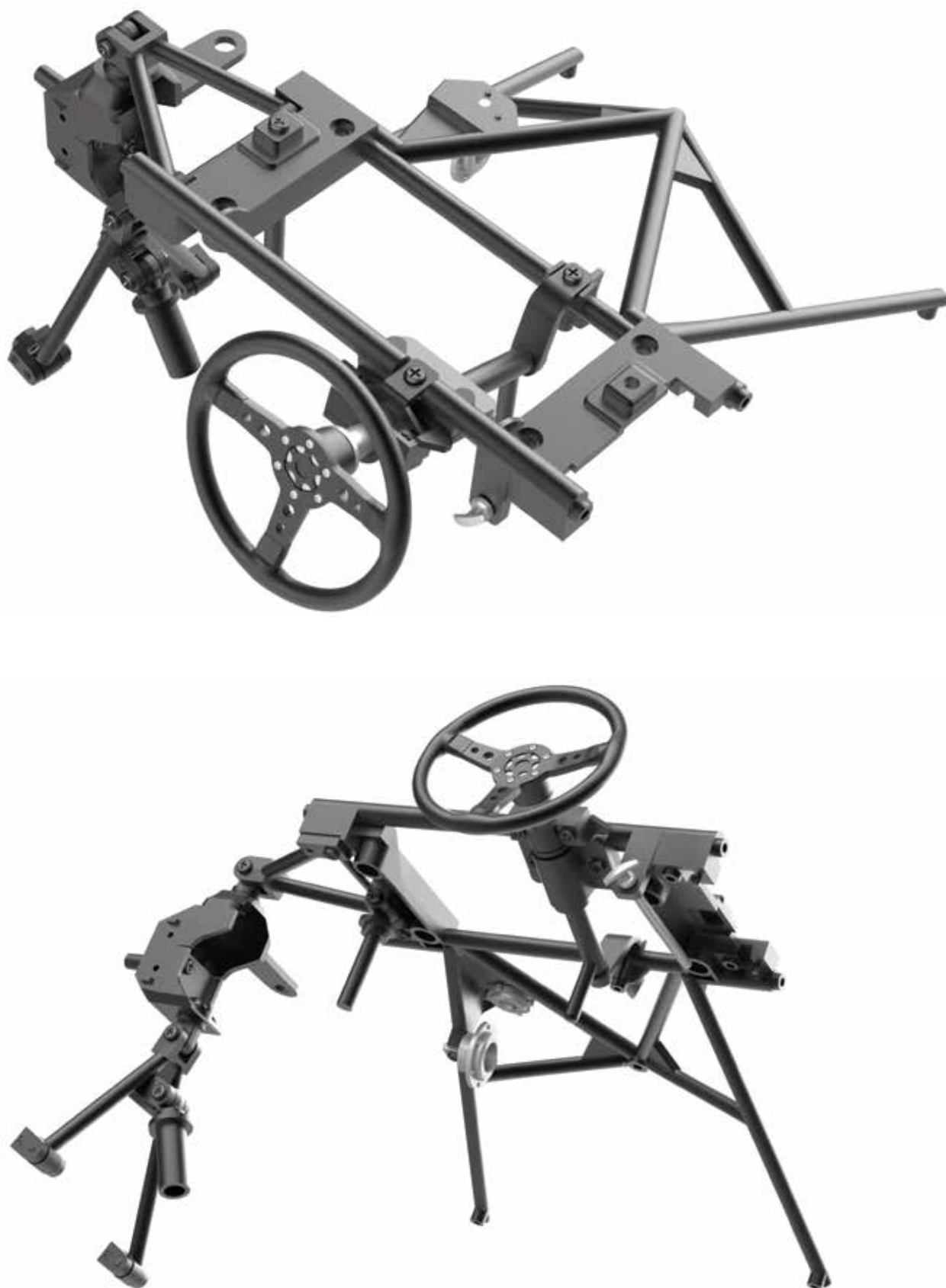


STEP 4

Attach the 2B steering column to the 27A dashboard frame using 28A attachment and two screws IM.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 29

29A Upper front wishbone

29B Bracket (x 2)

29C Shock absorber upper support (marked 1)

29D Shock piston

29E Shock spring

29F Shock cylinder

29G Lower shock absorber support (marked 2)

29H Hub carrier top

29I Lower hub carrier

29J Lower front wishbone

29K Lower wishbone support (x2, marked 3)

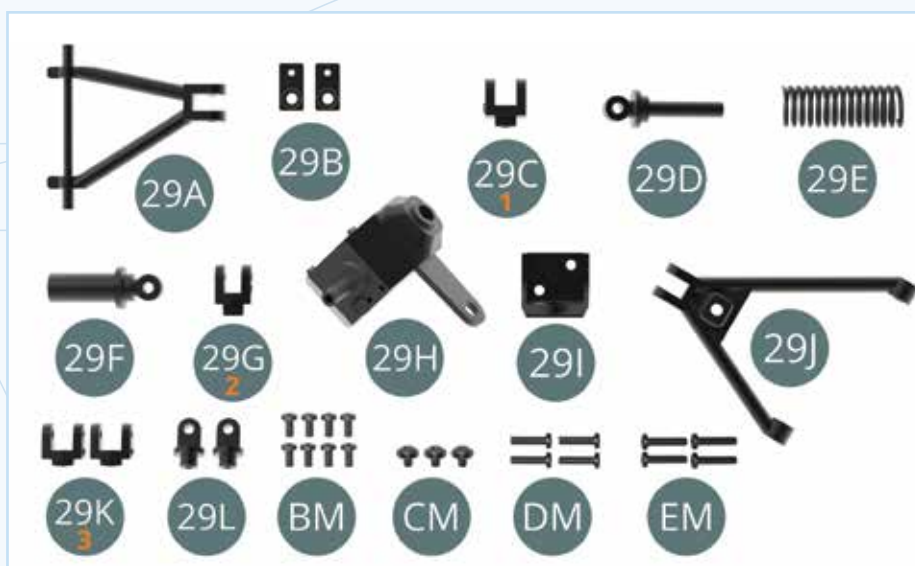
29L Hub carrier joint (x 2)

BM Screw M 2.0 x 4 mm (x8)

CM Screw M 2.0 x 3 x 5 mm (x3)

DM Screw M 2.0 x 8 mm (x4)

EM Screw M 2.0 x 9 mm (x4)



Assembly of the right front suspension and mounting on the dashboard frame

ASSEMBLY DIAGRAM



STEP 1

Position 29L hub carrier joint on 29A front upper wishbone and fix with a DM screw through the widest hole (red arrow), maintain mobility.



Position the top of 29H hub carrier on 29L hub carrier joint and fix with a CM screw, do not overtighten, allow the wheel to turn.

STEP 2

Position the two 29K lower wishbone supports (marked 3) successively on 29J lower front wishbone and secure each of them with an EM screw through the widest hole (red arrow), maintain mobility.



Position 29L hub carrier joint on 29J front lower wishbone and fix it with a DM screw through the widest hole (red arrow), maintain mobility.

STEP 3

Position 29G Lower shock absorber support (marked 2) on 29F Shock cylinder and fix with a DM screw through the widest hole (red arrow), maintain mobility.

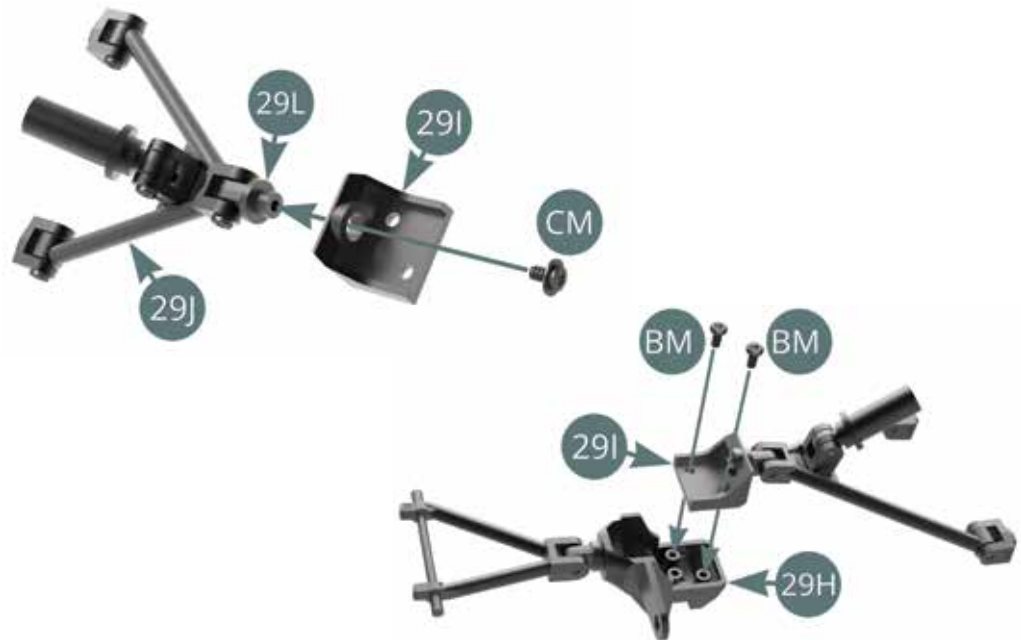


Position 29G Lower shock absorber support (marked 2) on 29J Front lower wishbone and fix with a BM screw.



STEP 4

Position the bottom of 29I hub carrier on 29L hub carrier joint and secure with a CM screw, do not overtighten – allow the wheel to turn. Position the bottom of 29I hub carrier on the top of 29H hub carrier and secure with two BM screws.

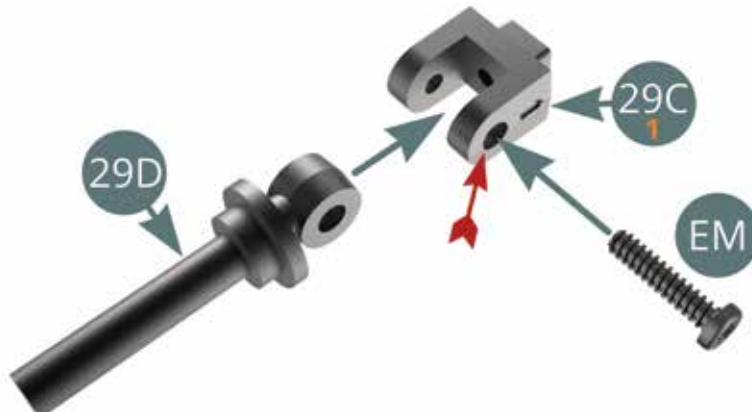


Preassembly of the right front suspension in unfolded position



STEP 5

Position 29C upper shock absorber 29C (marked 1) on 29D shock piston and secure with an EM screw through the widest hole (red arrow), maintain mobility!

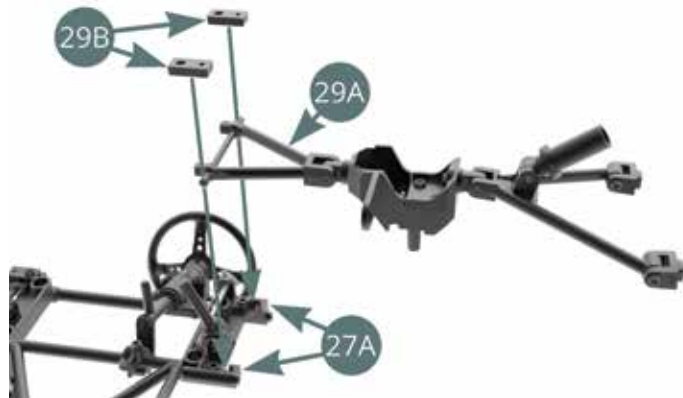


STEP 6

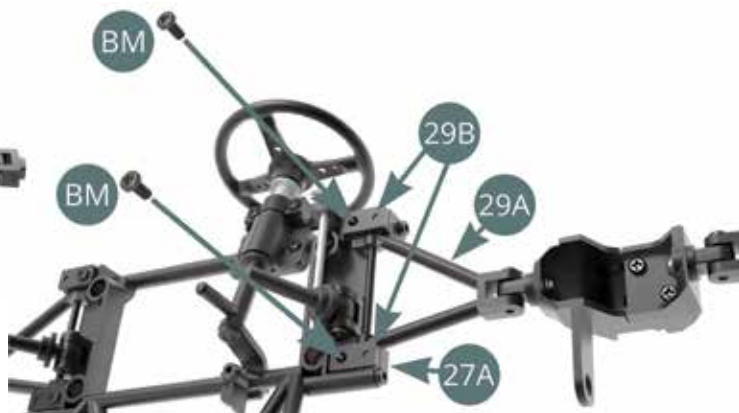
Position 29C upper shock absorber bracket (marked 1) on 27A dashboard frame and secure with a BM screw.



STEP 7



Position 29A upper front wishbone on 27A dashboard frame and secure with 29B brackets and two BM screws (shown above and opposite). Do not overtighten to allow movement.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 30

30A Left brake caliper

30B Brake piston cover (x 2)

30C Left brake bailer / Brake force regulator

30D Inner surface of right brake disc
(note direction of ventilation holes)

30E Outer surface of right brake disc
(note direction of ventilation holes)

30F Right inner brake half disc

30G Right Outer Brake Half Disc

30H Right brake caliper

30I Right brake scoop

30J Steering Rod

30K Steering Bar

BM Screw M 2.0 x 4 mm (x 8)

CM Screw M 2.0 x 3 x 5 mm (x 3)

IM Screw M 1.7 x 3.5 mm (x 10)

KM Screw M 1.7 x 3 x 5 mm (x 2)

CP Screw M 1.7 x 3 x 5 mm (x 3)



*Installation of brakes,
steering and front sus-
pension on the chassis*

ASSEMBLY DIAGRAM



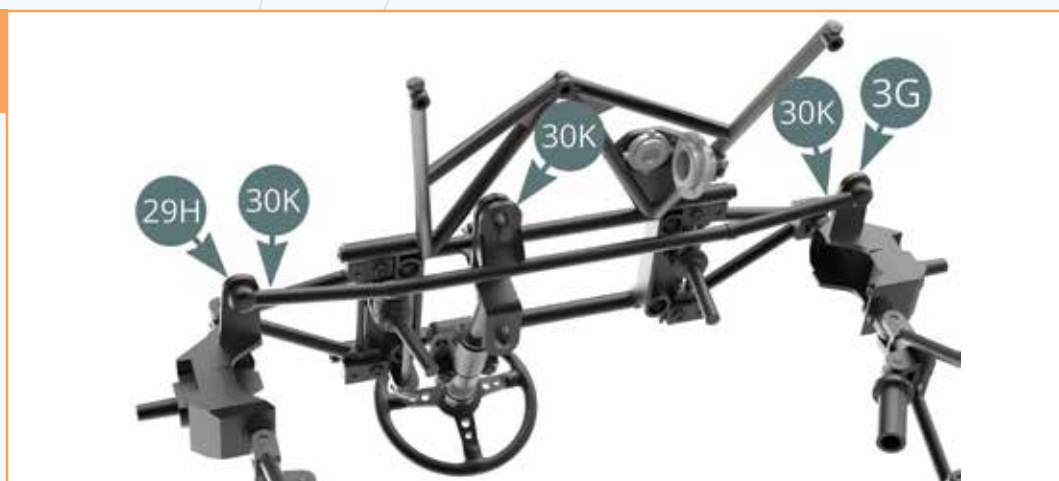
STEP 1

Position 30J steering link on 27A dashboard frame while engaging the lever at the end of the steering column in the slot provided (red arrow), then secure with a KM screw.



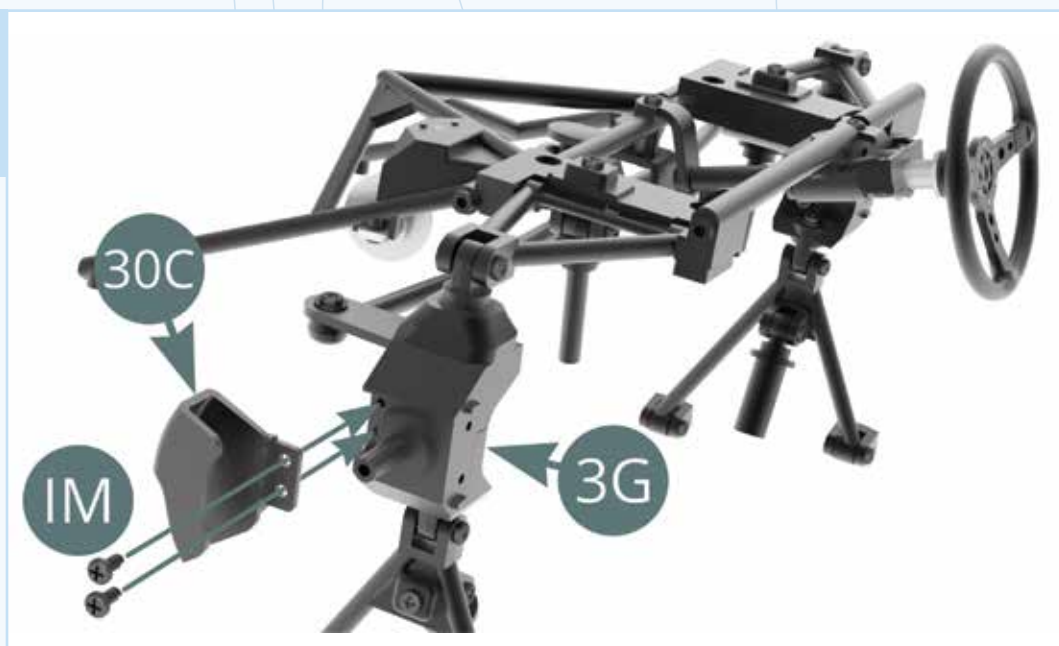
Position 30K steering bar on the upper hub carrier arms 29H and 3G, engaging it in the axis of the steering rod (red arrow) and secure with two CM screws.

30K steering bar installed



STEP 2

Position 30C left brake caliper on top of 3G hub carrier and secure with two IM screws.





STEP 3

Position left brake disc 30-3N (note the direction of the ventilation holes, red arrow) on 3G hub carrier while inserting it into 30C Left brake bailer (blue arrows). Illustrations opposite.



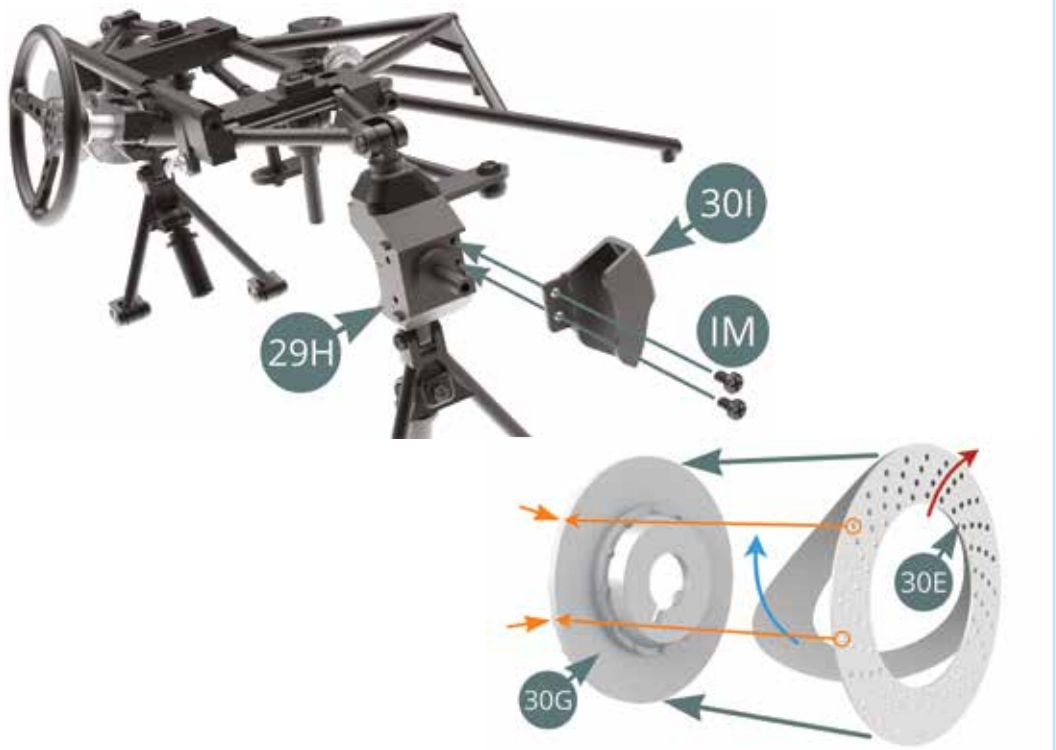
STEP 4

Position 30A left brake caliper on 3G hub carrier and secure with two IM screws. Position 30B piston cover on 30A left brake caliper.



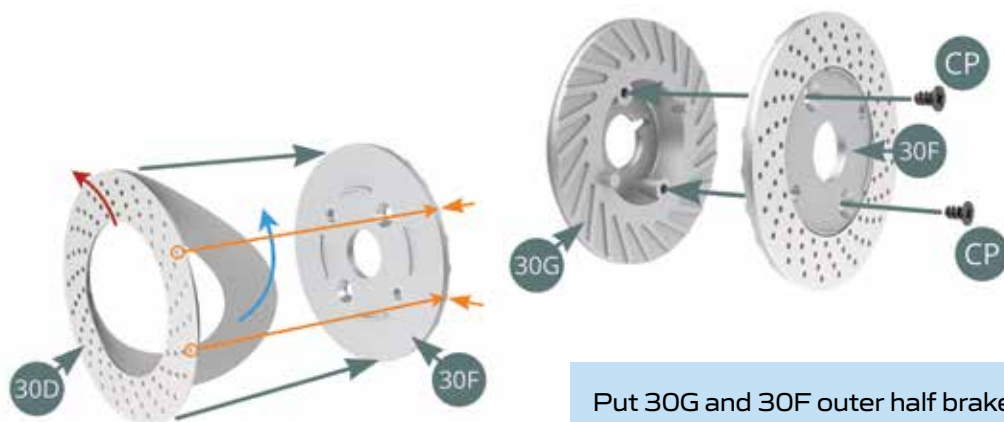
STEP 5

Position 30I right brake scoop on 29H hub carrier and secure with two IM screws. Remove the backing paper (blue arrow) from the outer surface of 30E right brake disc and apply the adhesive to 30G right outer half brake disc (note the direction of the ventilation holes, red arrow). Ensure that the outer holes face the ribs of the disc (orange arrows).



STEP 6

Remove the backing paper (blue arrow) from the inner surface of 30D right brake disc and apply the adhesive to 30F right outer brake half disc (note the direction of the ventilation holes, red arrow). Ensure that the outer holes face the disc ribs (orange arrows).



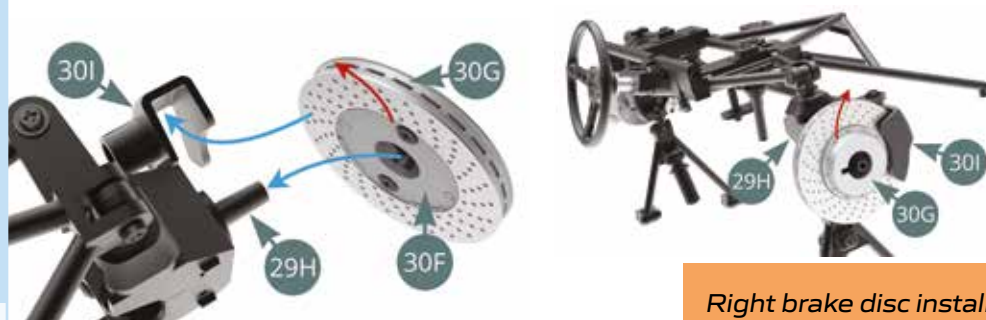
Put 30G and 30F outer half brake discs together and fix them with two CP screws.

Assembled right brake disc



STEP 7

Position the right brake discs 30G-30F (check the direction of the ventilation holes, red arrow) on 29H hub carrier while engaging it in the 30I right brake scoop (blue arrows). Illustrations opposite.



Right brake disc installed on 29H hub carrier

STEP 8

Position 30H right brake caliper on 29H hub carrier and secure with two IM screws.





STEP 9

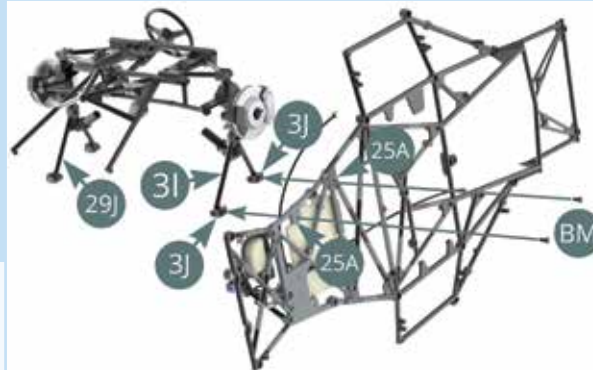
Position 30B piston cover on 30H right brake caliper.



Preassembly of front suspension and steering

STEP 10

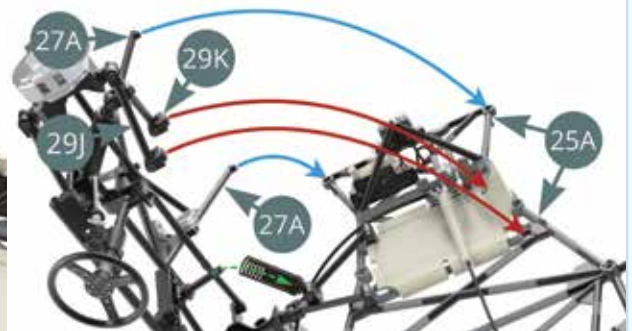
Install the front suspension by positioning the two lower swingarm brackets 3J/3I on 25A lower frame and fix them with two BM screws.



Position 29E shock absorber spring (interchangeable with 3D spring) on 29F shock absorber cylinder, then while tilting the assembly (green arrow), position 29D shock absorber piston in 29F shock absorber cylinder and through 29E spring (blue dotted arrow).

STEP 11

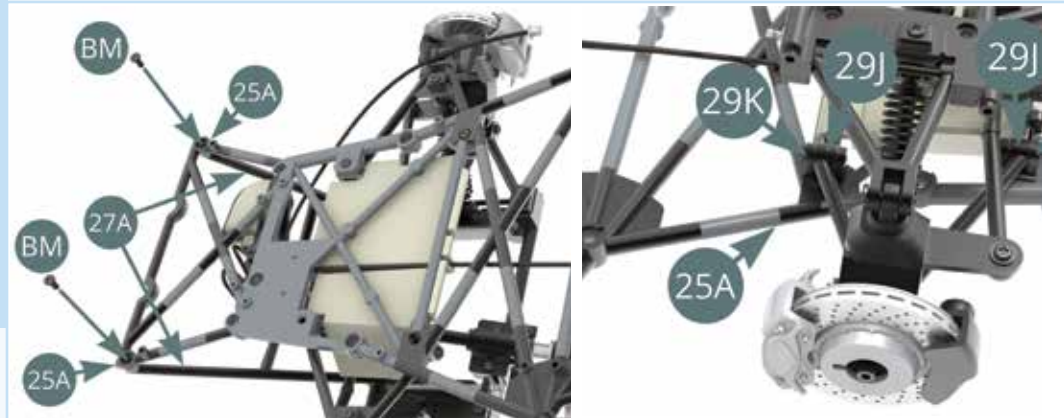
Position 3D shock spring (interchangeable with 29E spring) on 3E shock absorber cylinder, then while tilting the assembly (green arrow), position 3C shock absorber piston in 3E shock absorber cylinder and through 3D spring (blue dotted arrow).



While tilting, align 27A dashboard frame arms (blue arrows) and 29K lower wishbone brackets (red arrows) in their respective housings on the lower frame 25A.

STEP 12

Attach the frame arms of 27A instrument panel to the ends of 25A lower frame with two BM screws. Align the two 29K lower wishbone brackets with the slots on the upper right of the lower frame 25A.



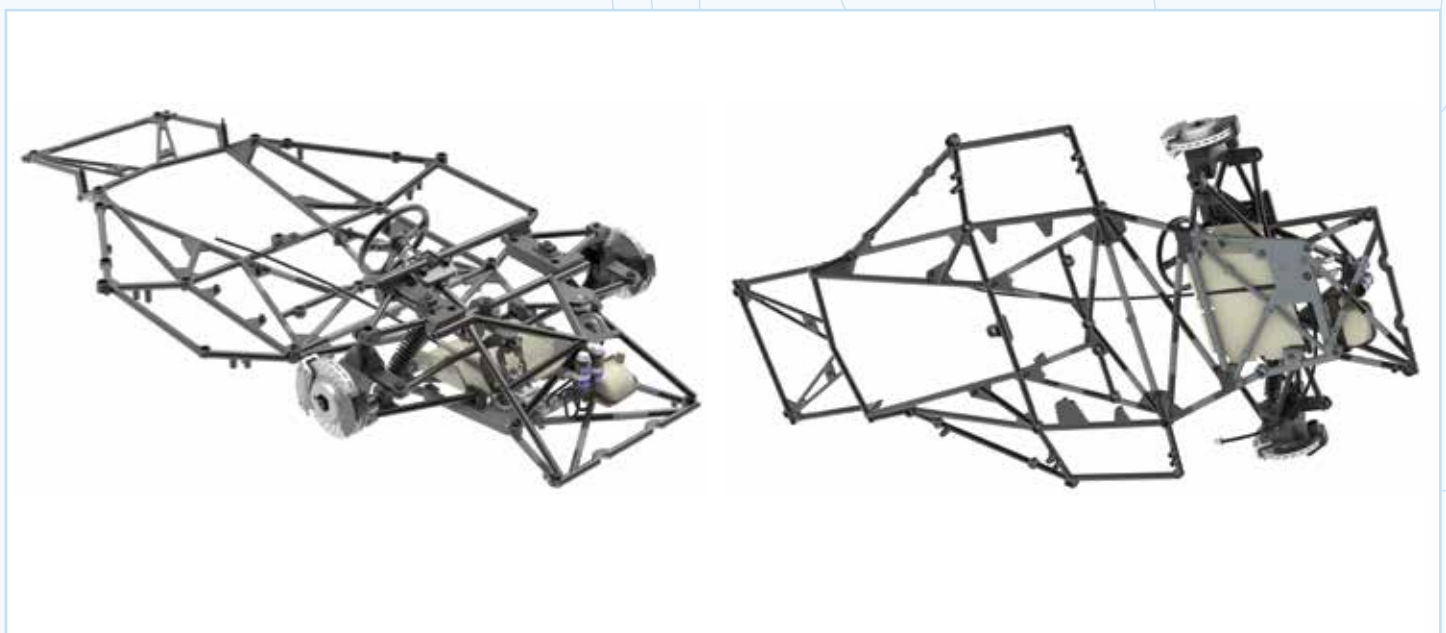
STEP 13

Attach the two 29K lower wishbone brackets to 25A lower chassis with two BM screws.



Front suspension and steering installed on the chassis

GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 31

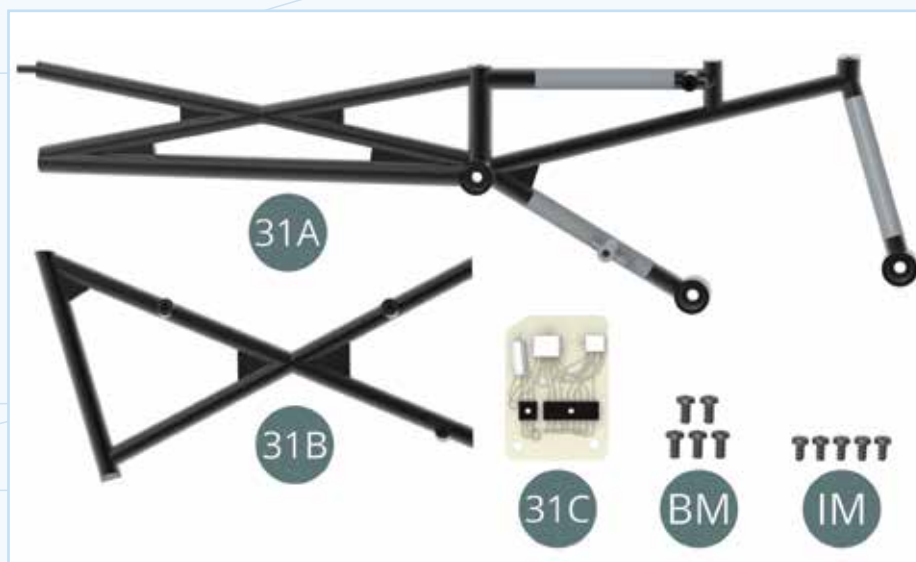
31A Chassis

31B Chassis

31C Wiring board

BM Screw M 2 x 4 mm (x 5)

IM Screw M 1.7 x 3.5 mm (x 5)



Assembly of the cockpit tubular mesh assembly on the chassis

ASSEMBLY DIAGRAM



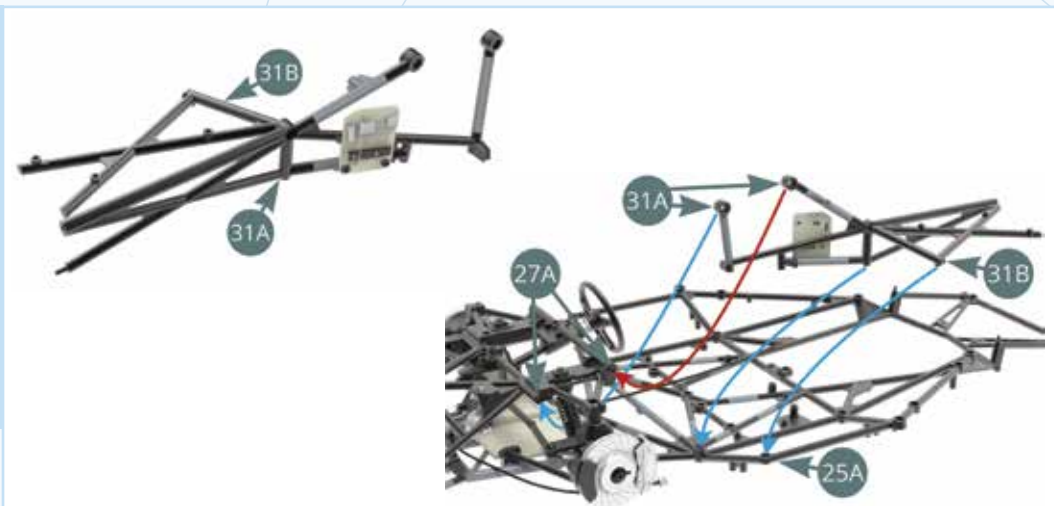
STEP 1

Position 31C wiring board on 31A chassis and secure it with two IM screws. Position 31B chassis on 31A chassis and fix it with an IM screw.



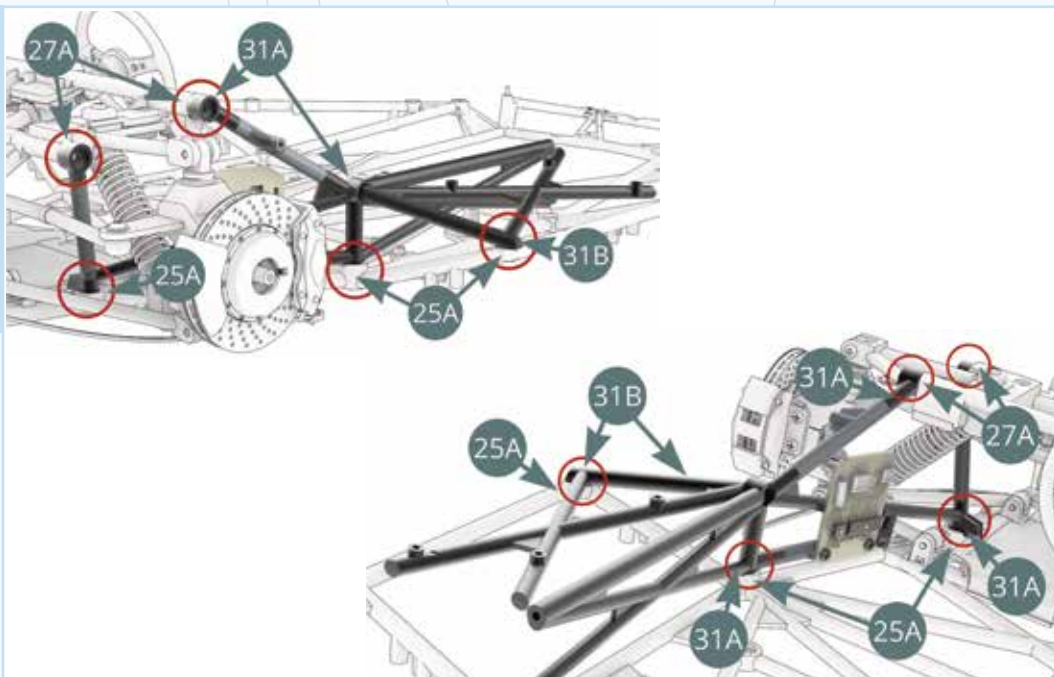
STEP 2

Install 31A-31B preassembly (illustration opposite) on 25A lower chassis and 27A dashboard frame (red arrow and blue arrows – see right hand illustration). Please check carefully the illustrations in the next step for a good understanding of the attachment points.



STEP 3

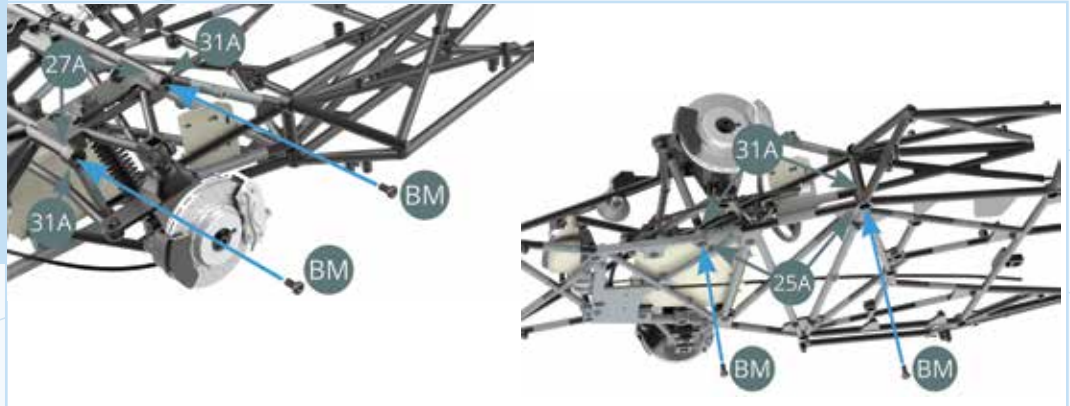
Locate the five attachment points (red circles) between 31A-31B chassis and 25A lower chassis assembly / 27A dashboard frame will be fixed with their respective screws as shown in the following two steps.





STEP 4

Secure 31A chassis to the 27A dashboard frame with two BM screws. Attach 31A chassis to 25A bottom chassis with two BM screws.

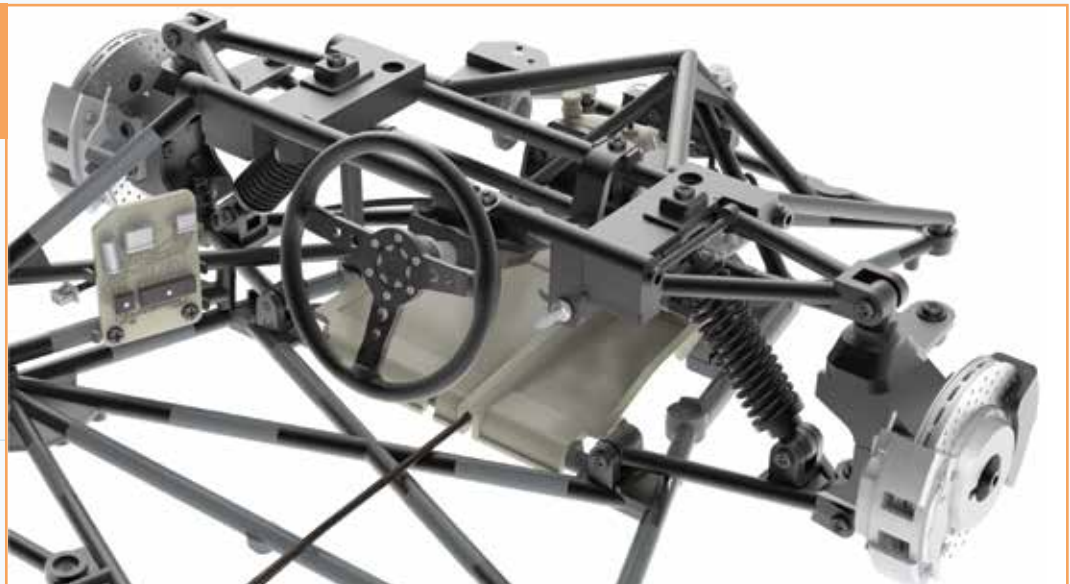


STEP 5

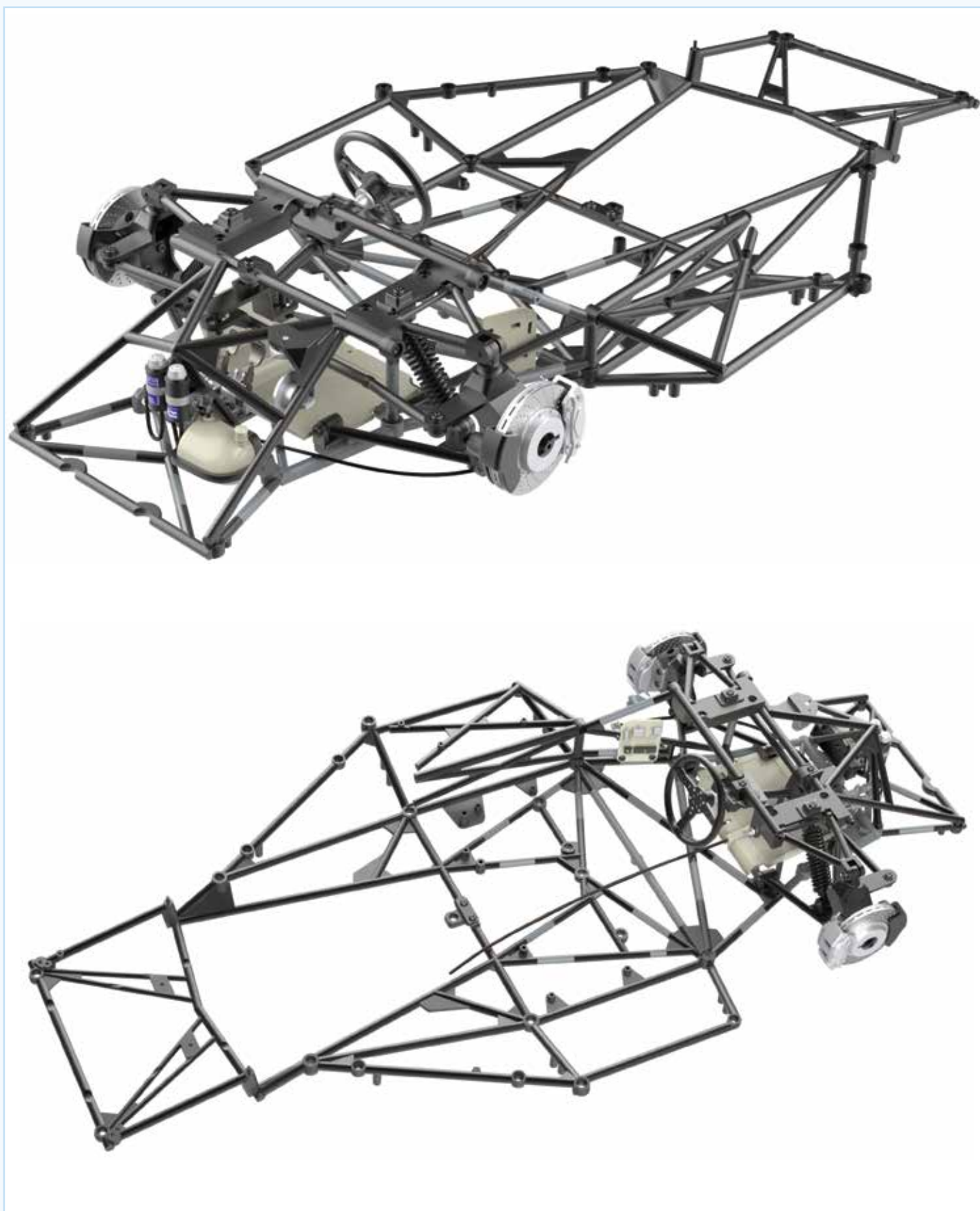
Secure the 31B chassis to the 25A lower chassis with an IM screw.



View of the tubular mesh assembly frame at cockpit level



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 32

32A Top panel

32B Left fuel tank

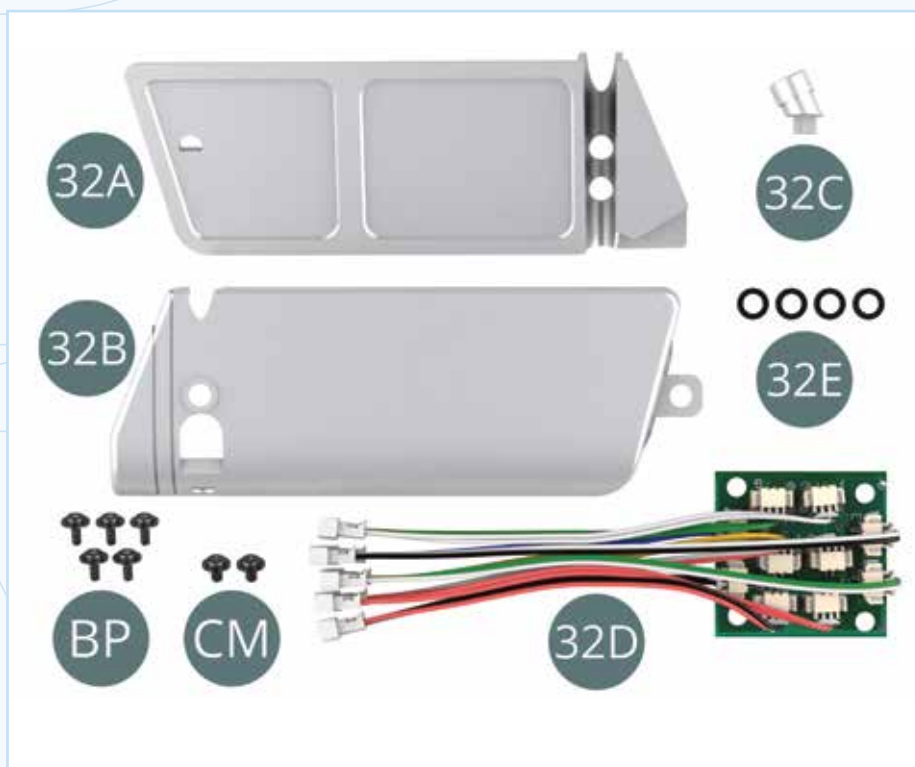
32C Filling pipe/neck

32D Printed circuit board with wires

32E Spacer washers

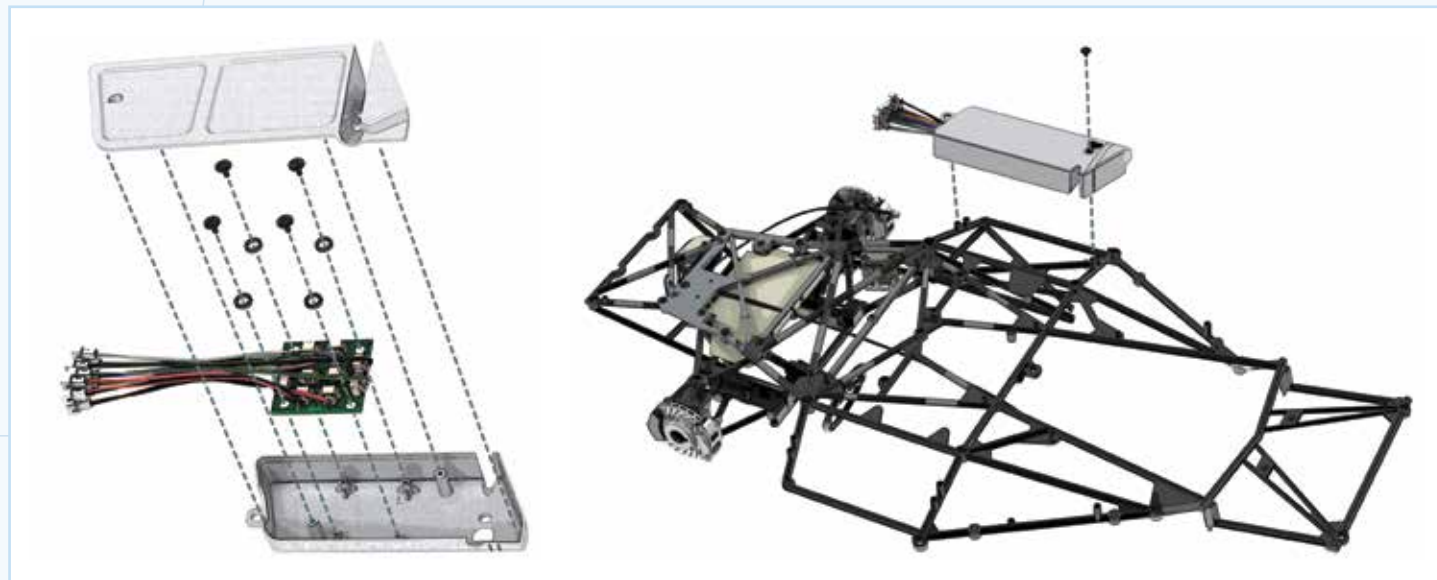
BP Screw M 1.7 x 4 x 5 mm (x 5)

CM Screw M 2.0 x 3 x 5 mm (x 2)



Installation of the left fuel tank and the printed circuit board

ASSEMBLY DIAGRAM



STEP 1

Position the 32D printed circuit board on the four pins located inside the 32B fuel tank, then place a washer above each of them (illustrations opposite).



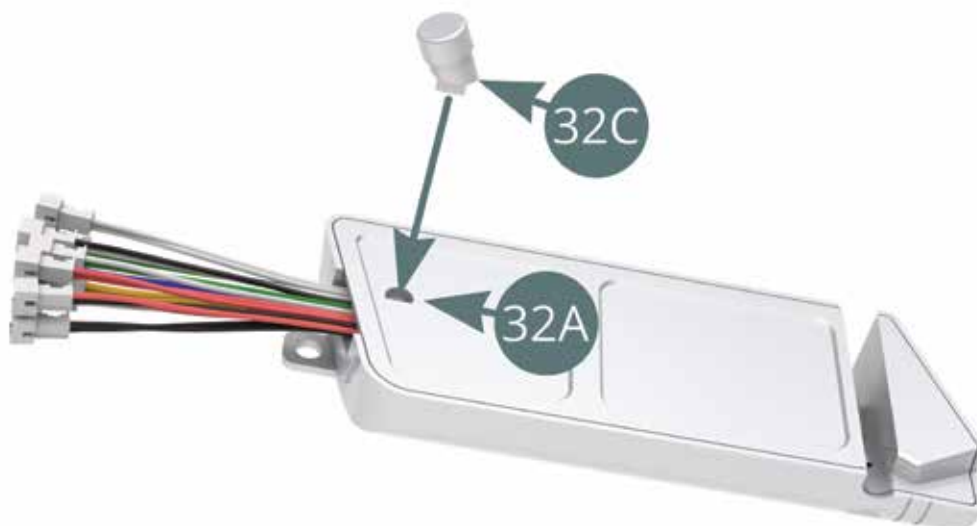
STEP 2

Attach the 32D PCB to the 32B fuel tank with four BP screws. Position 32A top panel on 32B fuel tank using the two pins (red arrows).



STEP 3

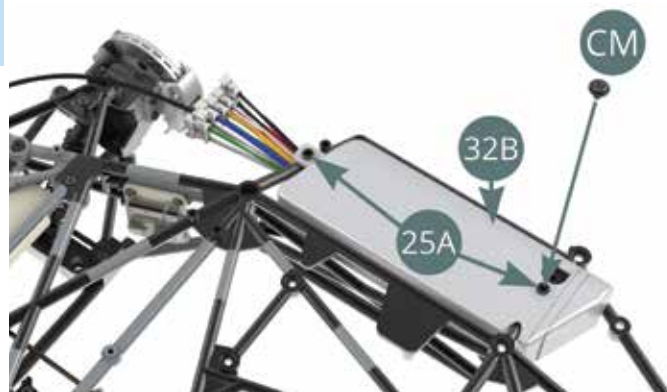
Position the 32C filling neck on the top panel of 32A left fuel tank.





STEP 4

Position 32B fuel tank on the lugs provided on 25A lower chassis and secure with a CM screw (illustrations opposite). Refer to the illustrations in the next step for the arrangement of the cables.

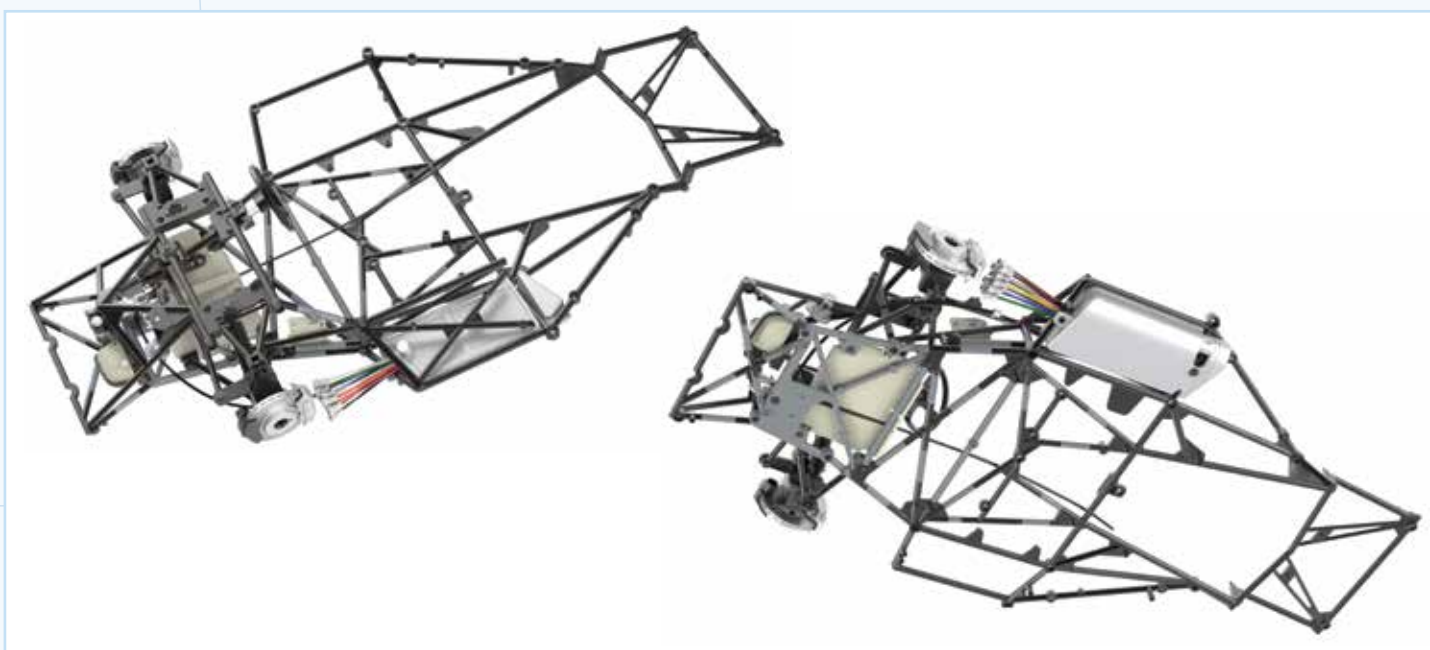


STEP 5

32D electrical wires must run between 25A lower chassis and 31B chassis as shown in the illustrations below.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 33

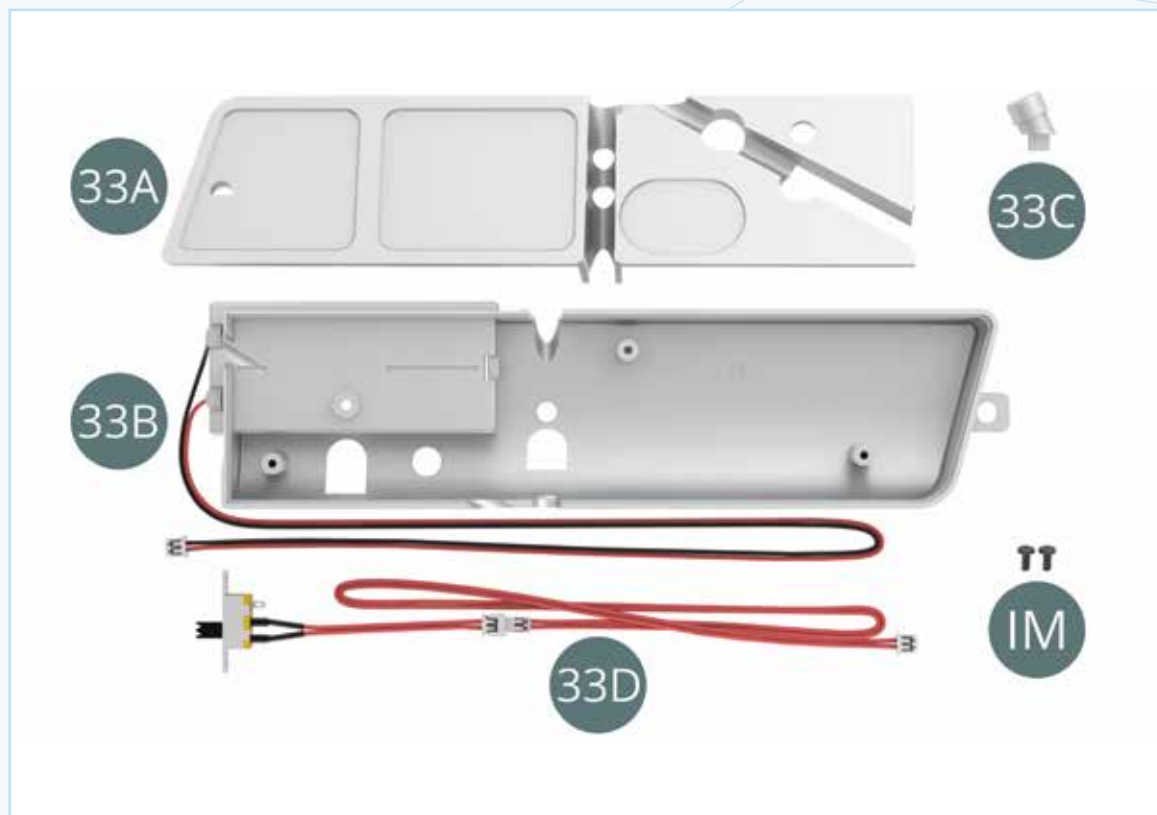
33A Top Panel

33B Right fuel tank

33C Filling neck

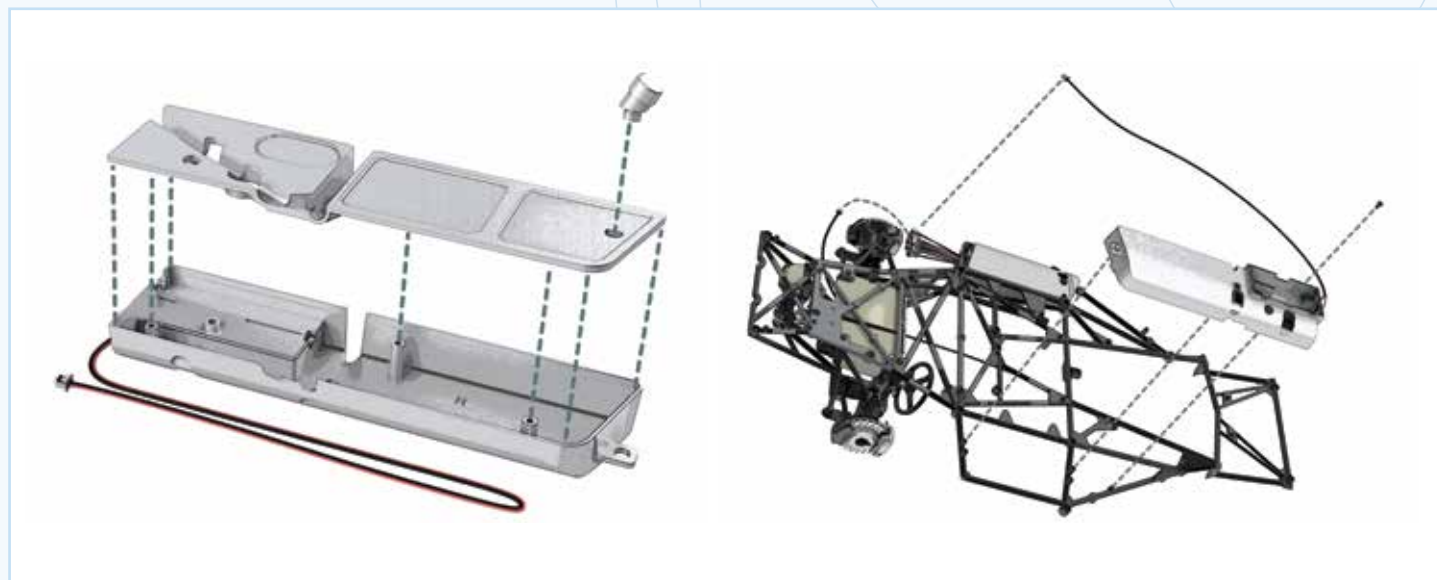
33D Switch cable (double red)

IM Screw M 1.7x 3.5 mm (x 2)



*Installation of
the right fuel
tank*

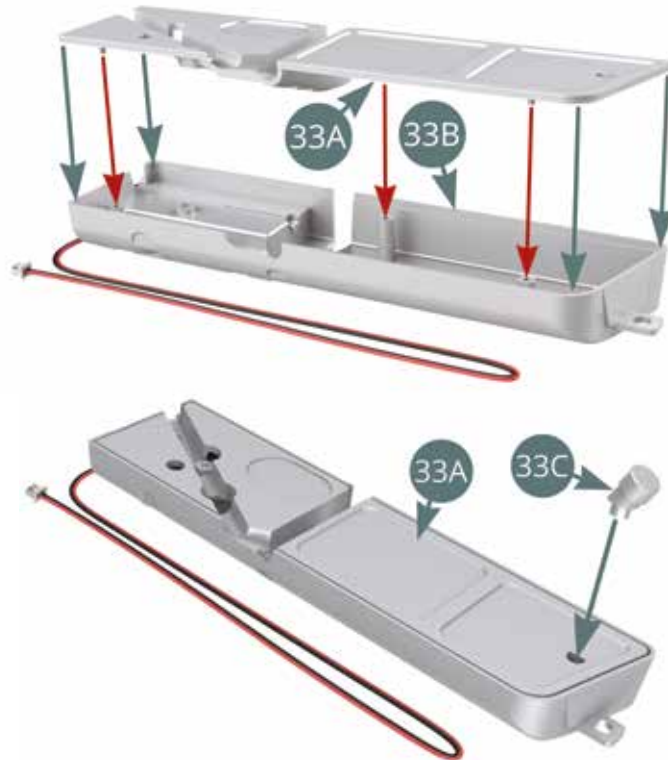
ASSEMBLY DIAGRAM





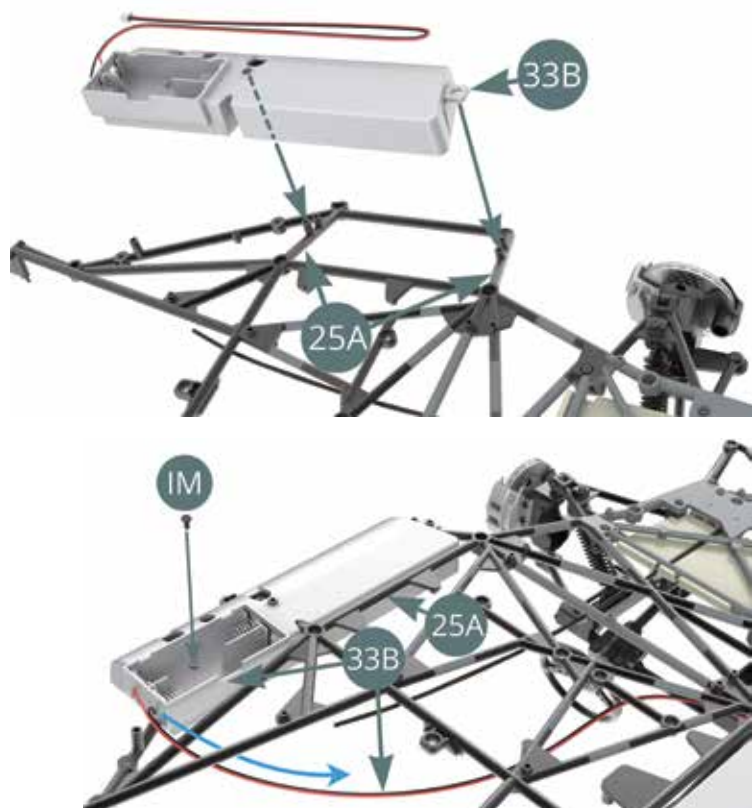
STEP 1

Position the top panel (33A) on the right fuel tank (33B) using the three pins (red arrows). Position the filling neck (33C) on the top panel (33A) of the right fuel tank.



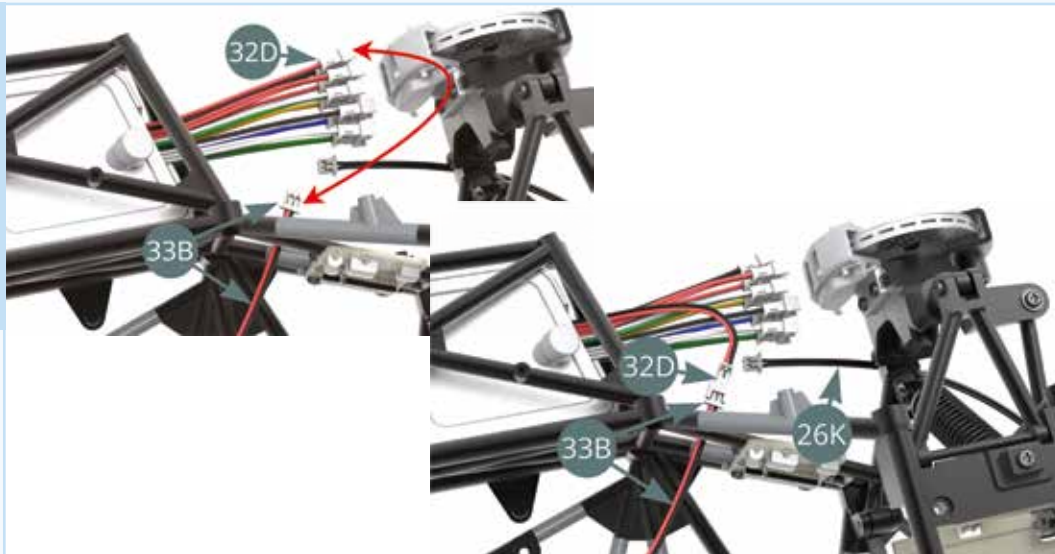
STEP 2

Position the right fuel tank (33B) on the lugs provided on the lower frame (25A) and secure with an IM screw (see illustrations). Route the red and black cable (33B) to the side of the upper part of the lower frame (25A) - blue arrow.



STEP 3

Connect the red and black cable (33B) - note its passage through the chassis tubes - to the socket of the red and black cable (32D) from the battery compartment (illustrations opposite).

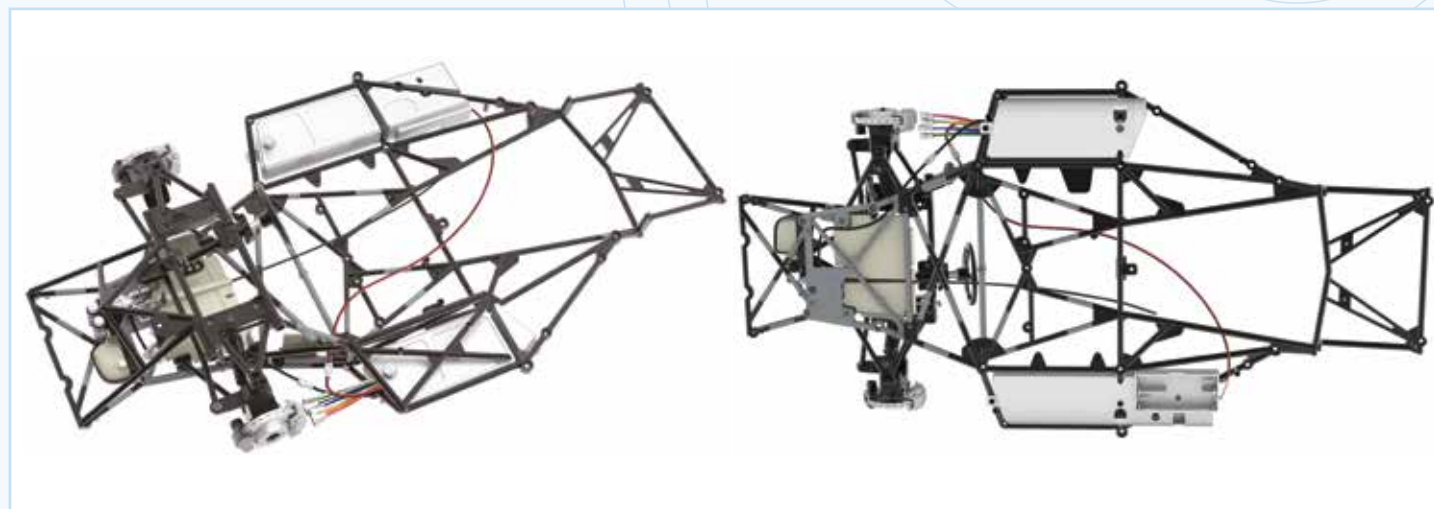


STEP 4

Guide the black double cable (26K) along the footrest (26A), then through the chassis tubes and plug it into the black twin cable socket of the battery compartment (32D) - illustrations opposite.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 34

34A Chassis

34B Chassis

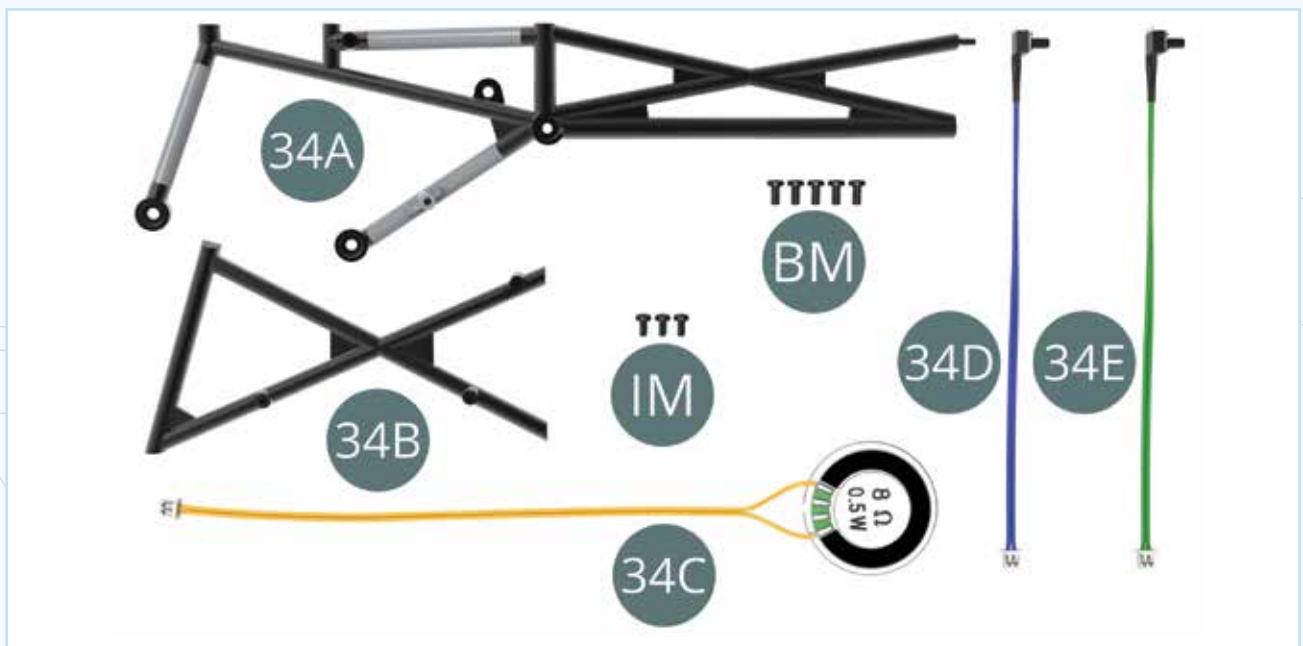
34C Speaker (yellow cable)

34D Engine Sound Switch (Blue Cable)

34E Horn Switch (Green Cable)

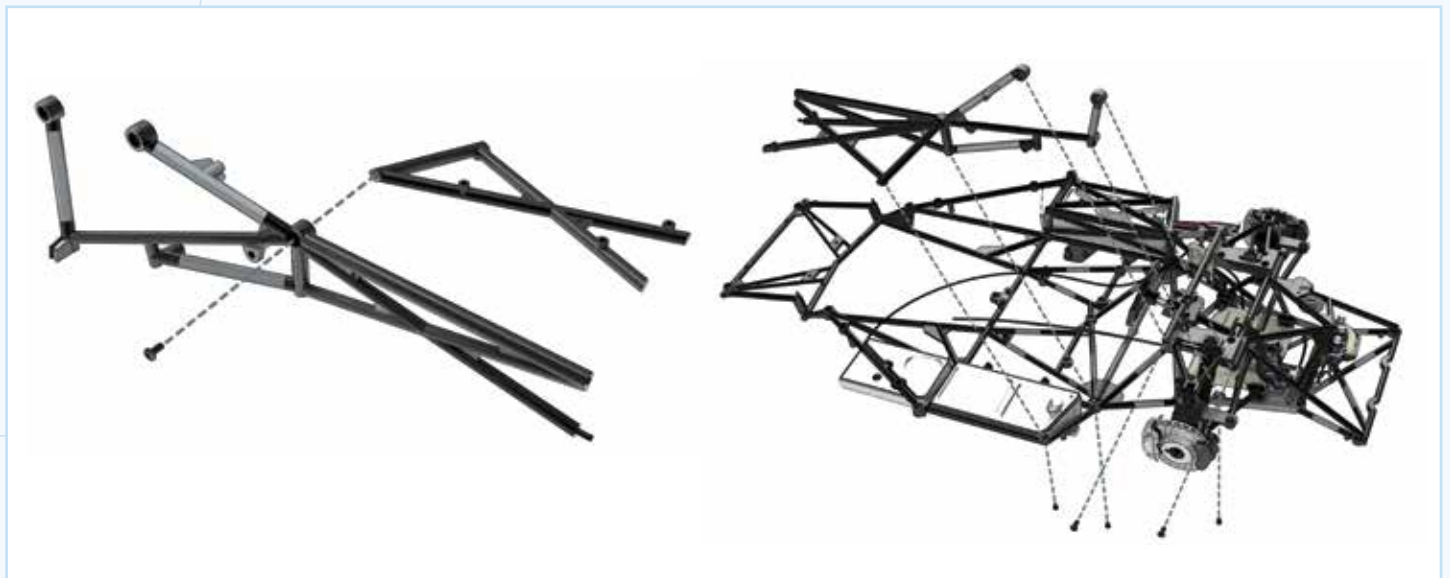
BM Screw M 2.0 x 4 mm (x 5)

IM Screw M 1.7 x 3.5 mm (x 3)



Assembly of the cockpit tubular mesh to the frame - Elements 34C, 34D and 34E will be used in future assemblies

ASSEMBLY DIAGRAM



STEP 1

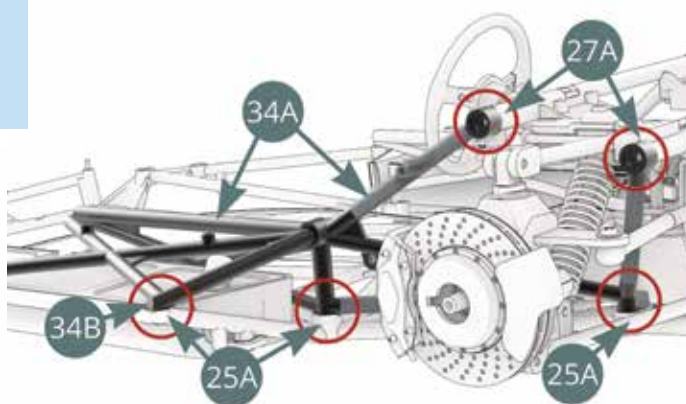
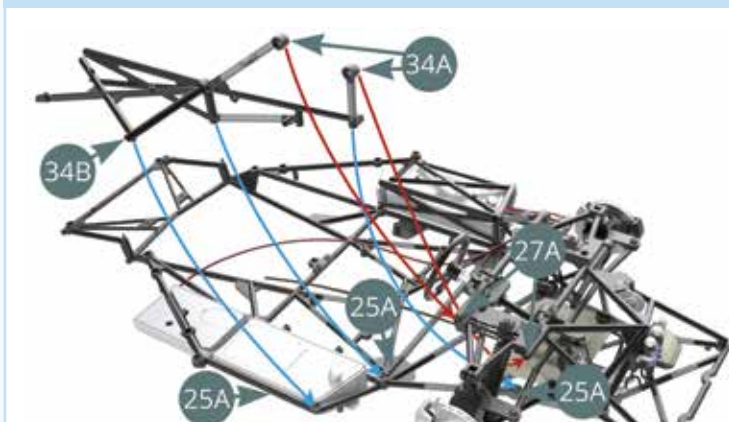
Assembly of the cockpit tubular mesh to the frame - Elements 34C, 34D and 34E will be used in future assemblies



Preassembled 34A-34B chassis

STEP 2

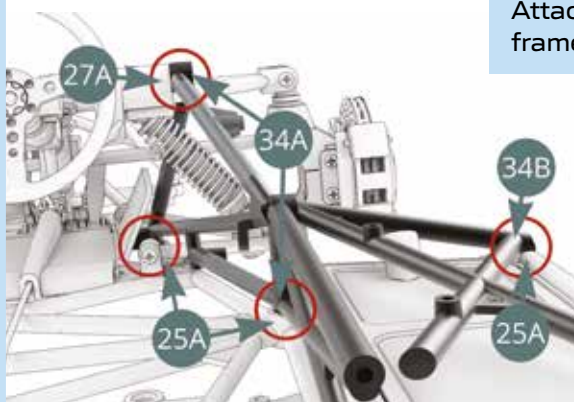
Position the preassembled chassis (34A-34B) - previous illustration - on the lower chassis (25A) and the dashboard frame (27A) - red and blue arrows.



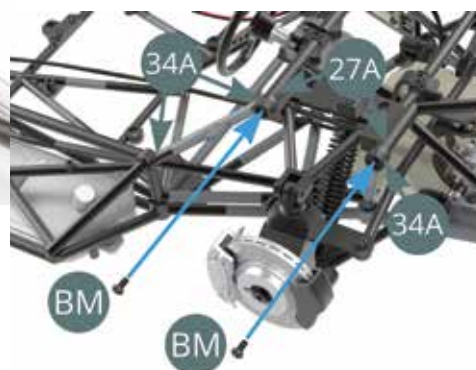
For a good understanding of the connection points, carefully study the following two illustrations.

STEP 3

Identify the connection points (red circles) between the preassembled chassis (34A-34B) and the lower frame assembly (25A) / frame of the dashboard (27A). The fixation of these points must be ensured by the respective screws as indicated in the following three illustrations.



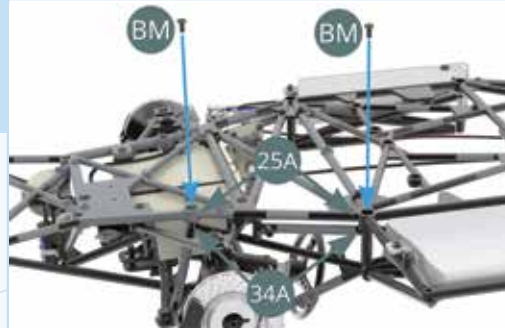
Attach the chassis (34A) to the dashboard frame (27A) with two BM screws.





STEP 4

Attach the chassis (34A) to the lower frame (25A) with two BM screws.



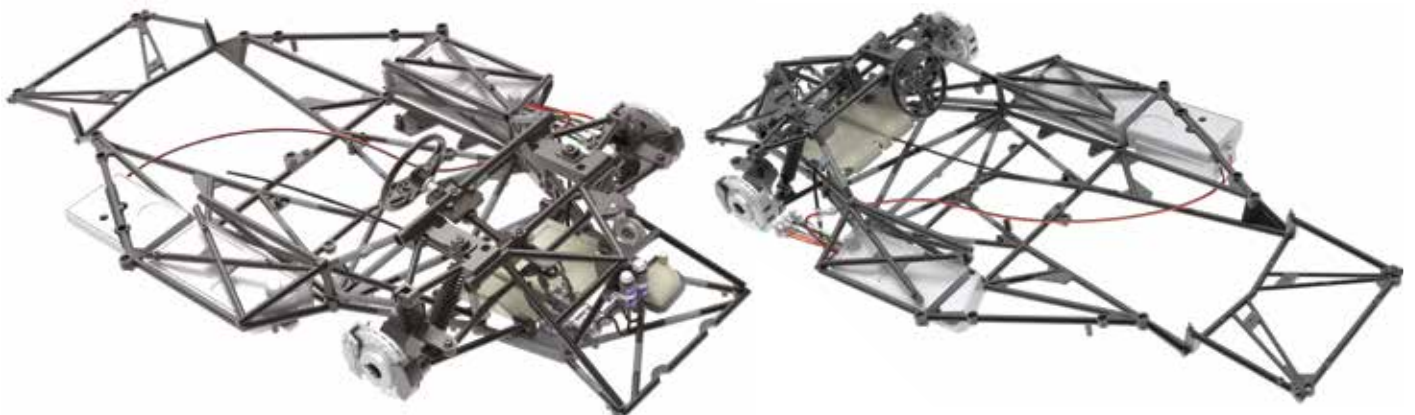
Attach the chassis (34B) to the lower frame (25A) with two IM screws.

STEP 5

The assembly of the preassembled frame (34A-34B) on the lower frame (25A) is completed.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 35

35A Left mudguard

35B Right mudguard

35C Washer

35D Left brake hose

35E Right Brake Hose

35F LED Cable Headlight (White-Green)

35G LED Cable Taillights (Black-White)

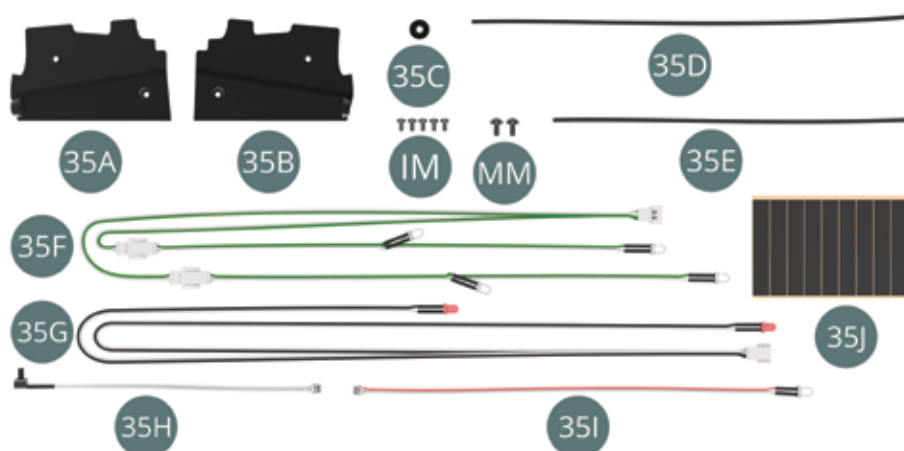
35H Light switch cable (white)

35I Instrument Backlight LED Cable (Red-White)

35J Adhesive tape (x 6)

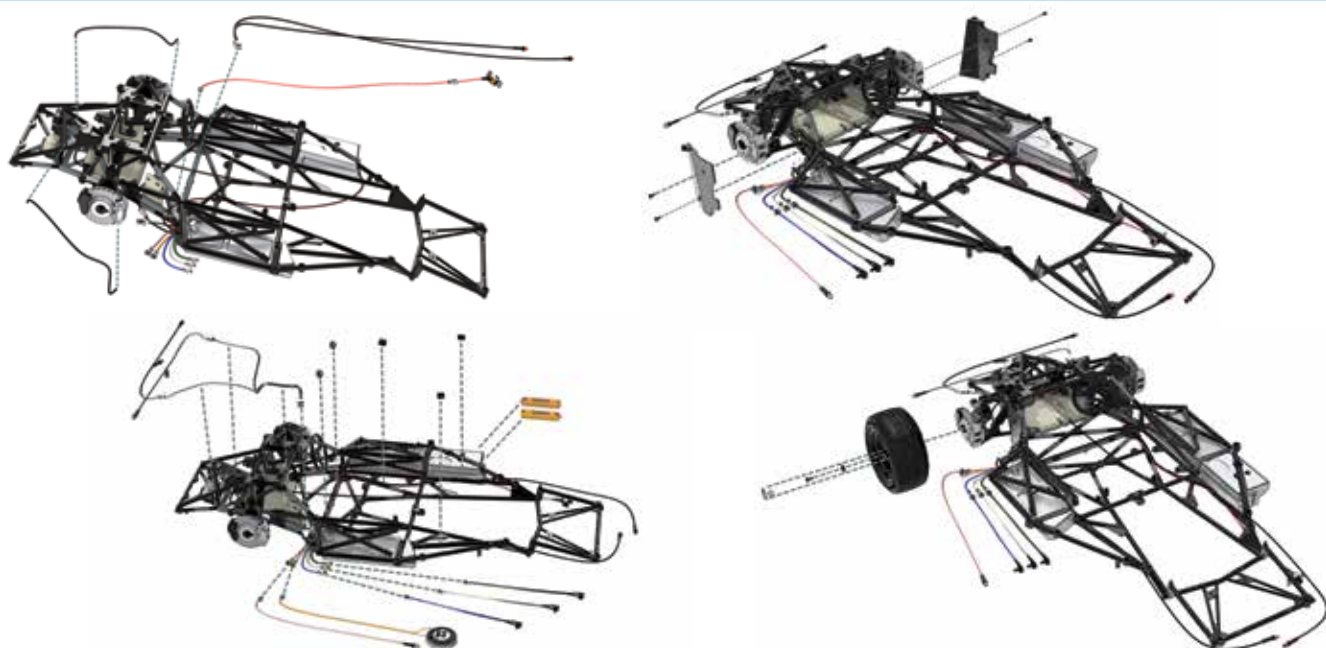
IM Screw M 1.7 x 3.5 mm (x 5)

MM Screw M 2 x 4 x 5mm (x 2)



Installation of electrical cables and functional test. Mounting of the mudguards and the left front wheel

ASSEMBLY DIAGRAM





STEP 1

The illustration on the right shows the installation of the right (35E) and left (35D) brake hoses that will be carried out in the following four steps.



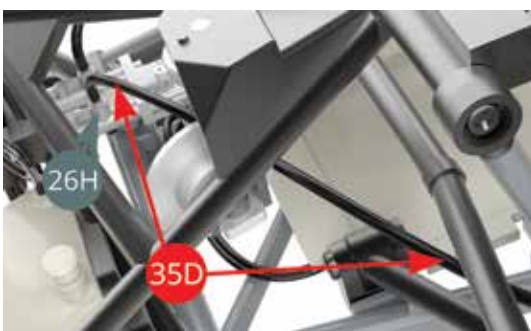
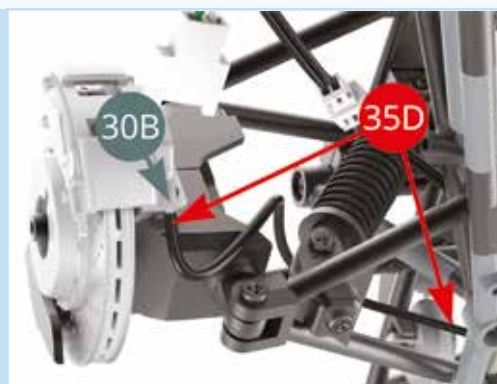
STEP 2

Position the right brake hose (35E) on the nipple located under the brake piston cover (30B). Guide the other end of the hose (35E) towards the master cylinder (26H) and attach it to the master cylinder (26H) - illustrations opposite.



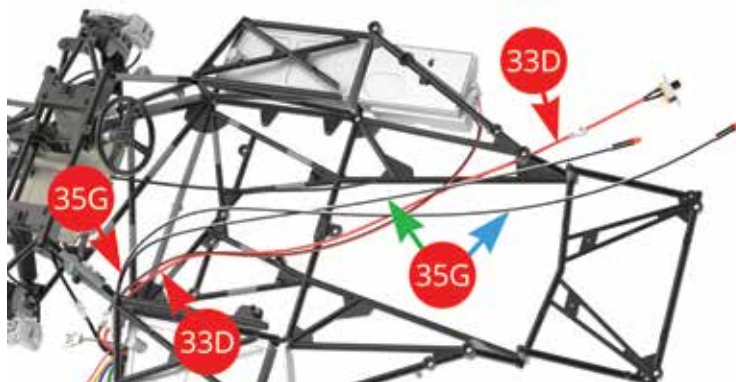
STEP 3

Position the left brake hose (35D) on the nipple located under the brake piston cover (30B). Guide the other end of the hose (35D) towards the master cylinder (26H) and attach it to the master cylinder (26H) - illustrations opposite.



STEP 4

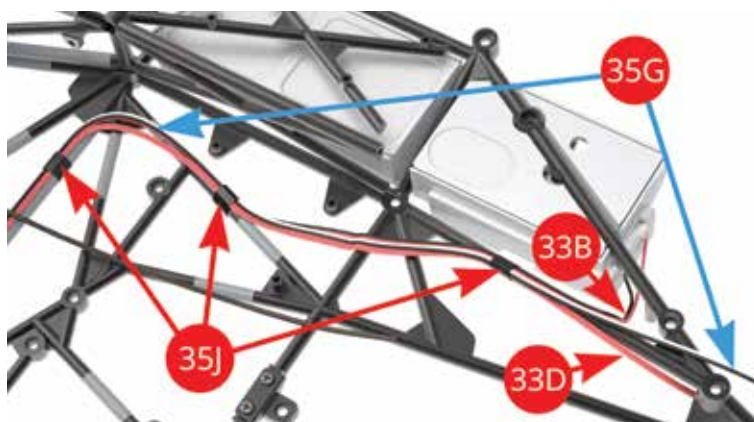
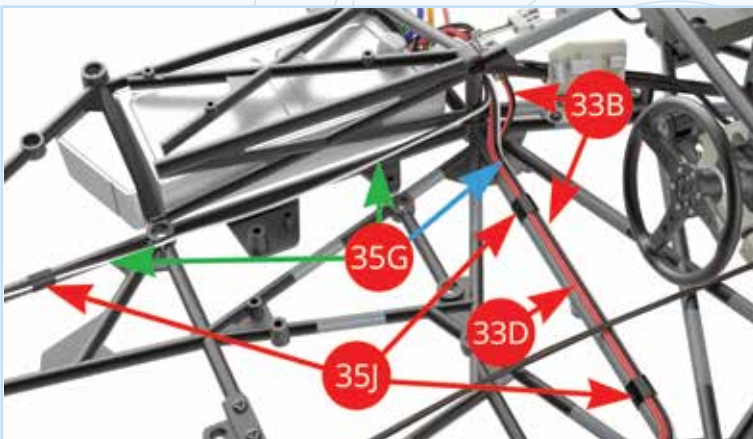
Connect the tail light LED cable / black-white (35G) and the switch cable / red (33D) to the same colour cables on the circuit board (32D).



Carefully identify the longest (blue arrow) and shortest (green arrow) of the tail light LED cables / black-white (35G) in the illustration above.

STEP 5

Guide the right fuel tank cable / black-red (33B), the switch cable / red (33D) and the longer (blue arrow) tail light LED cable / black-white (35G) along the right side of the frame, then tape them together on the main frame tube with two pieces of tape (35J). Guide the shorter tail light LED cable / black-white (35G) - green arrow - along the left side of the chassis, then tape it to the main frame tube with one piece of tape (35J).

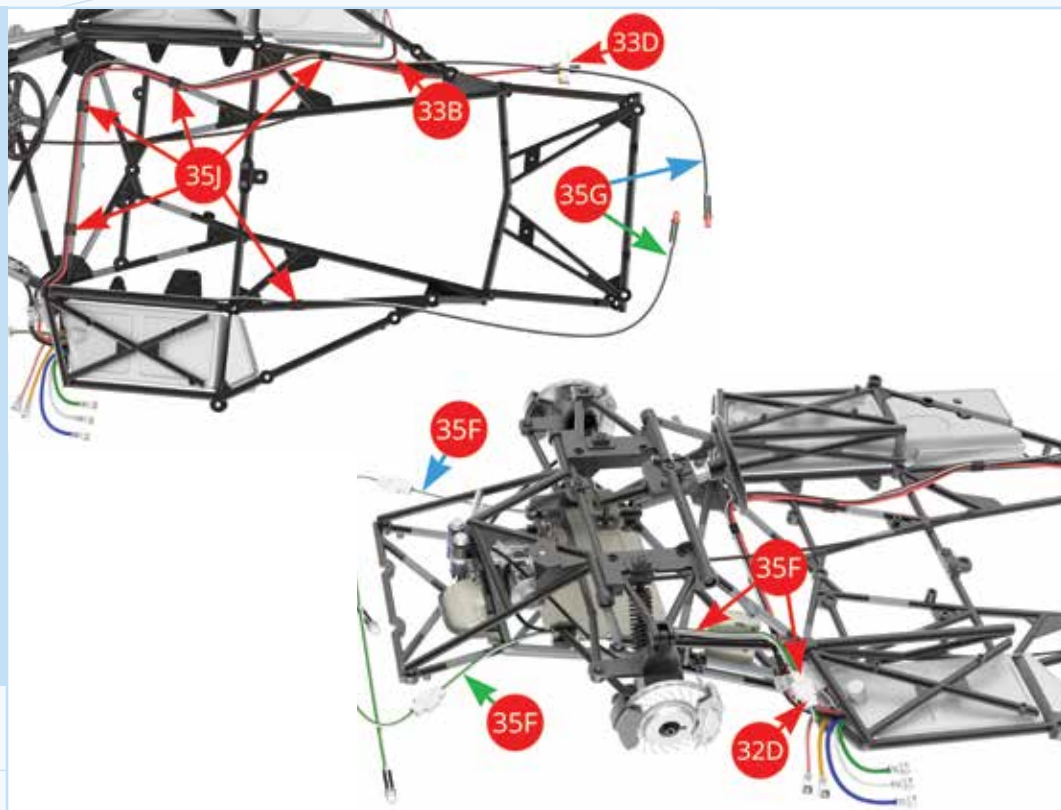


Attach the right fuel tank cable / black-red (33B), the switch cable / red (33D) and the longer (blue arrow) tail light LED cable / black-white (35G) to the right side of the frame with two more pieces of tape (35J).



STEP 6

The right fuel tank cable / black-red (33B), the switch cable / red (33D) and the tail light LED cable / black-white (35G) are installed on the chassis. Connect the headlight LED cable / white-green (35F) and the cable of the same colour from the circuit board (32D). Identify the longest (blue arrow) and shortest (green arrow) of the headlight LED cables (35F), their positioning is specified in the detailed view in the next step.



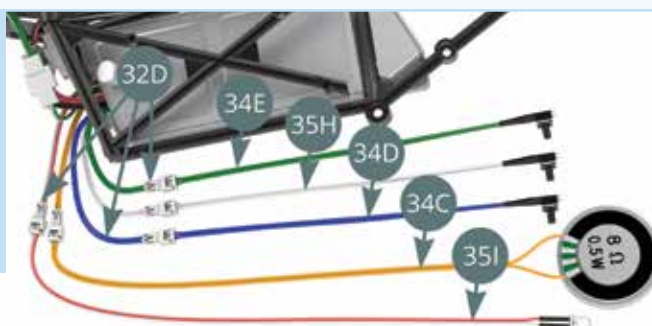
STEP 7

Identify the passage to the right of the longest (blue arrow) and to the left of the shorter (green arrow) of the headlight LED cables / white-green (35F) in the illustrations opposite.

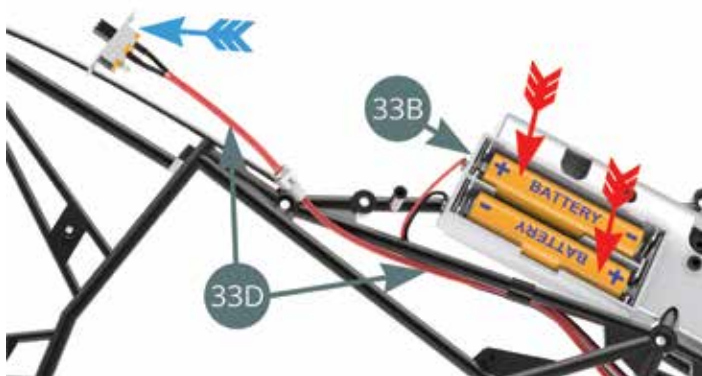


STEP 8

Connect the horn switch cable / green (34E), the light switch cable / white (35H), the engine sound switch cable / blue (34D), the speaker cable / yellow (34C) and the instrument light LED cable / red-white (35I) to the same coloured cables on the circuit board (32D).

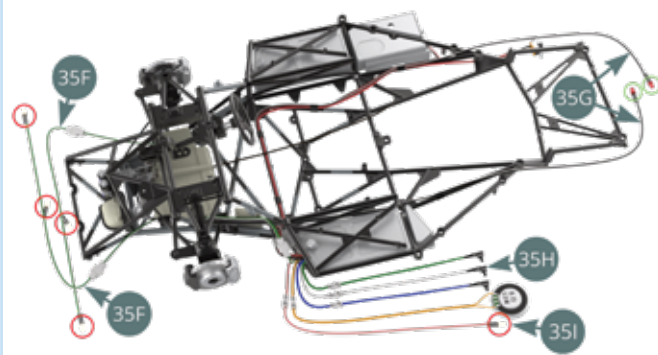


Place two AAA batteries (not supplied) in the battery compartment / red arrows (33B). Turn switch 33D to the 'on' position (blue arrow).



STEP 9

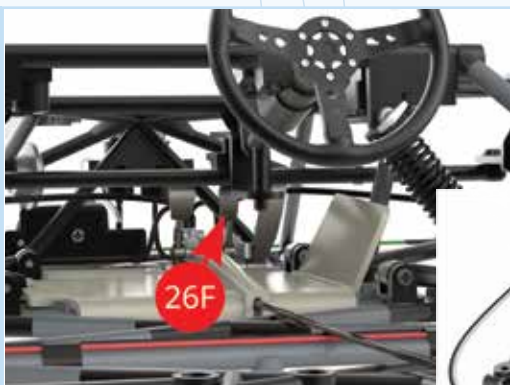
Turn on the horn switch / green wire (34E) to hear it through the speaker (34C). Turn on the engine sound switch / blue wire (34D) to hear it through the speaker (34C).



Reduce the ambient light for better effect, then operate the lighting switch / white lead (35H) to observe the illumination of the headlight LEDs (35F), the instrument panel backlight LEDs / red circles (35I) illuminating in white and taillight LEDs / green circles (35G) glowing red.

STEP 10

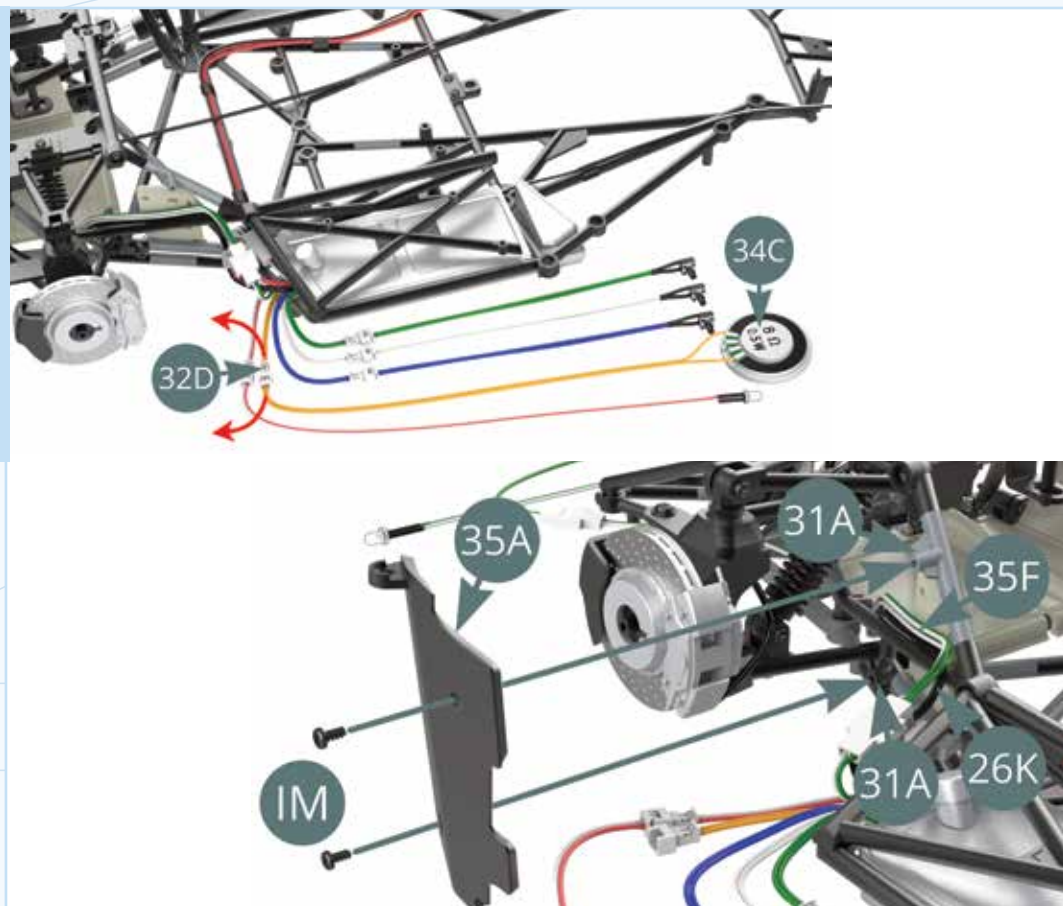
Press the middle pedal (26F) and observe the red lighting of the brakes on the tail light LEDs (35G) / illustrations opposite). After having tested the operation of all the lights, turn the switch (33D) to the 'off' position (red arrow).





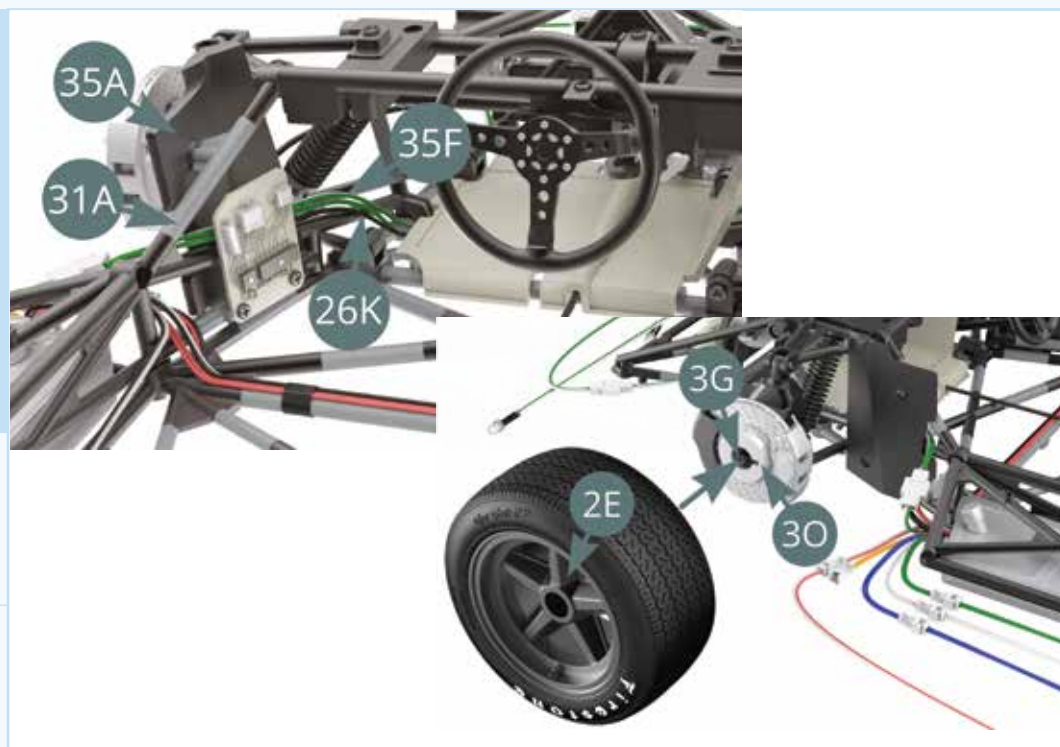
STEP 11

Disconnect the yellow speaker cable (34C) from the yellow circuit board cable (32D) so as not to damage it during the following assembly steps. Position the left mud-guard (35A) on the chassis (31A) - hidden behind the 35F and 26K cables - and secure it with two IM screws.



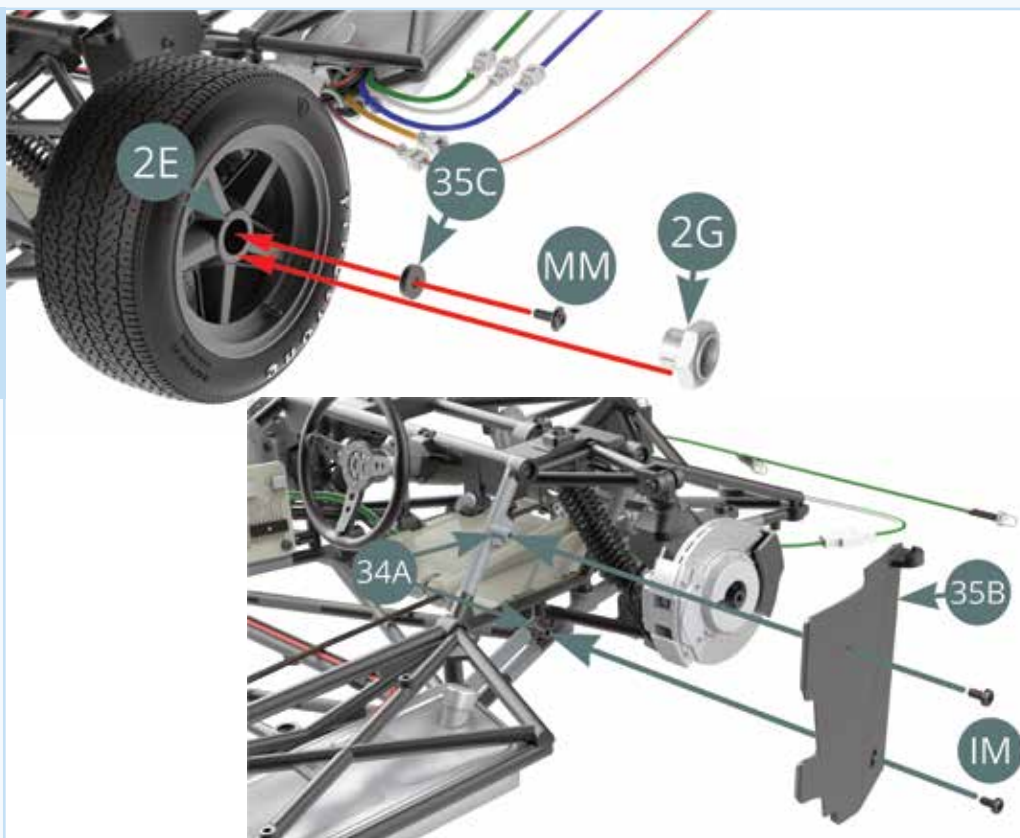
STEP 12

Check the correct positioning of the 35F (green-white) and 26K (black) cables after mounting the left mud-guard (35A). Position the left front wheel rim (2E) on the hub carrier axle (3G) by turning it gently until it engages in the notch on the outer brake disc (30).

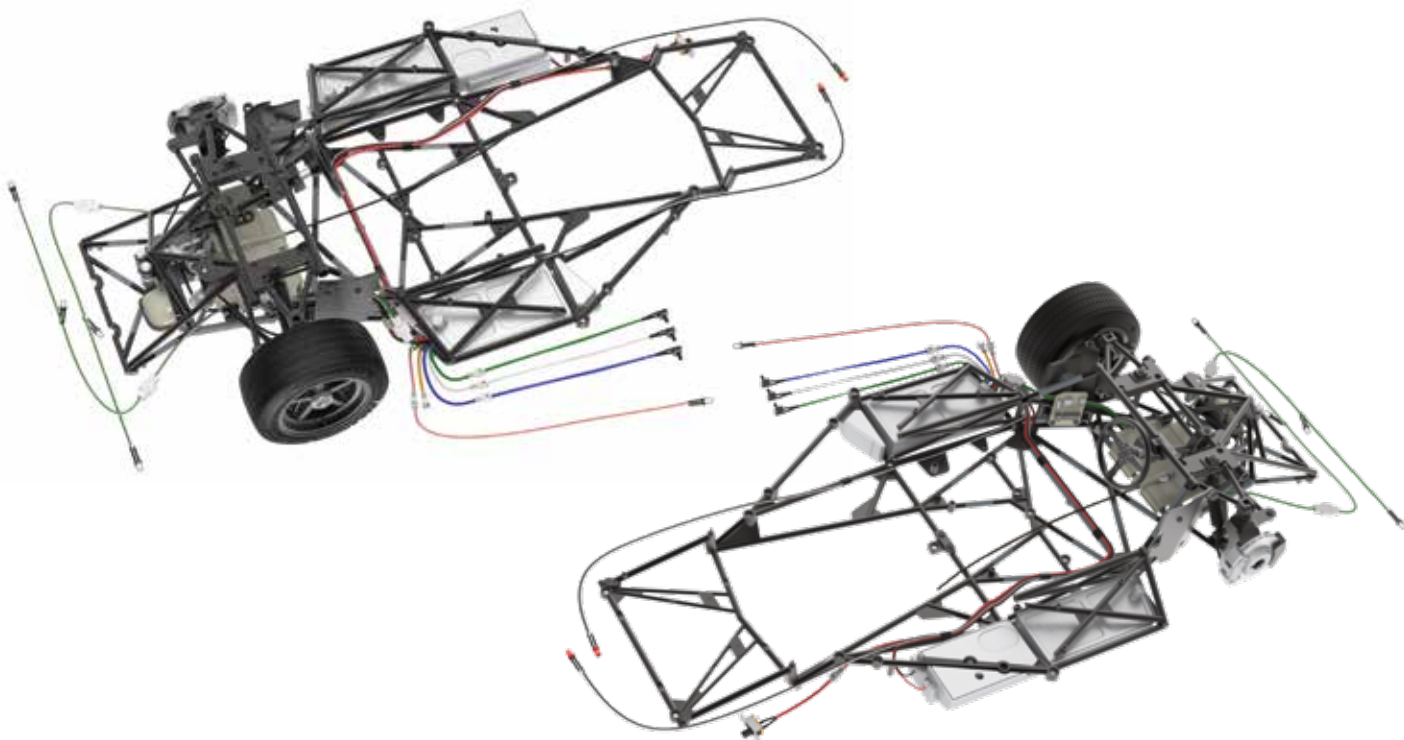


STEP 13

Attach the wheel rim (2E) with an MM screw by first passing it through the washer (35C). Position the hub cap (2G) on the wheel rim (2E). Position the right mudguard (35B) on the chassis (34A) and fix it with two screws IM.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 36

36A Front tyre

36B Front wheel outer rim

36C Front wheel inner rim

36D Hub Cover

36E Washer

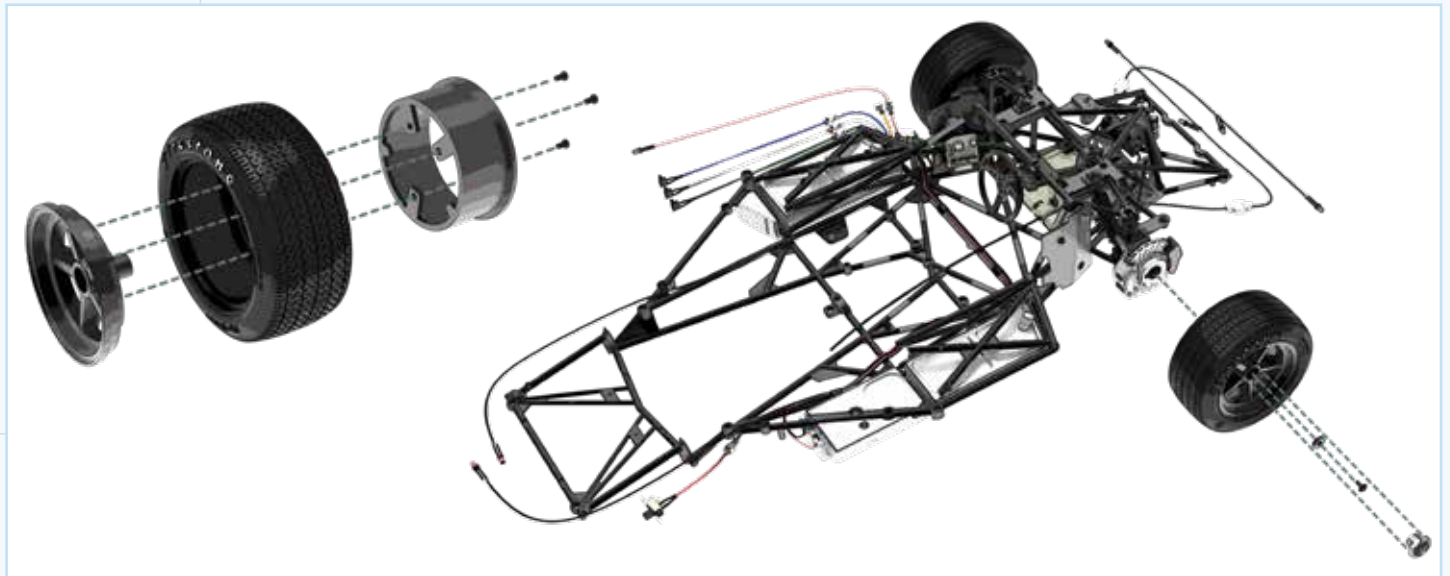
MM Screw M 2 x 5 x 5mm (x 2)

BM Screw M 2 x 34 mm (x 4)



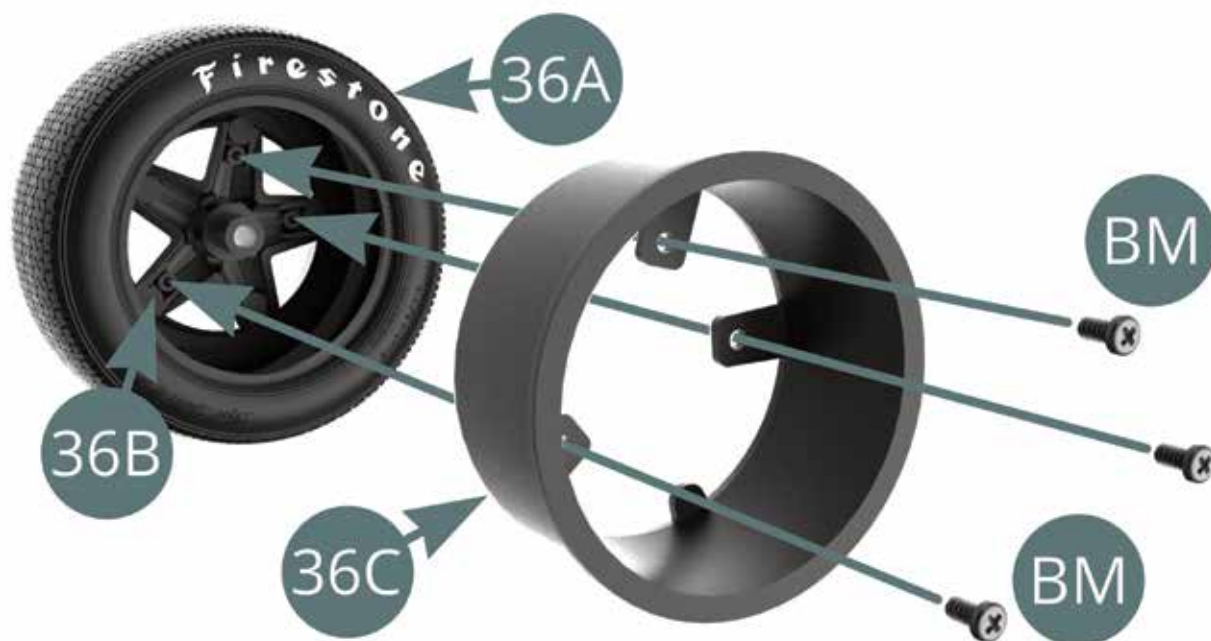
Assembly and installation
of the right front wheel

ASSEMBLY DIAGRAM



STEP 1

Position the outer rim (36B) on the front tyre (36A).

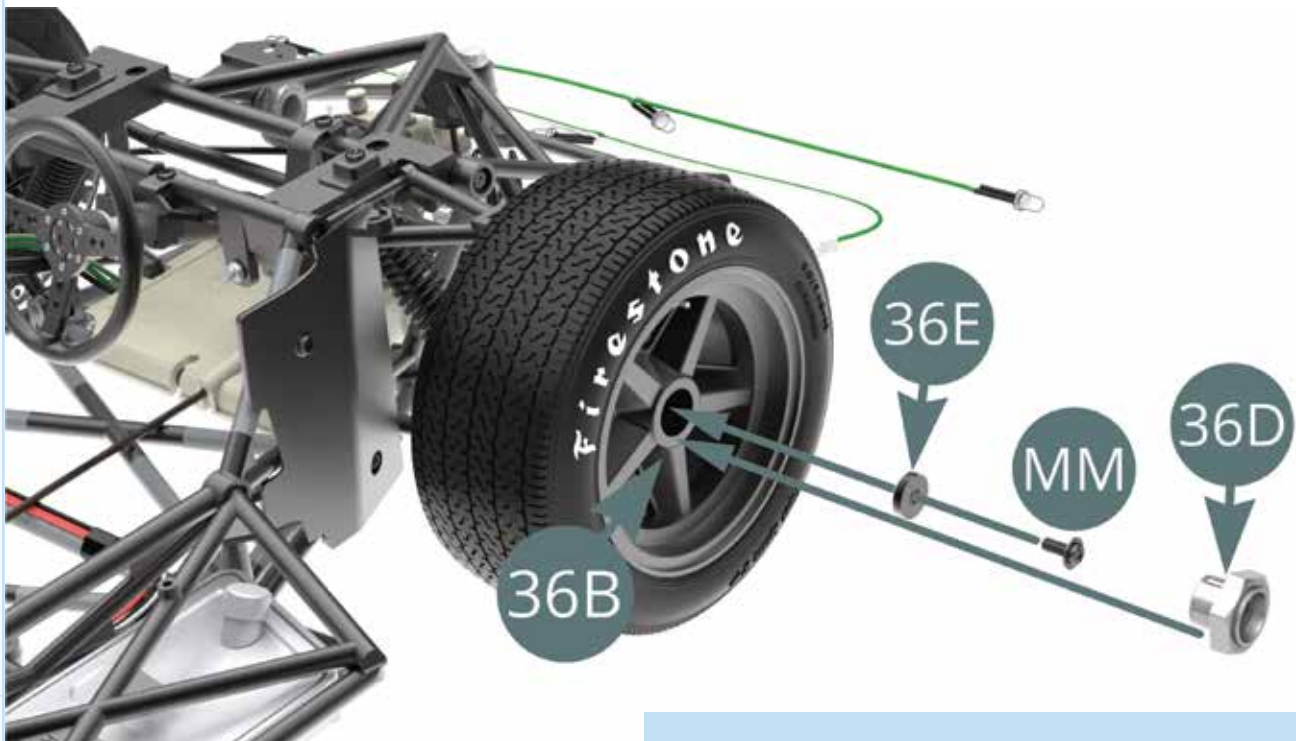
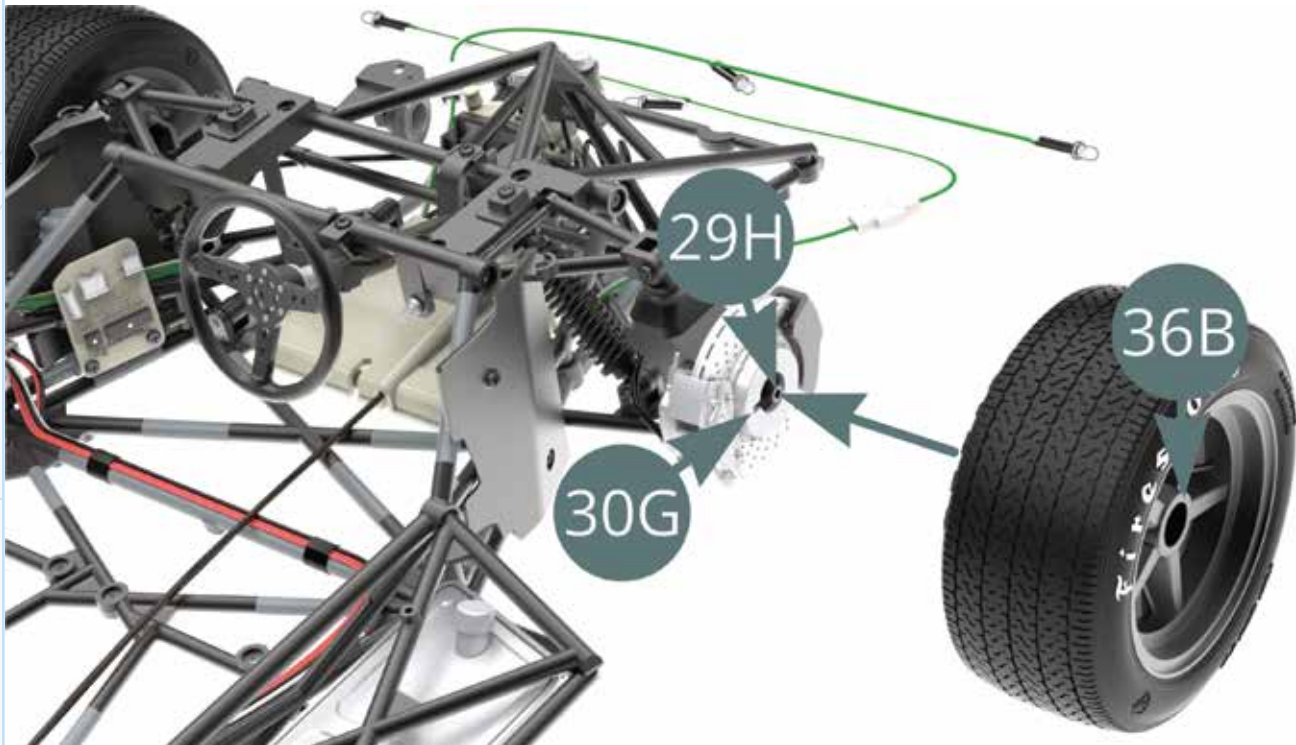


Position the inner rim (36C) on the front tyre (36A) and secure it to the outer rim (36B) with three BM screws.



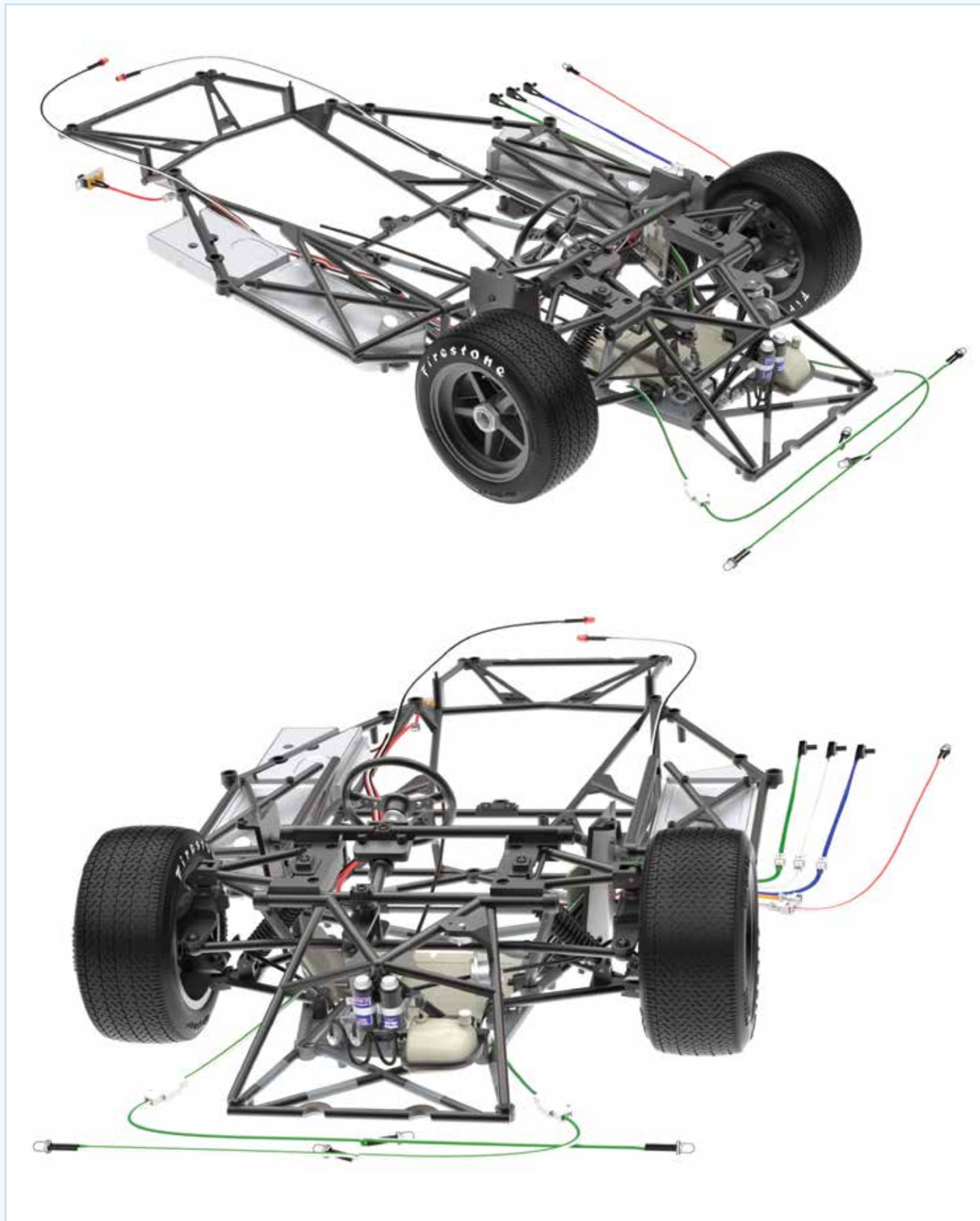
STEP 2

Position the rim of the left front wheel (36B) on the axle of the hub carrier (29H) by turning it gently until it engages the notch in the outer brake disc (30G).



Attach the front outer wheel rim (36B) with an MM screw by first passing it through the washer (36E). Position the 36D hub cover (36D) on the wheel rim (36B).

GENERAL VIEW





Assembly guide

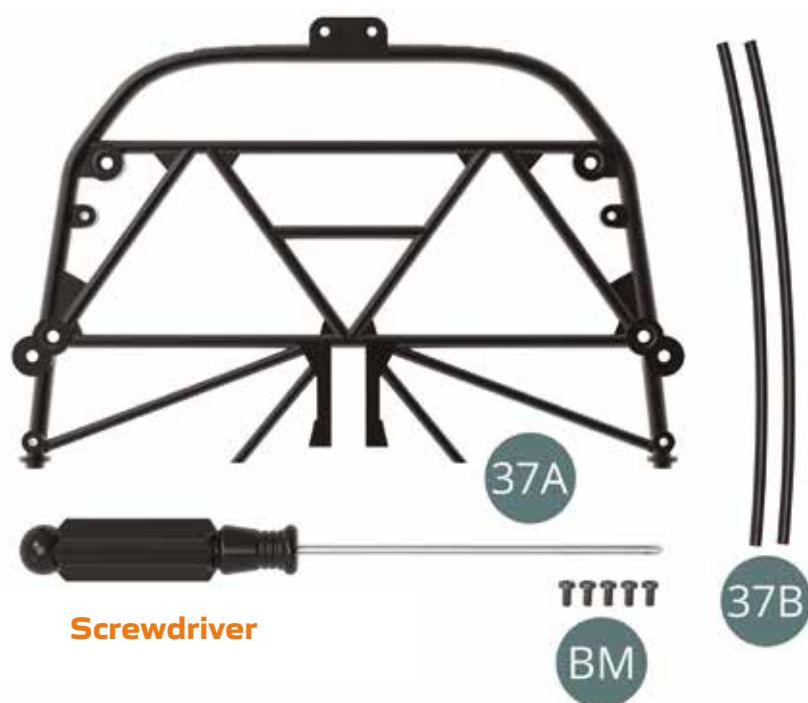
PARTS OF THE ISSUE 37

37A Cockpit partition frame

37B Oil hose (x2)

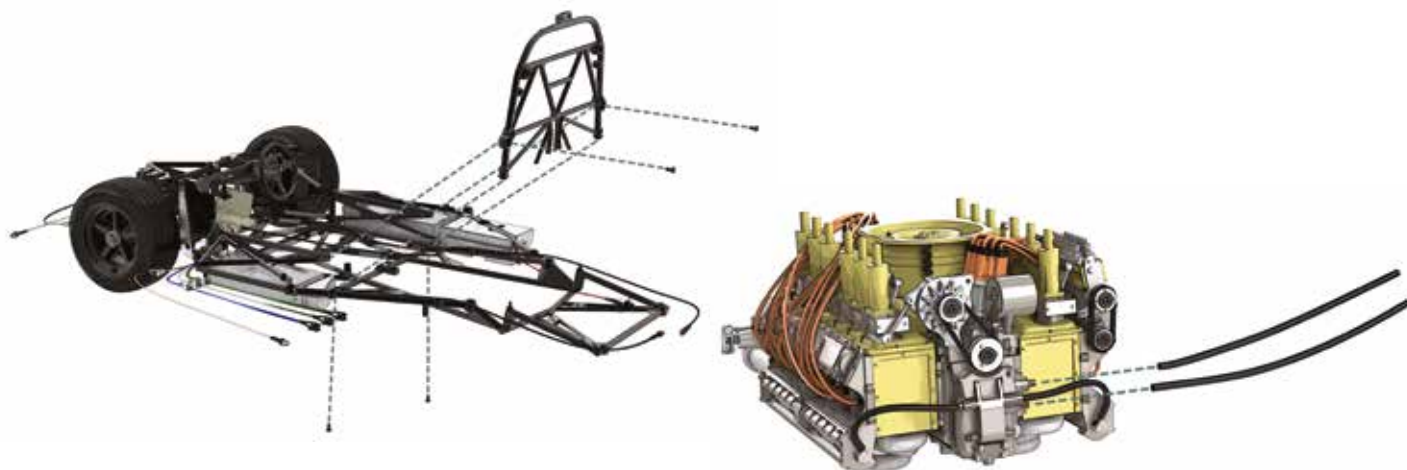
Screwdriver

BM screw M 2,0 x4mm (x5)



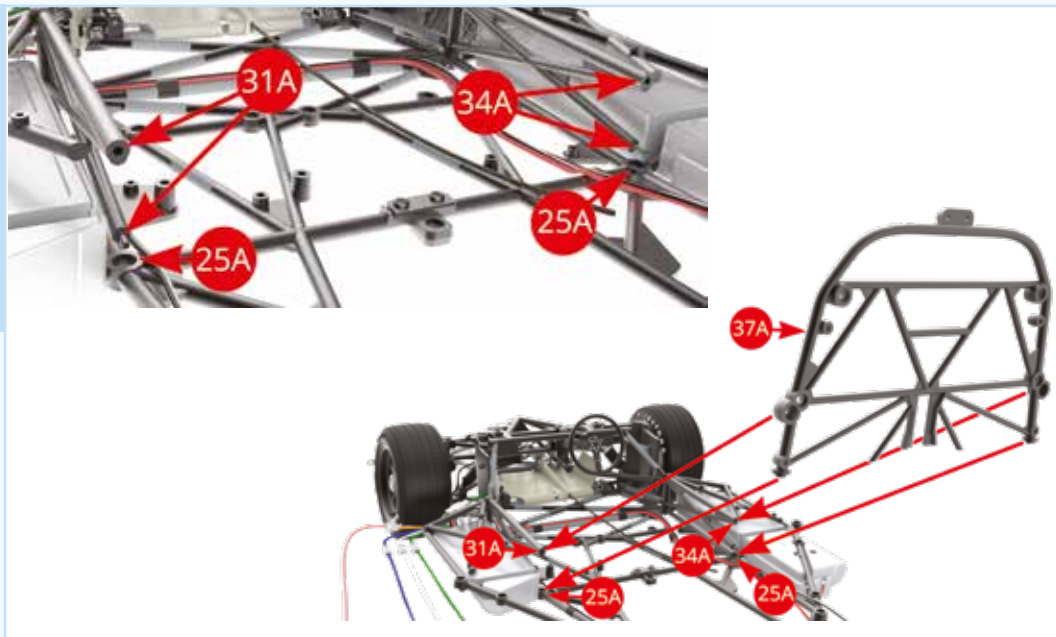
Cockpit
partition frame
and oil hoses
installation on
the engine

ASSEMBLY DIAGRAM



STEP 1

Fit 37A Cockpit partition frame to 25A Chassis lower frame sockets and 31A Left, 34A Right Side frames. Illustration below shows the attachment points on chassis in closer detail.



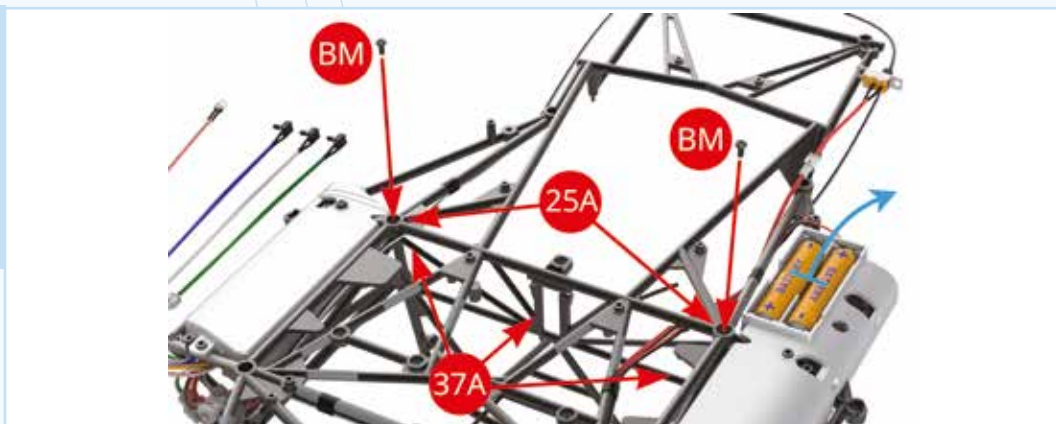
STEP 2

Fix 37A Cockpit partition frame to 31A Left and 34A Right Side frames with two BM screws.



STEP 3

Fix 37A Cockpit partition frame to 25A Chassis lower frame with two BM screws. Take two AAA batteries out of battery compartment until further use.





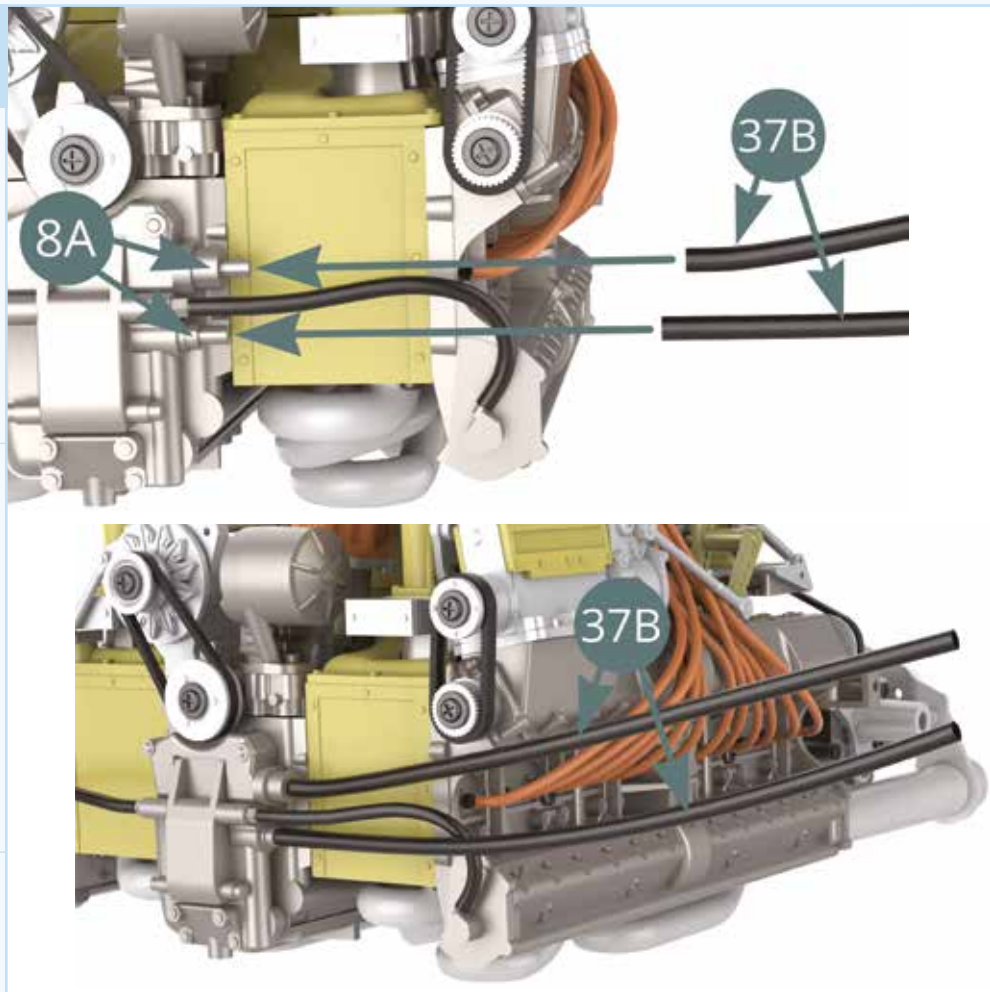
STEP 4

37A Cockpit partition frame installed on chassis.

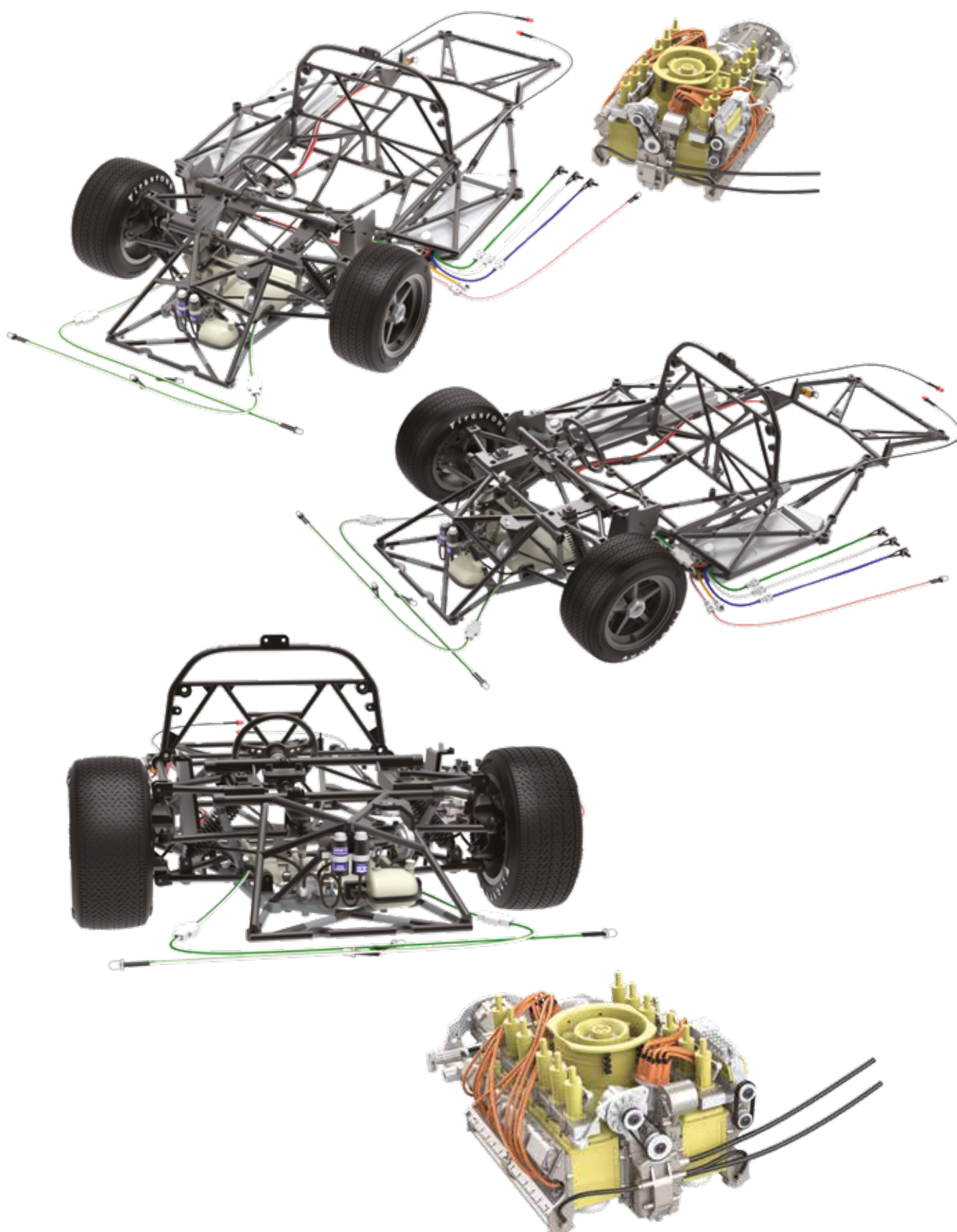


STEP 5

Fit two 37B Oil hoses to 8A Front cover pins.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 38

38A Left side frame

38B Fuel filter

38C Connectors (x3)

38D Fuel hose

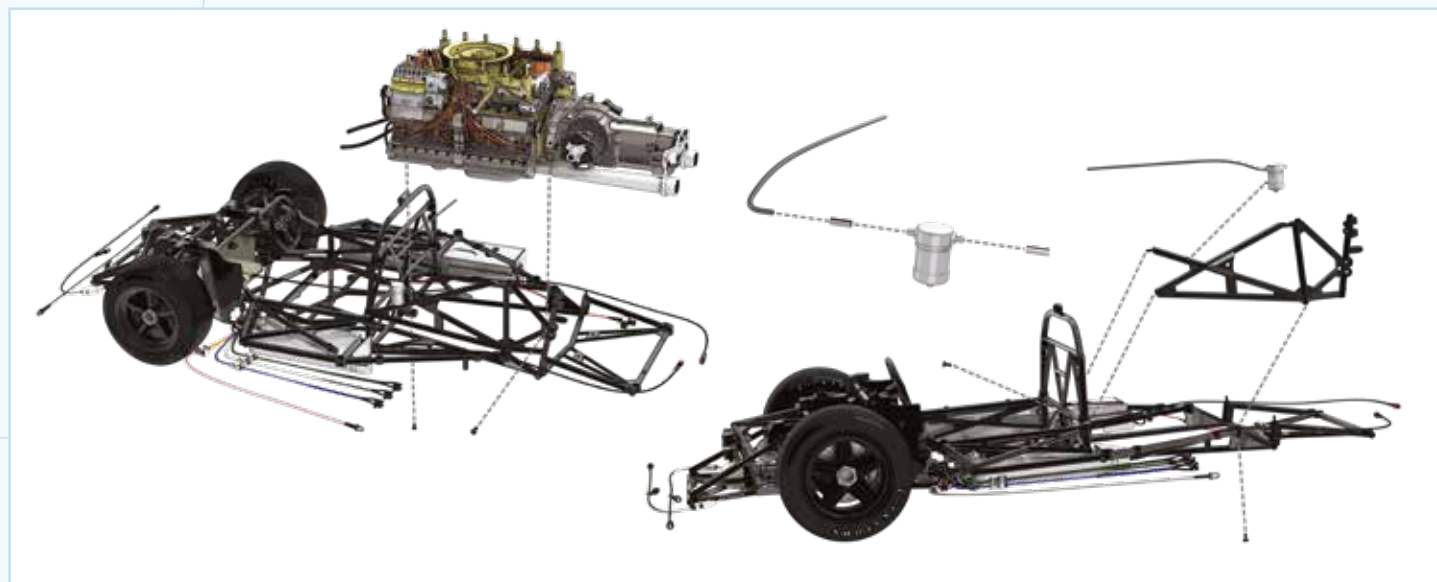
BM screw M2,0 x4mm (x4)

JM screw M2,0 x5mm (x2)



Installation of the fuel filter on the side chassis and the engine on the chassis

ASSEMBLY DIAGRAM



STEP 1

Fit two Connectors (38D) to Fuel filter (38B) pins. Fit Fuel hose (38xc) into Connector (38D).



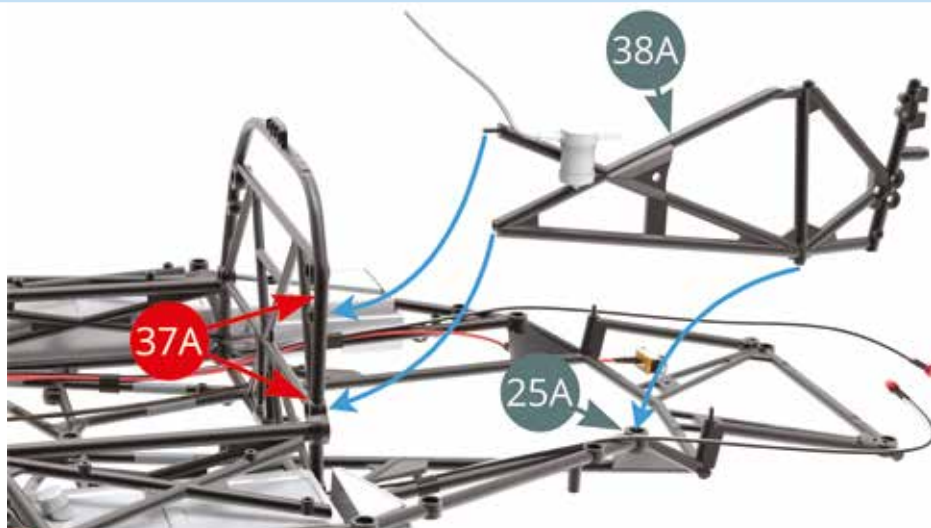
STEP 2

Fit Fuel filter (38B) to Left side frame (38A).



STEP 3

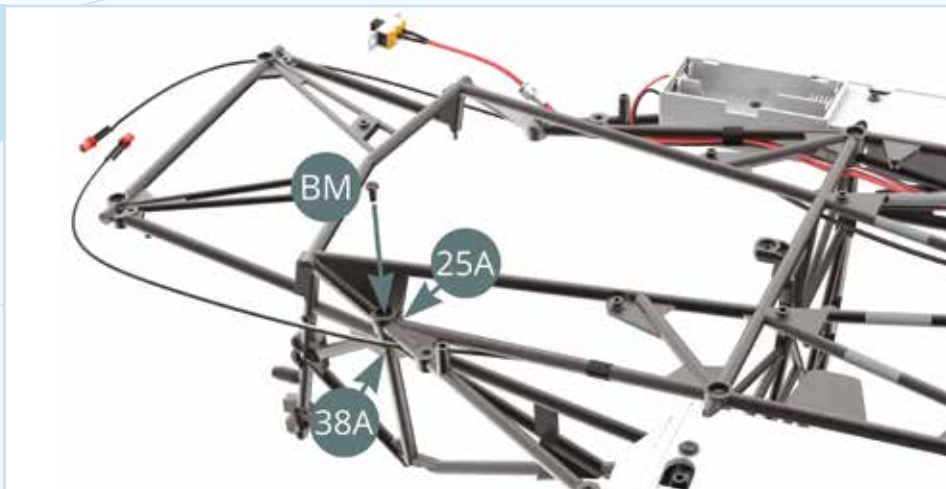
Fit 38A Left side frame (38A) to Cockpit partition frame (37A) and Chassis frame (25A).





STEP 4

Fix Left side frame (38A) to Chassis frame (25A) with BM screw.



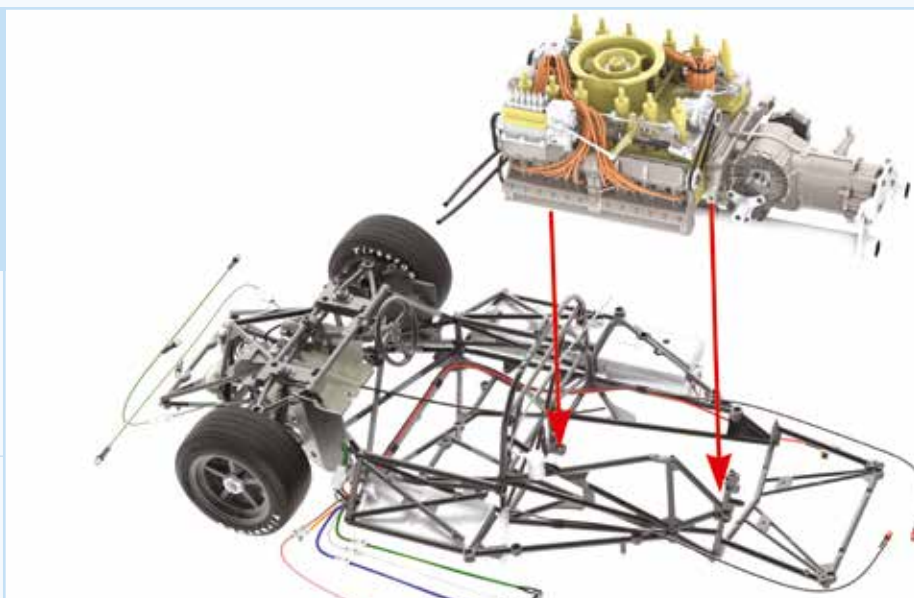
STEP 5

Fix Left side frame (38A) to Cockpit partition frame (37A) with BM screw.



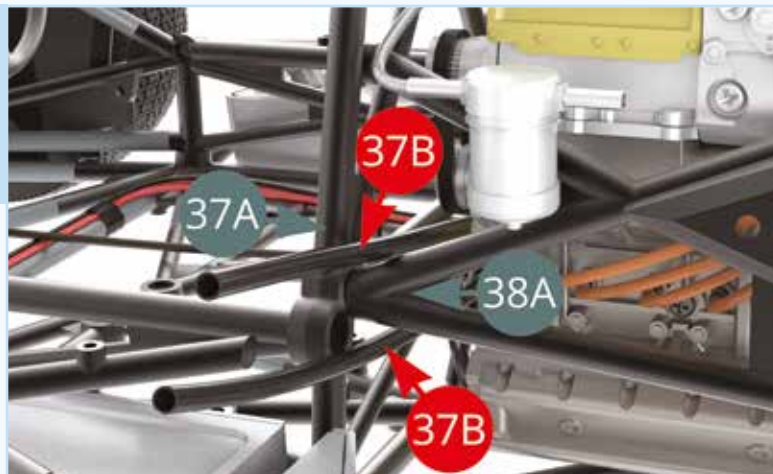
STEP 6

Fit Engine assembly to Chassis, aligning two immediate attachment points (red arrows). Lead Oil hoses (37B) as shown on next illustration.

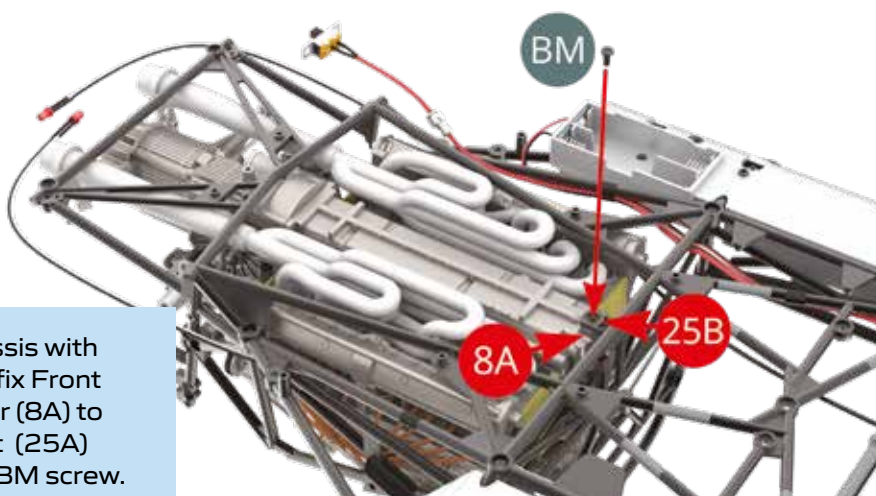


STEP 7

Pass the upper Oil hose (37B) above and the lower Oil hose (37B) below Left side frame V-bars (38A).

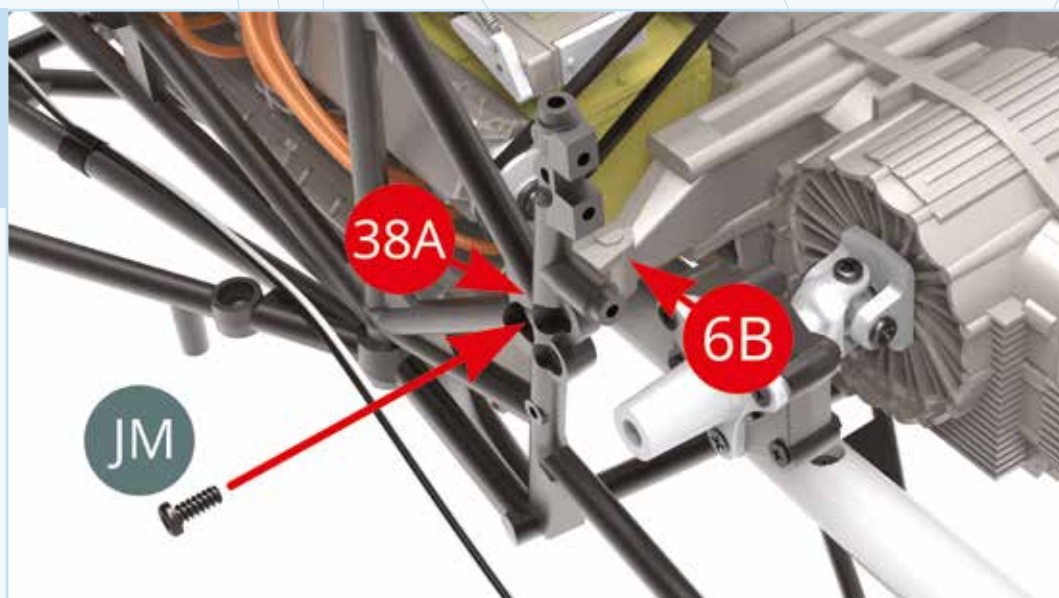


Upturn Chassis with Engine and fix Front Engine cover (8A) to Engine front (25A) mount with BM screw.



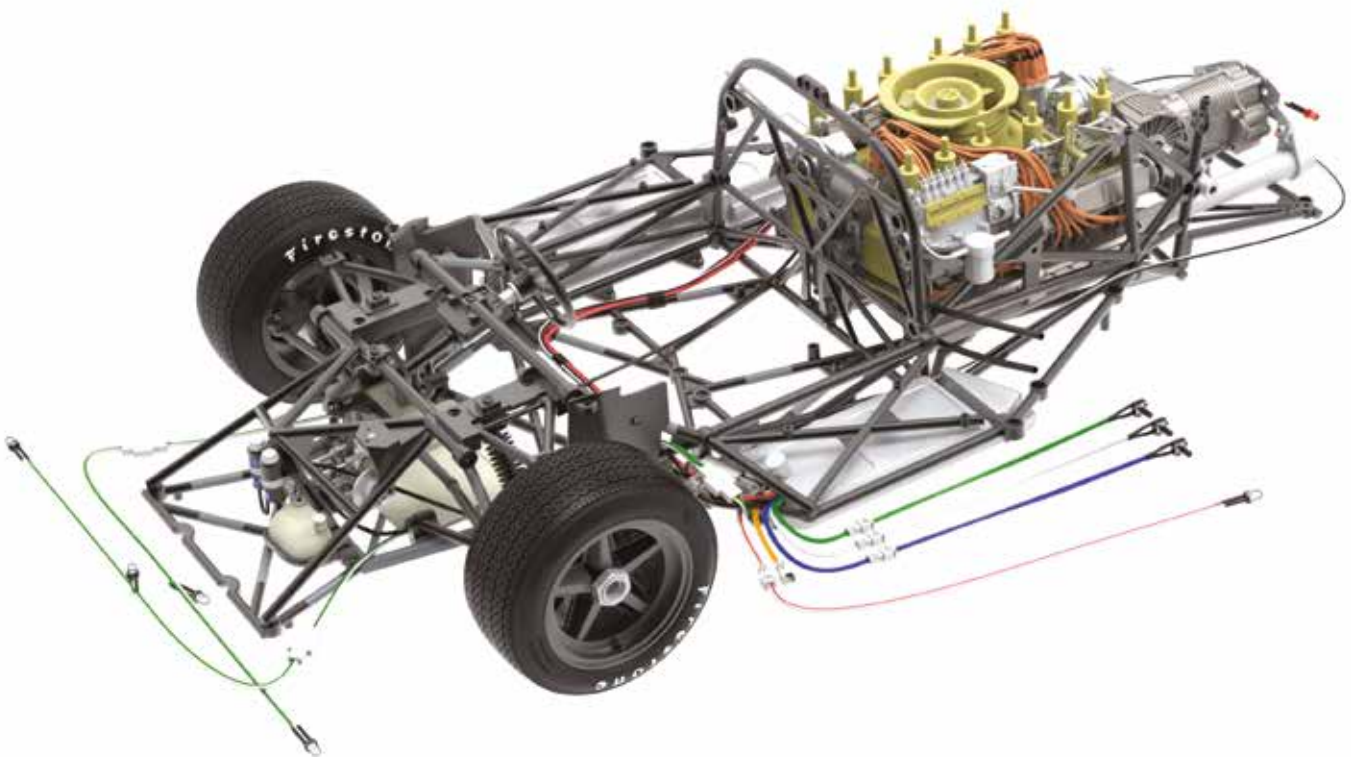
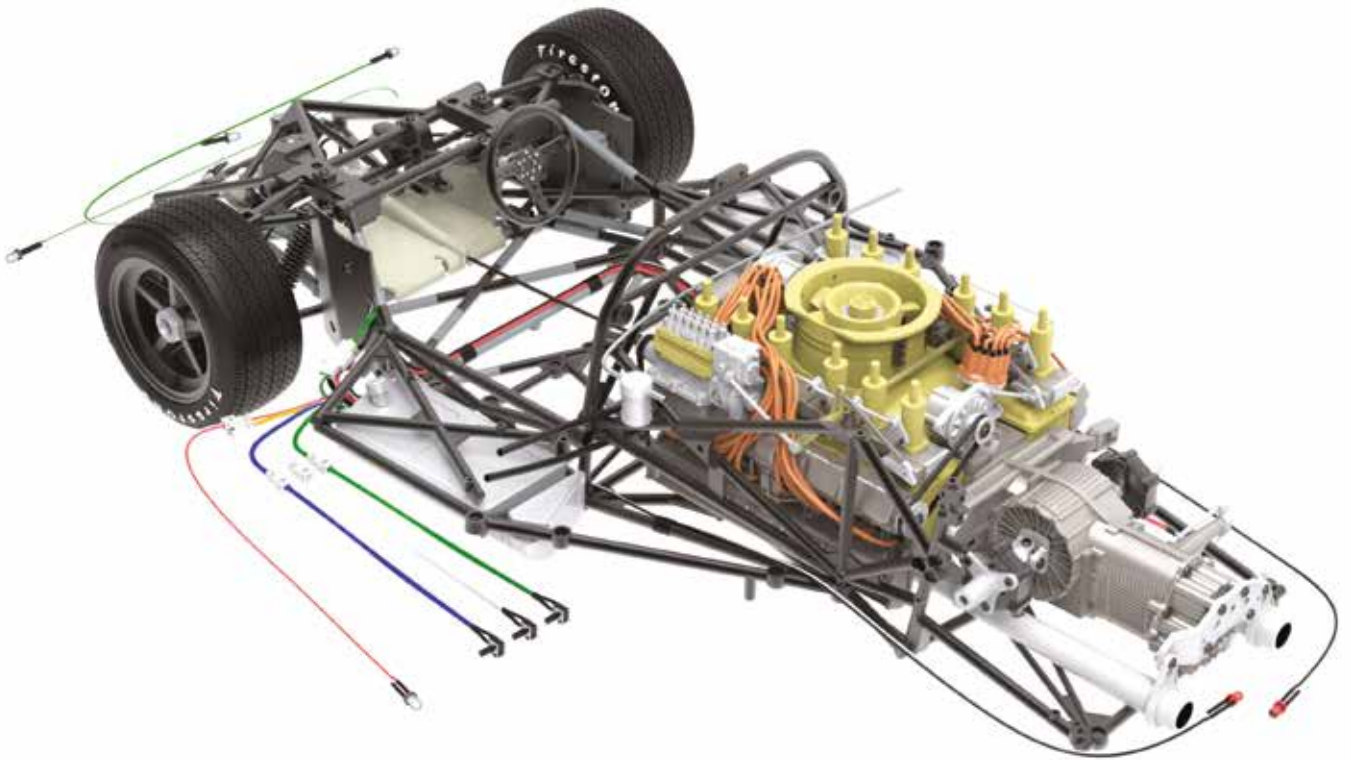
STEP 8

Upturn Chassis with Engine and fix Front Engine cover (8A) to Engine front (25A) mount with JM screw.





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 39

39A Right side frame

39B Hose manifold

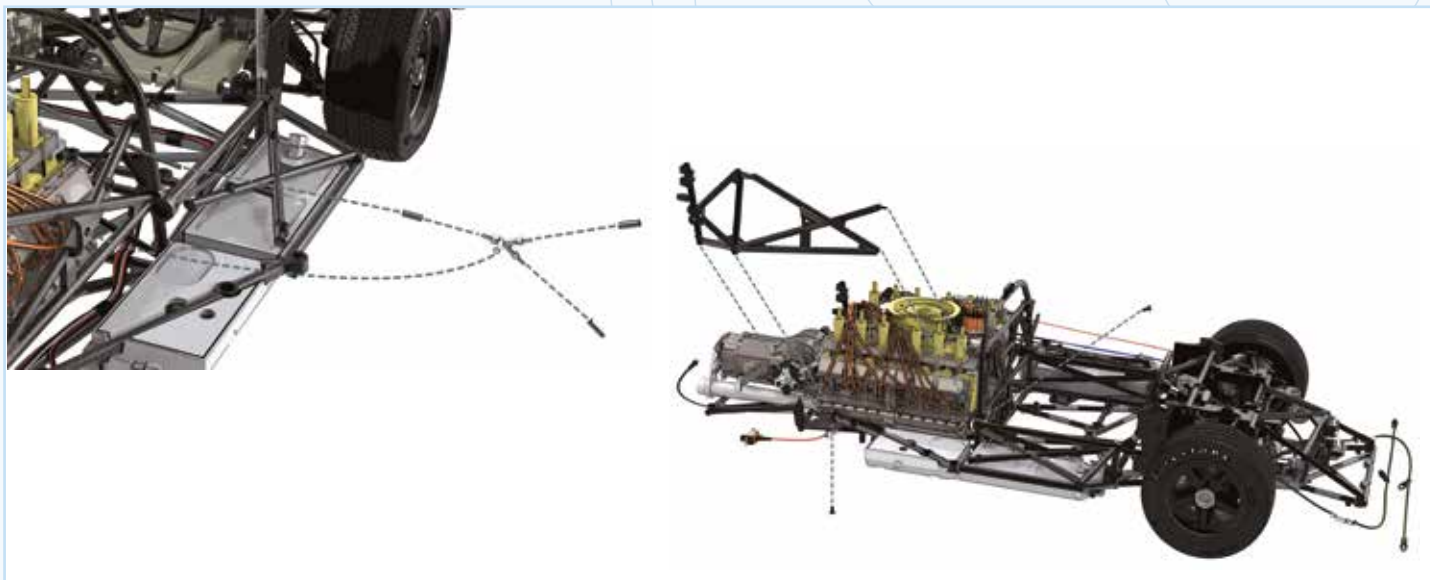
39C Connectors (x3)

BM screw M2,0 x4mm (x3)



Right side frame and fuel hose attachment

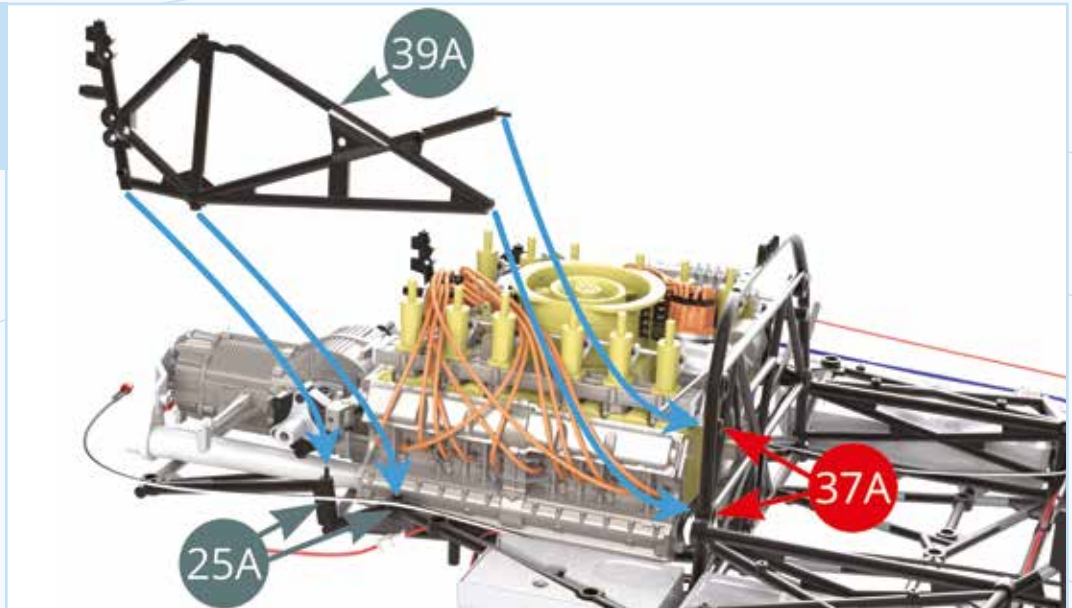
ASSEMBLY DIAGRAM





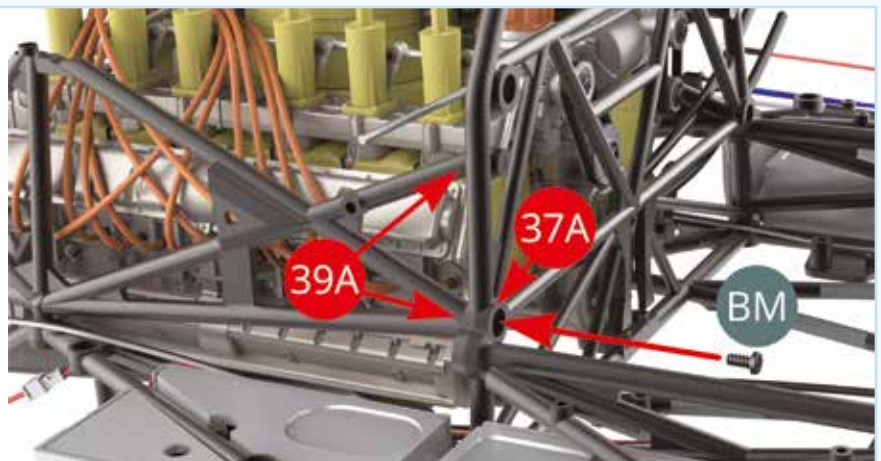
STEP 1

Fit Right side frame (39A) to Chassis frame (25A) and cockpit partition frame (37A) .



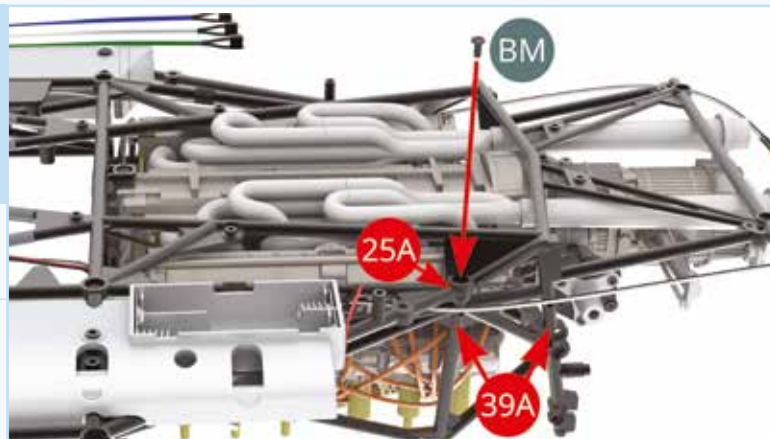
STEP 2

Fix Right side frame (39A) to cockpit partition frame (37A) with BM screw.



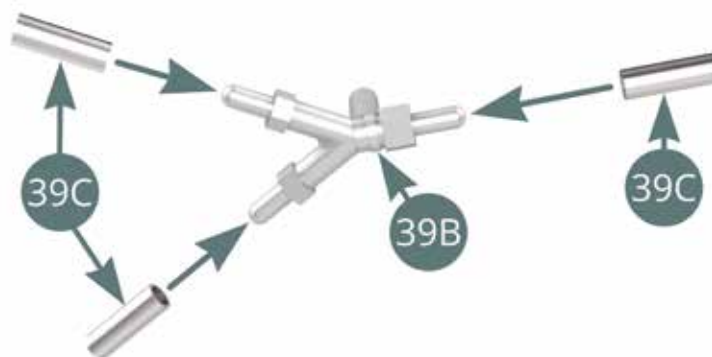
STEP 3

Fix Right side frame (39A) to Chassis frame (25A) with BM screw from under side of chassis.

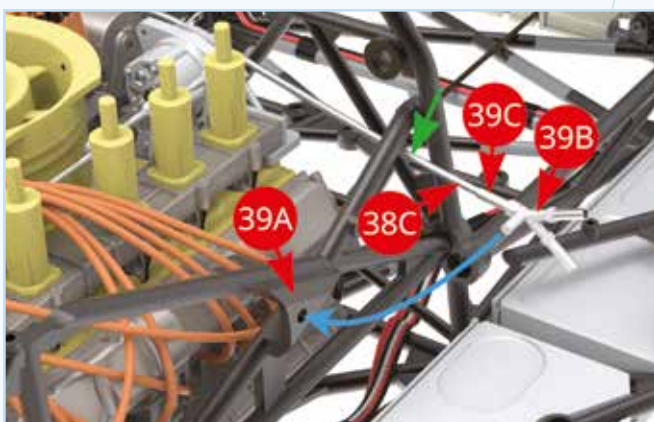


STEP 4

Fit three Connectors (39C) to Hose manifold (39B).



STEP 5

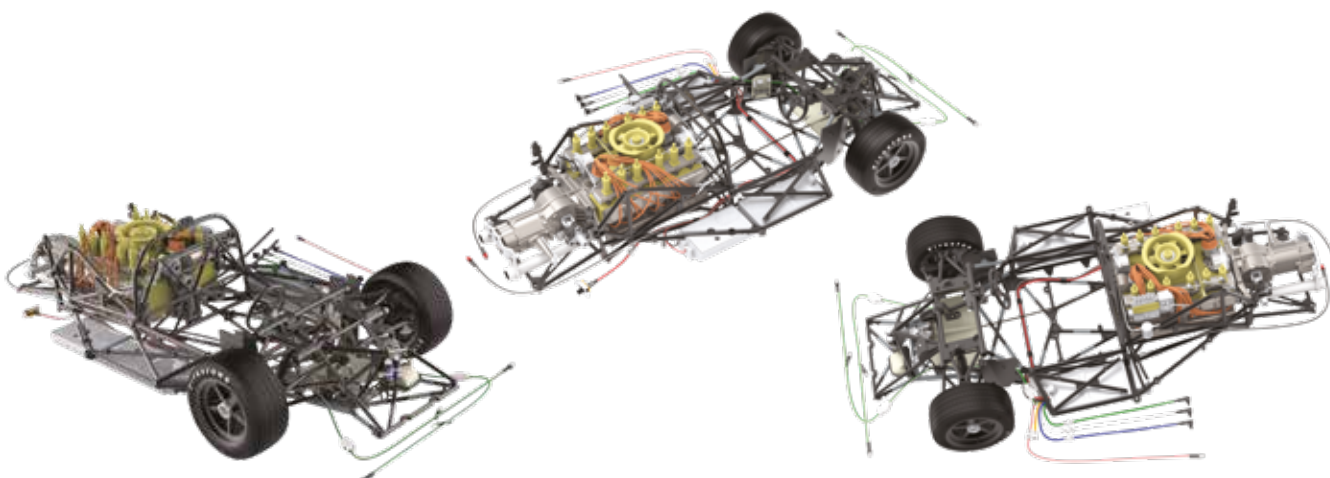


Fit Hose manifold (39B) by single Connector (39C) to 38C Fuel hose (38C) - pass Fuel hose (38C) below side frame bar - green arrow.

Fit Hose manifold (39B) with attached Fuel hose (38C) to Right side frame (39A).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 40

40A X- Frame

40B Ignition coils (x2)

40C High tension cables (x2)

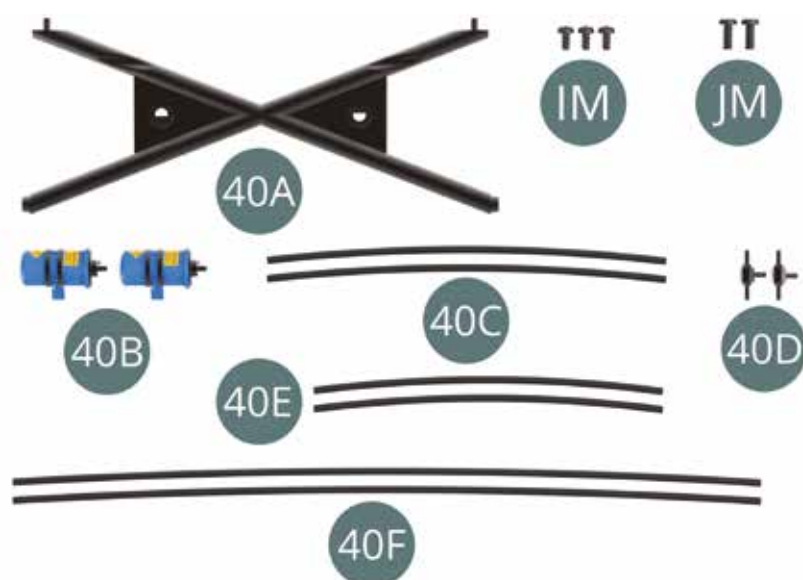
40D Connector (x2)

40E Brake line (x2)

40F Brake line (x2)

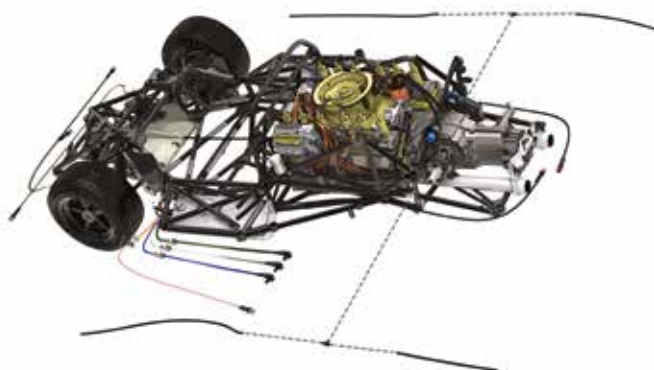
IM screw M1,7 x3,5mm (x3)

JM screw M2,0 x5mm (x2)



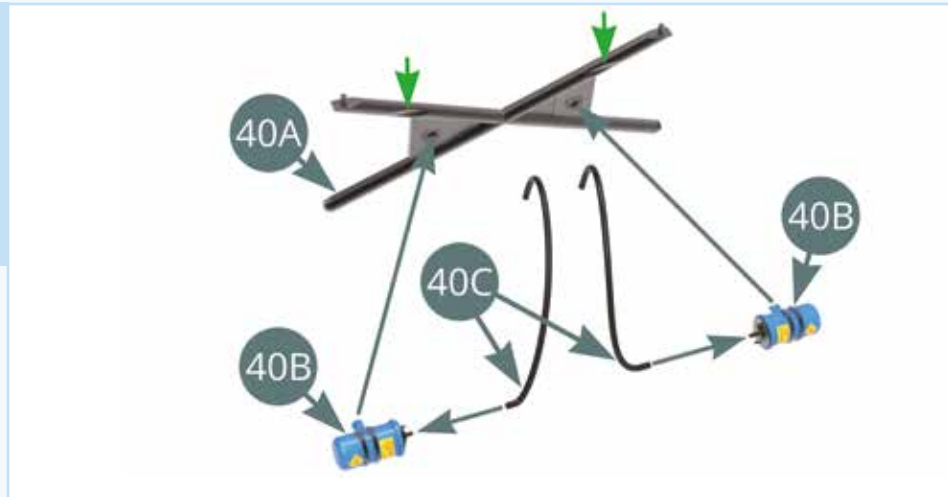
*Installation of ignition coils
and brake line*

ASSEMBLY DIAGRAM



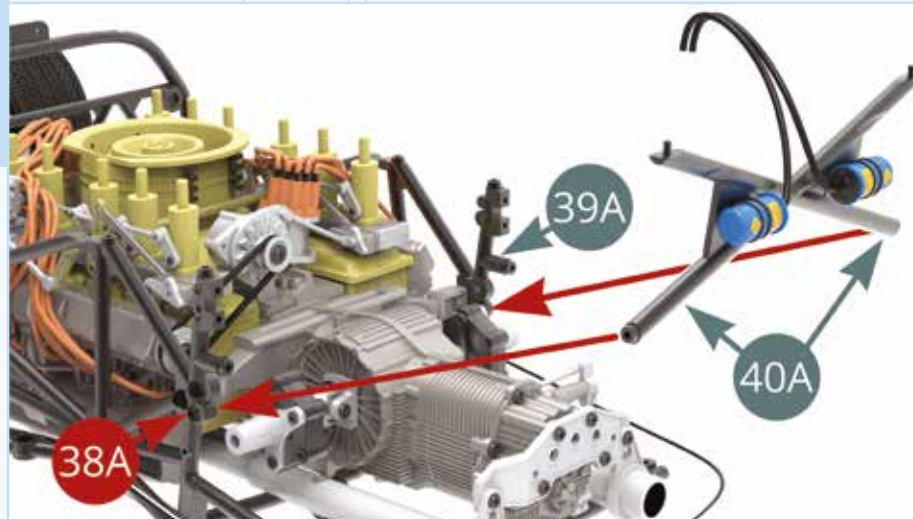
STEP 1

Fit High tension cables (40C) to both Ignition coils (40B) and fit them to X-frame (40A) - note notch orientation pointed by green arrows.



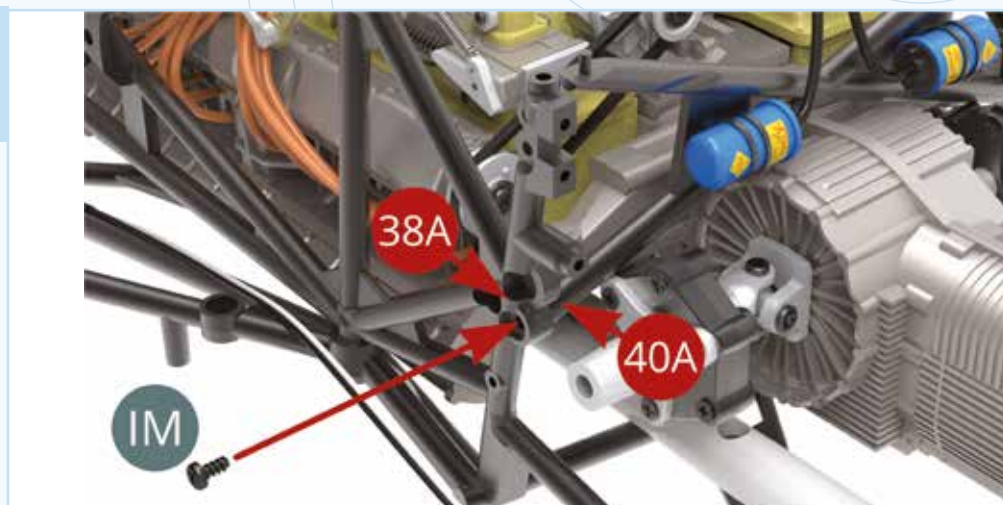
STEP 2

Fit 40A X-Frame (40A) to Left (38A) and 3 Right (39A) side frames.



STEP 3

Fix X-Frame (40A) to Left side frame (38A) with IM screw.

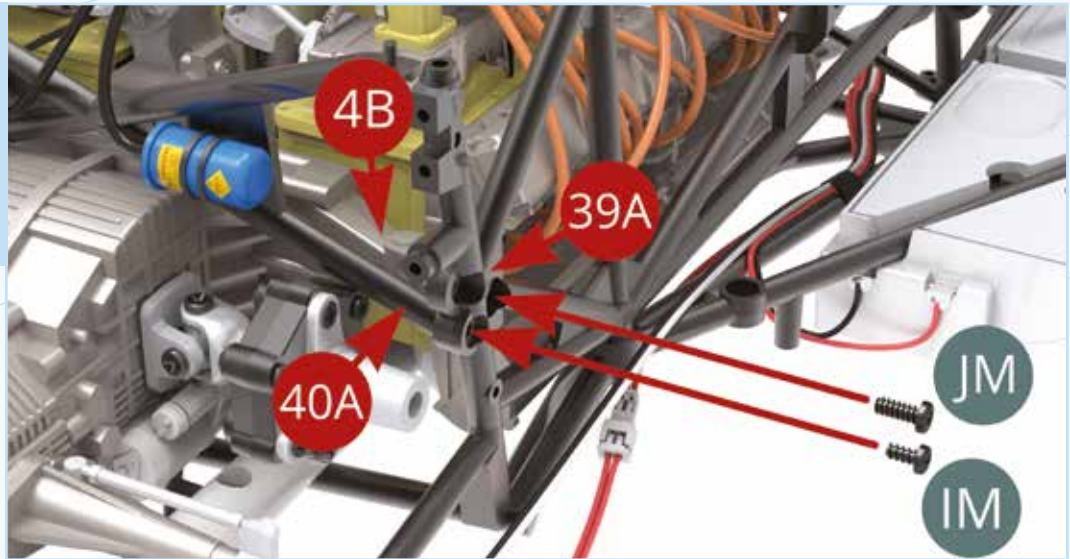




STEP 4

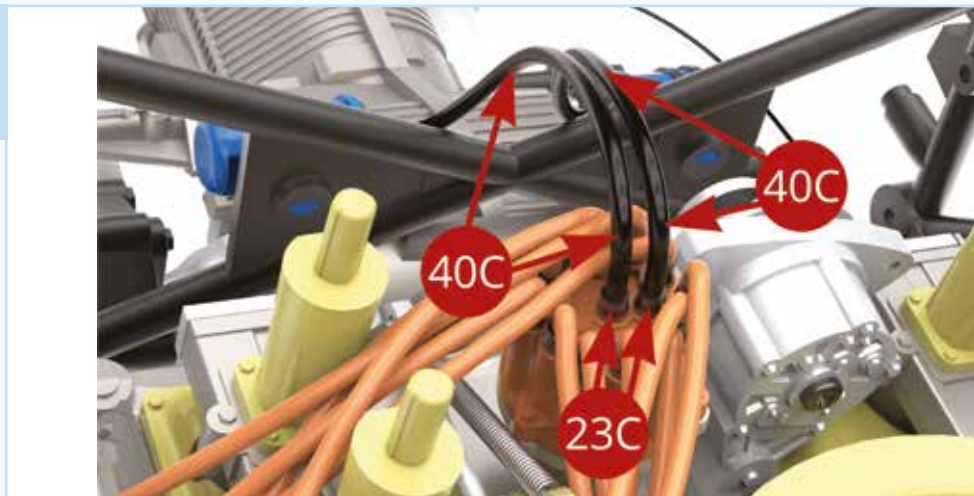
Fix X-Frame (40A) to Right side frame (39A) with IM screw.

Fix Mounting arm (4B) to Right side frame (39A) with JM screw.



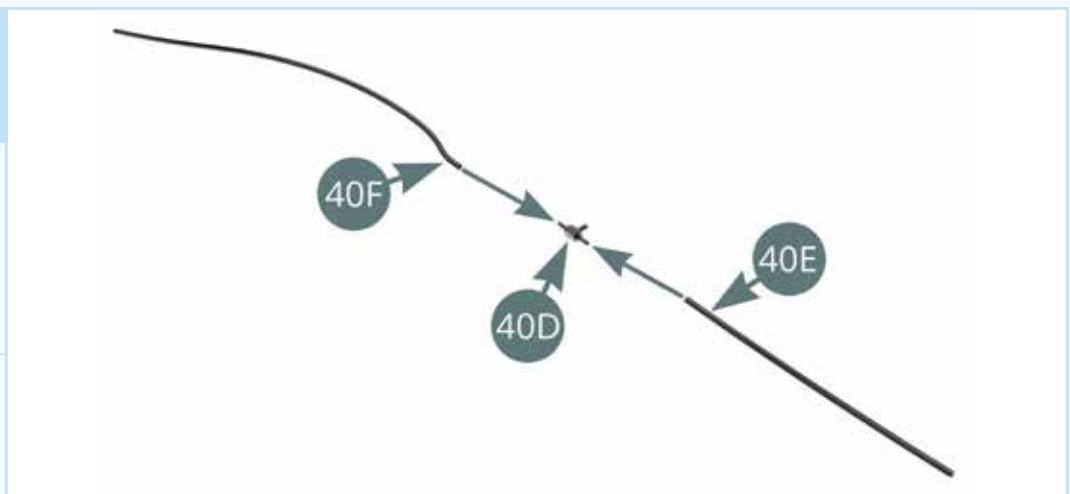
STEP 5

Fit both High tension cables ends (40C) on two Plugs (23C).



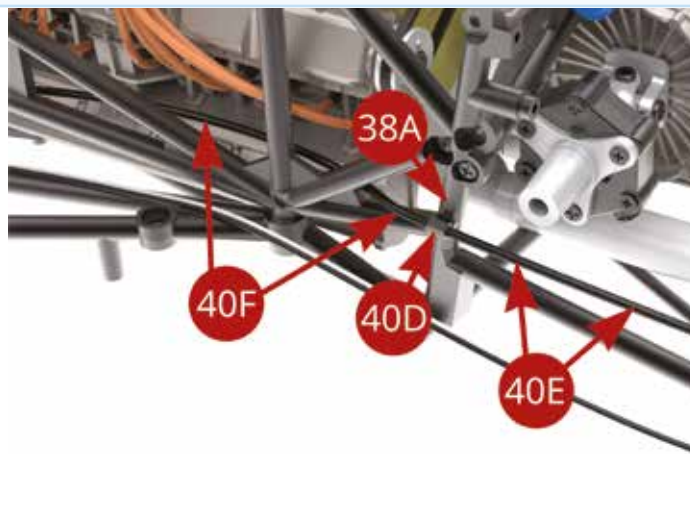
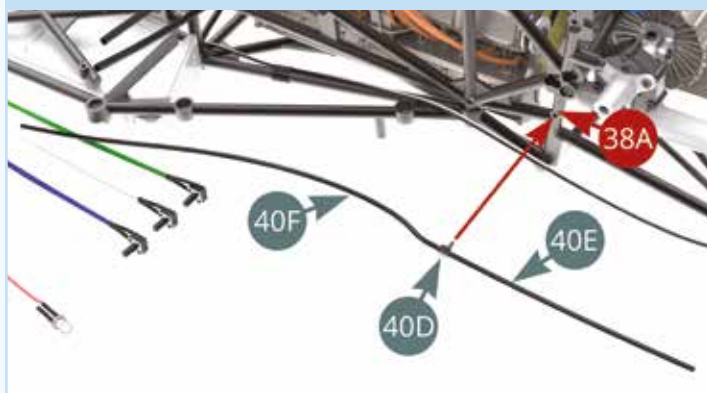
STEP 6

Fit and Brake lines (40E & 40F) to Connector (40D).



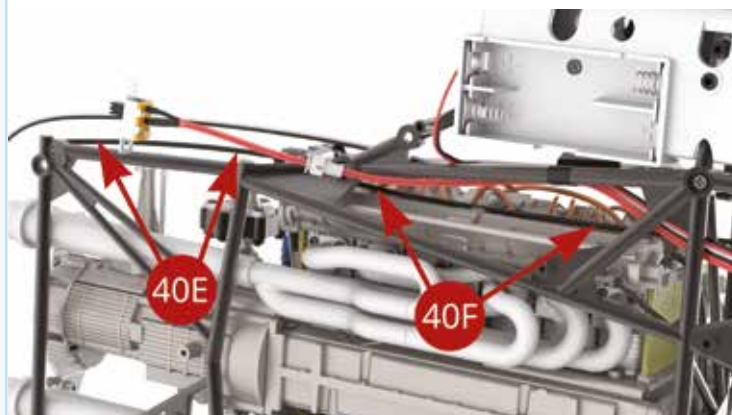
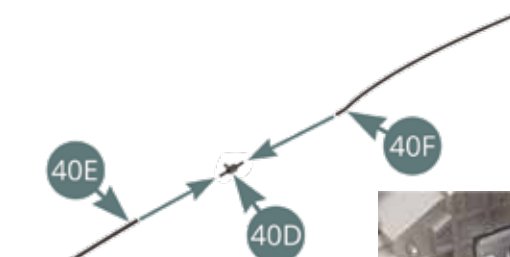
STEP 7

Fit Connector (40D) with attached Brake lines (40E & 40F) to 38A Left side frame bar (38A) - upper and lower illustrations.



STEP 8

Fit Brake lines (40E & 40F) to Connector (40D). Fit Connector (40D) to 39A Right side frame bar (39A) - upper and two lower illustrations.





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 41

41A Rear left upright

41B Radius arm with upper link

41C Bottom wish bone

41D Radius arm

41E Bracket

41F Piston rod

41G Bracket

41H Suspension damper

41I Suspension spring

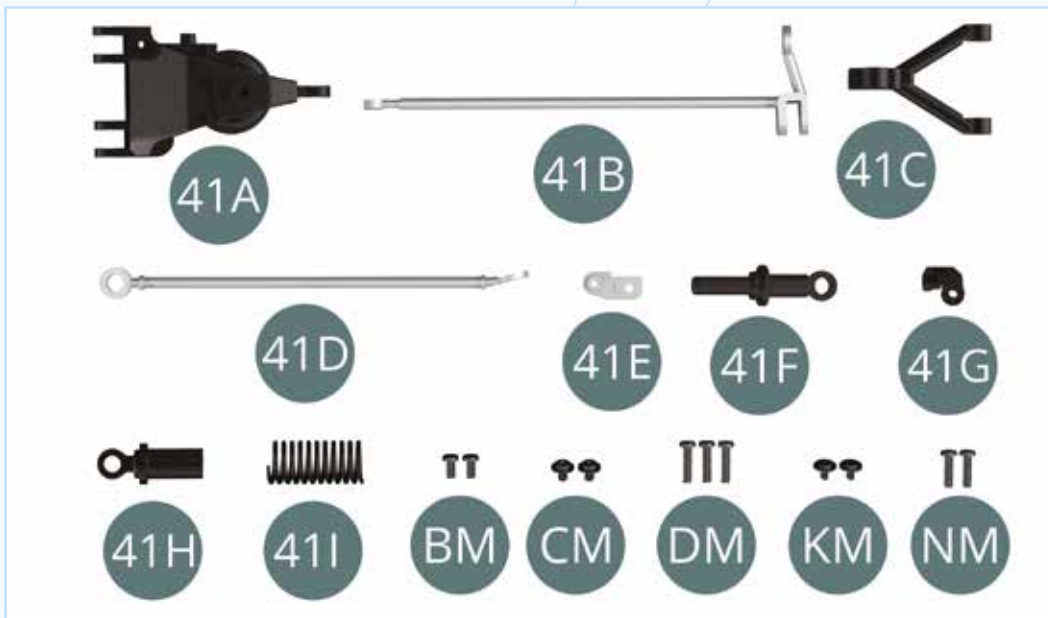
BM Screw M 2.0 x 4 mm (x 2)

CM Screw M 2.0 x 3 x 5 mm (x 2)

DM Screw M 2.0 x 8 mm (x 3)

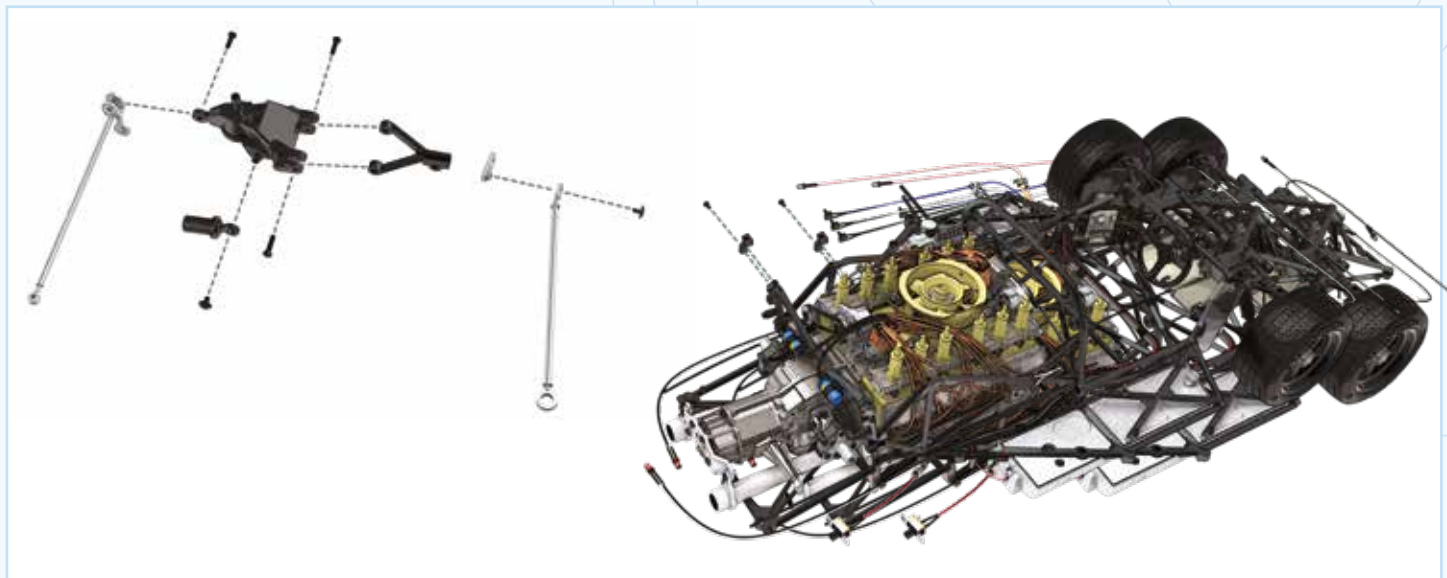
KM Vis M 1.7 x 3 x 5 mm (x 2)

NM Screw M 2.0 x 7 mm (x 2)



*Preambly of the
left rear suspension*

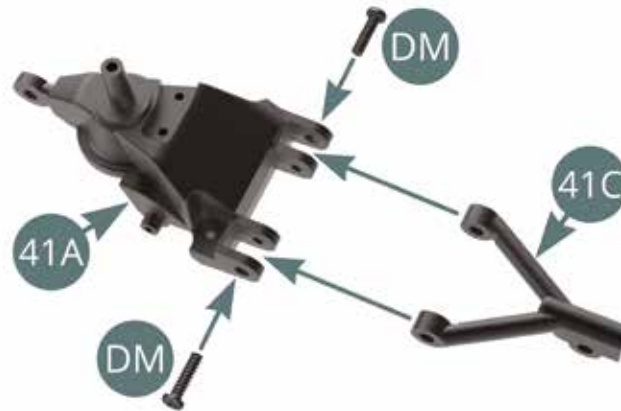
ASSEMBLY DIAGRAM





STEP 1

Fit Bottom wish bone (41C) to Rear left upright (41A) and fix with two DM screws.

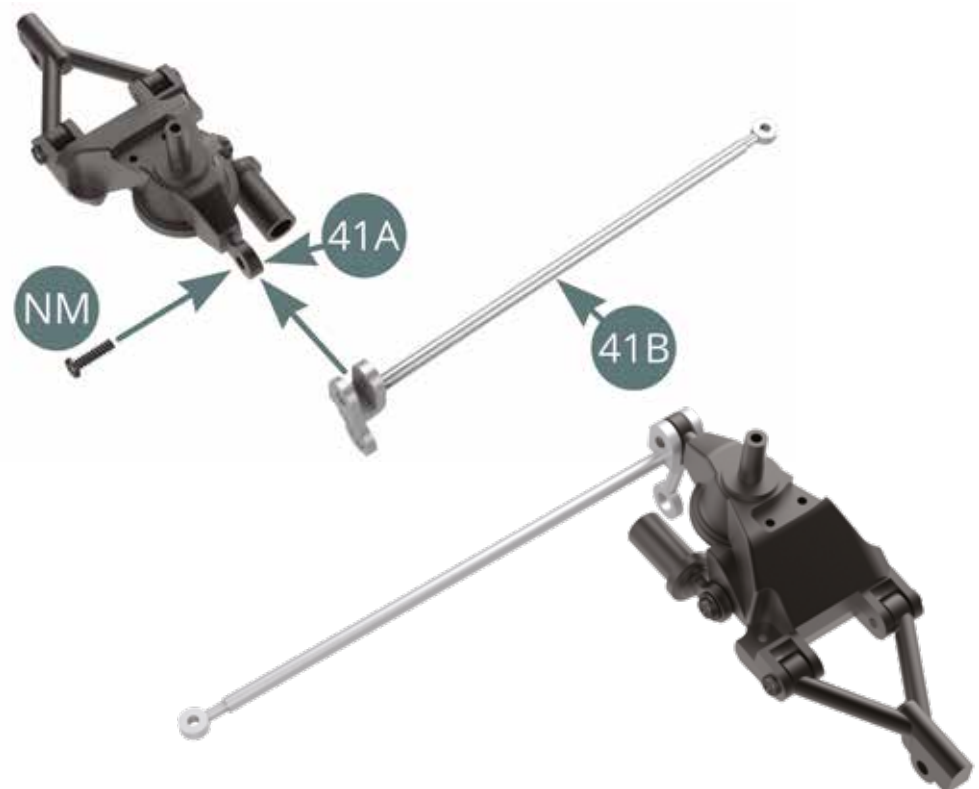


Fit Suspension damper (41H) to A Rear left upright (41A) and fix with CM screw.



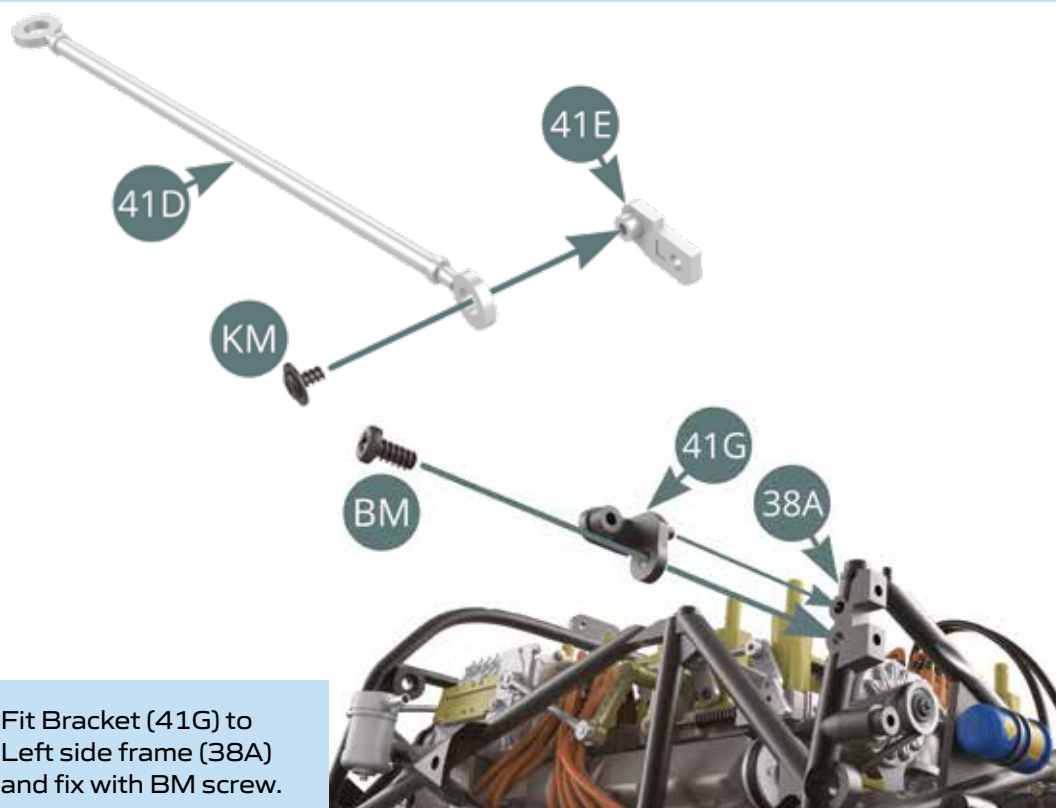
STEP 2

Fit Radius arm (41B) with upper link to Left rear upright (41A) and fix with NM screw (upper and lower illustrations).



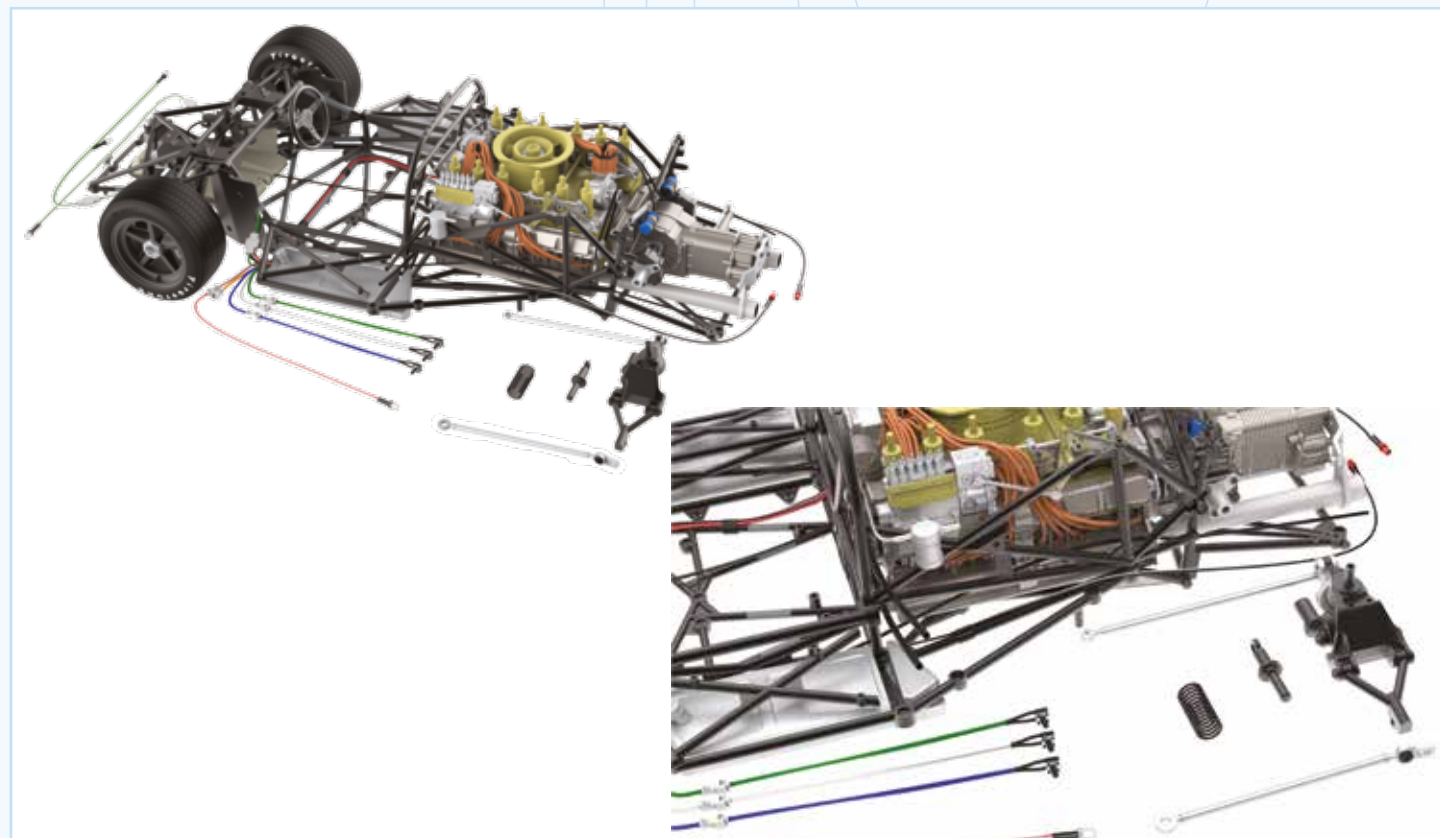
STEP 3

Fit Radius arm (41D) to Bracket (41E) and fix with KM screw.



Fit Bracket (41G) to Left side frame (38A) and fix with BM screw.

GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 42

42A Rear right upright

42B Radius arm with upper link

42C Bottom wish bone

42D Radius arm

42E Bracket

42F Piston rod

42G Bracket

42H Suspension damper

42I Suspension spring

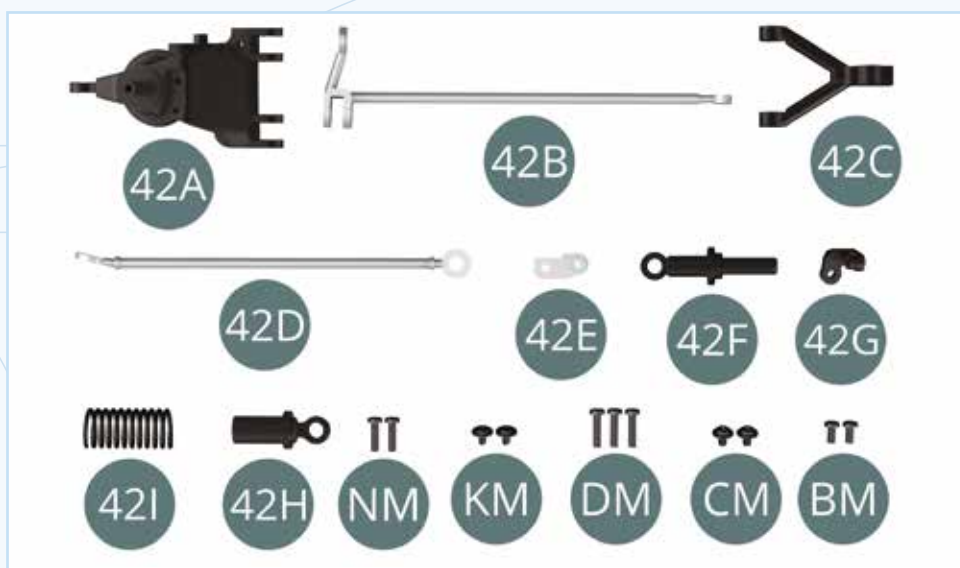
BM Screw M 2.0 x 4 mm (x 2)

CM Screw M 2.0 x 3 x 5 mm (x 2)

DM Screw M 2.0 x 8 mm (x 3)

KM Vis M 1.7 x 3 x 5 mm (x 2)

NM Screw M 2.0 x 7 mm (x 2)



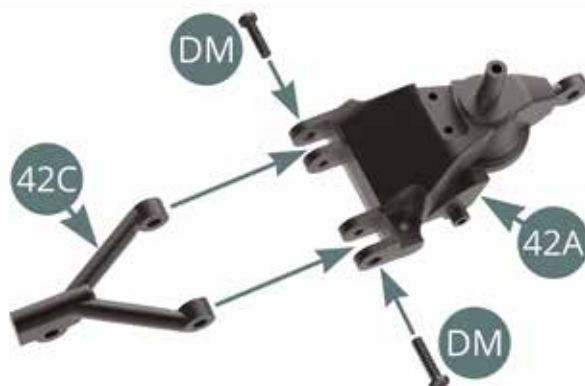
*Preassembly
of the right rear
suspension*

ASSEMBLY DIAGRAM

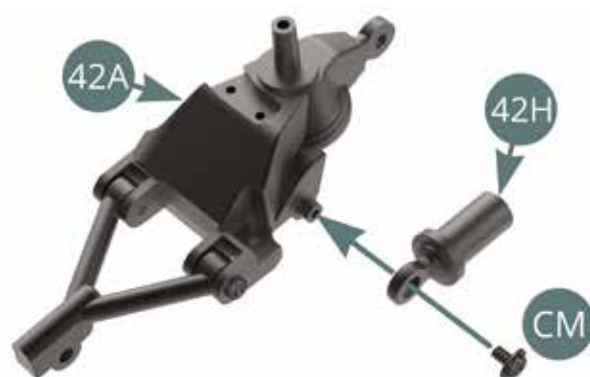


STEP 1

Fit Bottom wish bone (42C) to Rear right upright (42A) and fix with two DM screws.

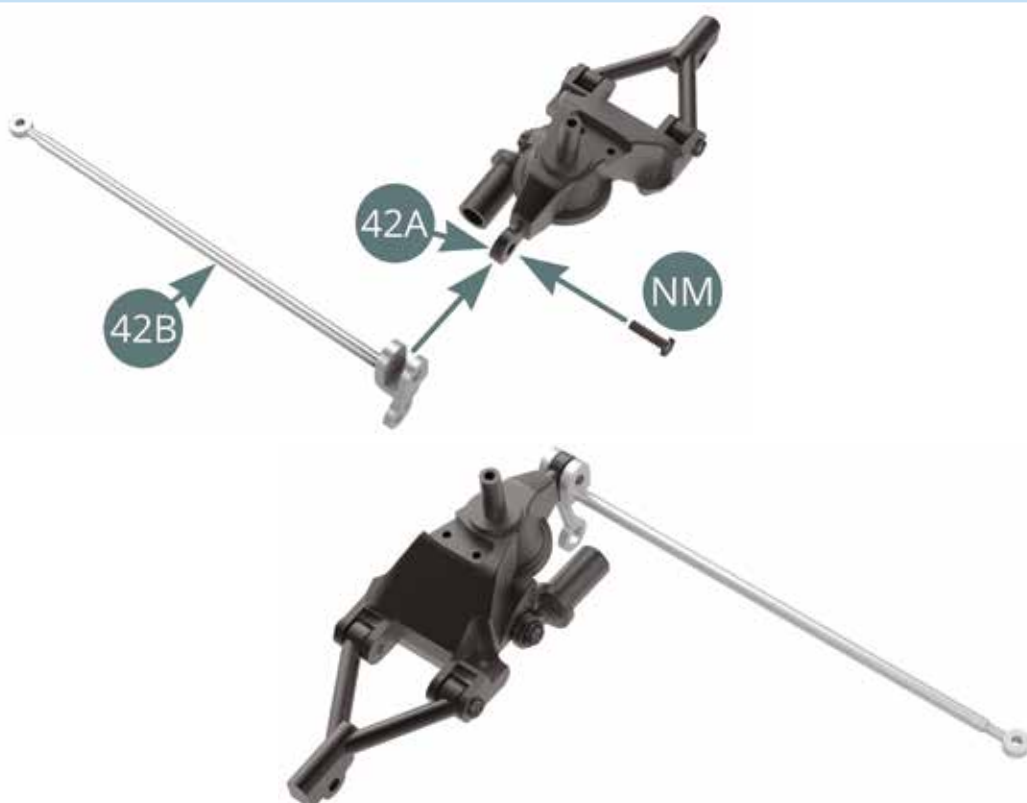


Fit Suspension damper (42H) to Rear left upright (42A) and fix with CM screw.



STEP 2

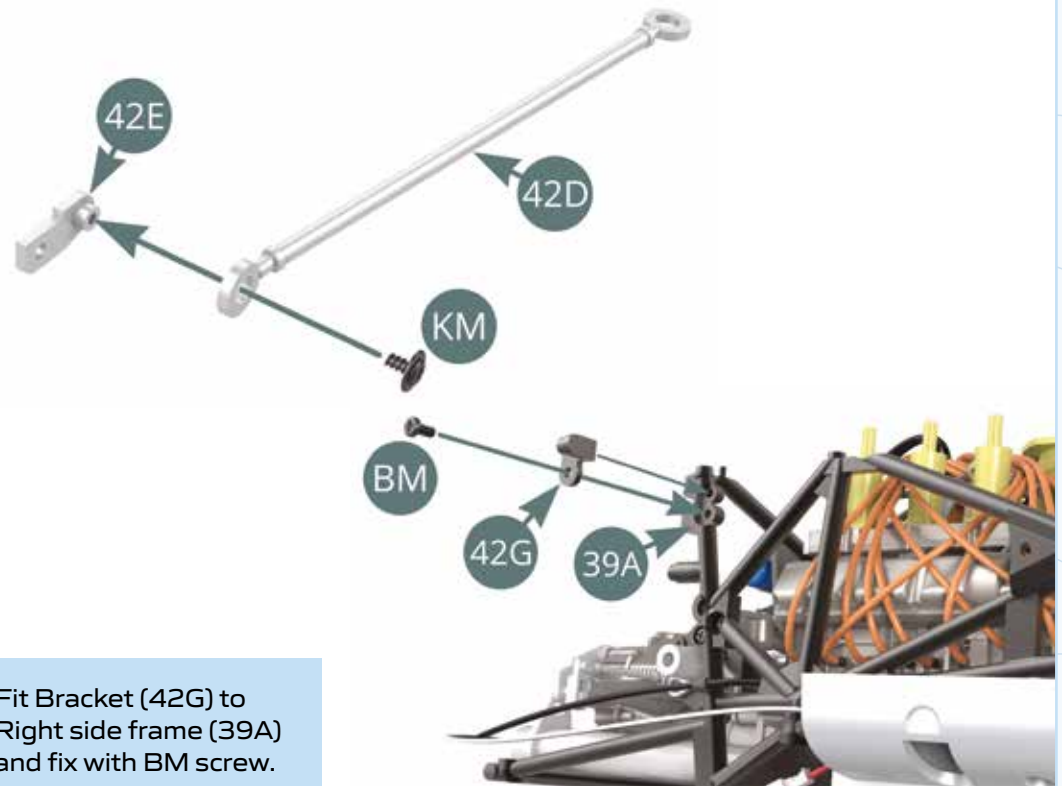
Fit Radius arm (42B) with upper link to Right rear upright (42A) and fix with NM screw (upper and lower illustrations).





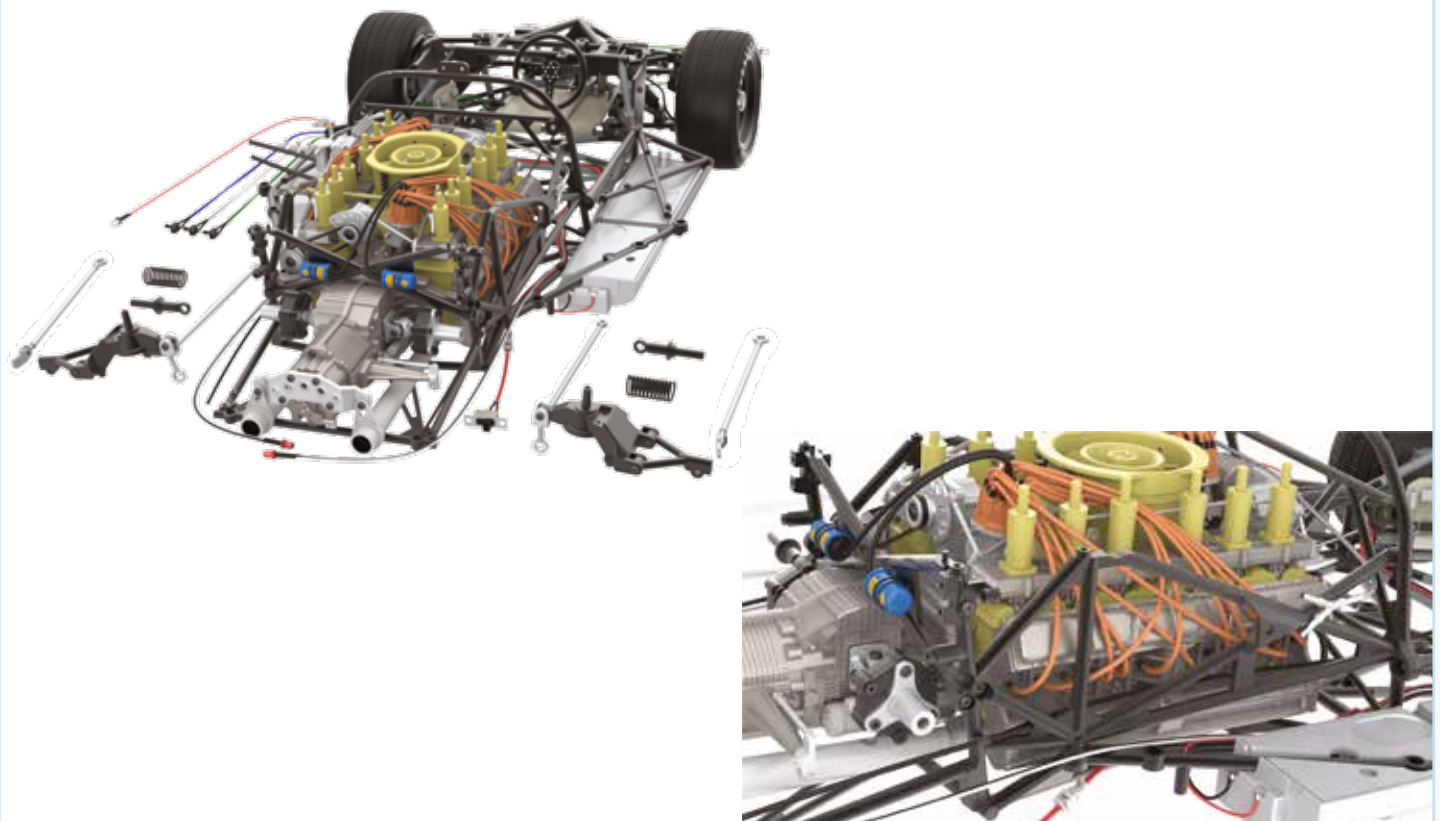
STEP 3

Fit Radius arm (42D) to Bracket (42E) and fix with KM screw.



Fit Bracket (42G) to Right side frame (39A) and fix with BM screw.

GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 43

43A Rear axle

43B Drop links (x2)

43C Rear anti roll bar

43D Tie down planks (x2) MOUNTINGS LUGS

43E Half shaft (x2)

43F Half shaft (x2)

43G Universal joint (x2)

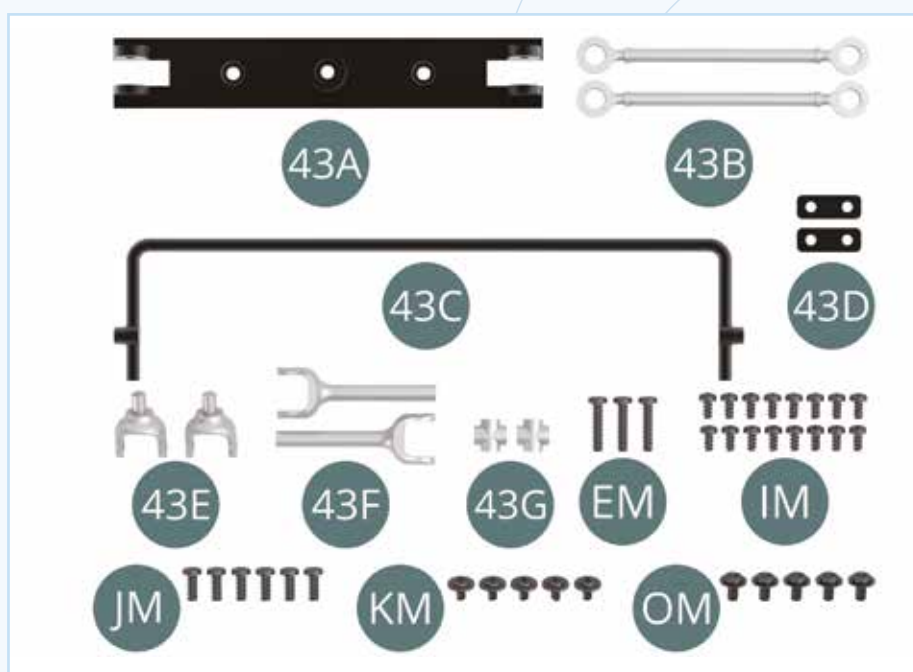
EM Screw M 2.0 x 9 mm (x 3)

IM Screw M 1.7 x 3.5 mm (x 16)

JM Screw M 2.0 x 5 mm (x 6)

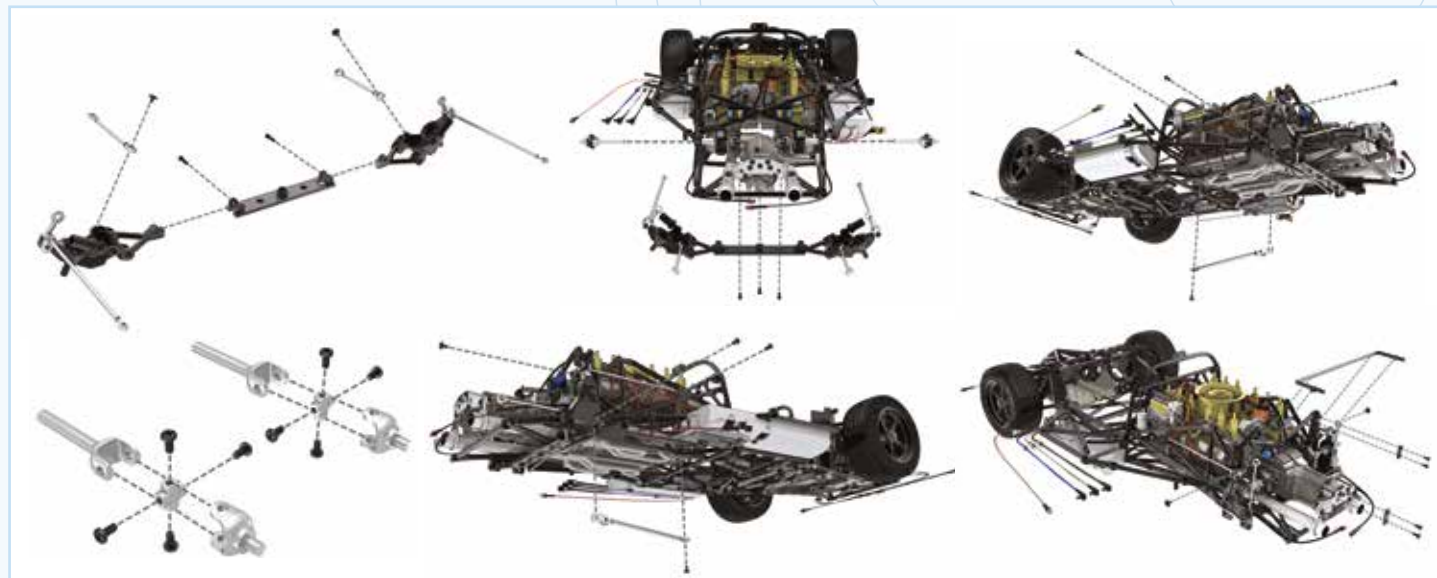
KM Vis M 1.7 x 3 x 5 mm (x 5)

OM Screw M 2.0 x 4 x 5 mm (x 5)



Installation of
the rear axle and
suspension

ASSEMBLY DIAGRAM





STEP 1

Fit Drop link (43B) to Rear left upright (41A) and fix with KM screw.



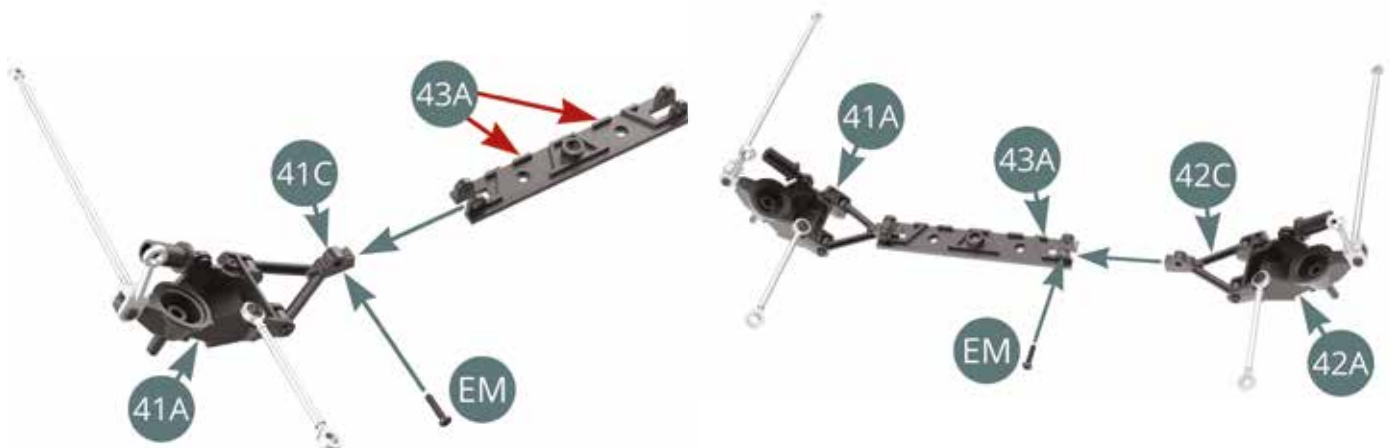
Fit Drop link (43B) to Rear right upright (42A) and fix with KM screw .



STEP 2

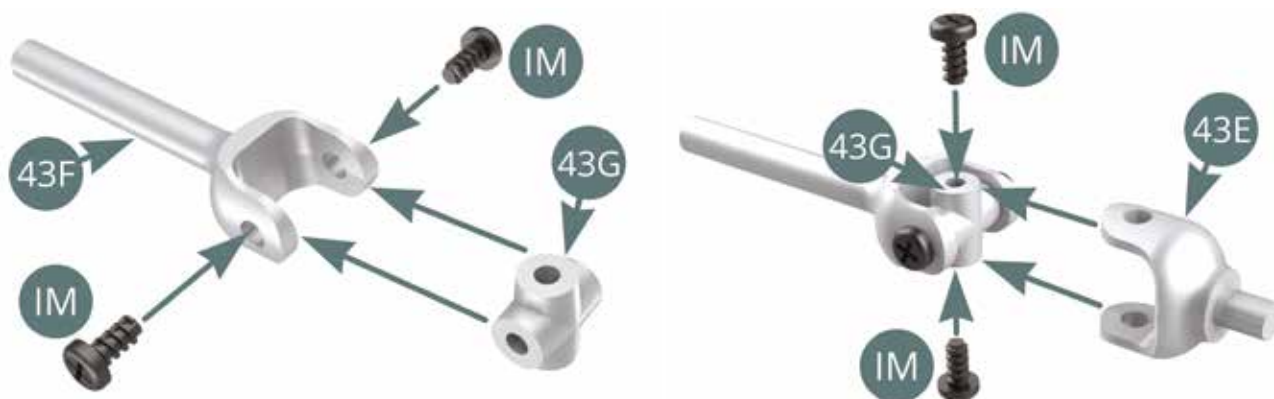
Fit Bottom wish bone (41C) of Left upright (41A) to Rear axle (43A) and fix with EM screw .

Fit the lower wishbone 42C (attached to the right rear pivot 42A) to the rear axle 43A and secure it with an EM screw.



STEP 3

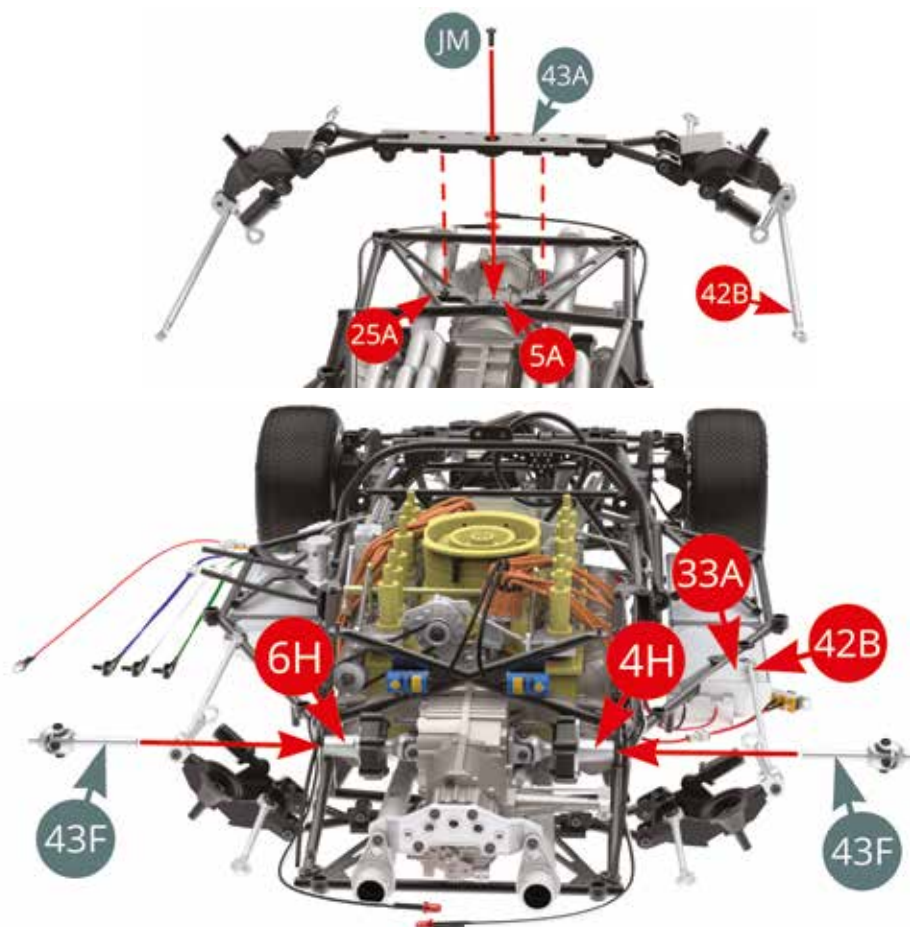
Assemble 2 sets of Half shafts following upper and lower illustrations :
Fit Universal joint (43G) to Half shaft (43F) and fix with two IM screws.
Fit Half shaft (43E) to Universal joint (43G) and fix with two IM screws.



STEP 4

Fit Rear axle (43A) to Chassis frame (25A) and Casing (5A) with JM screw. Take note to place the end of Radius arm (42B) above Right fuel tank (33A) top panel (lower illustration)

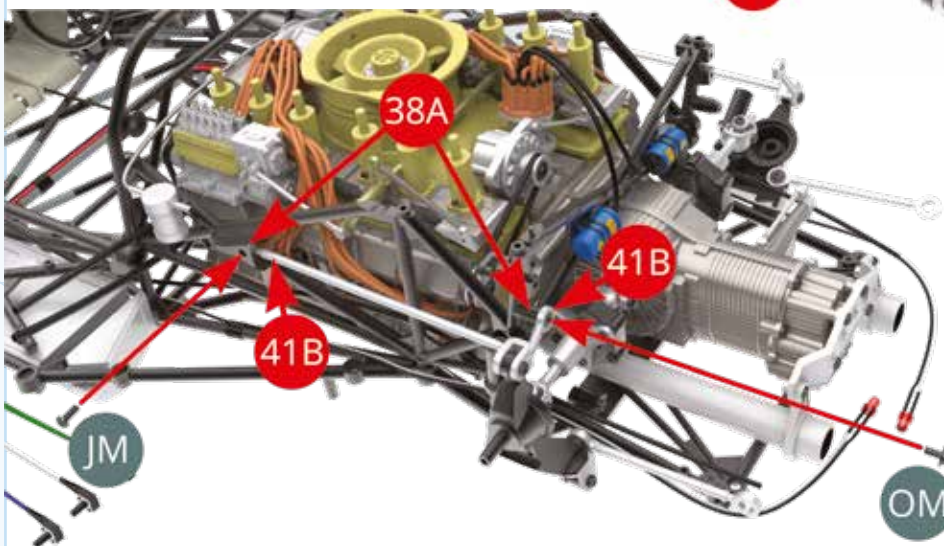
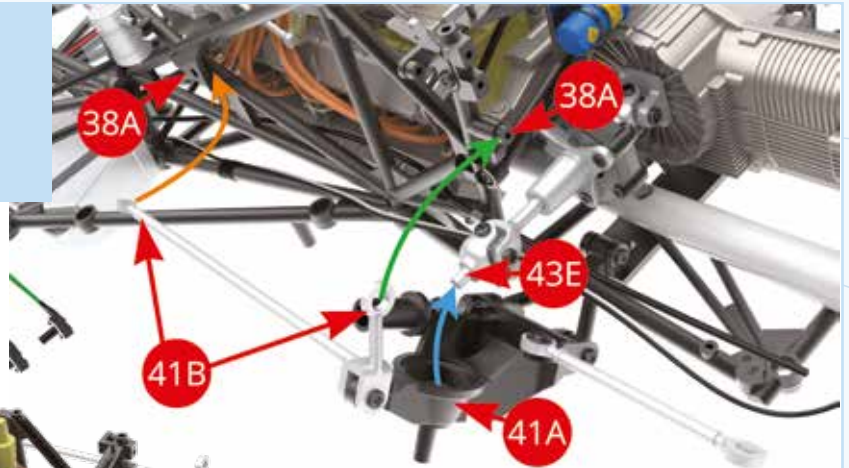
Fit two preassembled universal jointed Half shafts (43F) to Drive shaft compensation sleeves (6H & 4H).





STEP 5

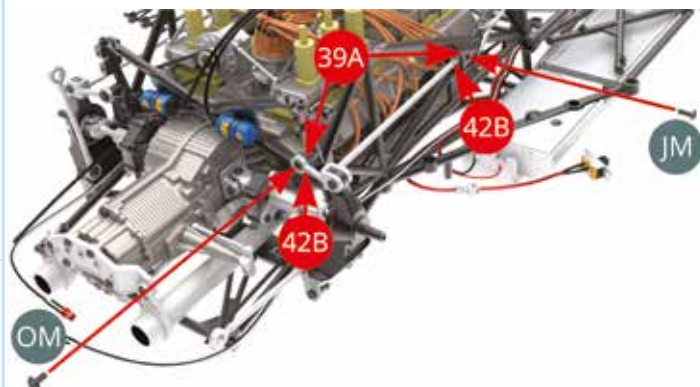
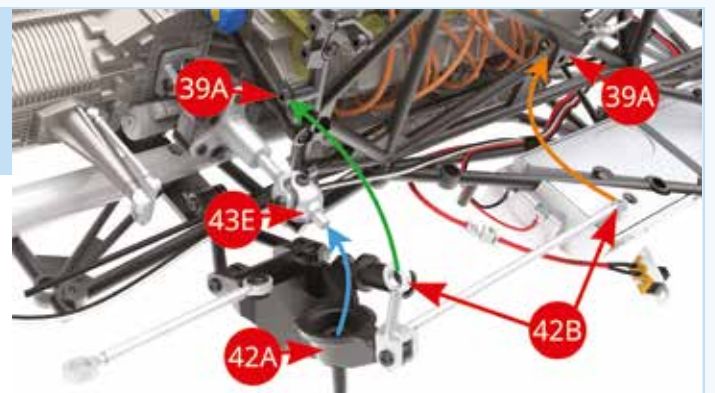
Elevate Left upright (41A) to catch the stub of Half axle (43E) - blue arrow -, at the same time aligning Radius arm (41B) with upper link to Left side frame (38A) attachment points (orange and green arrows).



Fix Radius arm (41B) with upper link to Left side frame (38A) with JM and OM screws.

STEP 6

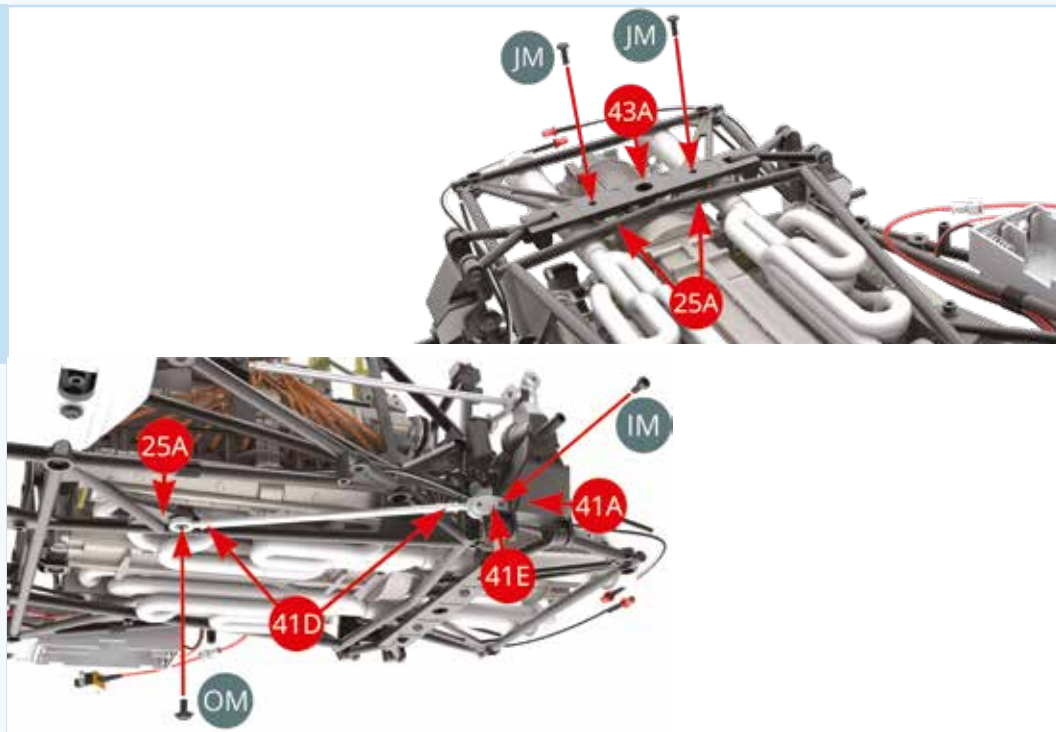
Elevate Right upright (42A) to catch the stub of Half axle (43E) - blue arrow -, at the same time aligning Radius arm (42B) with upper link to Right side frame (39A) attachment points (orange and green arrows) .



Fix Radius arm (42B) with upper link to Right side frame (39A) with JM and OM screws.

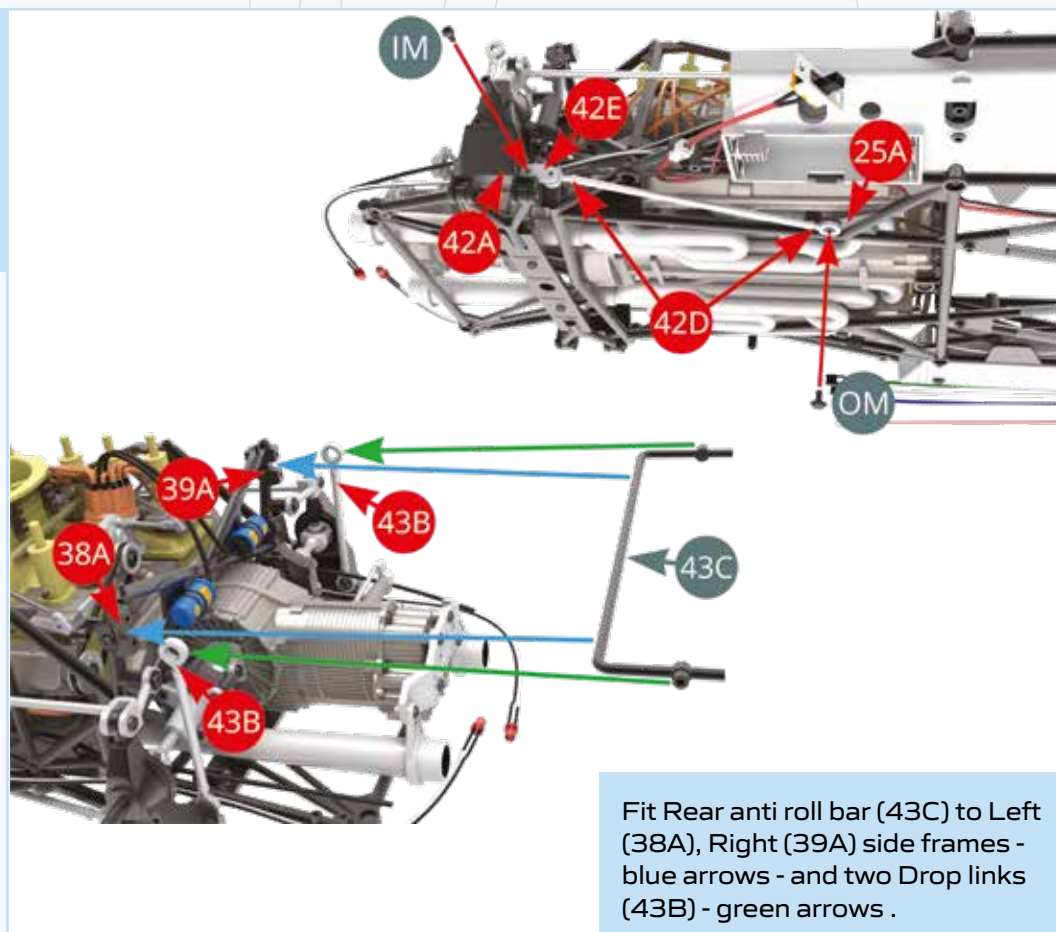
STEP 7

Fix Rear axle (43A) to Chassis frame (25A) with two JM screws. Fix preassembled Radius arm (41D) with Bracket (41E) to Chassis frame (25A) by OM screw, and Left upright (41A) by IM screw respectively.



STEP 8

Fix preassembled Radius arm (42D) with Bracket (42E) to Chassis frame (25A) by OM screw, and Right upright (42A) by IM screw respectively.

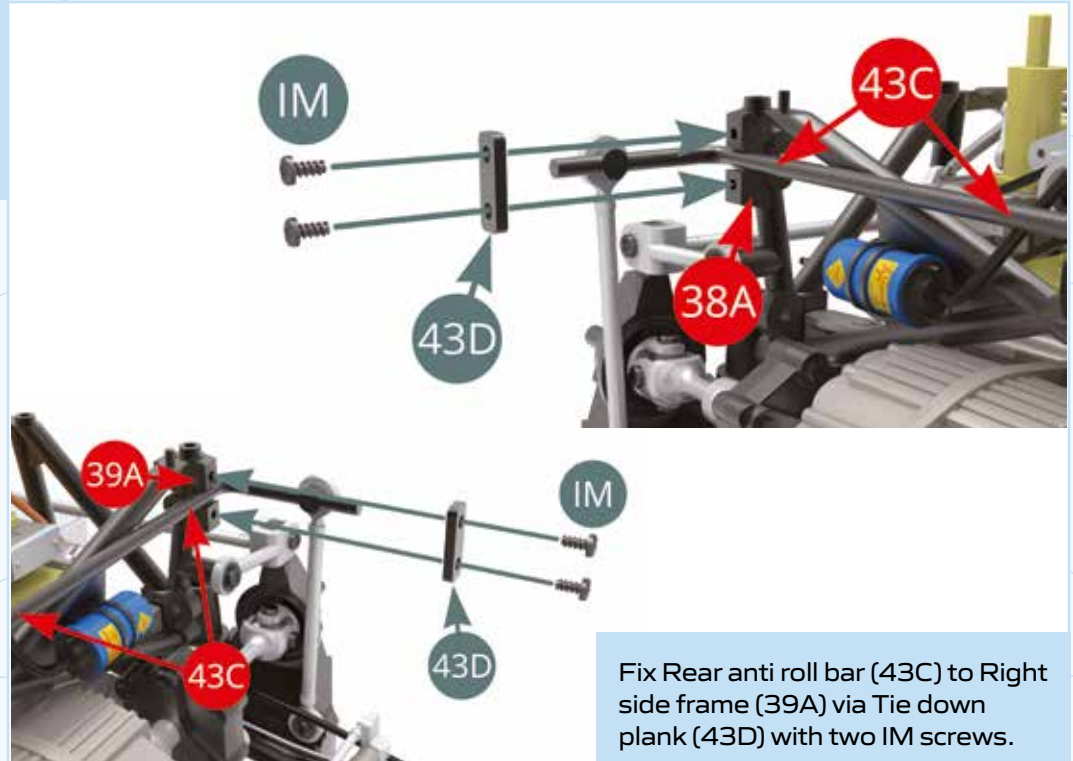


Fit Rear anti roll bar (43C) to Left (38A), Right (39A) side frames - blue arrows - and two Drop links (43B) - green arrows .



STEP 9

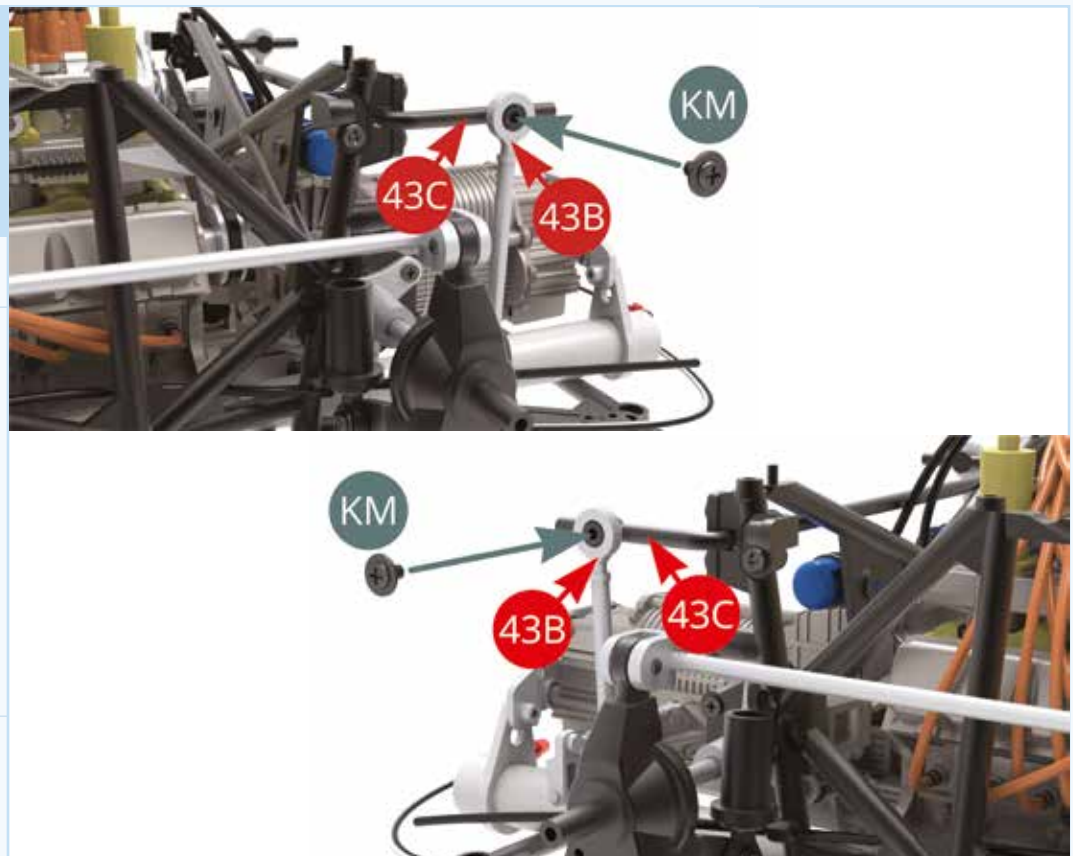
Fix Rear anti roll bar (43C) to Left side frame (38A) via Tie down plank (43D) with two IM screws.



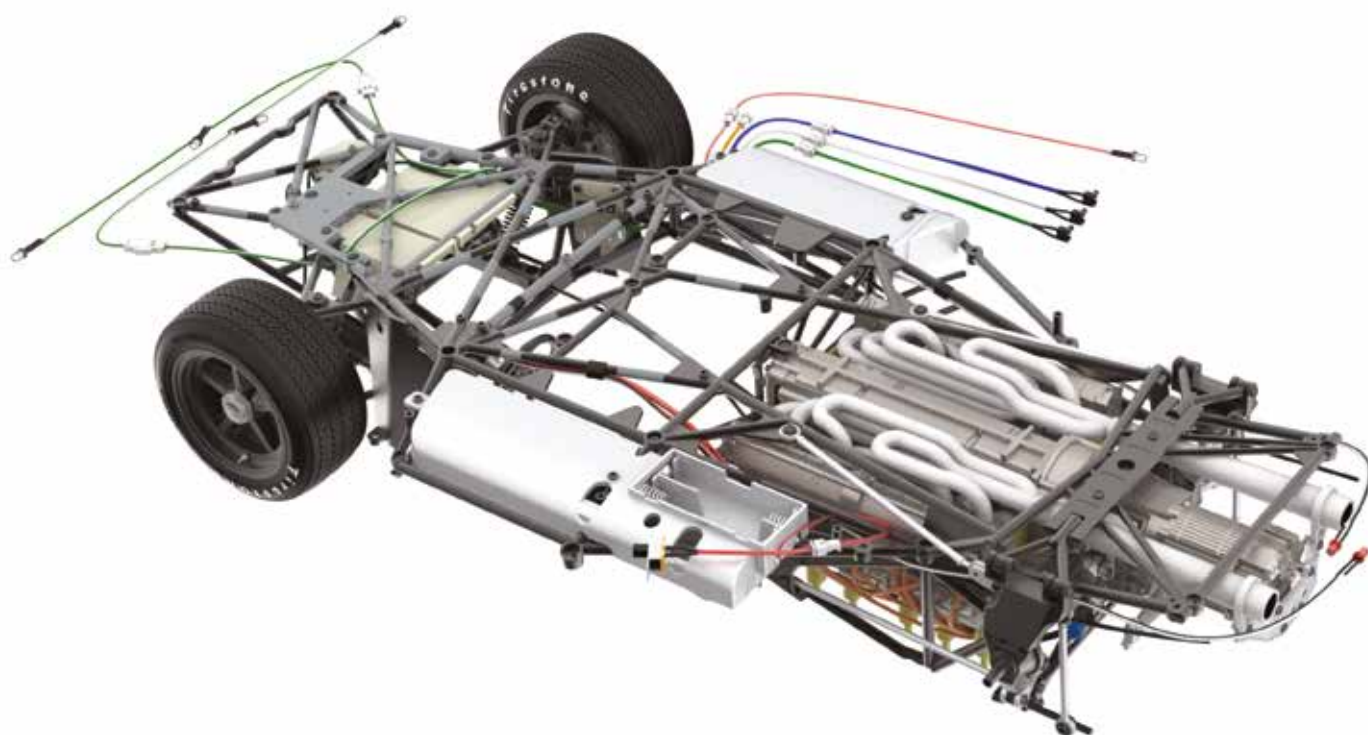
Fix Rear anti roll bar (43C) to Right side frame (39A) via Tie down plank (43D) with two IM screws.

STEP 10

Fix Rear anti roll bar (43C) to Left and Right side drop links (43B) with two KM screws (upper and lower illustrations).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 44

44A Left brake caliper

44B Right brake caliper

44C Brake piston cover (x 2)

44D Brake disc surface with ventilation holes to the right (x 2)

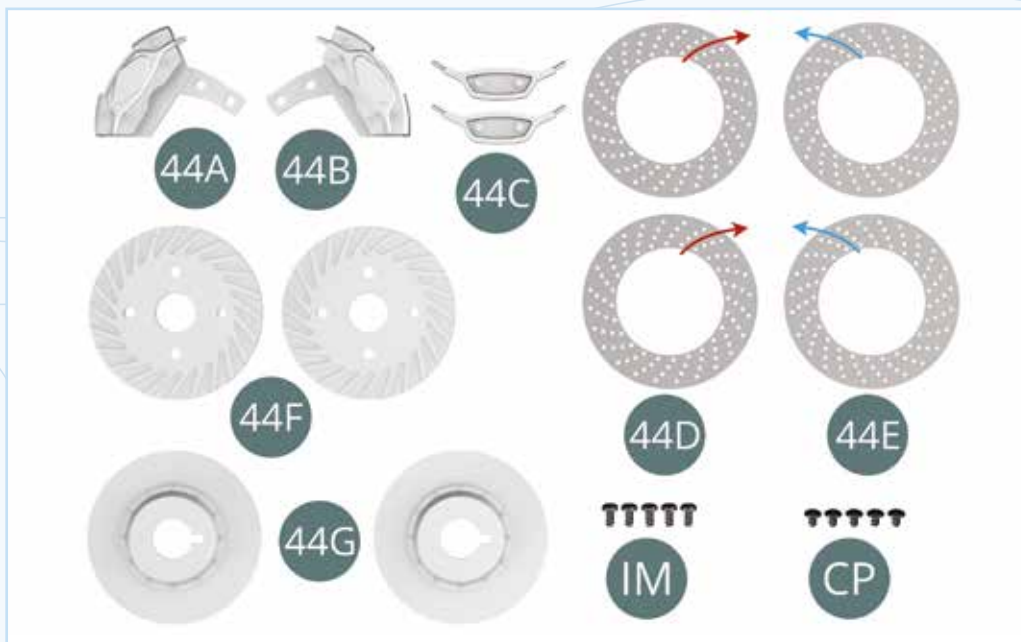
44E Brake disc surface with ventilation holes to the left (x 2)

44F Inner brake half disc (x 2)

44G Outer Brake half Disc (x 2)

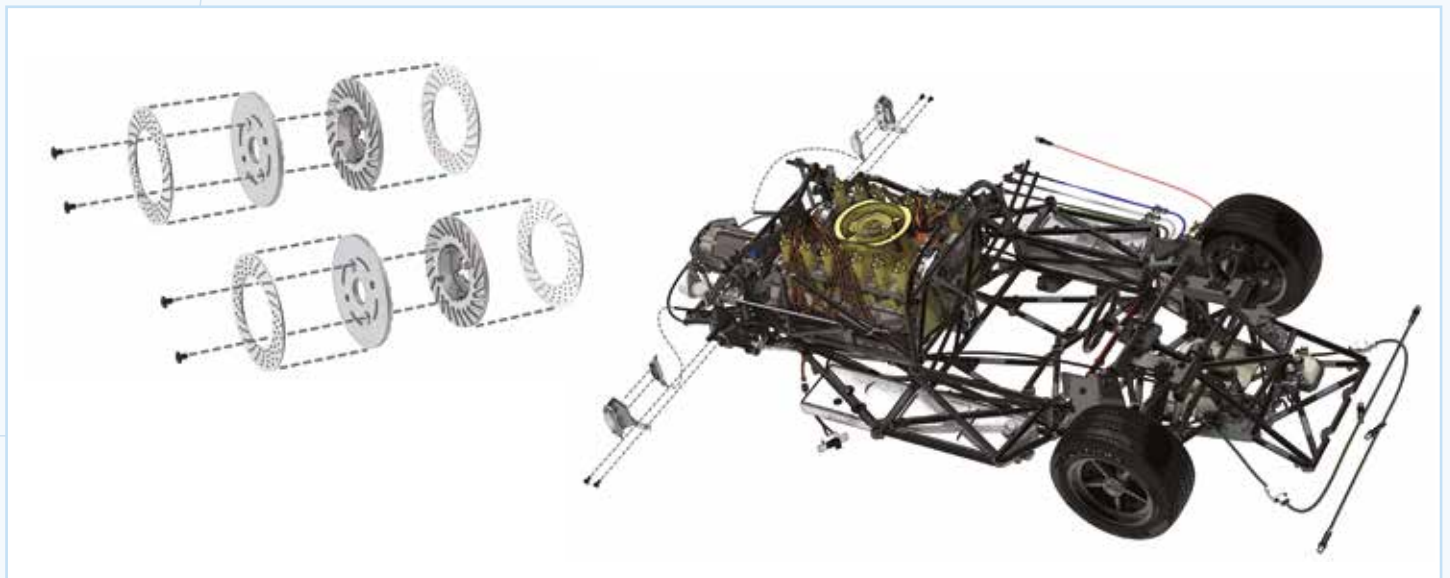
IM Screw M 1.7 x 3.5 mm (x 5)

CP Screw M 1.7 x 3 x 3 mm (x 5)



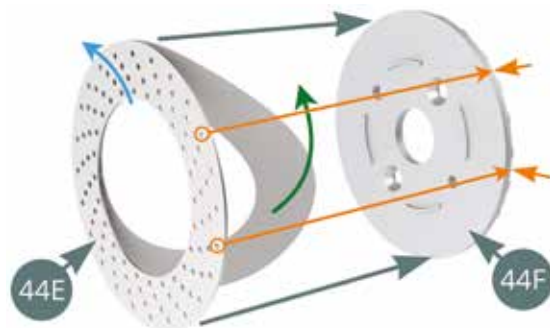
*Installation of
rear brake discs
and calipers*

ASSEMBLY DIAGRAM

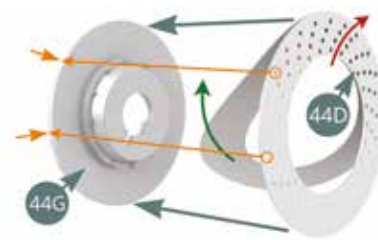


STEP 1

Remove the paper backing (green arrow) from the surface of the Brake disc (44E) - note the direction of the ventilation holes, blue arrow - and apply the adhesive to the inner Brake half disc (44F). Ensure that the outer holes are in front of the ribs of the disc (44F) - orange arrows.



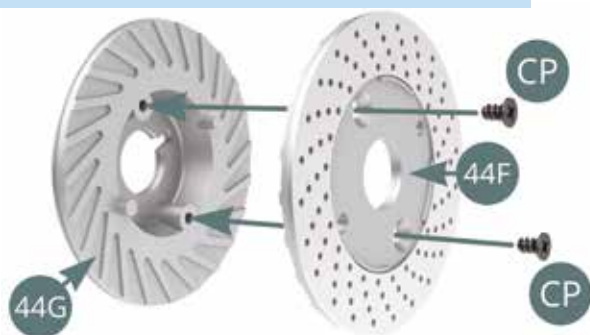
Right brake disc assembly



Peel off the paper backing (green arrow) from the surface of the Brake disc (44E) - note the direction of the ventilation holes, red arrow - and apply the adhesive to the outer Brake half disc (44G). Ensure that the outer holes are in front of the ribs of the disc (44G) - orange arrows.

STEP 2

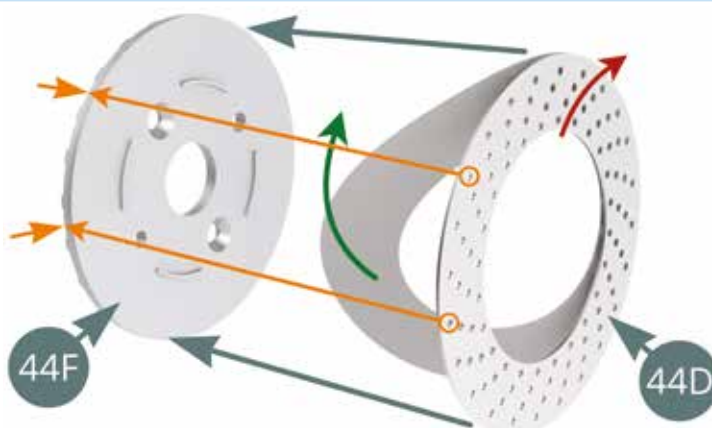
Position the Outer brake half discs (44G & 44F) together and attach them with two CP screws



Assembled right brake disc

STEP 3

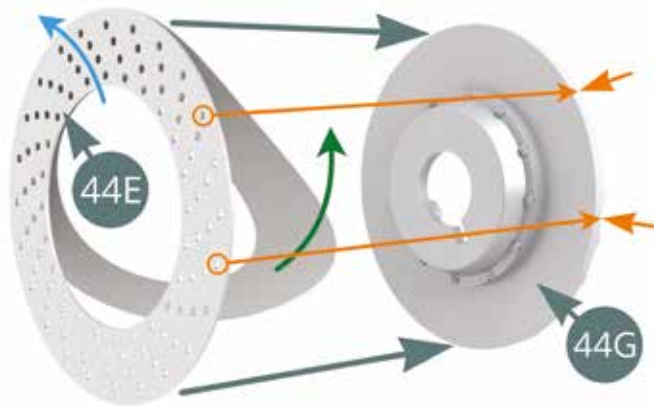
Remove the paper backing (green arrow) from the surface of the Brake disc (44D) - note the direction of the ventilation holes, red arrow - and apply the adhesive to the inner Brake half disc (44F). Ensure that the outer holes are in front of the ribs of the 44F disc (44F) - orange arrows.





STEP 4

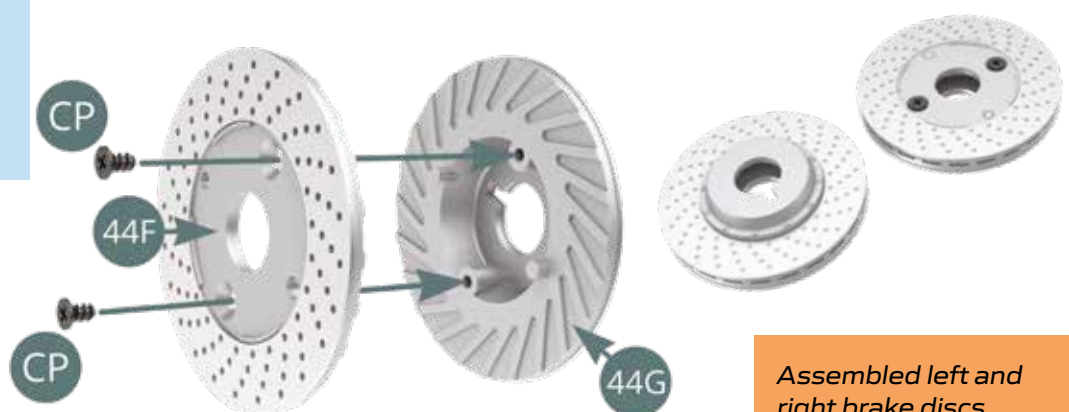
Remove the paper backing (green arrow) from the surface of the Brake disc (44E) - note the direction of the ventilation holes, blue arrow - and apply the adhesive to the outer Brake half disc (44G). Ensure that the outer holes are in front of the ribs of the disc (44G) - orange arrows.



Left brake disc assembly

STEP 5

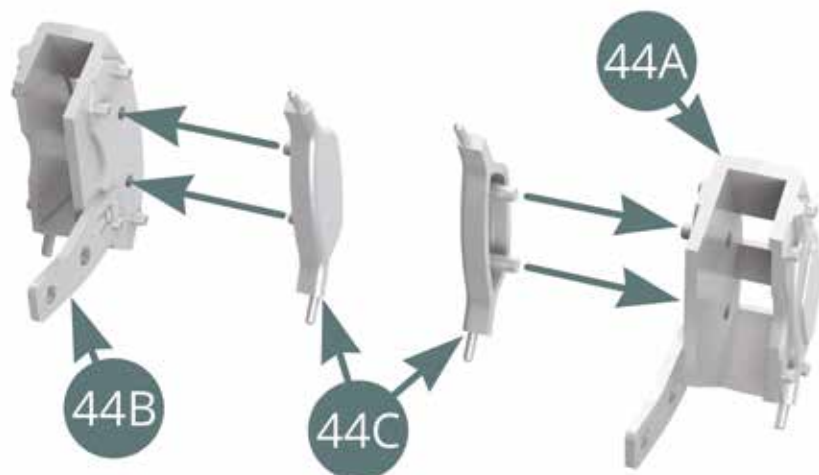
Position the outer Brake half discs (44G & 44F) together and secure them with two CP screws.



Assembled left and right brake discs

STEP 6

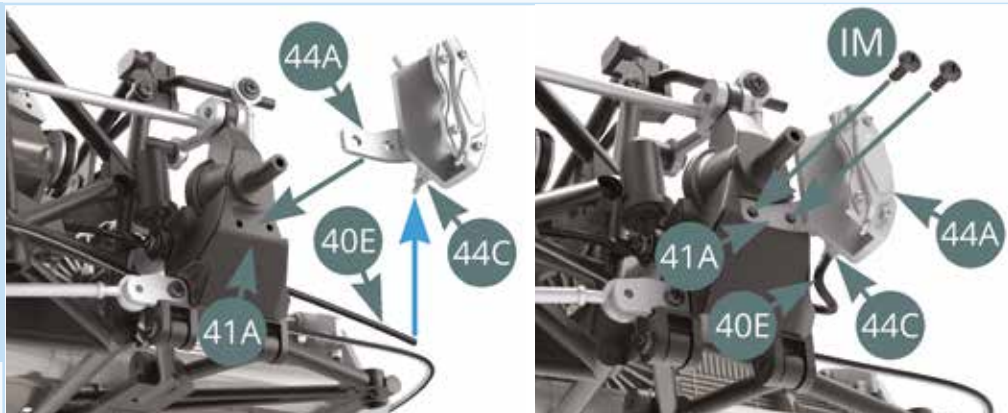
Position the Brake piston covers (44C) on the left Brake calipers (44A & 44B).



STEP 7

Connect the Brake line (40E) to the nipple at the bottom of the Piston cover (44C) - blue arrow.

Position the Left brake caliper (44A) on the left rear pivot (41A) and fix with two IM screws (illustrations opposite).



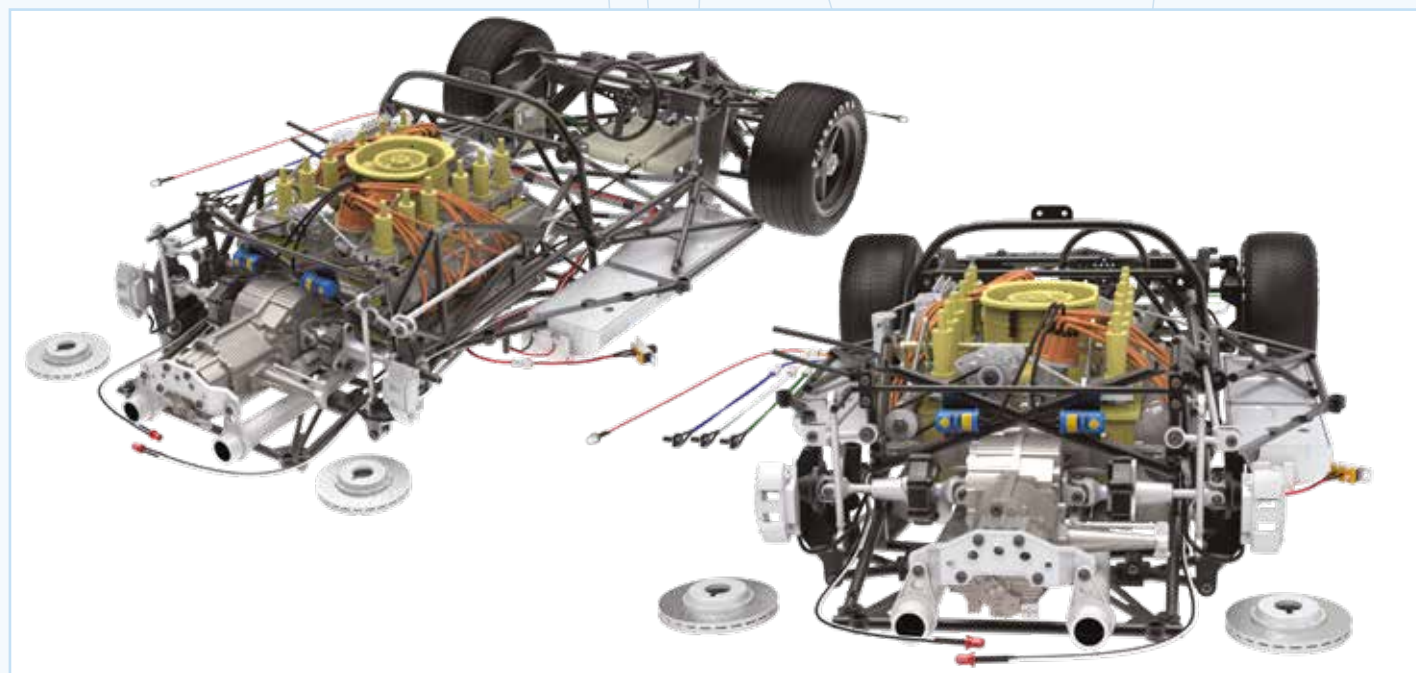
STEP 8

Connect the Brake line (40E) to the nipple at the bottom of the Piston cover (44C) - blue arrow.

Position the Right brake caliper (44B) on the Right rear pivot (42A) and fix it with two IM screws (illustrations opposite).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 45

45A Reinforcement frame

45B Left-hand stand

45C Right-hand stand

45D Transmission cooling line

45E Transmission cooling line

45F Pipe outlet

45G Support bracket

AP Screw M 1.7 x 4 mm (x 4)

IM Screw M 1.7 x 3.5 mm (x 3)

KM Screw M 1.7 x 3 x 5 mm (x 3)



Installation of the reinforcement frame and assembly of the transmission cooling line (left side)

ASSEMBLY DIAGRAM



STEP 1

Position the Pipe Outlet (45F) on the 45E-45D assembly.
Position the Support bracket (45G) on the line (45E) and secure it with an AP screw.
Connect the two Cooling line halves (45E and 45D) and secure with two AP screws.



STEP 2

Position the Pipe Outlet (45F) on the 45E-45D assembly.

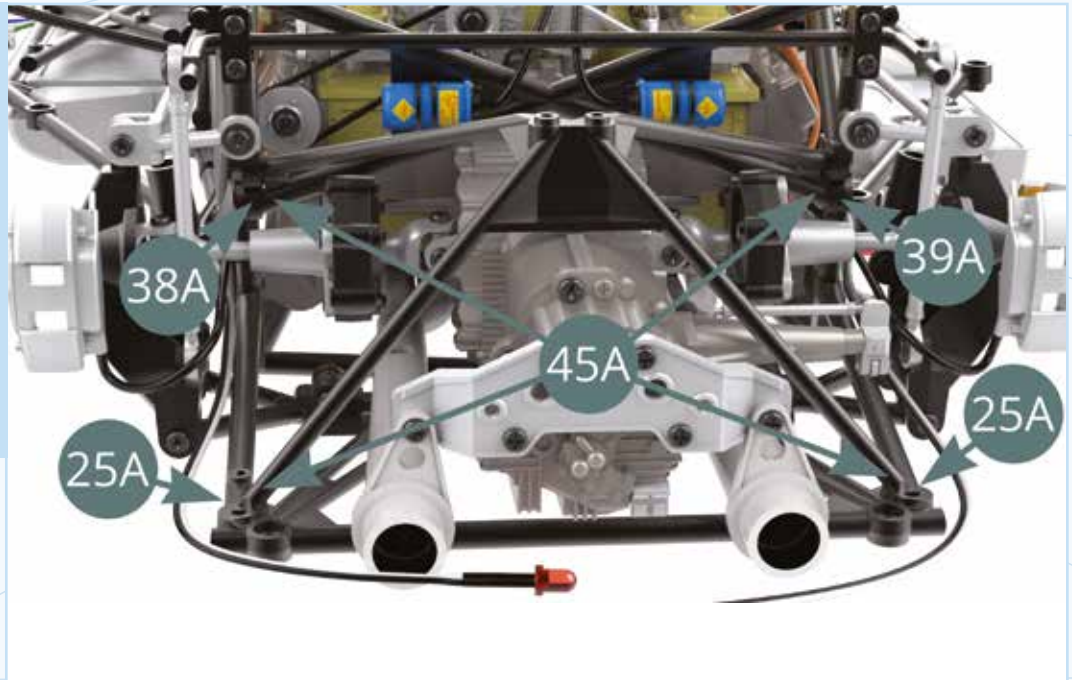




STEP 3

Position the Reinforcement frame (45A) on the Lower frame (25A) and on the left (38A) and right (39A) Side frames.

Fix the Reinforcement Frame (45A) to the left (38A) and right (39A) Side frames with two IM screws as shown in the two illustrations below.



Right side

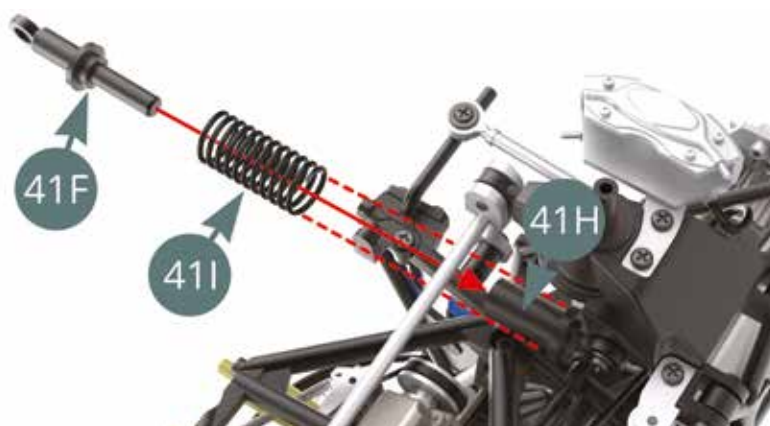


Left side



STEP 4

Position the Suspension Spring (41I) on the Damper (41H) - red dotted arrows. Position the Suspension piston rod (41F) into the Damper cylinder (41H) by passing it through the spring (41I). Position the Suspension piston rod head (41F) on the end of the bracket (41G) and secure it with a KM screw.



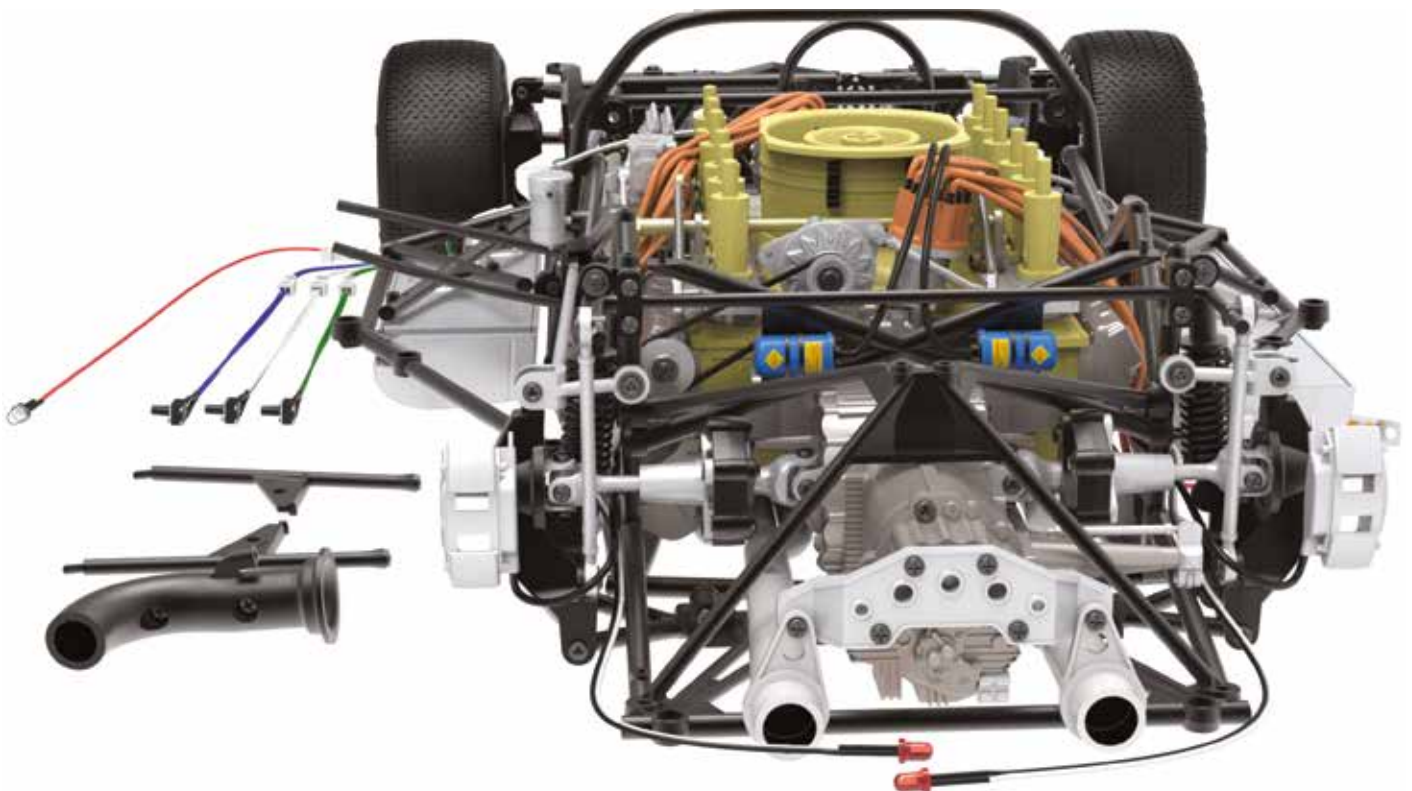
STEP 5

Position the Suspension spring (42I) on Damper (42H) - red dotted arrows. Position the Suspension piston rod (42F) into the Damper (42H) through the Spring (42I). Position the Suspension piston rod (42F) on the end of the Bracket (42G) and secure it with a KM screw.





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 46

46A Strut

46B Engine oil recovery tank

46C Tank cover

46D Engine oil recovery hose

46E Transmission cooling line

46F Transmission cooling line

46G Line outlet

46H Support bracket

46I Bonnet - Arm Support

46J Bonnet - Lift arm

46K Bonnet - Lift arm

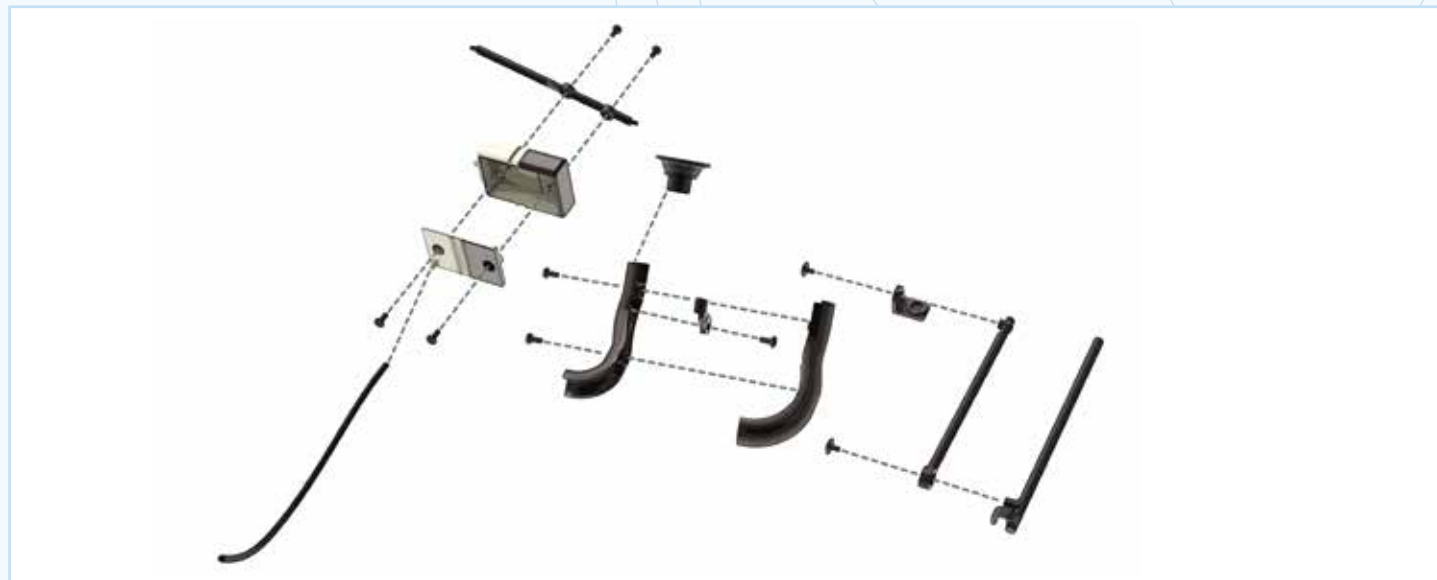
AP Screw M 1.7 x 4 mm (x 9)

KM Screw M 1.7 x 3 x 5 mm (x 3)



Assembly of engine oil recovery tank, transmission cooling line (right side) and bonnet folding lift arm

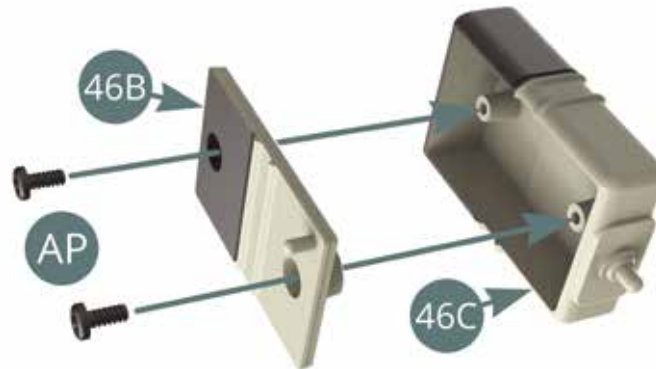
ASSEMBLY DIAGRAM





STEP 1

Position the Cover (46C) on the Engine oil recovery tank (46B) and secure with two AP screws.



Position the Strut (46A) on the Engine oil recovery tank (46B) and secure with two AP screws.



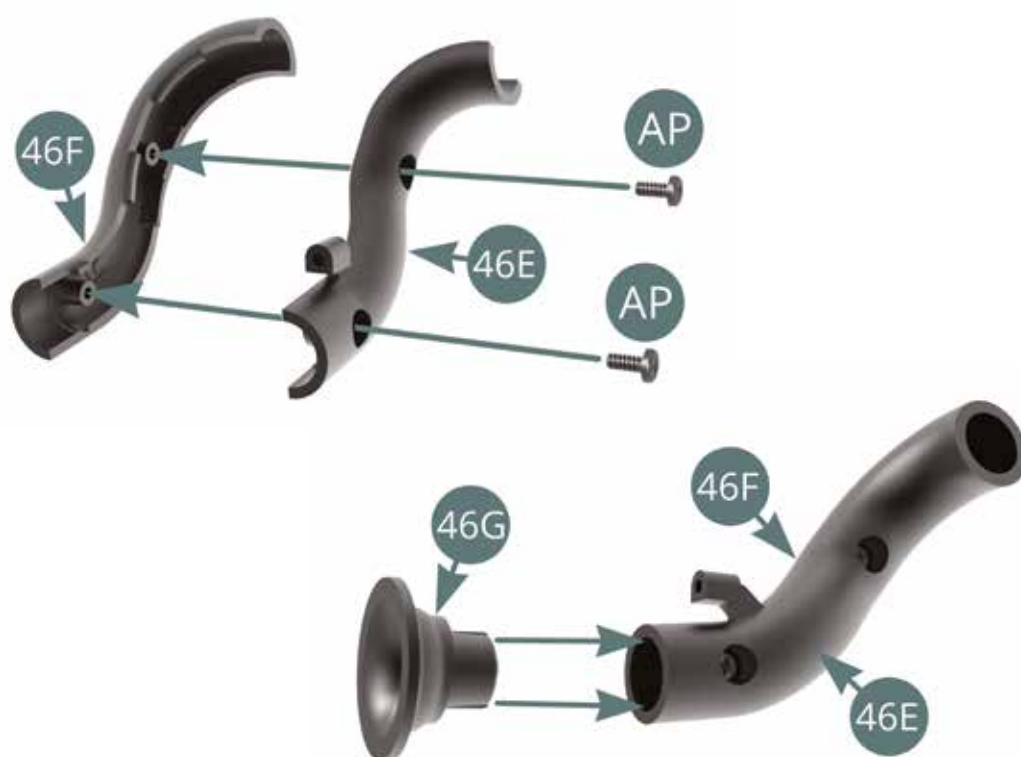
STEP 2

Position the Engine oil recovery hose (46D) on the Tank cover (46B). Position the Bracket (46H) on the line (46E) and secure it with an AP screw.



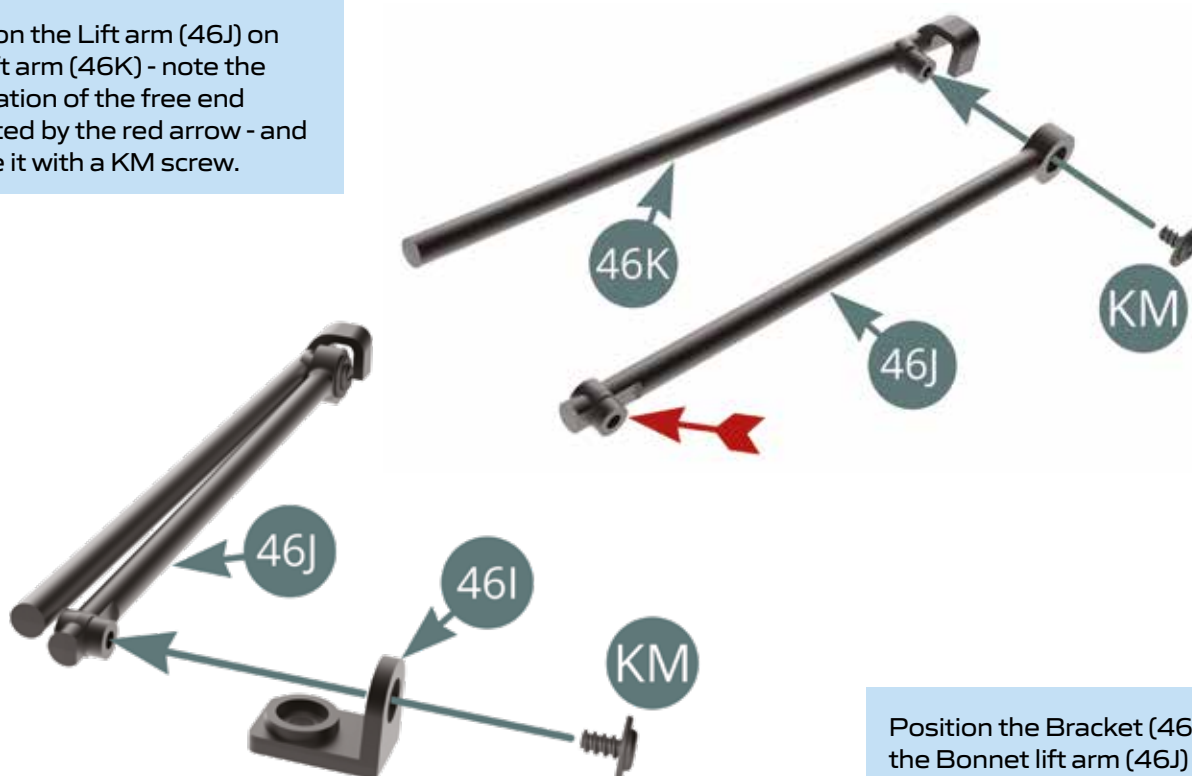
STEP 3

Connect the two Cooling line halves (46F and 46E) and secure them with two AP screws. Position the Line outlet (46G) on the 46E-46F assembly.



STEP 4

Position the Lift arm (46J) on the Lift arm (46K) - note the orientation of the free end indicated by the red arrow - and secure it with a KM screw.



Position the Bracket (46I) on the Bonnet lift arm (46J) and secure with a KM screw.

GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 47

47A Upper frame

47B Front lower strut (x 2)

47C Bracket (x 2)

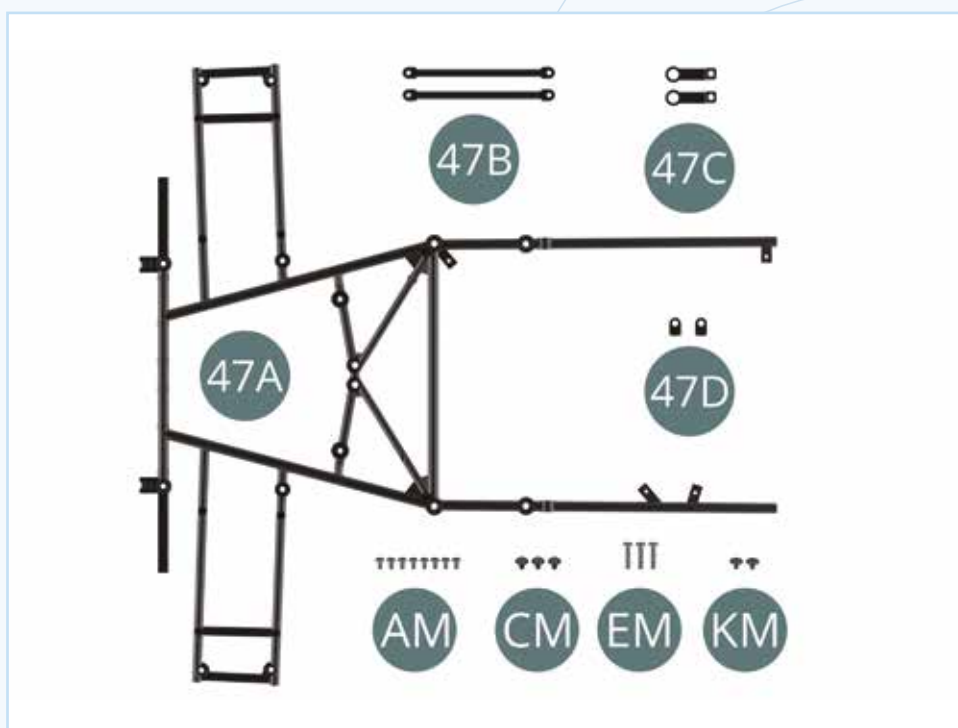
47D Bracket (x 2)

AM Screw M 1.7 x 3 mm (x 8)

CM Screw M 2.0 x 3 x 5 mm (x 3)

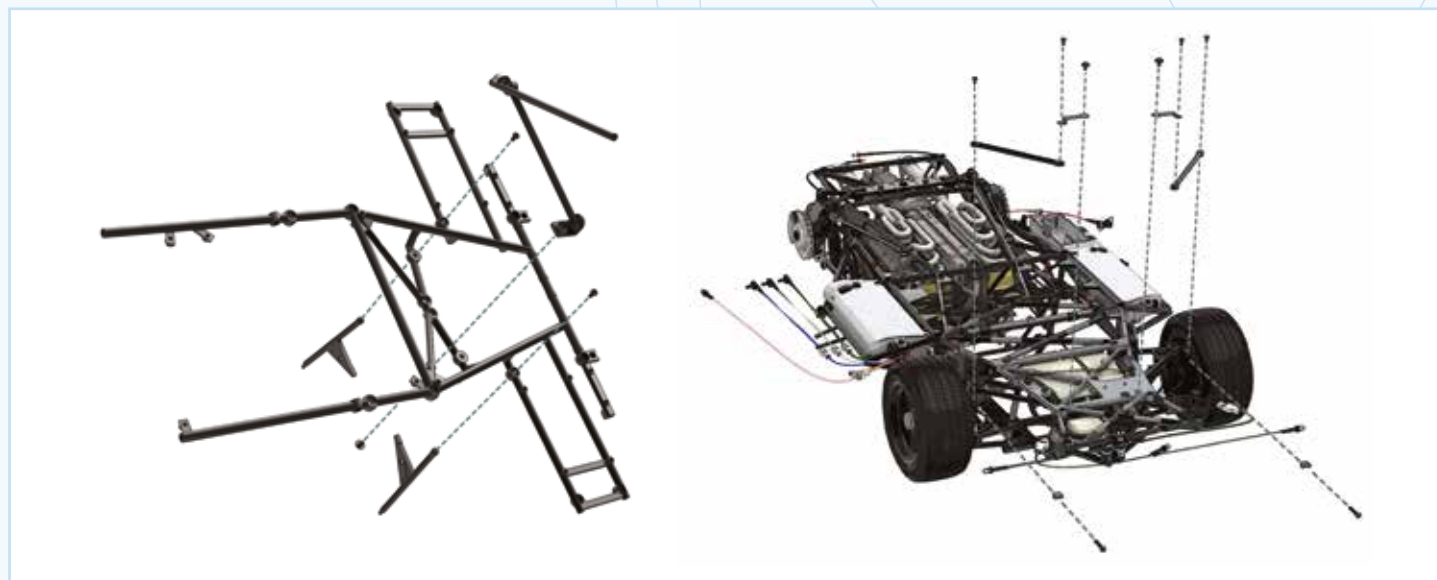
EM Screw M 2.0 x 9 mm (x 3)

KM Screw M 1.7 x 3 x 5 mm (x 2)



*Preassembly of
the upper frame.
Installation of
the front lower
struts*

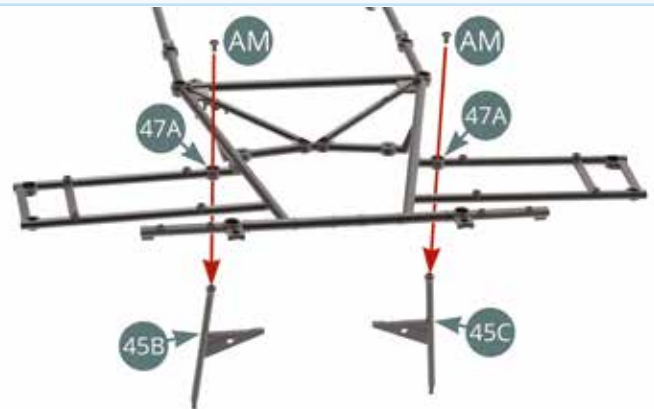
ASSEMBLY DIAGRAM





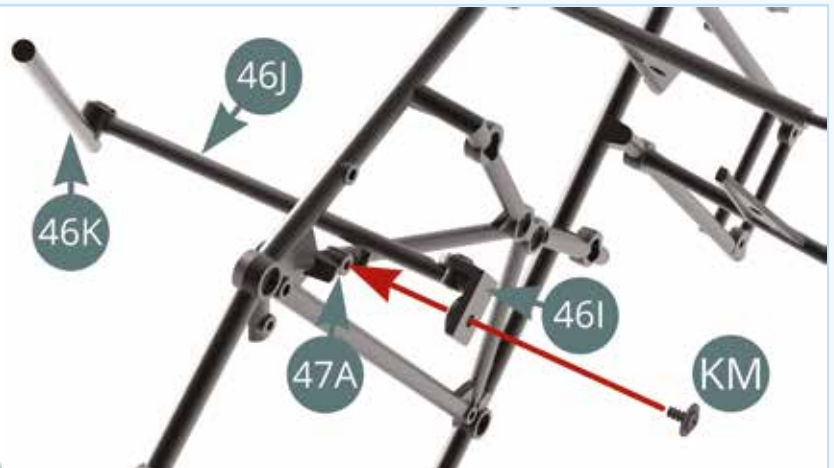
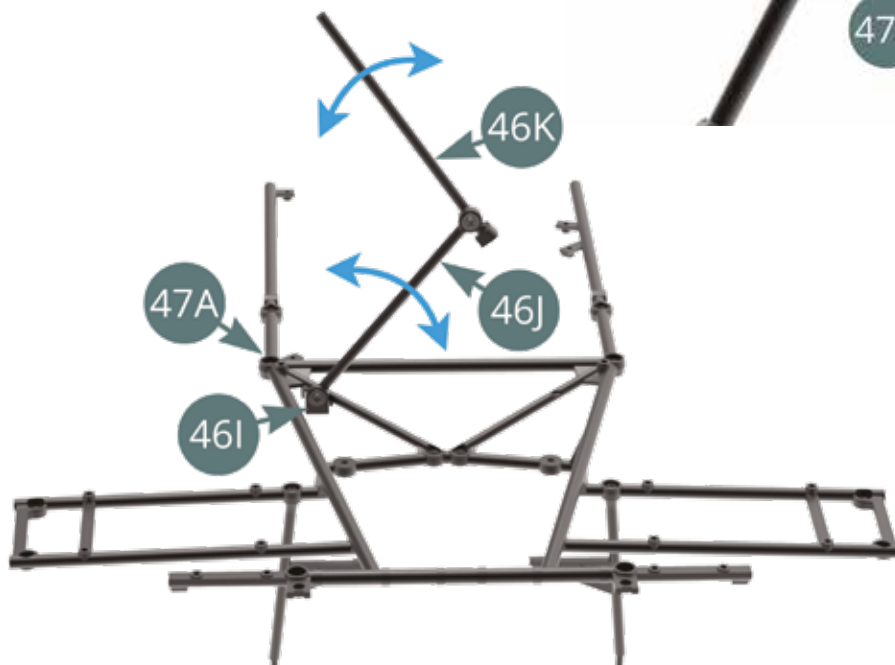
STEP 1

Position the left stand (45B) and right stand (45C) on the Upper frame (47A) and secure each with an AM screw (see illustrations opposite and below).



STEP 2

Position the Bonnet lift arm (46K-46J) on the Upper frame (47A) via the bracket 46I and secure with a KM screw.



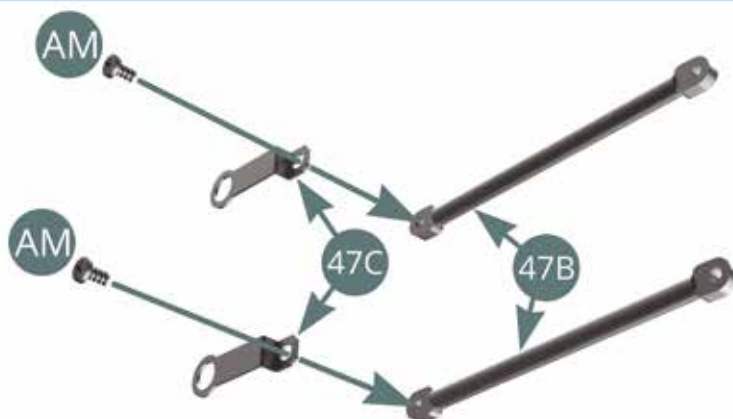
Check that the lift arms (46K-46J) fold and unfold correctly (blue arrows) as shown in the picture.

Preassembled
upper frame



STEP 3

Position a Bracket (47C) on each Front lower strut (47B) and secure with an AM screw.



STEP 4

Unscrew the DM screw from the left upright joint 3I & 3K (red arrow) and secure it on the other side with an EM screw by attaching the Bracket (47D) - blue arrow.

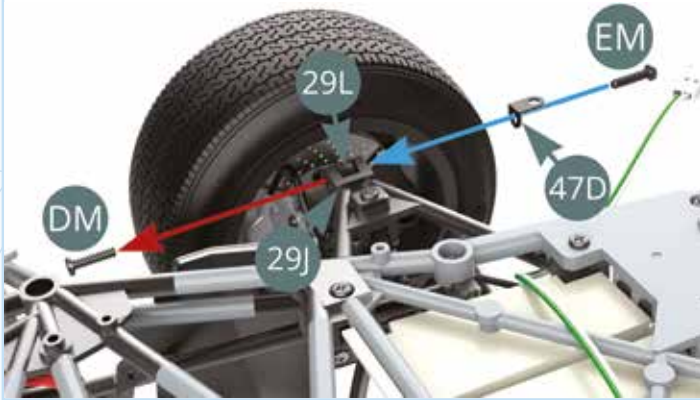


Position the free end of the Front lower strut (47B) on the Bracket (47D) and the Bracket (47C) of the other end on the Lower frame (25A). Then fix them with an AM and CM screw respectively (under the left side).



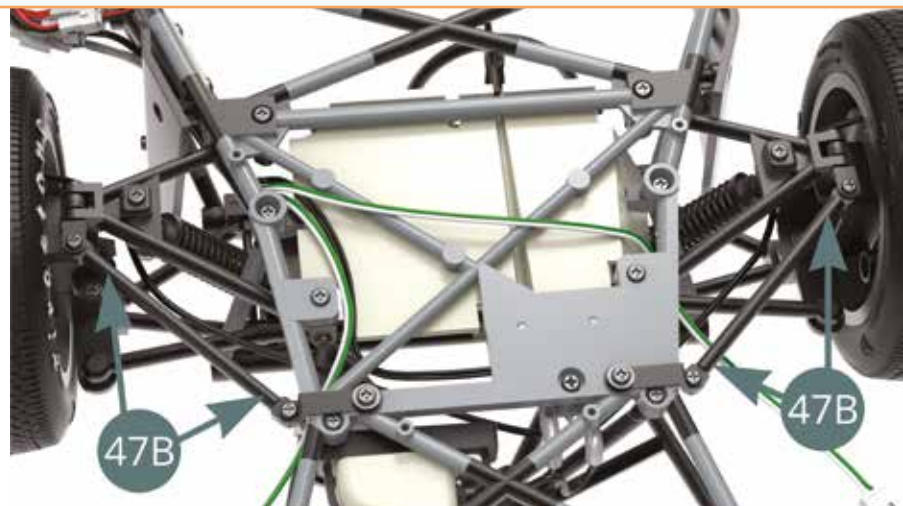
STEP 5

Unscrew the DM screw from the Left upright joint (3J-3L) - red arrow - and secure it on the other side with an EM screw by attaching the Bracket (47D) - blue arrow.

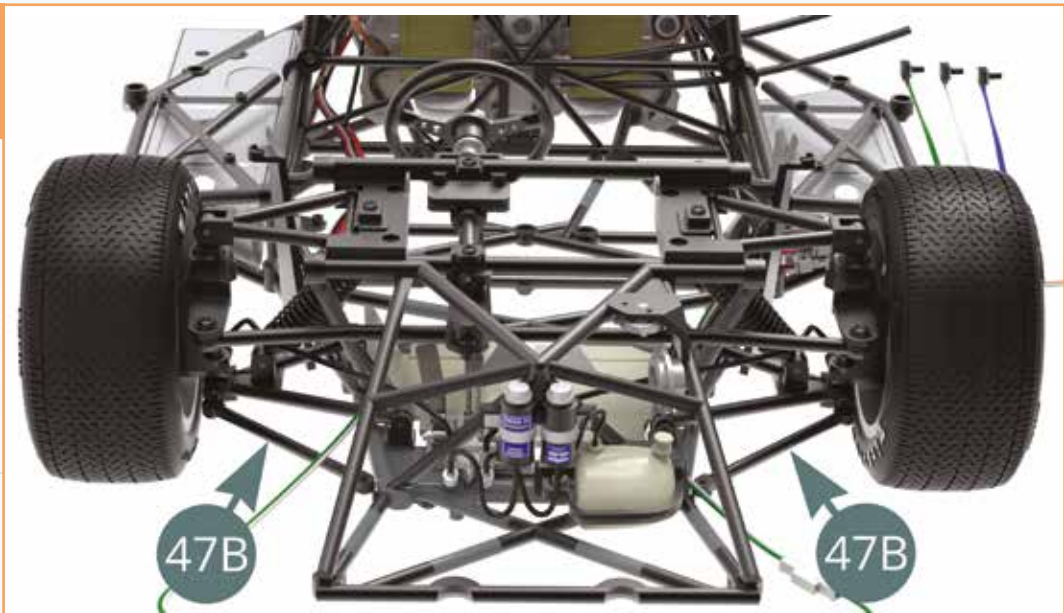


Position the free end of the Front lower strut (47B) on the Bracket (47D) and the Bracket (47C) of the other end on the Lower frame (25A). Then fix them with a screw AM and CM respectively (under the right side).

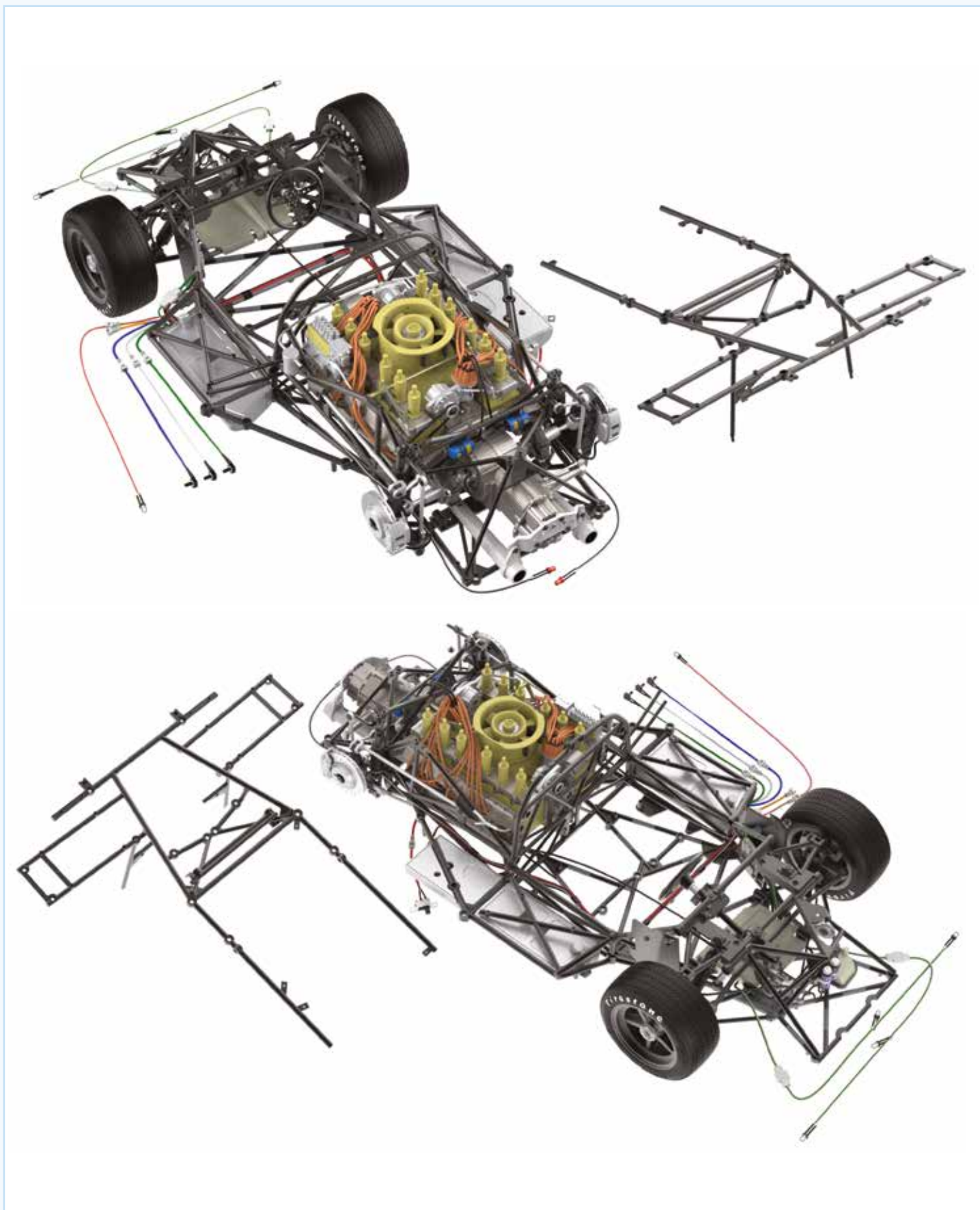
Front lower struts (47B) installed on the front suspension, view from below



Front lower struts (47B) installed on the front suspension, top view



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 48

48A Left tripod bar

48B Left tail light housing

48C Left tail light reflector

48D Left tail light

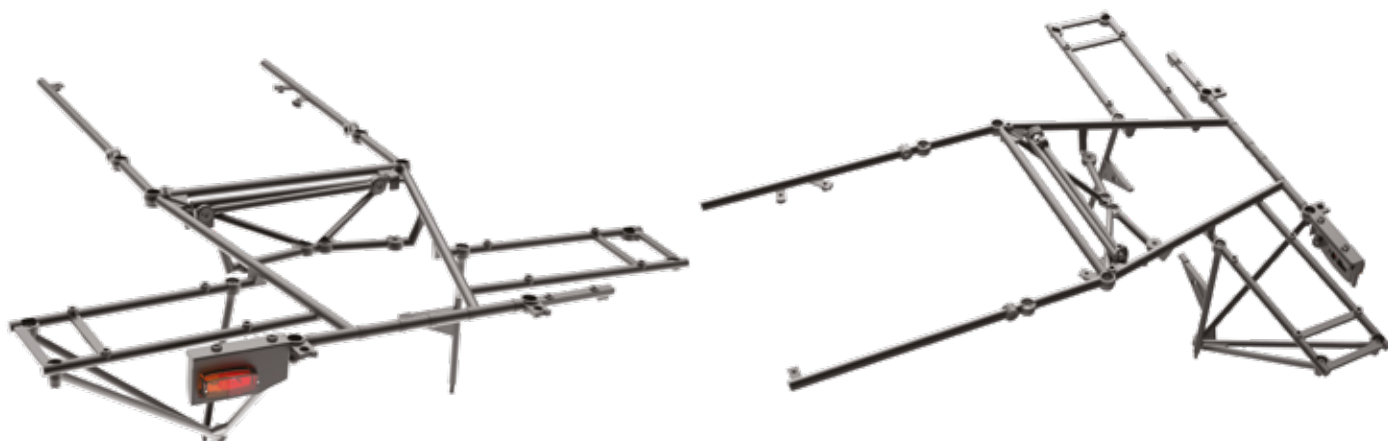
AM Screw M 1.7 x 3 mm (x 6)

AP Screw M 1.7 x 4 mm (x 2)



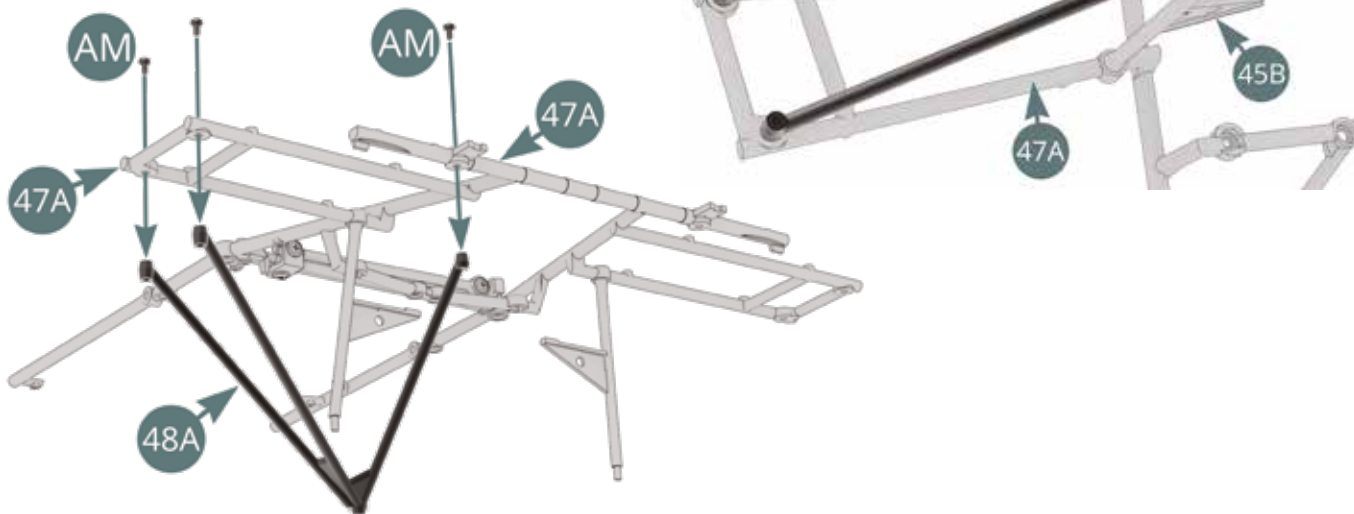
Preassembly of the upper chassis and installation of the left tail light

ASSEMBLY DIAGRAM



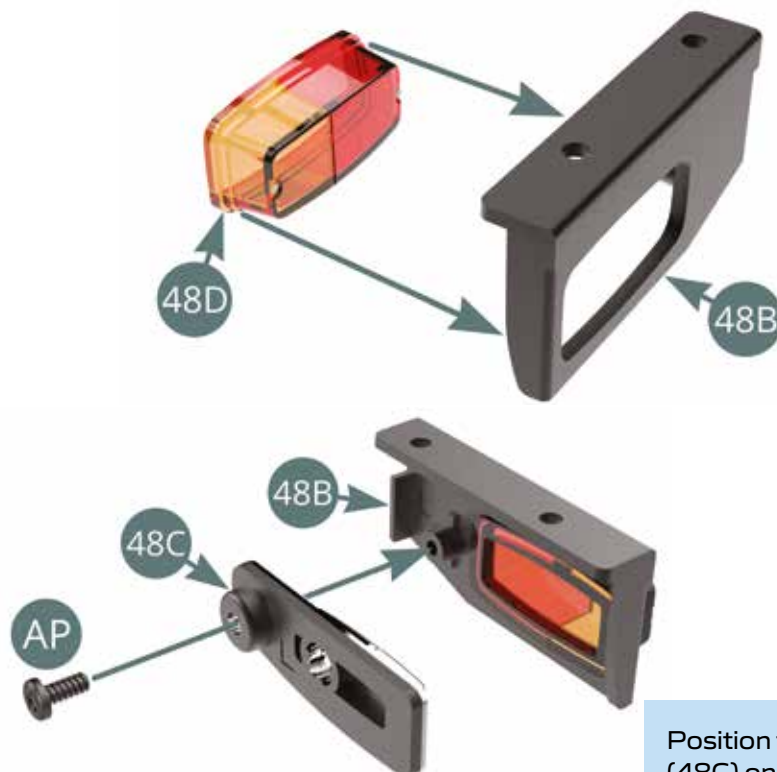
STEP 1

Position the Left Tripod Bar (48A) on the Top frame (47A) and secure with three AM screws (shown opposite and below).



STEP 2

Position the Left tail light (48D) in the housing (48B).

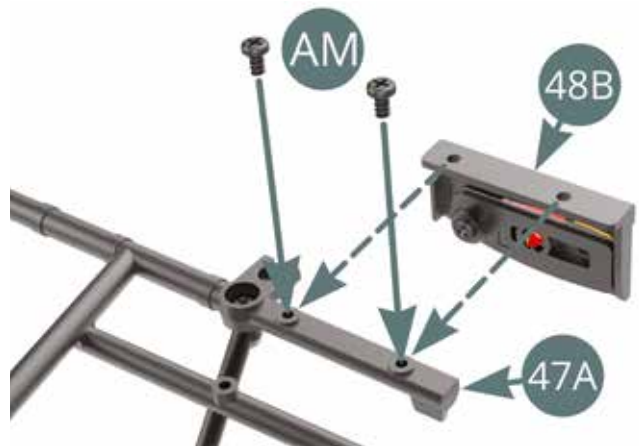


Position the Reflector (48C) on the Left tail light housing (48B) and secure it with an AP screw.



STEP 4

Position the left tail light housing (48B) on the right rear end of the Upper frame (47A) and secure with two AM screws (shown opposite).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 49

49A Right tripod bar

49B Right tail light housing

49C Right tail light reflector

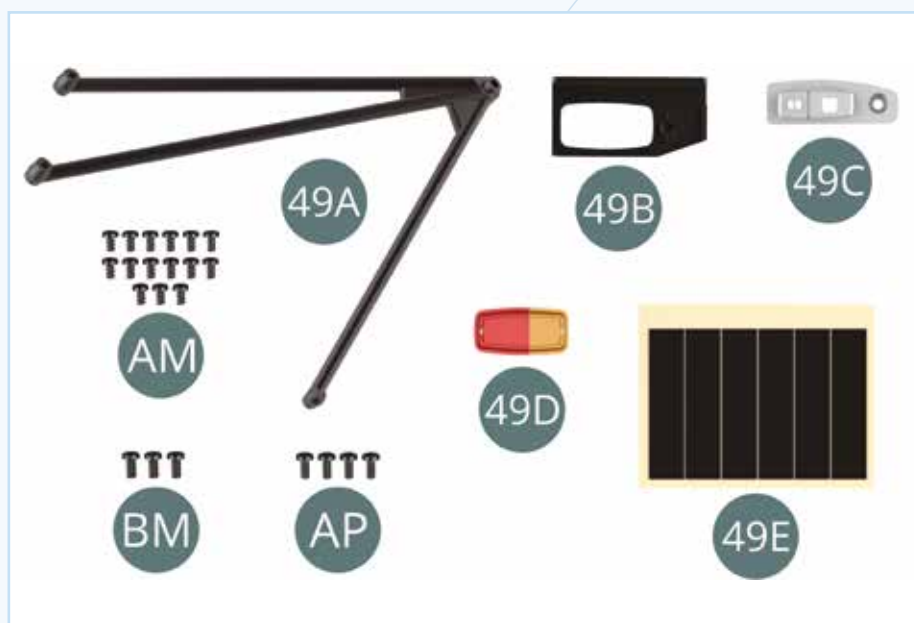
49D Right tail light

49E Adhesive tape (x 6)

AM Screw M 1.7 x 3 mm (x 15)

AP Screw M 1.7 x 4 mm (x 4)

BM Screw M 2.0 x 4 mm (x 3)



*Preambly of the upper frame and installation of the right rear light
Assembly of the transmission cooling lines and engine oil recovery tank
Assembly of the upper frame to the main frame*

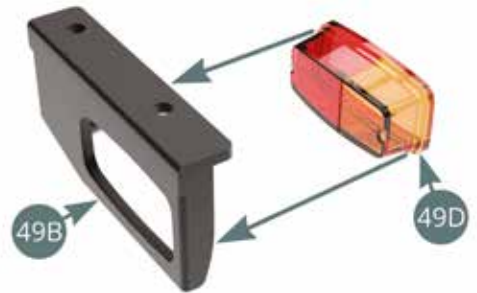
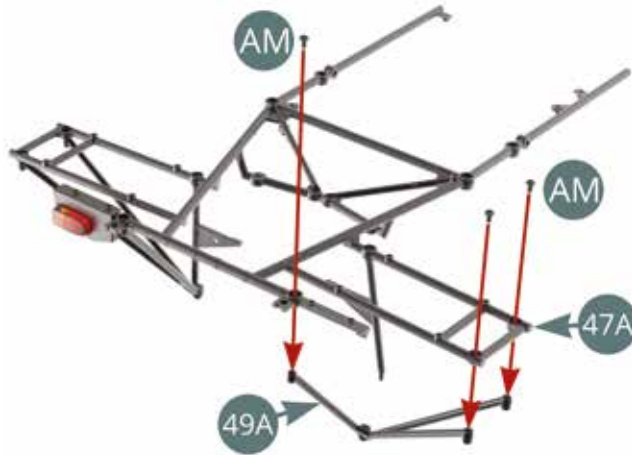
ASSEMBLY DIAGRAM





STEP 1

Position the right tripod bar (49A) on the upper frame (47A) and secure it with three screws AM.

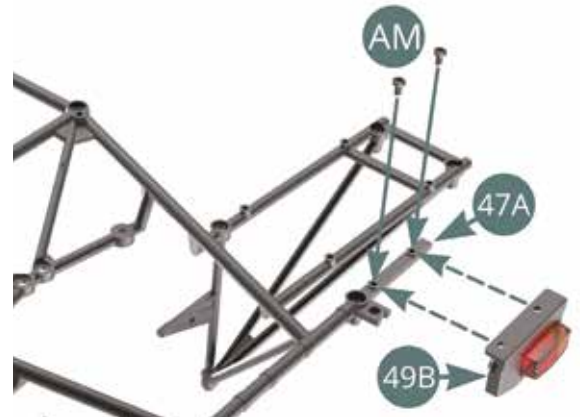


Position the right rear light (49D) into the housing (49B).

STEP 2

Position the reflector (49C) onto the right rear light housing (49B) and secure with one AP screw.

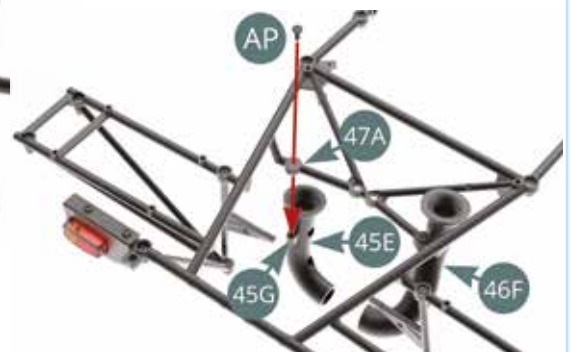
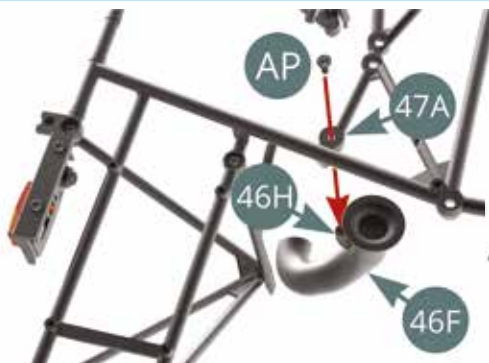
Position the right rear light housing (49B) on the right rear end of the upper frame (47A) and secure with two AM screws.



STEP 3

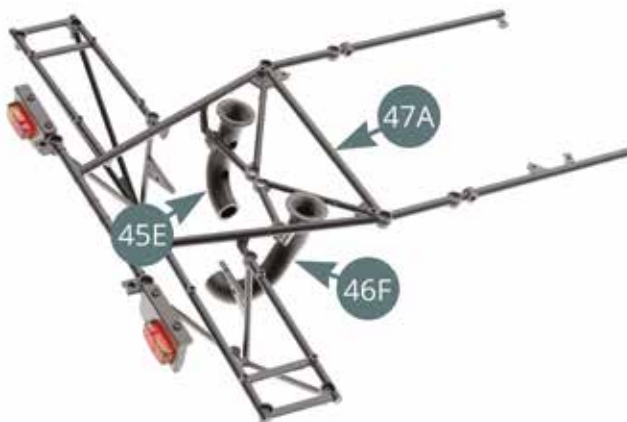
Position the transmission cooling line (46F) on the right side of the upper frame (47A) and secure it with an AP screw.

Position the transmission cooling line (45E) on the left side of the upper frame (47A) and secure with an AP screw.



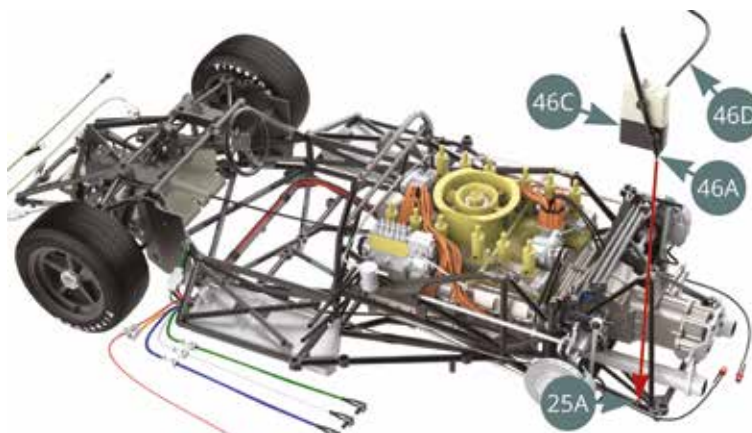
STEP 4

The upper frame (47A) is ready to be installed on the main frame.



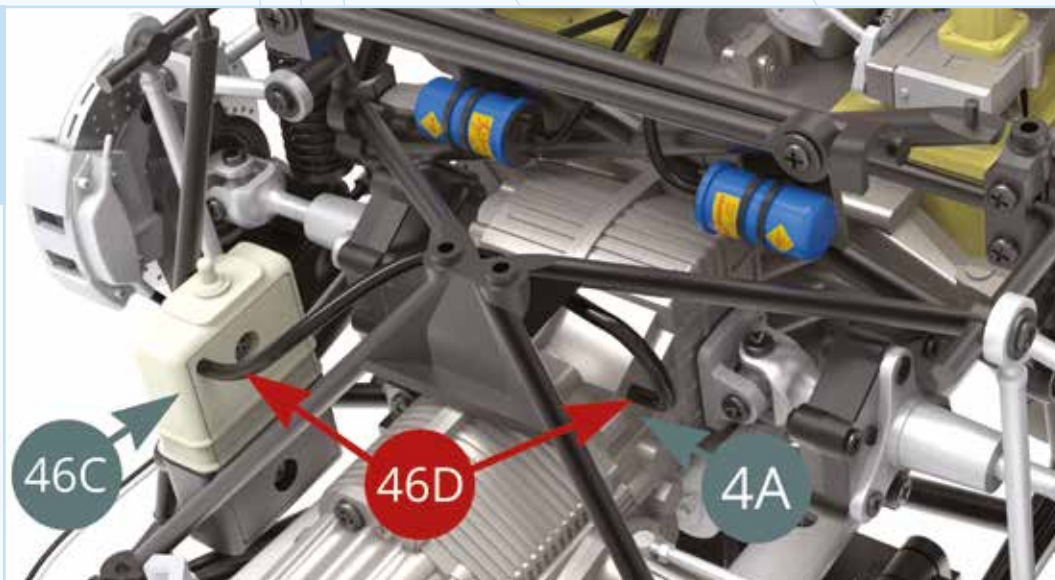
STEP 5

Position the engine oil recovery tank (46C) on the lower frame (25A) via the strut (46A).



STEP 6

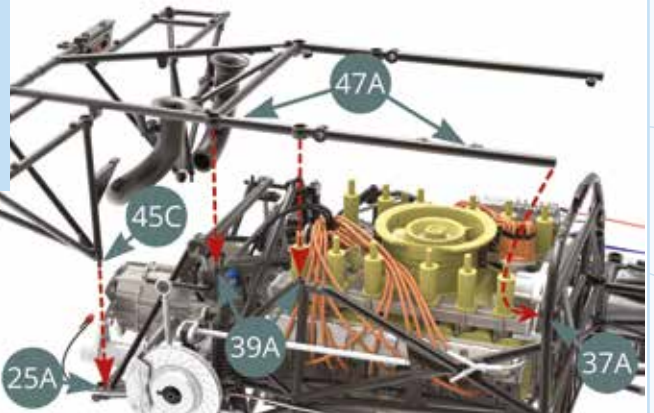
Position the engine oil recovery hose (46D) onto the nipple of the right gearbox housing (4A).





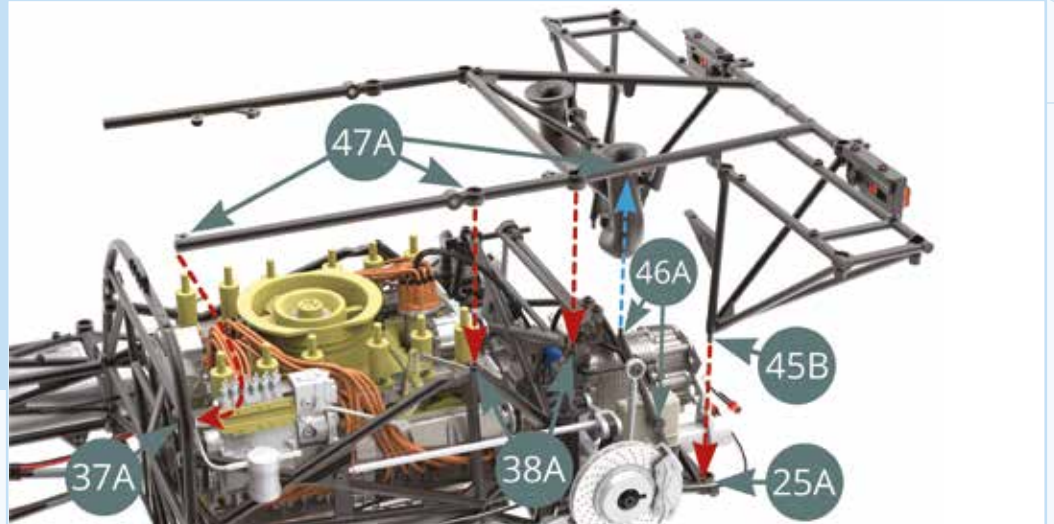
STEP 7

Align and position (by engaging the studs in the corresponding sockets as indicated by the red dotted arrows) the upper frame (47A) and the right-hand stand (45C) on the lower frame (25A), the right side frame (39A) and the cockpit partition frame (37A).



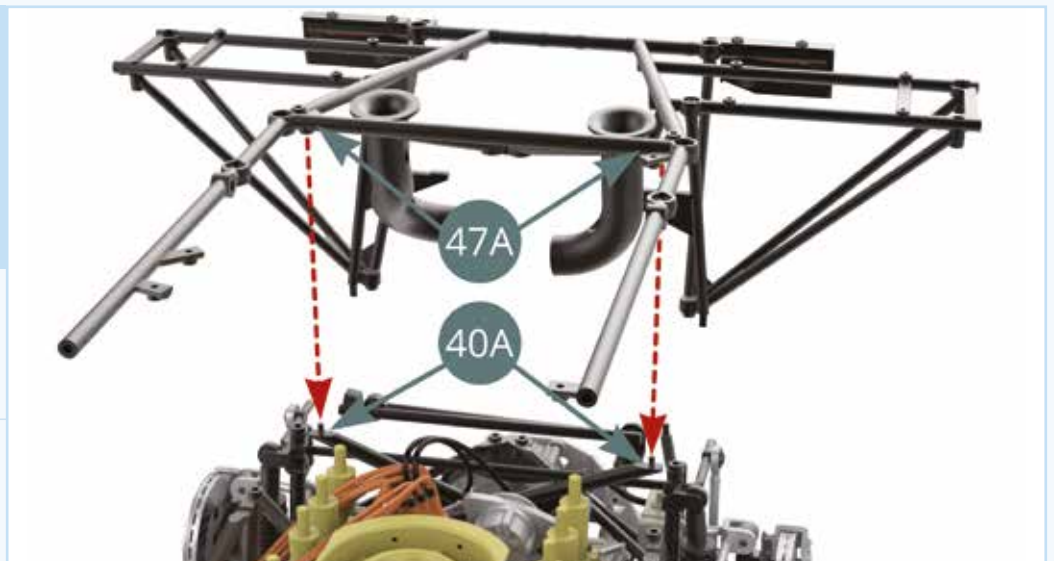
STEP 8

Align and position (by engaging the studs in the corresponding sockets as indicated by the red dotted arrows) the upper frame (47A) and the left-hand stand (45B) on the lower frame (25A), the left side frame (38A) and the cockpit partition frame (37A).



STEP 9

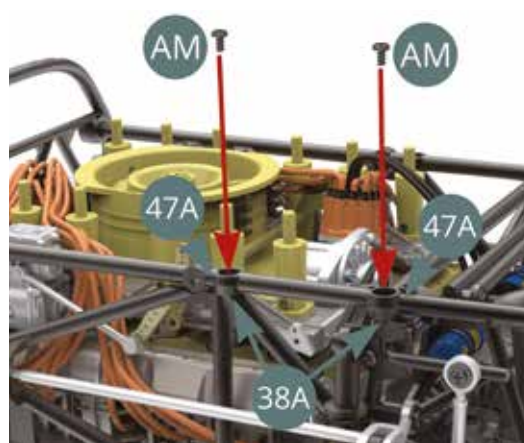
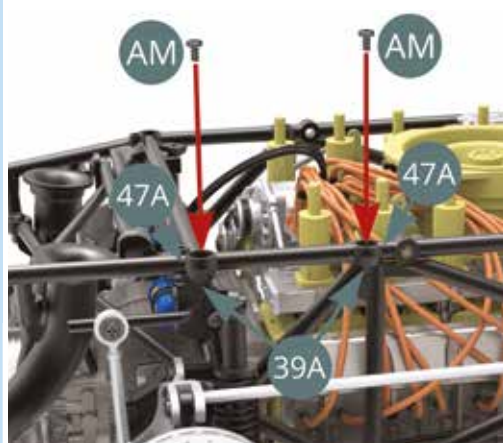
Align and position the upper frame (47A) - by engaging the pins in the corresponding sockets as indicated by the red dotted arrows - on the X-frame (40A).



STEP 10

Attach the upper frame (47A) to the right side frame (39A) with two AM screws.

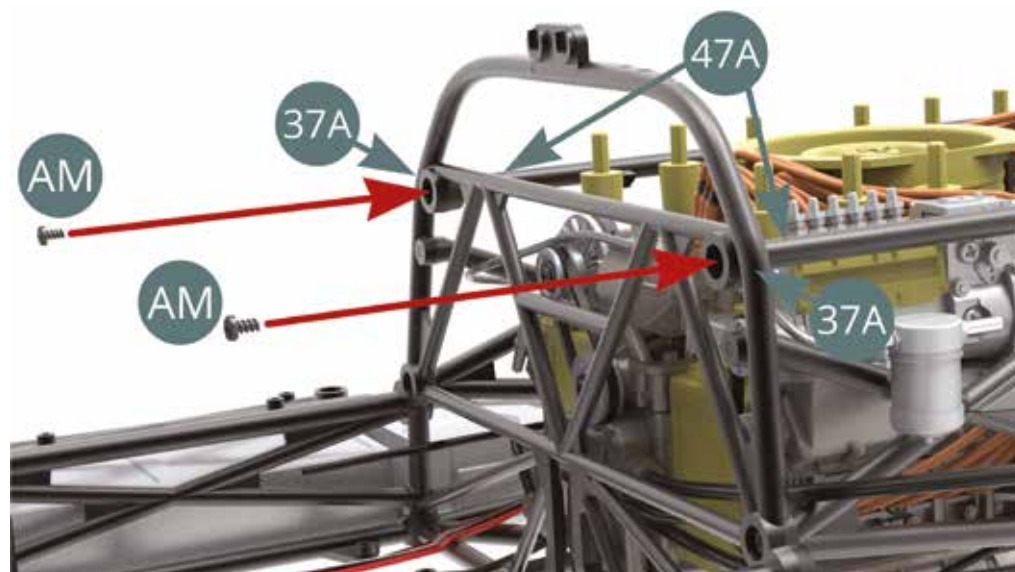
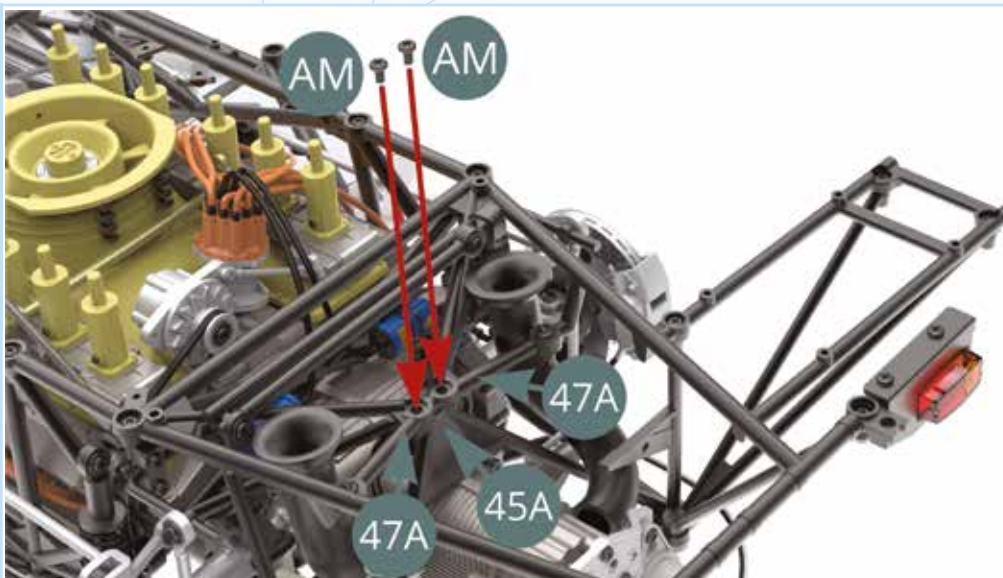
Fix the upper frame (47A) to the left side frame (38A) with two AM screws.



STEP 11

Attach the upper frame (47A) to the reinforcement frame (45A) with two AM screws.

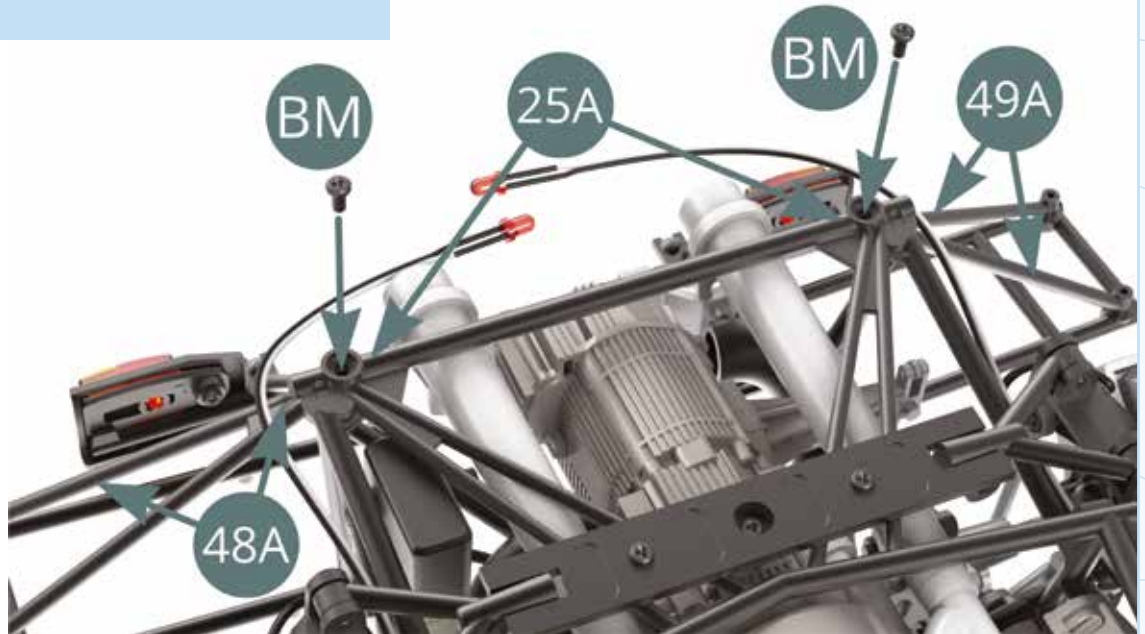
Secure the upper frame (47A) to the cockpit partition frame (37A) with two AM screws.





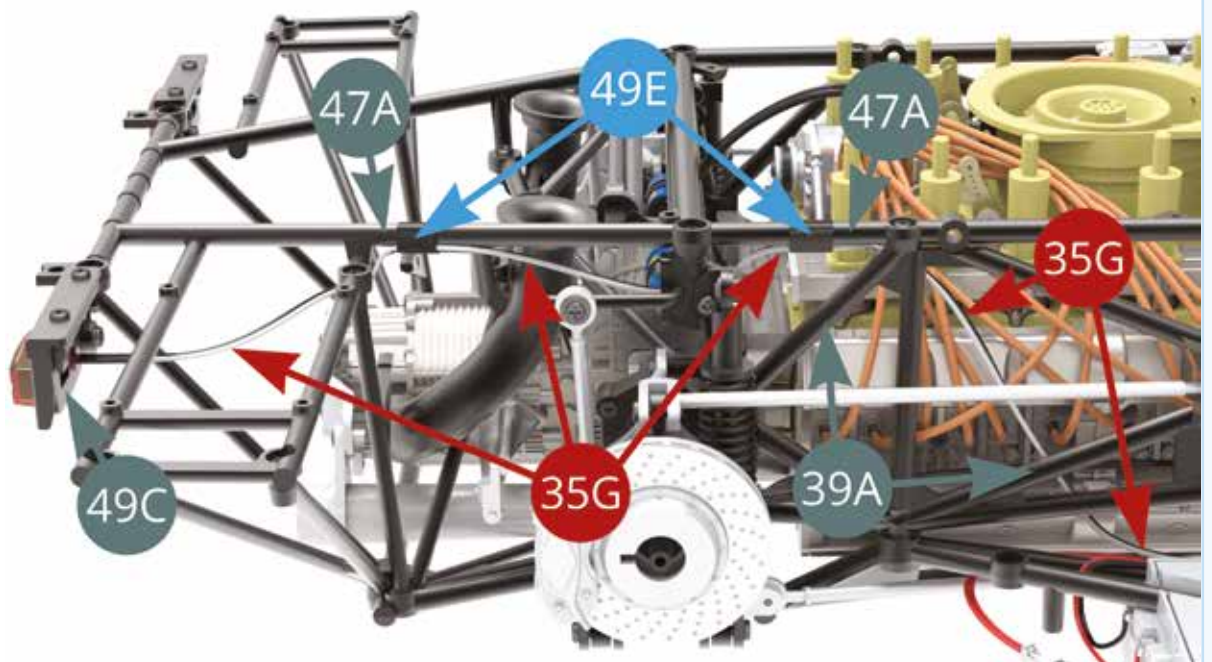
STEP 12

Attach the rear ends of the lower frame (25A) to the left (48A) and right (49A) tripod bars with two BM screws.



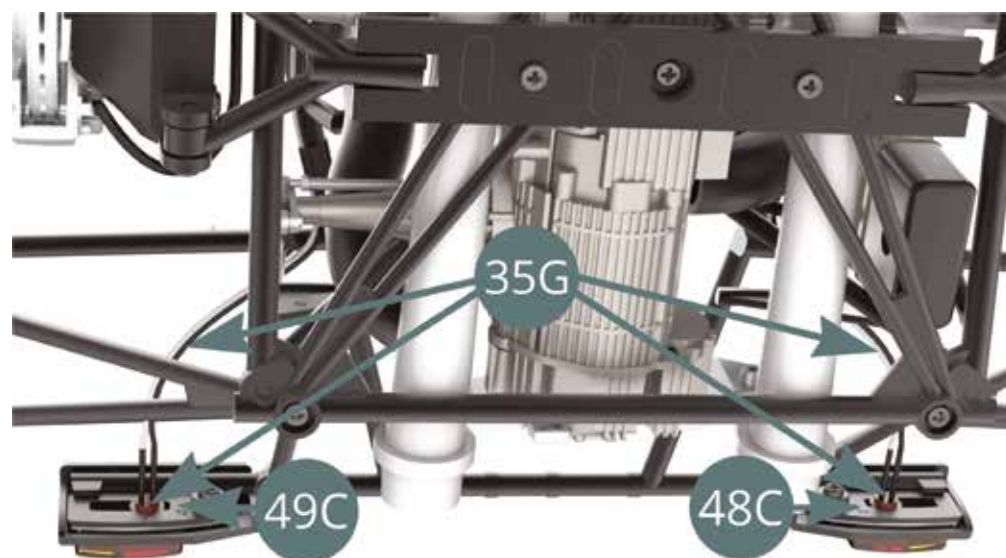
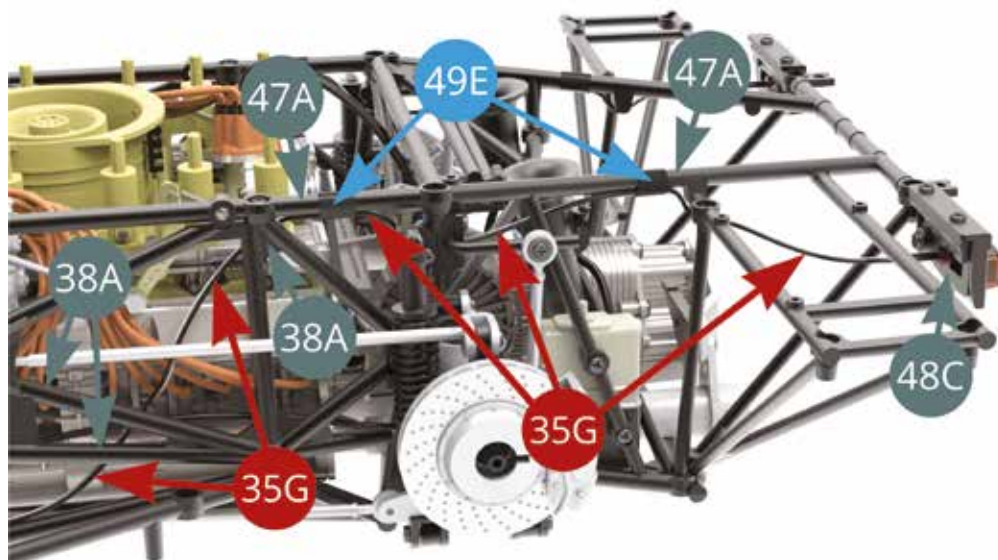
STEP 13

Run the tail light LED cable (35G) - black-white - behind the right side frame (39A), attach it to the top right bar of the upper frame (47A) with two adhesive tapes (49E), then engage the lamp in the right tail light reflector (49C).



STEP 14

Run the tail light LED cable (35G) - black-white - behind the left side frame (38A), attach it to the top left bar of the upper frame (47A) with two pieces of tape (49E), and then engage the lamp in the left tail light reflector (48C).

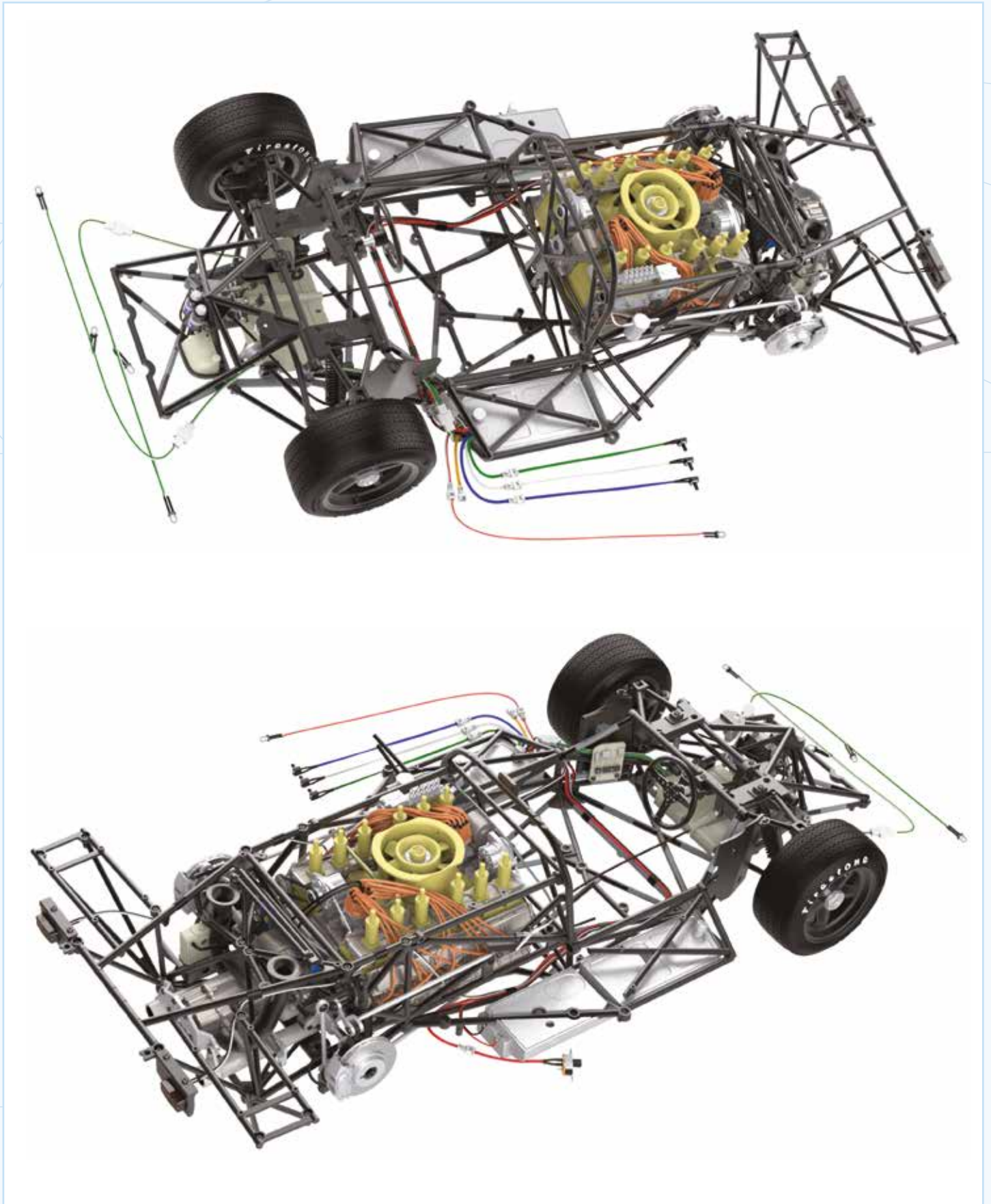


Installation of the upper frame on the main frame completed





GENERAL VIEW





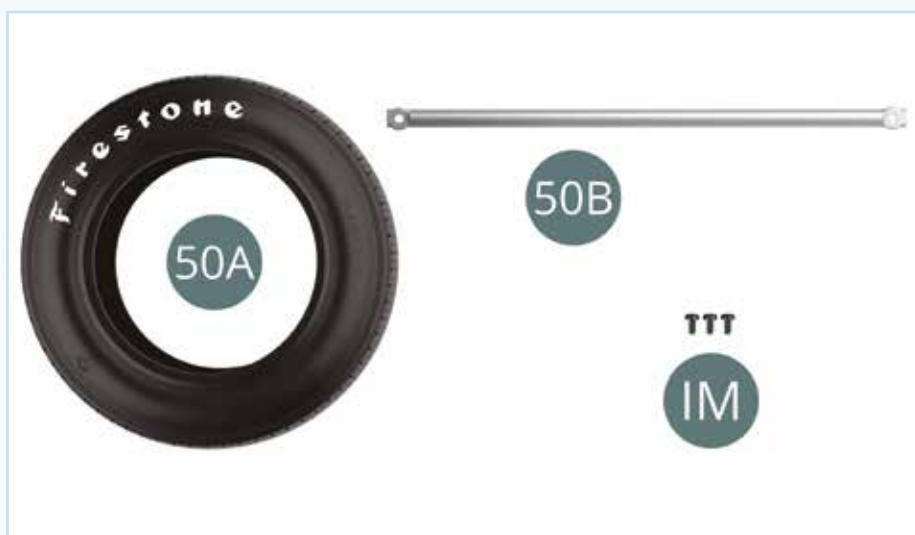
Assembly guide

PARTS OF THE ISSUE 50

50A Left rear tire

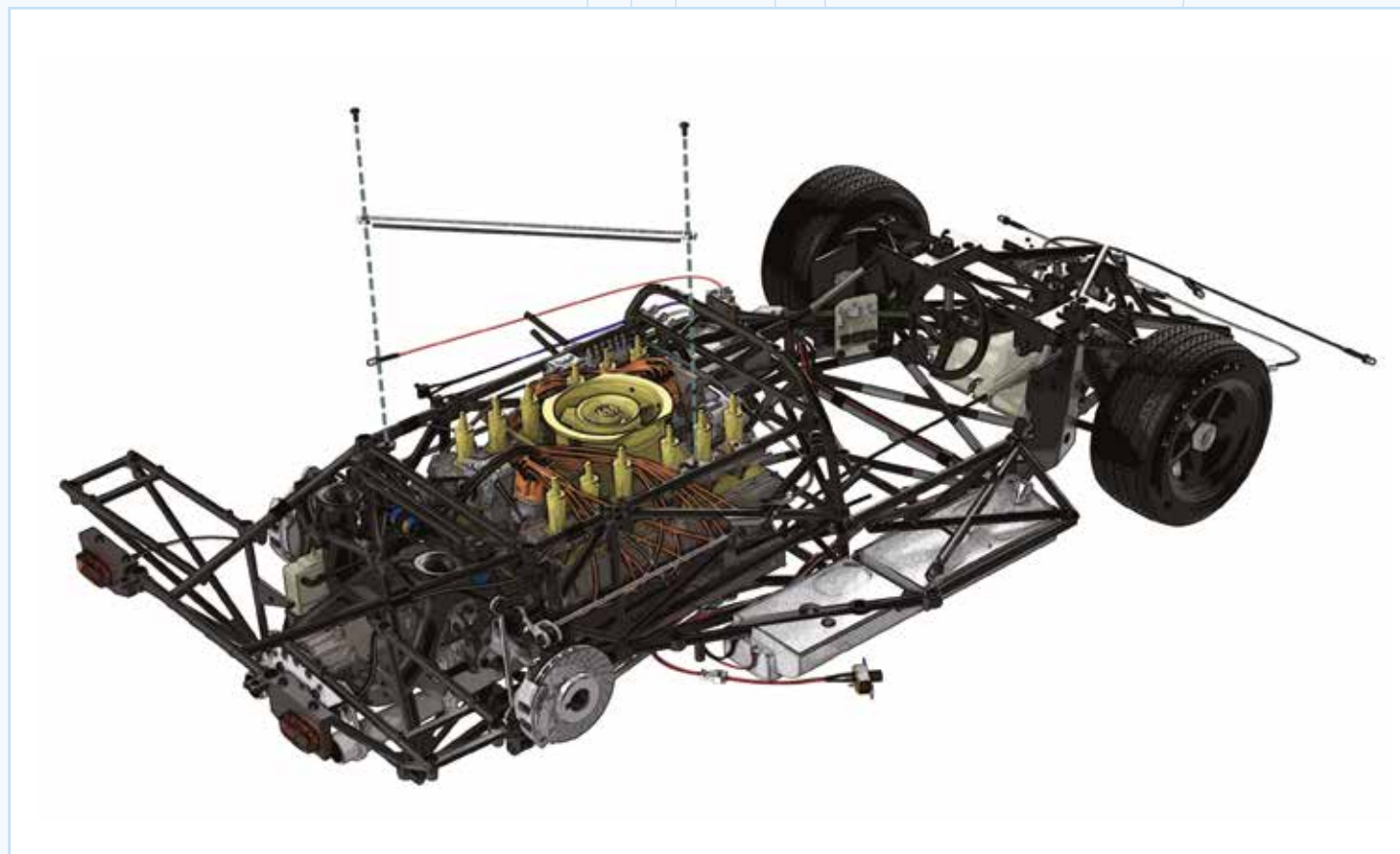
IM M1,7 x3,5mm (x3)

50B Removable brace



Removable brace fitting
on upper frame

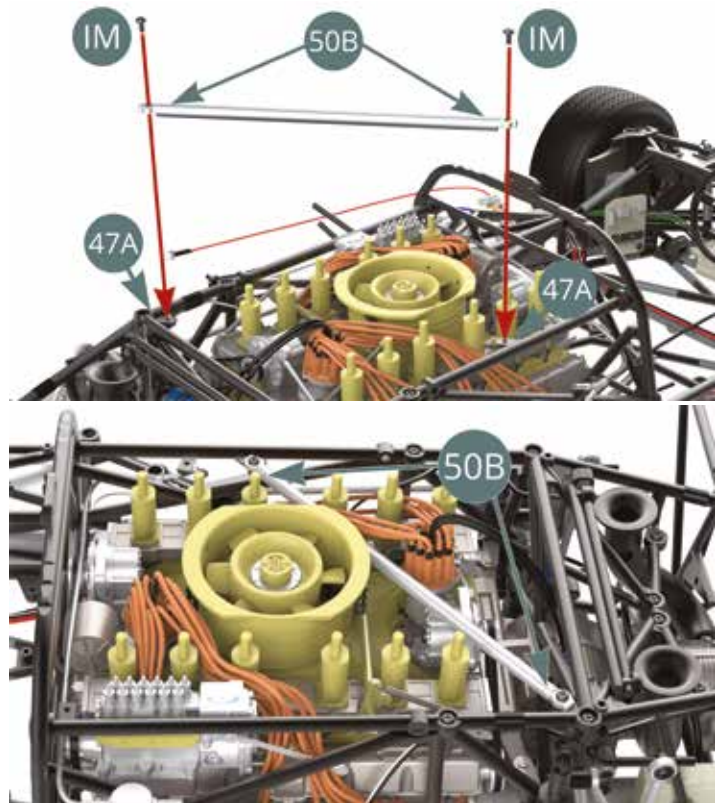
ASSEMBLY DIAGRAM



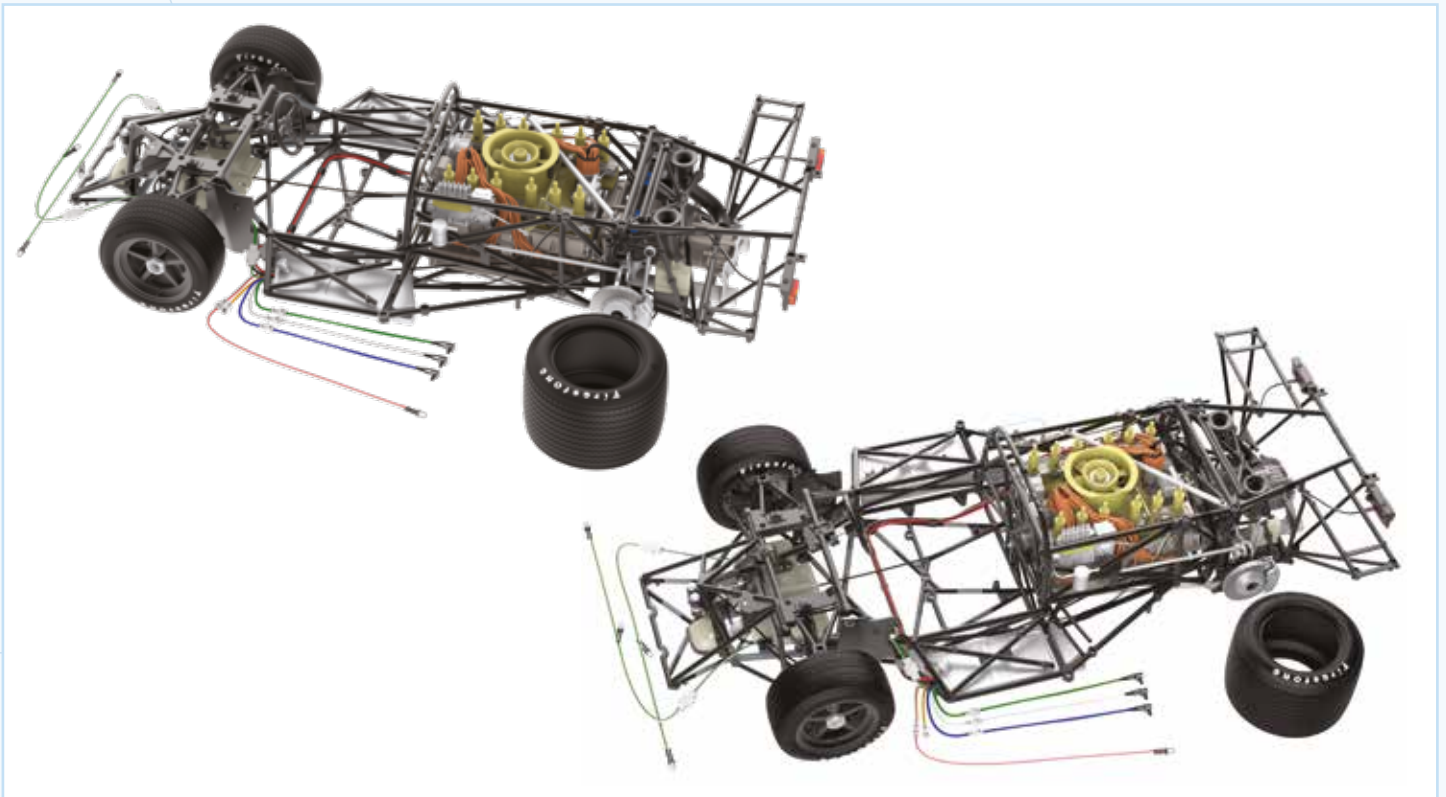


STEP 1

Fit 50B Removable brace to 47A Upper frame brackets and fix with two IM screws (upper and lower illustrations).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 51

51A Rear wheel outer rim

51B Rear wheel inner rim

51C Hub cover

51D Washer

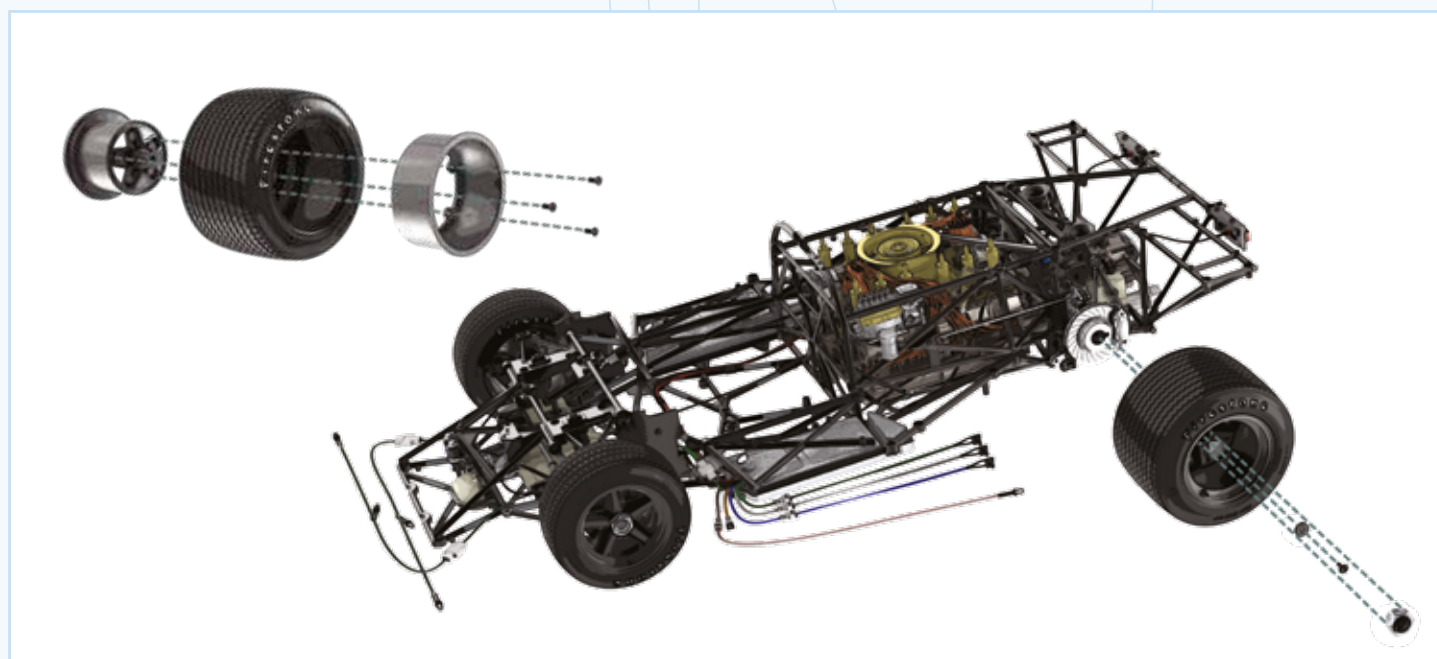
BM Screw M 2 x 4 mm (x 4)

MM Screw M 2 x 5 x 5mm (x 2)



Assembly of the left rear wheel and installation on the framework

ASSEMBLY DIAGRAM





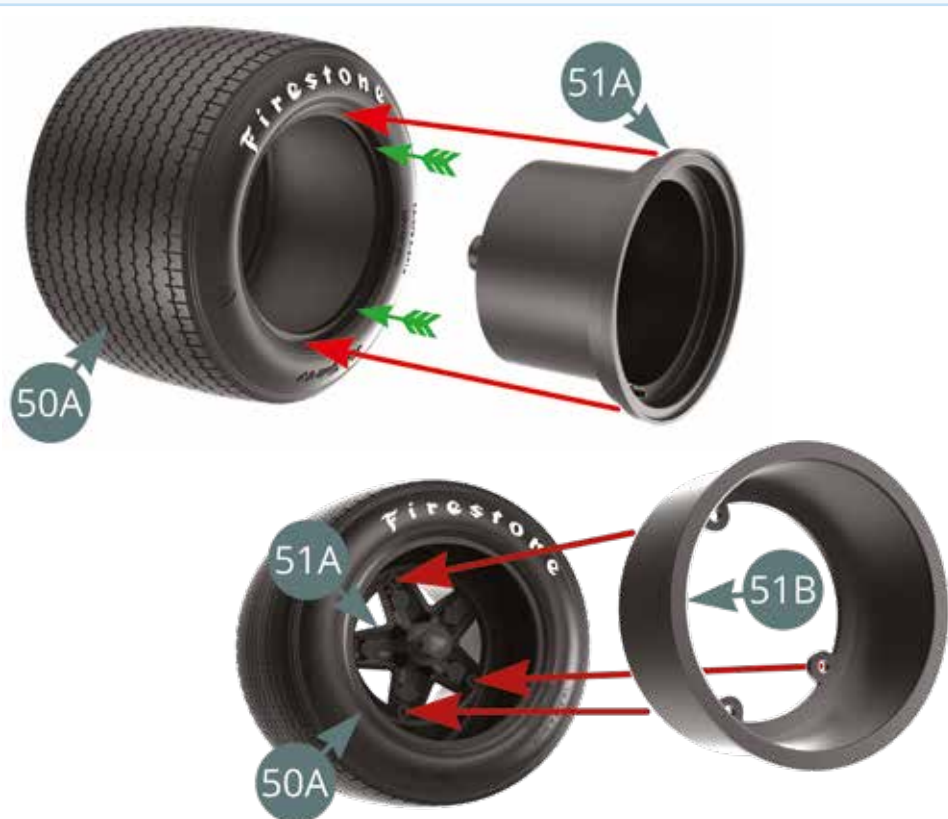
STEP 1

Before starting the assembly of the left rear wheel, locate the side of the tyre (50A) with the deepest bead by the red markings in order to position the outer rim (51A). The deepest bead (2 mm) is indicated by the green arrow, while the shallowest (1 mm) is indicated by the orange arrow.



STEP 2

To fit the tyre (50A) - on the side with the deepest bead, green arrows - to the outer rim (51A), plunge it into hot water for two minutes so that the rubber becomes more flexible.



Position the inner rim (51B) on the other side of the tyre, aligning the three fixing points correctly.

STEP 3

Fix the inner rim (51B) and the outer rim (51A) together with three BM screws. The left rear wheel is ready to be mounted on the chassis.



STEP 4

Identify the locking groove on the outer rim hub axle (51A) - red arrow.

Position the outer rim of the left rear wheel (51A) on the left rear pin (41A) and rotate the wheel (blue arrow) until the locking groove engages the slot in the outer brake half disc (44G).





STEP 5

Fix the outer rim of the left rear wheel (51A) with a MM screw by first passing it through the washer (51D).

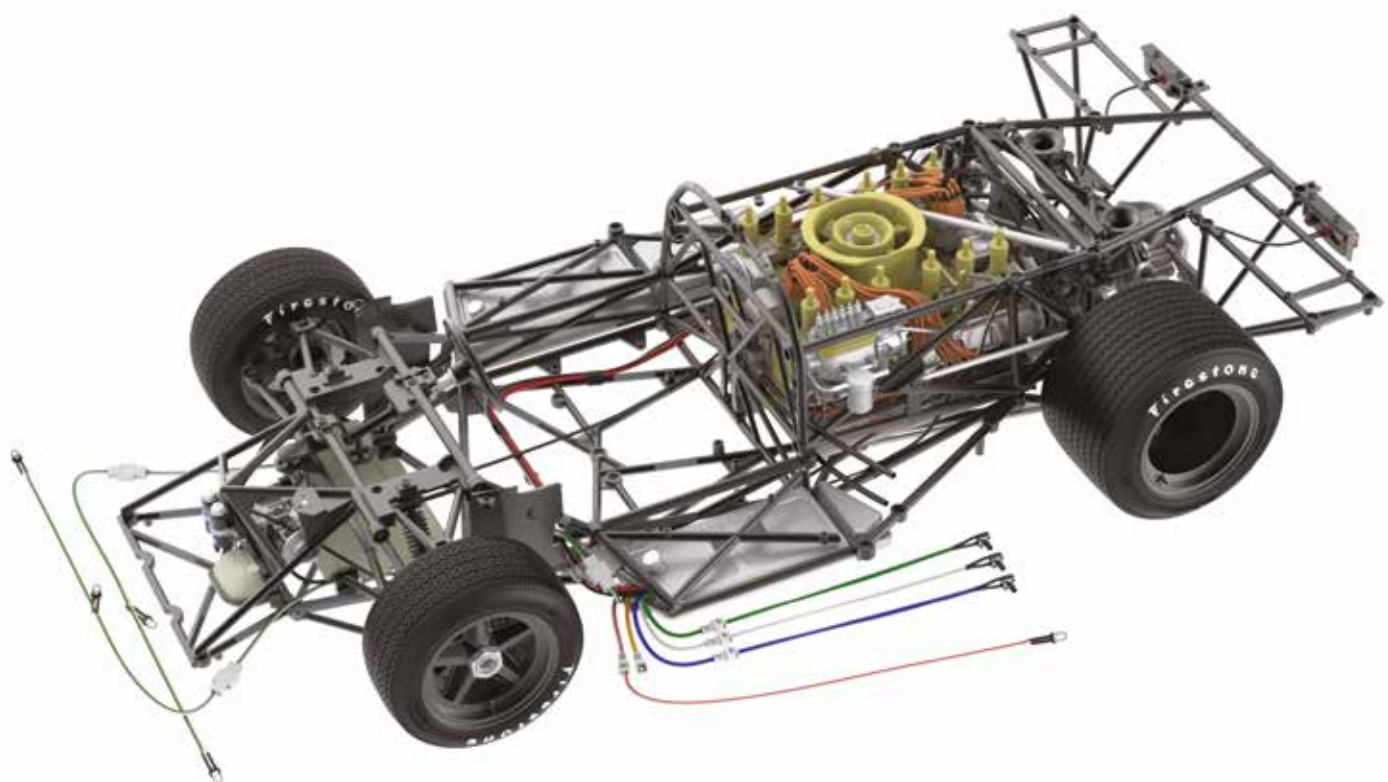
Position the hub cover (51C) on the outer rim (51A).



Left rear wheel 51A installed on the frame



GENERAL VIEW





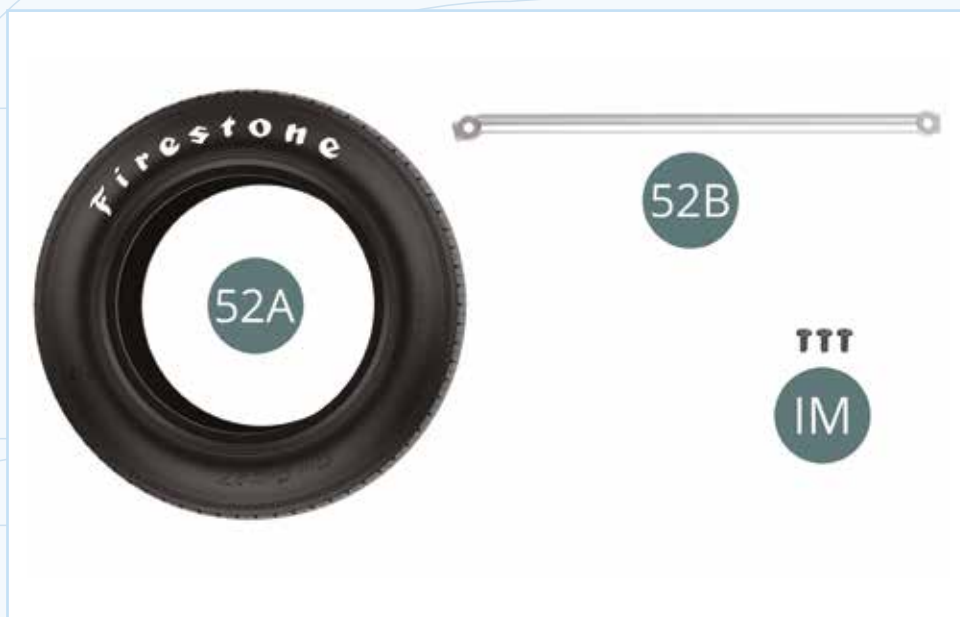
Assembly guide

PARTS OF THE ISSUE 52

52A Rear left tyre

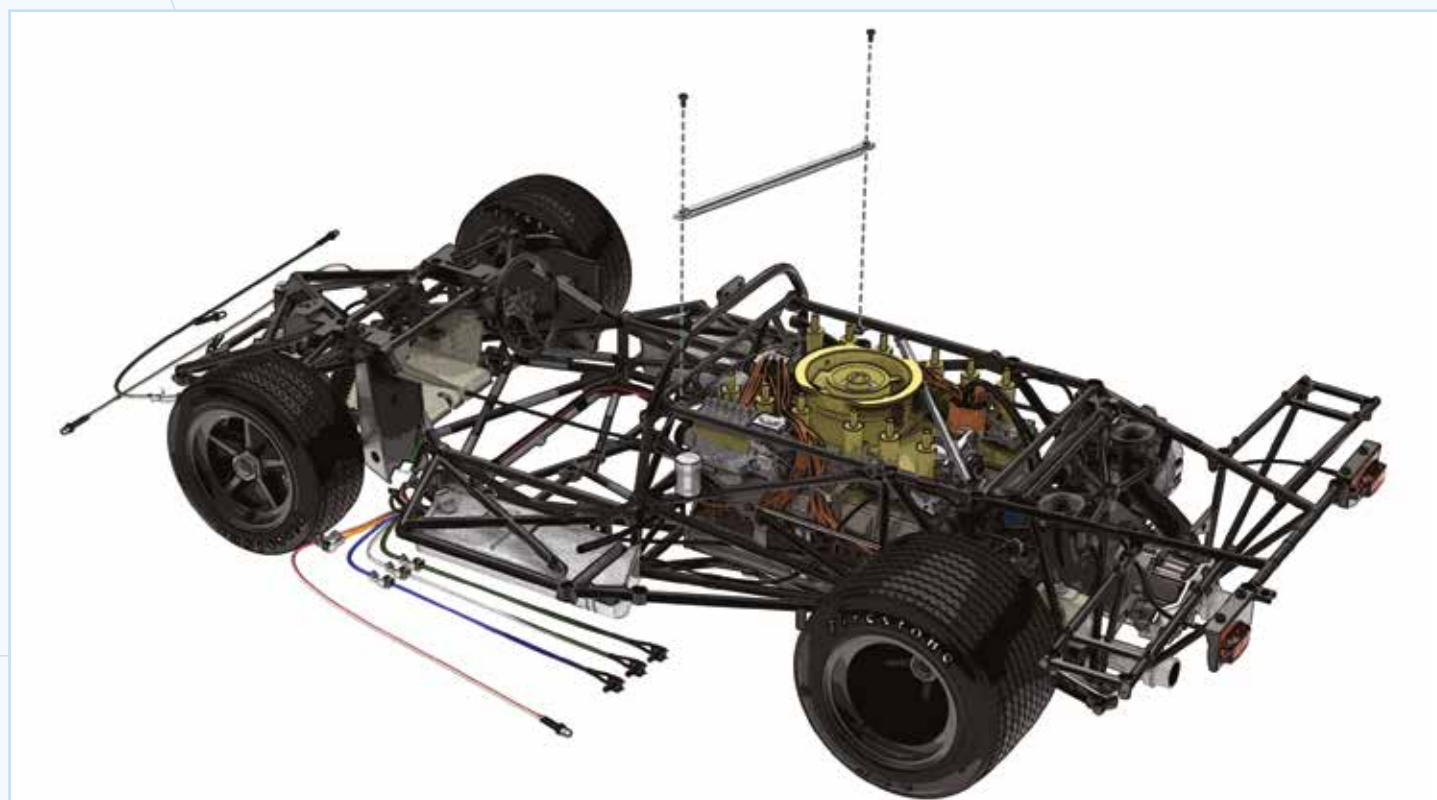
IM Screw M 1.7 x 3.5 mm (x 3)

52B Reinforcement bar



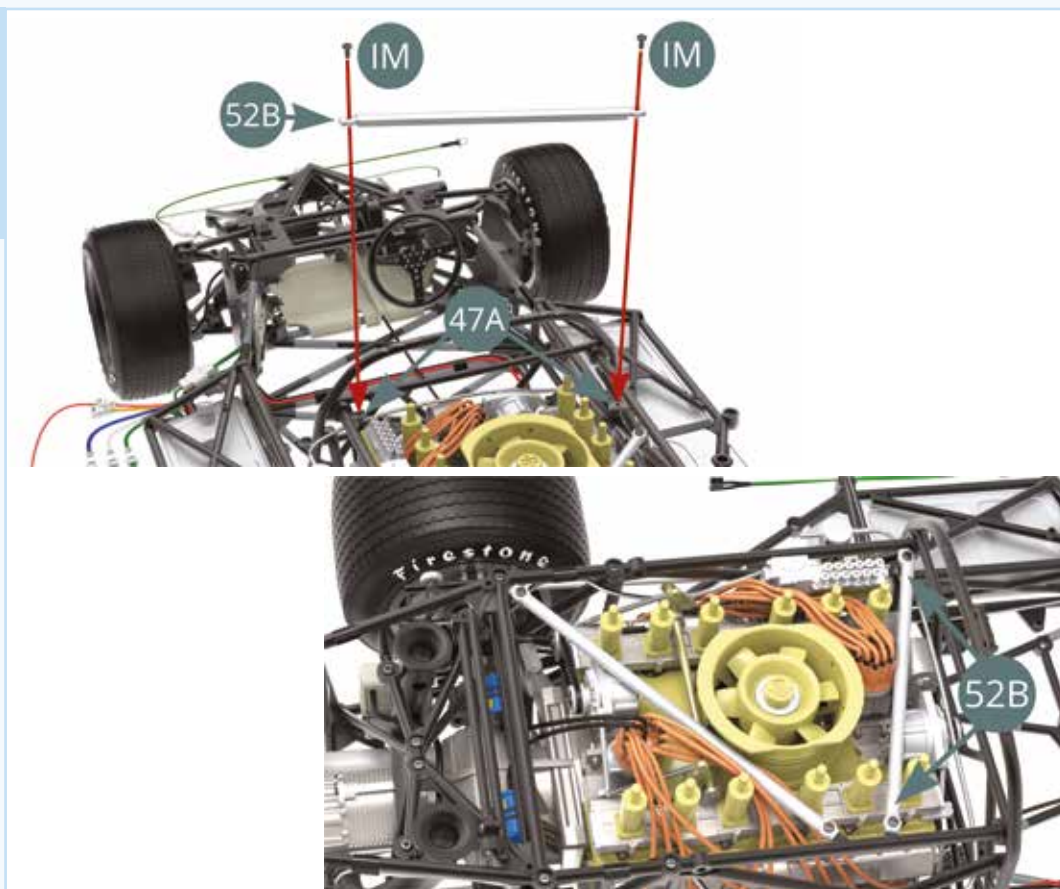
Mounting the
reinforcement
bar on the upper
frame

ASSEMBLY DIAGRAM

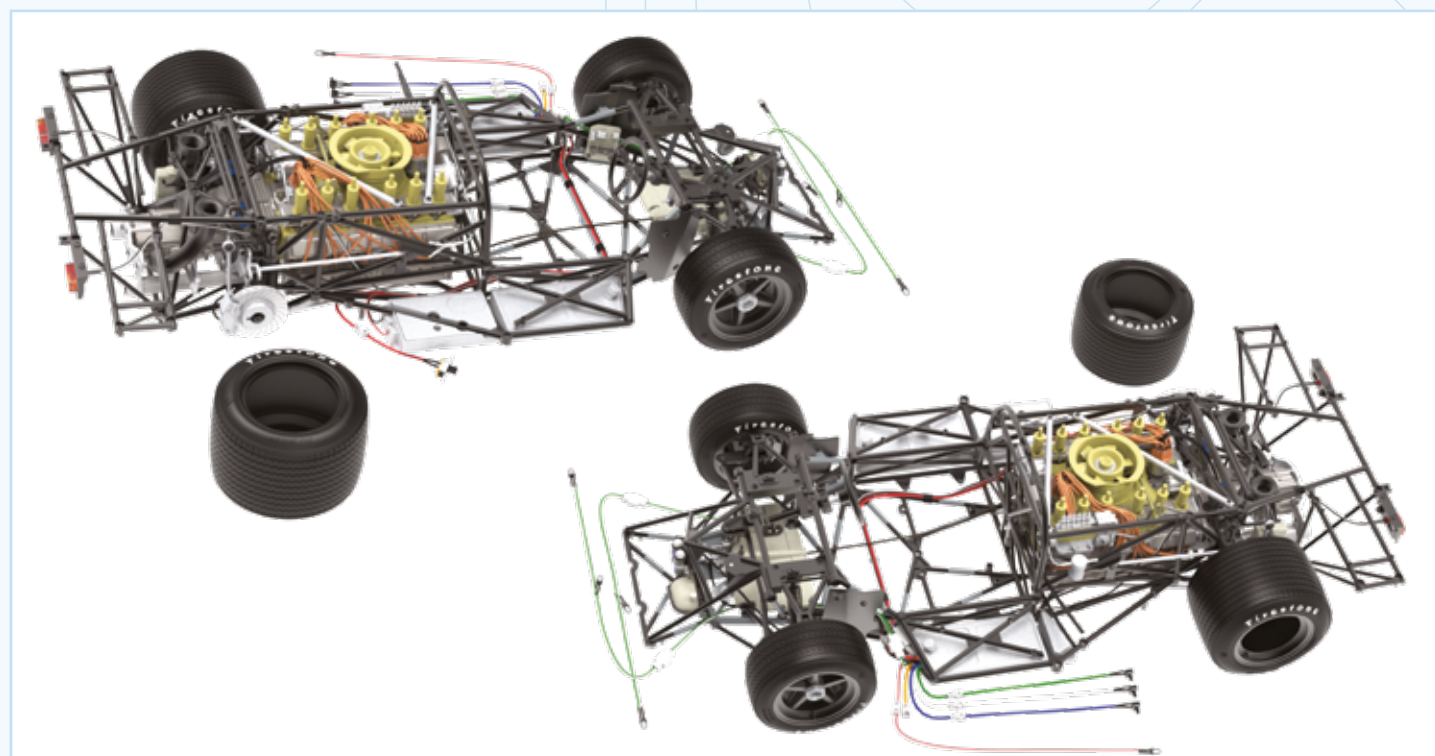


STEP 1

Position the reinforcement bar (52B) on the upper frame supports (47A) and secure it with two IM screws (shown opposite).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 53

53A Outer rear wheel rim

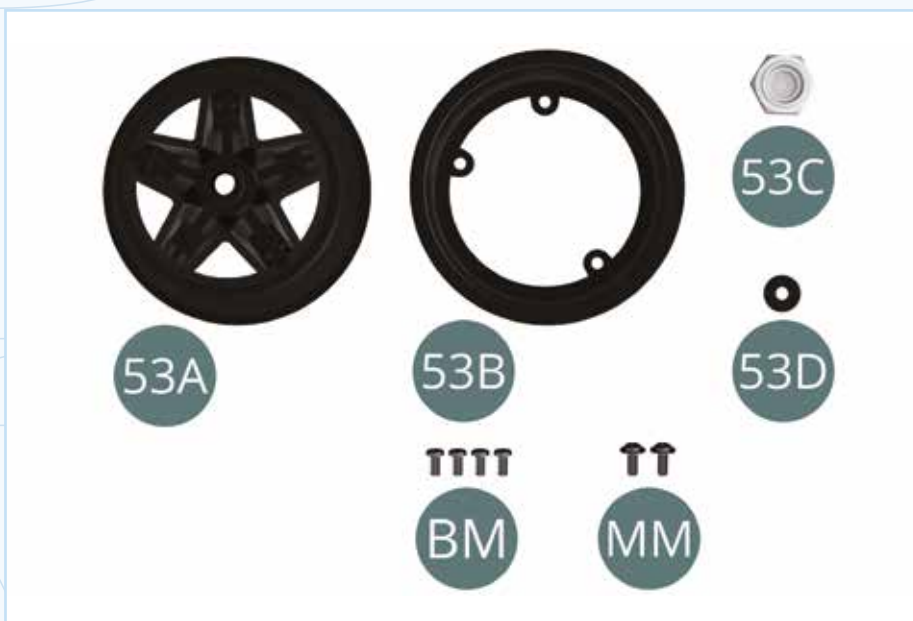
53B Inner rear wheel rim

53C Hub nut

53D Washer

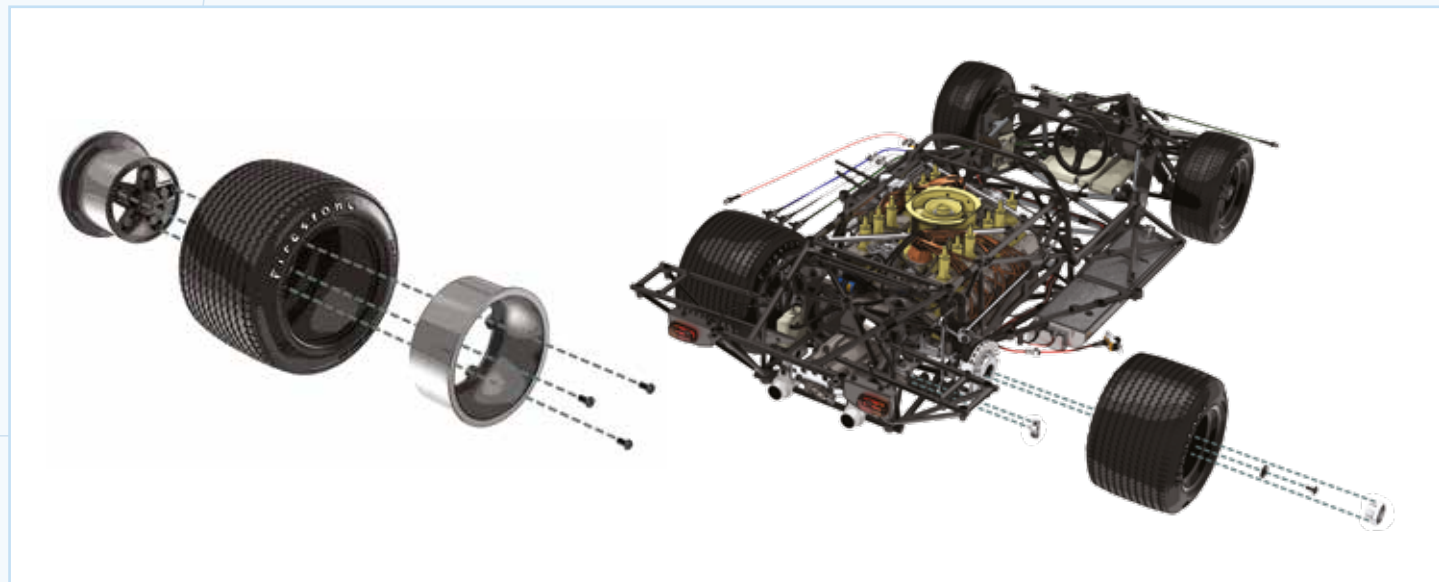
BM M2,0 x4mm (x4)

MM M2,0 x5x5mm (x2)



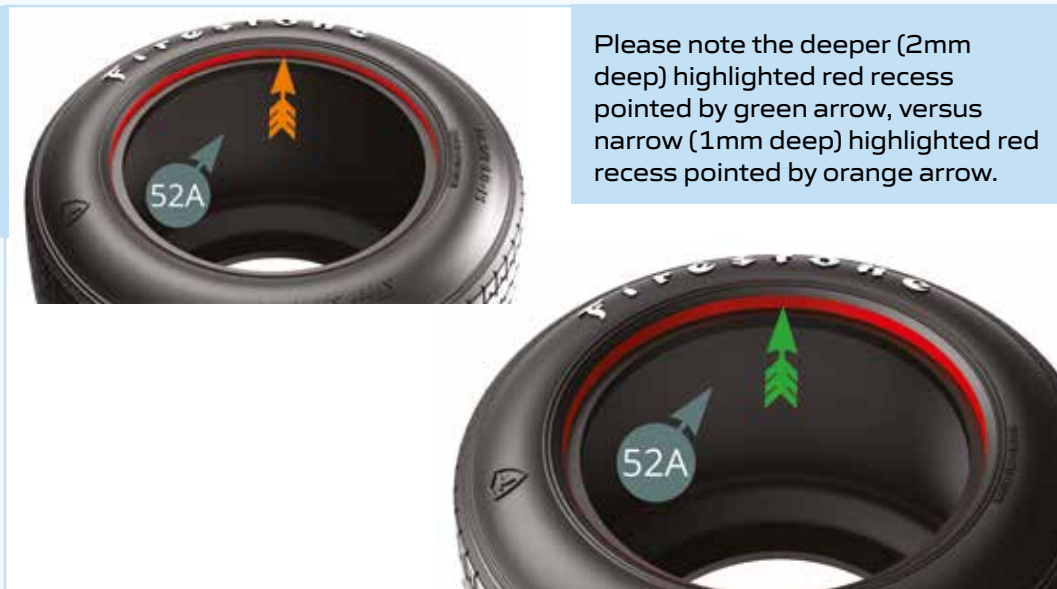
*Rear right wheel
assembly and mounting
on chassis*

ASSEMBLY DIAGRAM



STEP 1

Rear left wheel assembly begins with identification of 52A
Tire side having a deeper recess for 53A
Outer wheel rim.



STEP 2

To fit 53A Outer rear wheel rim into 52A Tire (from its deeper recess side, green arrows), put 52A Tire 3 times for 30 seconds in Micro wave Oven, flexing it with fingers each time in between to make rubber softer.



STEP 3

Fit 53B Inner rear wheel rim from the other side into 52A Tire, aligning it at the same time to 53A Outer wheel rim three connection points.





STEP 4

Fix 53B Inner and 53A Outer rear wheel rims with three BM screws. Rear right wheel is preassembled for mounting on Chassis.



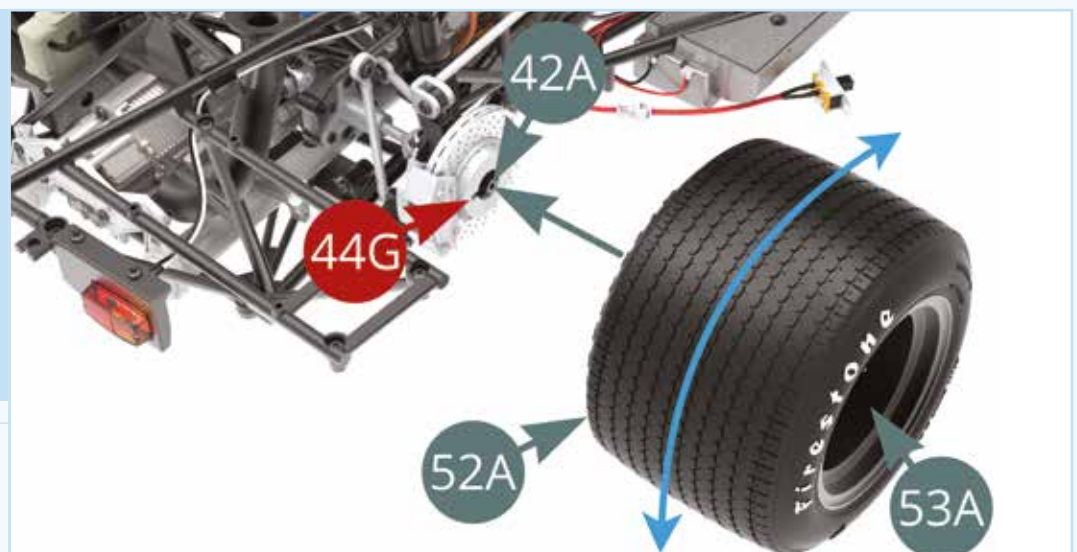
STEP 5

Note the positioning rib on 53A Outer rear wheel rim hub axle (red arrow).

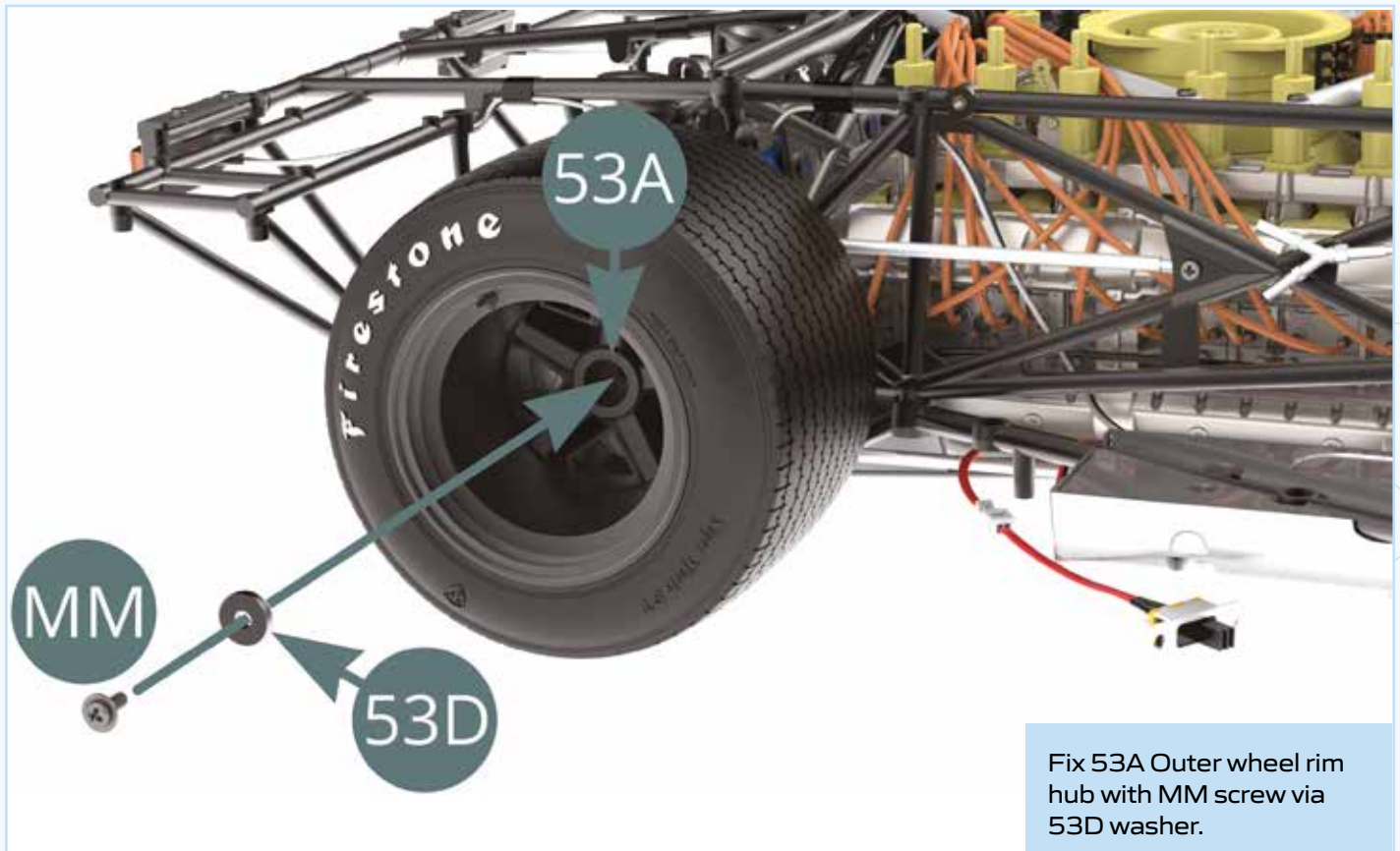


STEP 6

Put 44G Rotor (right spin pattern) on 42A Rear right upright axle. Attach Rear right wheel by its 53A Outer wheel rim hub axle to 42A Rear right upright axle, spinning sideways (blue arrow) for the positioning rib to engage in 44G Outer rotor hub slot.

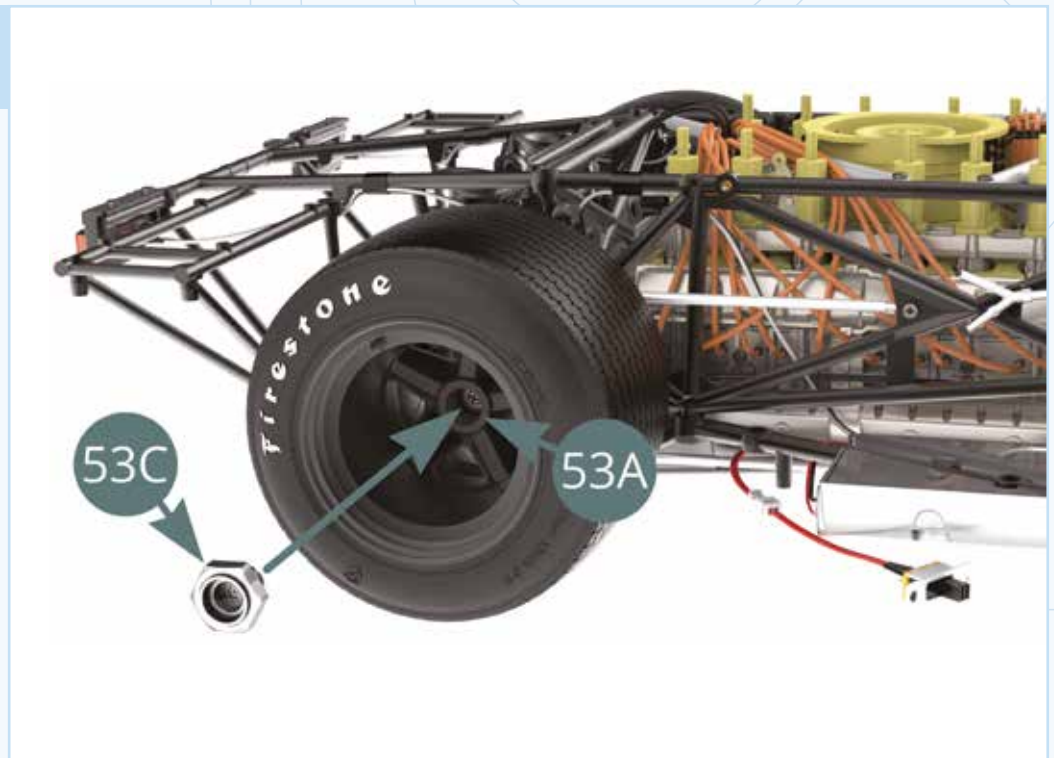


STEP 7



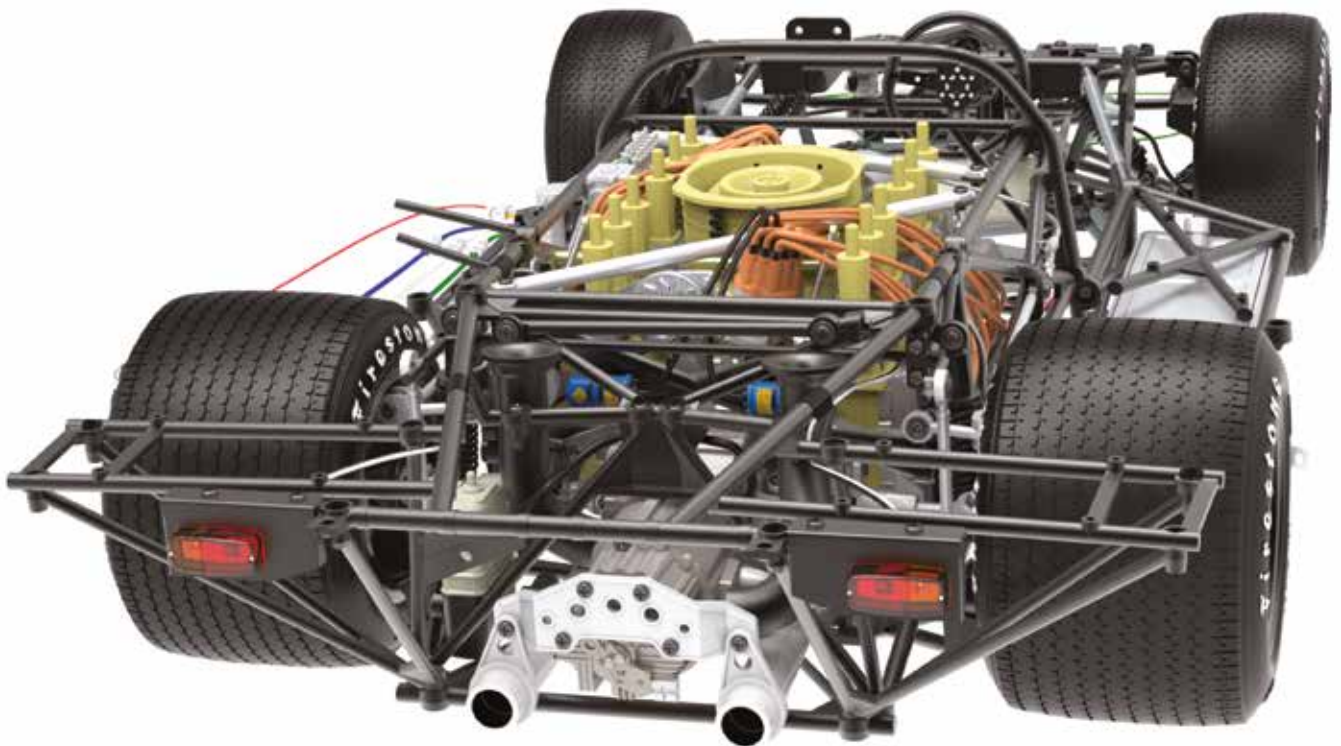
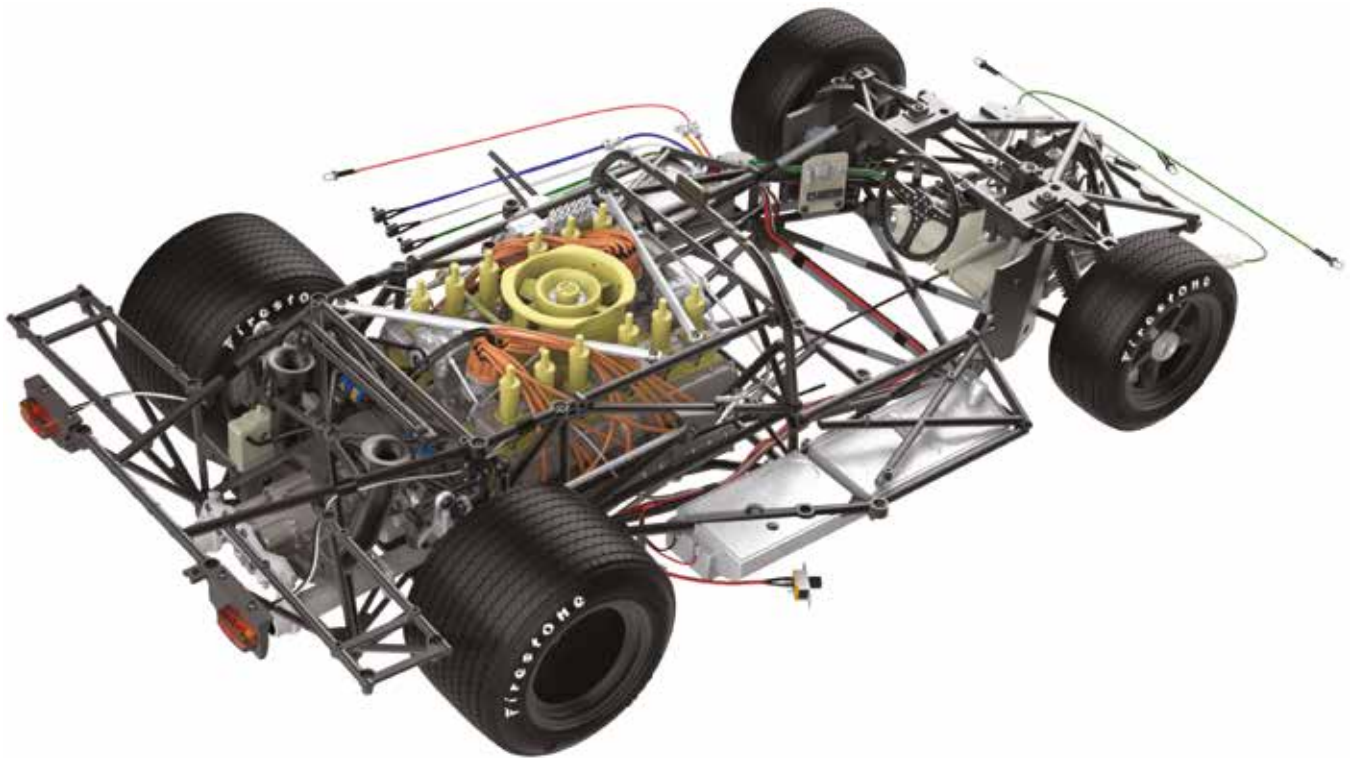
STEP 8

Fit 53C Hub nut to 53A Outer rear wheel rim hub.





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 54

54A Cabin bulkhead

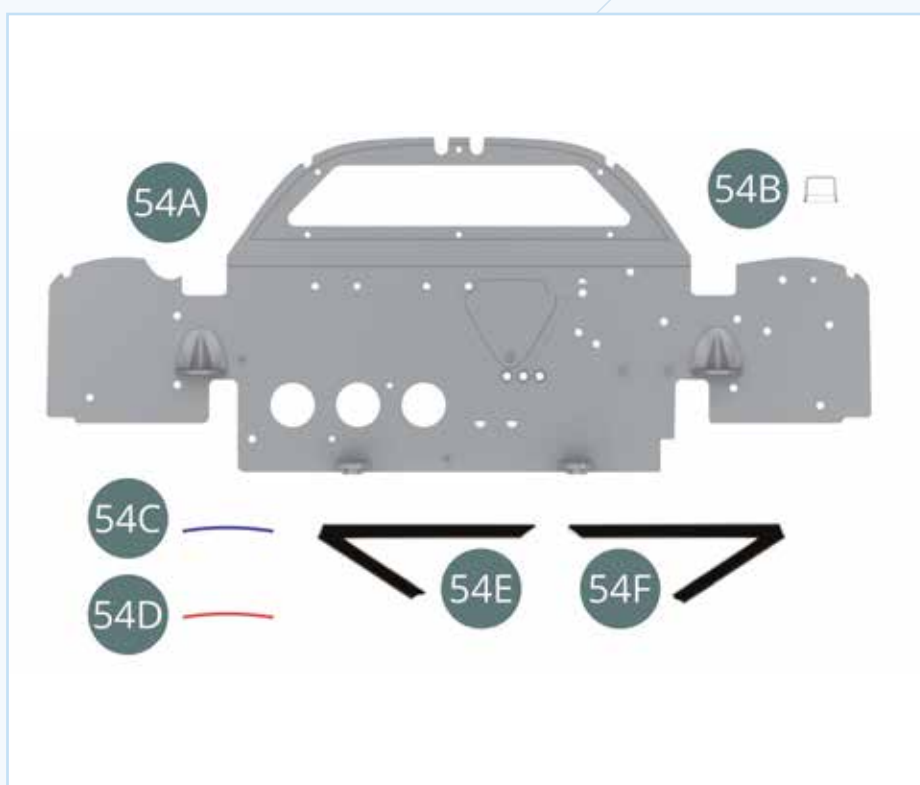
54B Voltage regulator

54C Electrical cable (blue)

54D Electrical cable (red)

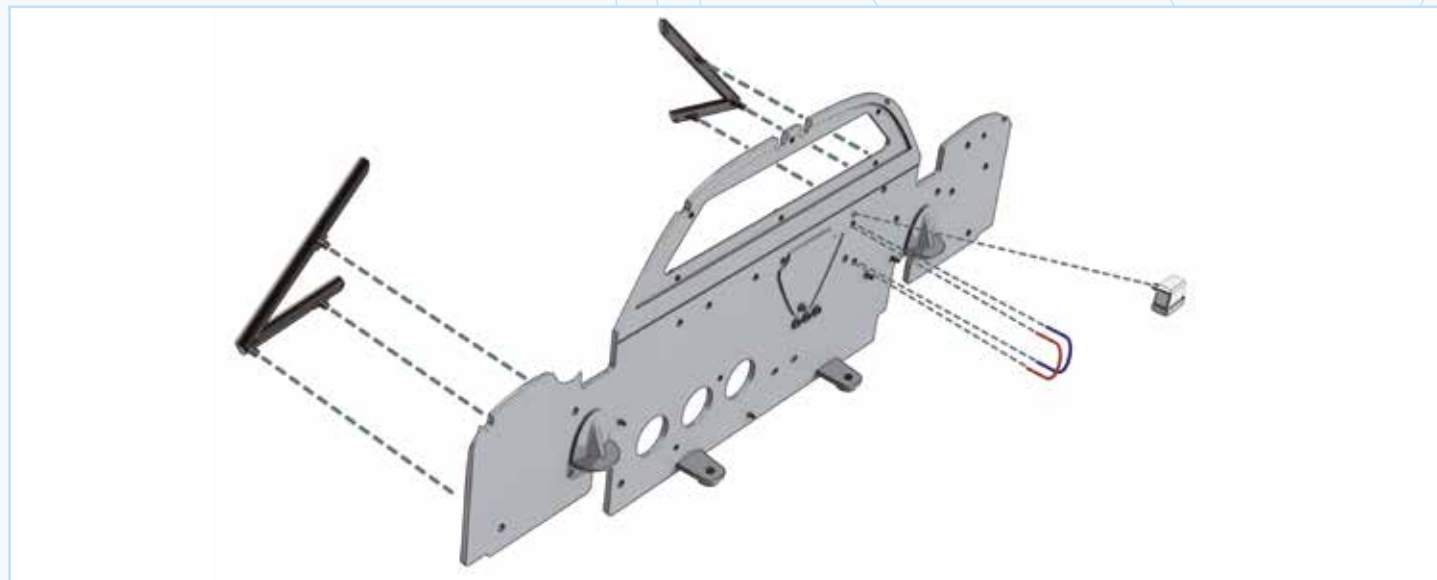
54E Left tubular frame post

54F Right tubular frame post



Separation of the cabin. Preassembly of the firewall

ASSEMBLY DIAGRAM





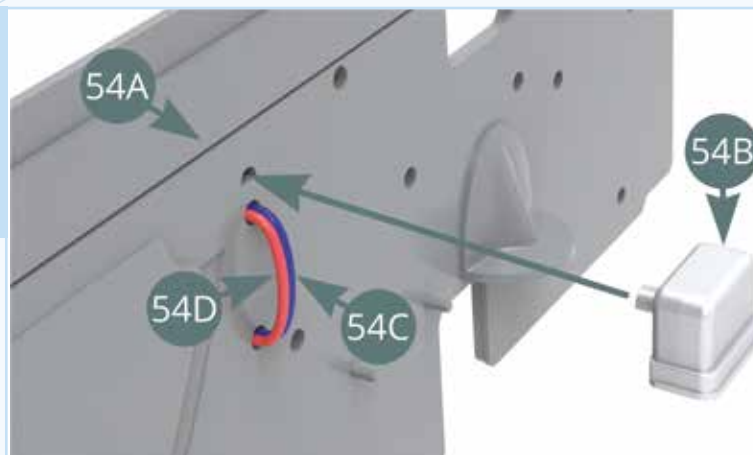
STEP 1

Position both electric cables, blue (54C) and red (54D), on the cabin bulkhead (54A) - grey side - by clamping them together.



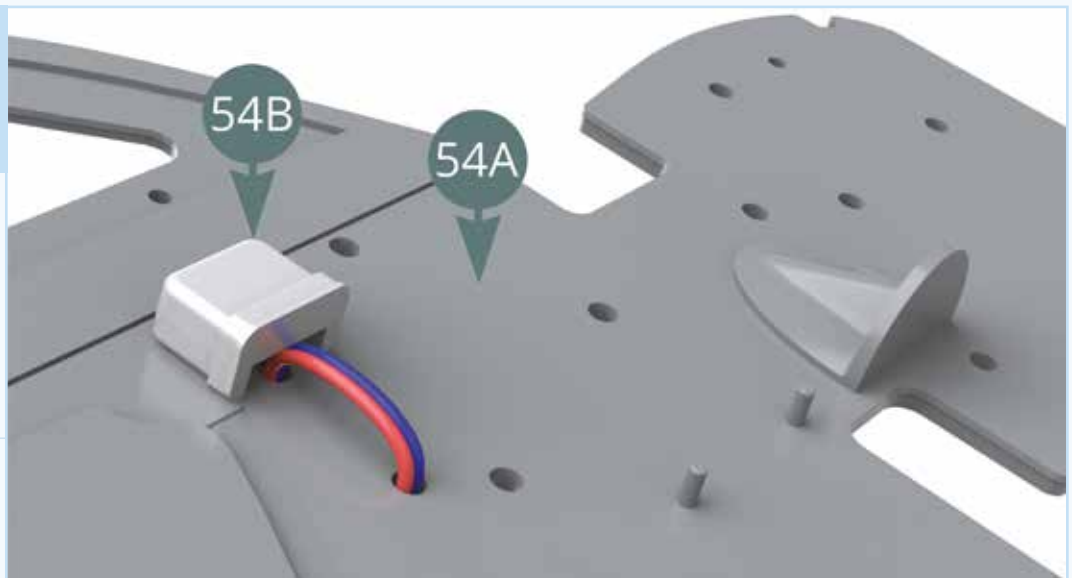
STEP 2

Position the voltage regulator (54B) above the Blue 54C and Red 54D power cables on the cabin's bulkhead (54A) - grey side.



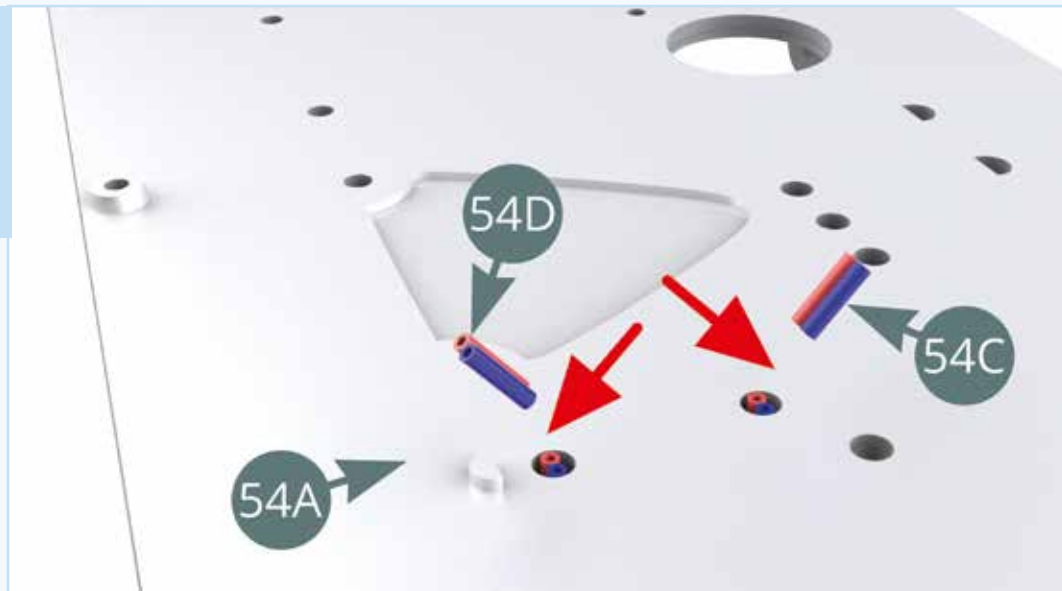
STEP 3

The voltage regulator (54B) is positioned on the cabin's partition wall (54A).



STEP 4

Cut the length of the electric blue (54C) and red (54D) cables (red arrows) that protrude from the cabin's bulkhead 54A (silver side).



STEP 5

Position the left tubular frame post (54E) on the cabin's bulkhead (54A) - silver side.



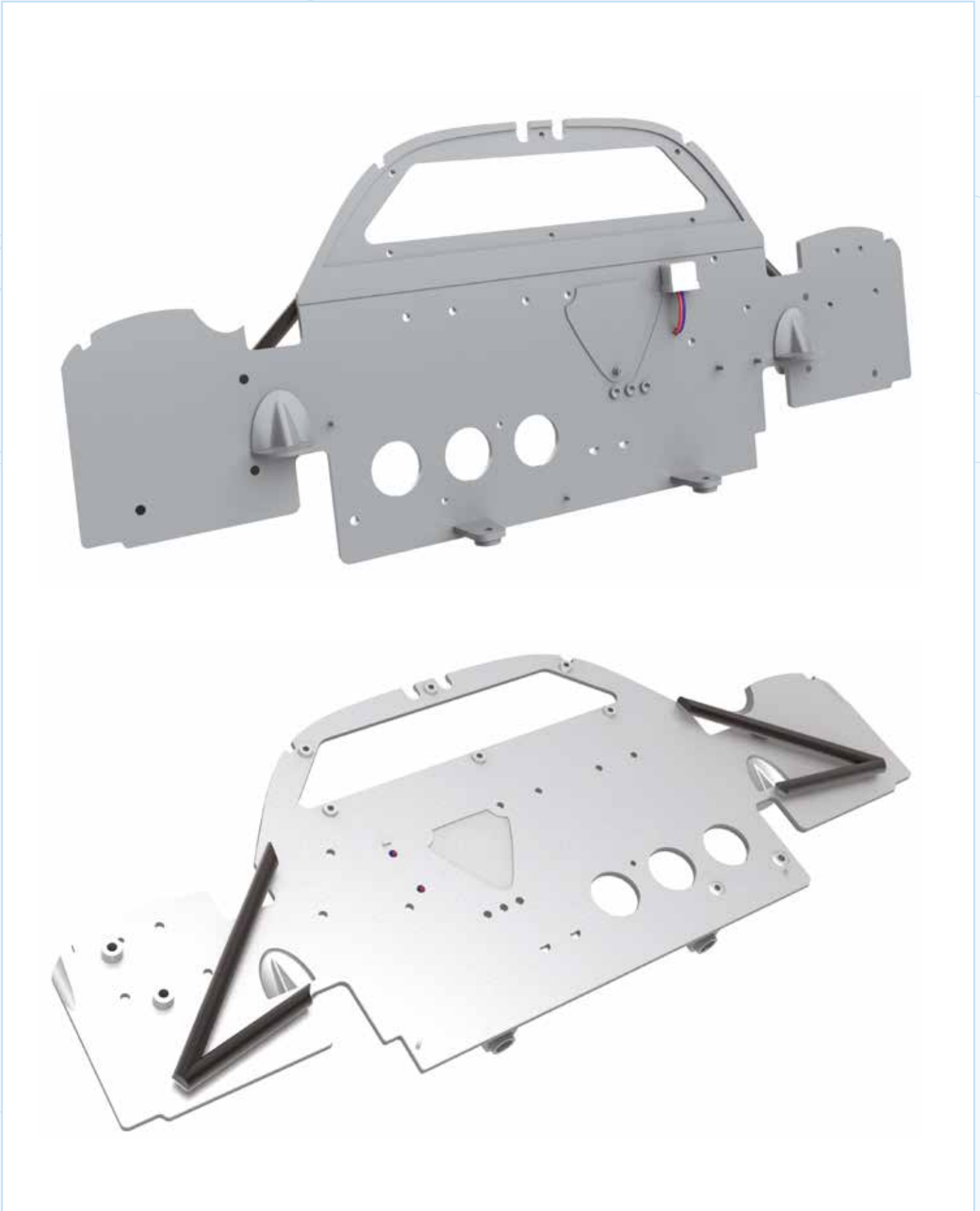
STEP 6

Position the right tubular frame post (54F) on the cabin's bulkhead (54A) - silver side.





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 55

55A Plexiglass partition

55B Seat belt support (x 2)

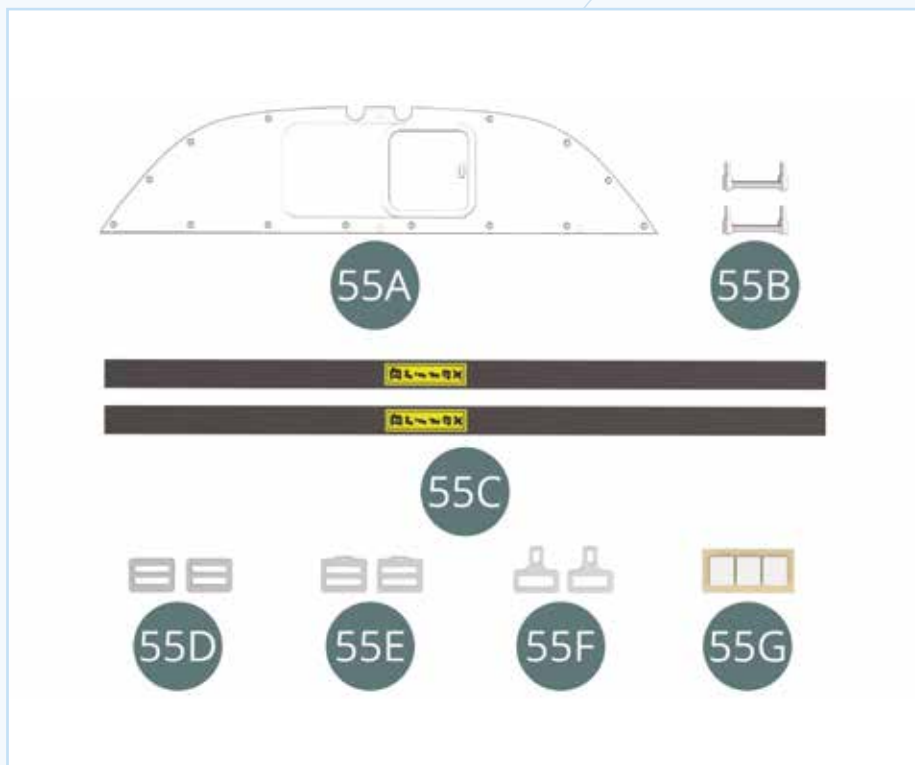
55C Seat belt (x 2)

55D Buckle, top (x 2)

55E Buckle, bottom (x 2)

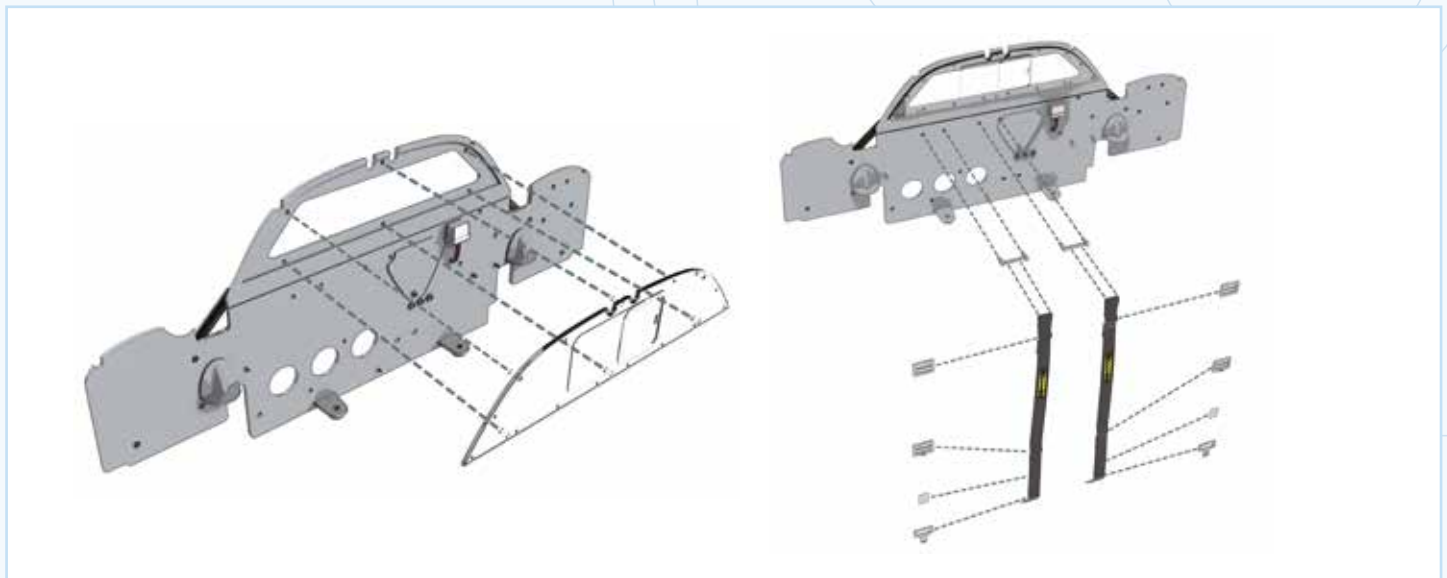
55F Buckle lock (x 2)

55G Double-sided tape (x 3)



Assembly of seat
belts and cabin's
bulkhead

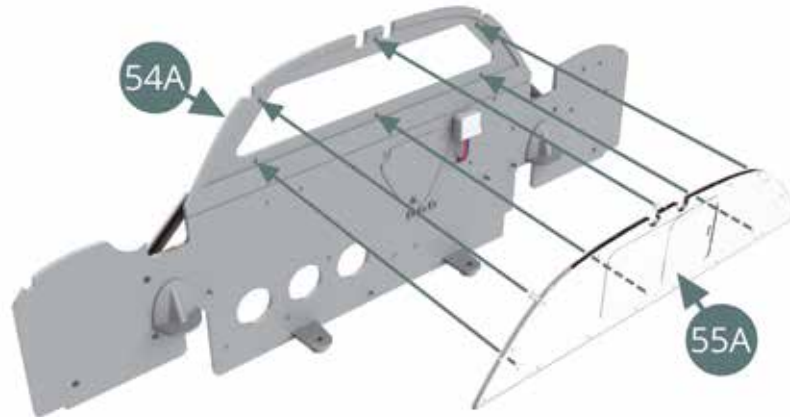
ASSEMBLY DIAGRAM





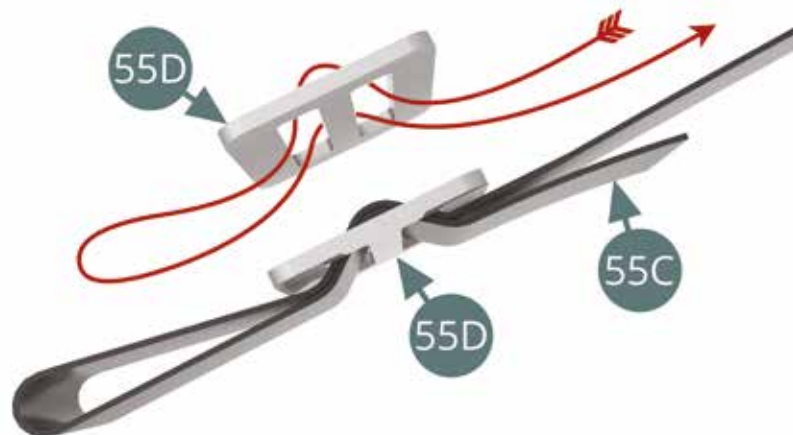
STEP 1

Position the plexiglass partition (55A) on the cabin's bulkhead (54A) - grey side - using the six pins provided.



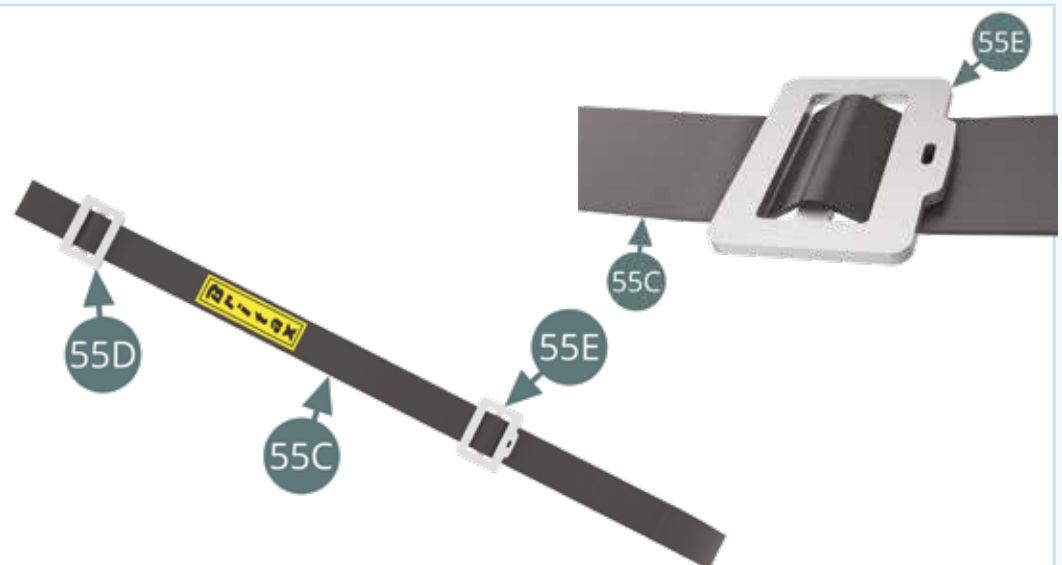
STEP 2

Pass the seat belt (55C) through the top buckle (55D) as indicated by the red arrows. Repeat the operation with the second belt (55C). Check the installation as shown in the illustration.



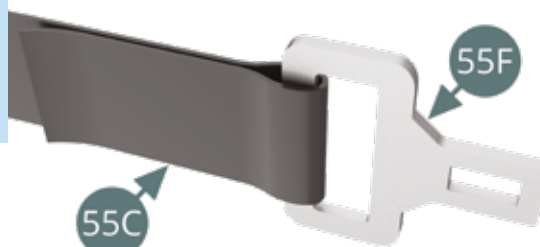
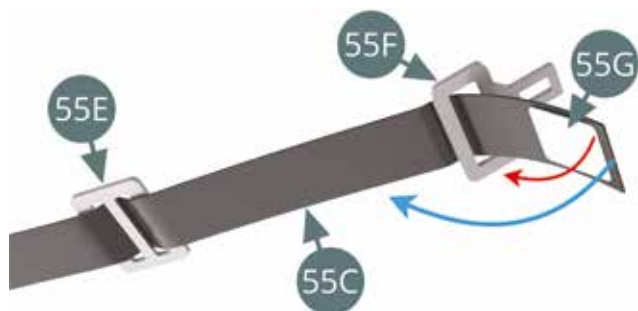
STEP 3

After installing the top buckle (55D), continue in the same way by passing the seat belt (55C) through the bottom buckle (55E) as shown in the illustration. Repeat the operation with the second belt (55C).



STEP 4

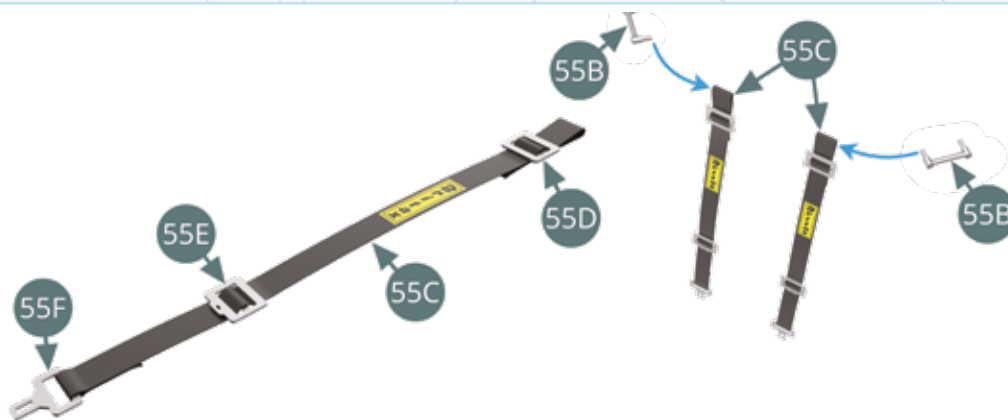
Pass the seat belt (55C) through the buckle lock (55F). Apply double-sided adhesive (55G) to the end of the seat belt (55C). Remove the backing paper (red arrow) from the adhesive (55G), then fold the belt over and stick the free end (blue arrow) so that it holds the buckle (55F).



Refer to the illustrations opposite and above. Repeat with the second belt (55C).

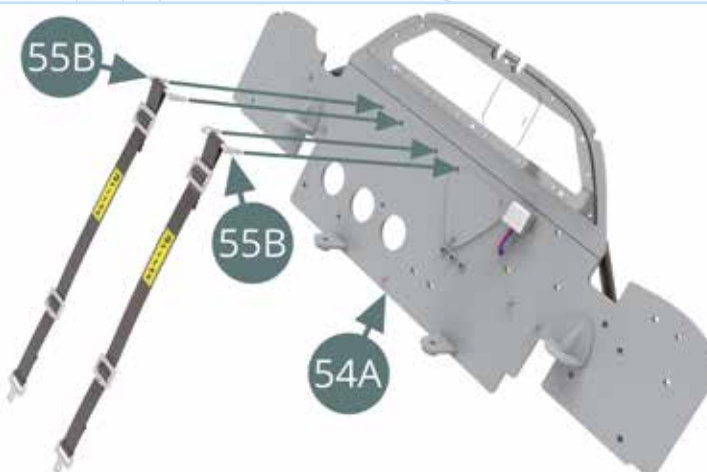
STEP 5

Pass the belt support (55B) through the buckle at the upper end of the seat belt (55C) - see illustrations opposite. Repeat with the second belt (55C).

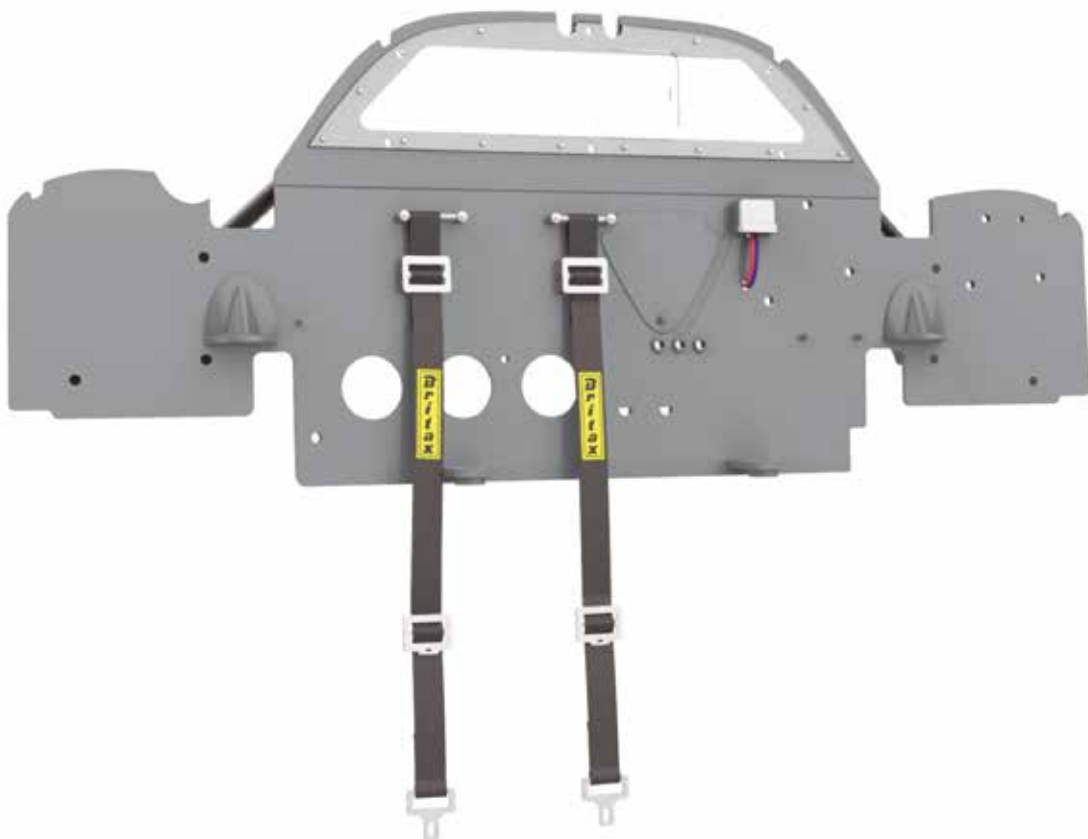
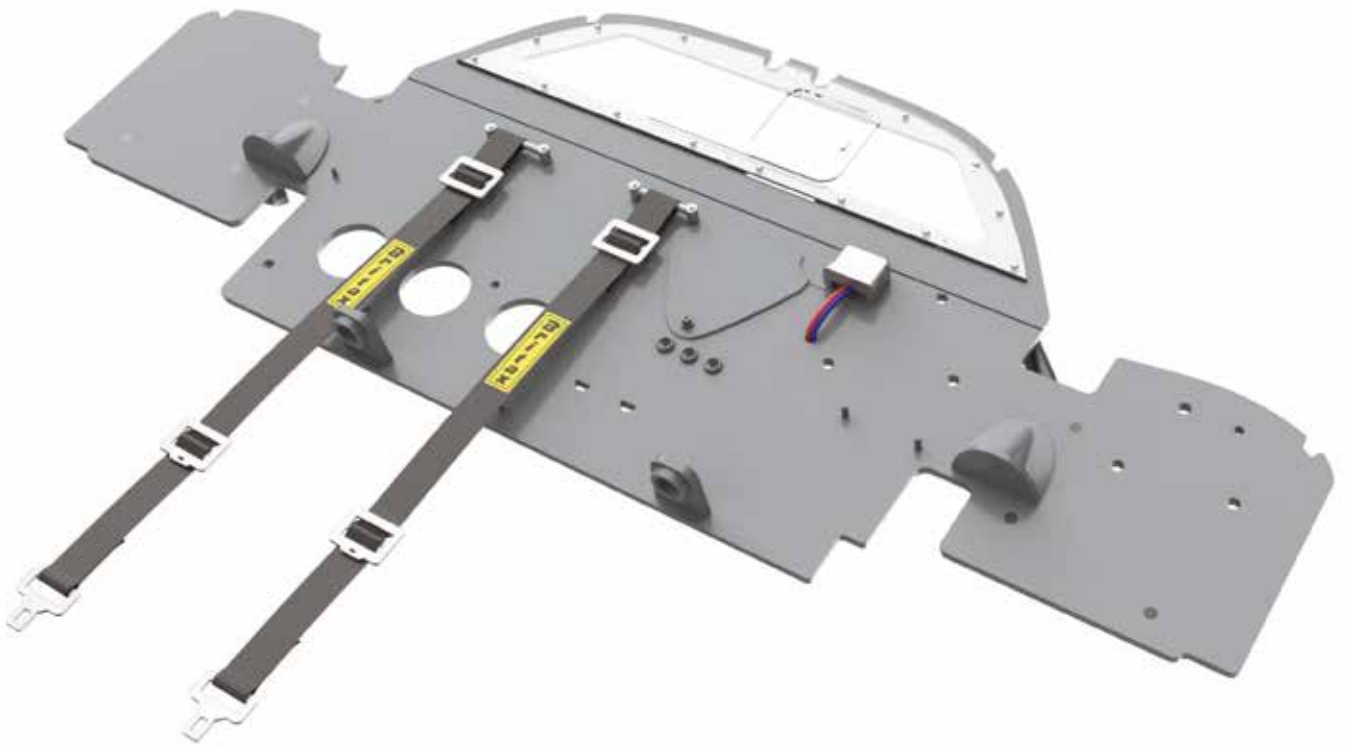


STEP 6

Position the two seat belt supports (55B) on the cabin's bulkhead (54A) - grey side.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 56

56A Ignition coil (x 2)

56B Black cable

56C Red cable

56D Black cable sheath

56E White cable

56F Red cable

56G Yellow cable

56H Blue cable

56I Brown cable

56J Black cable

56K Ignition box

56L Ignition box

56M Rev limiter relay

56N Regulator housing

56O Fire extinguisher

56P Fire extinguisher

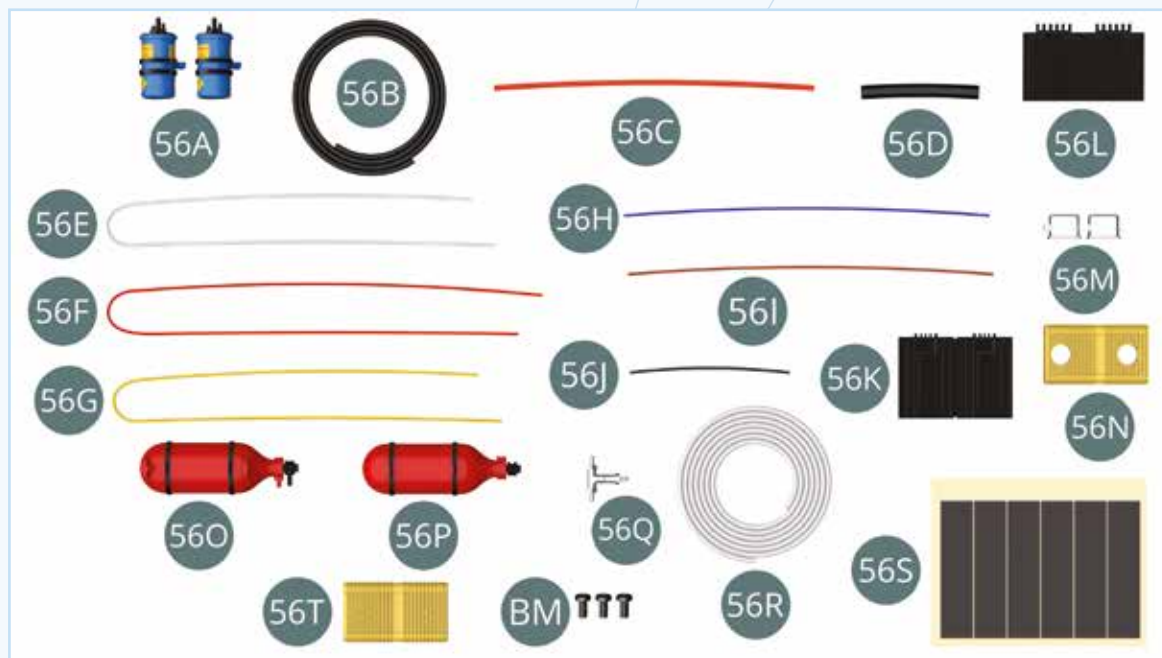
56Q Branch connector

56R Fire extinguisher hose

56S Adhesive tape (x 6)

56T Regulator housing

BM Screw M 2 x 4 mm (x 3)



Assembly of the cockpit partition, ignition and fire extinguisher system and mounting on the chassis

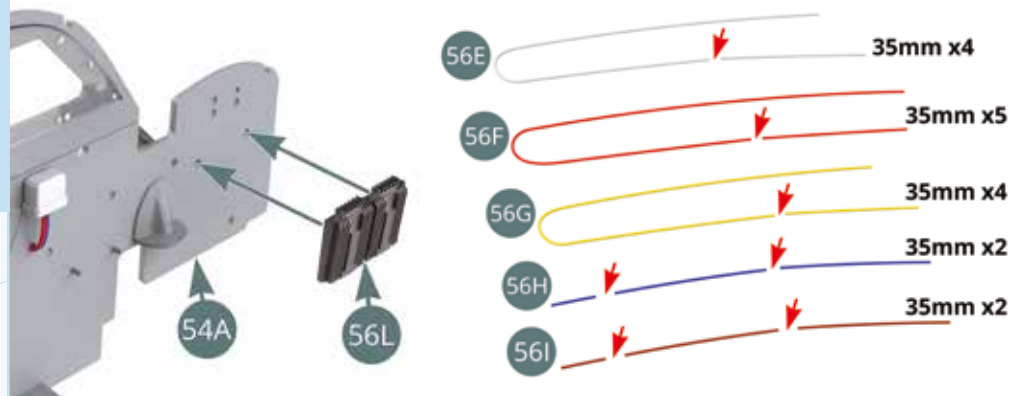
ASSEMBLY DIAGRAM





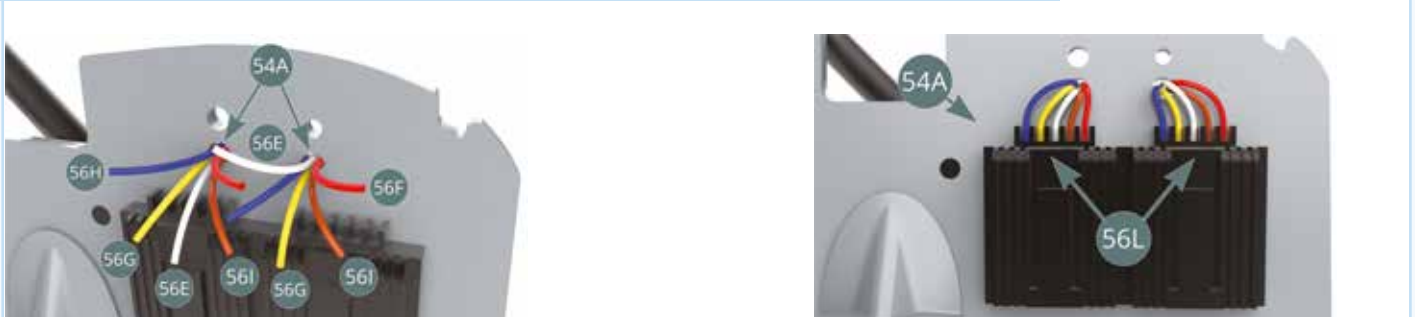
STEP 1

Position the ignition box (56L) on the cabin's partition (54A). Cut the quantities and lengths of the coloured cables as shown opposite.



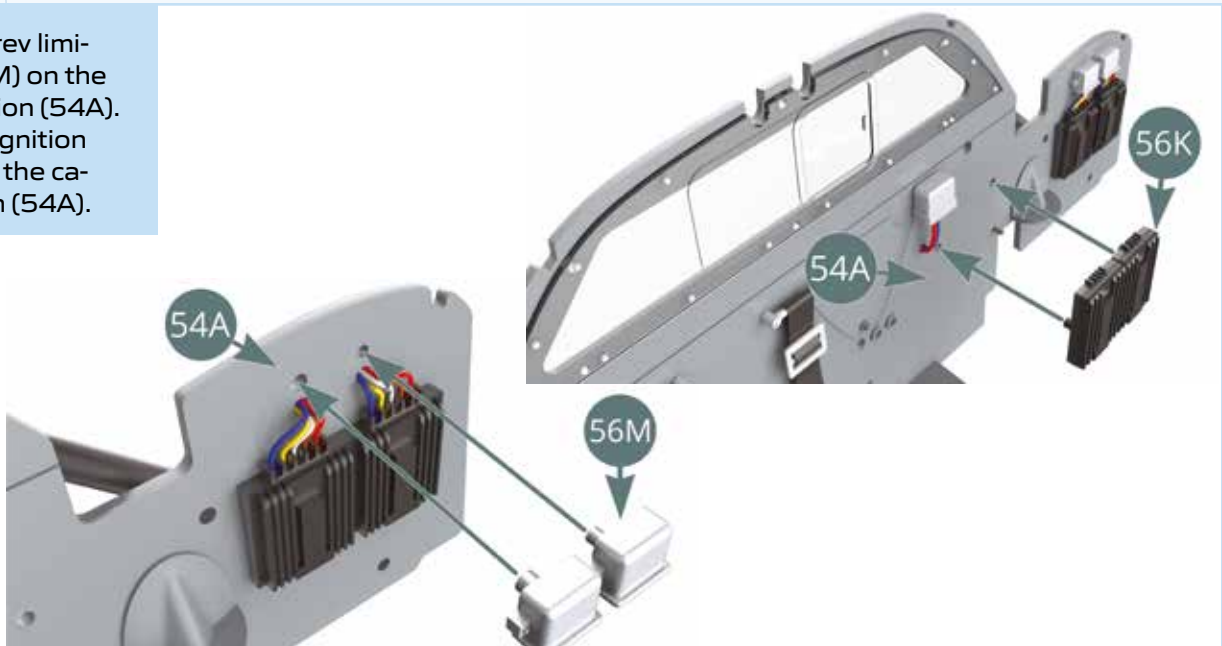
STEP 2

Insert the white (56E); red (56F); yellow (56G); blue (56H) and brown (56I) wires previously cut into the two lower openings of the cabin bulkhead (54A), then connect their ends to the slots above the ignition box (56L), as shown below.



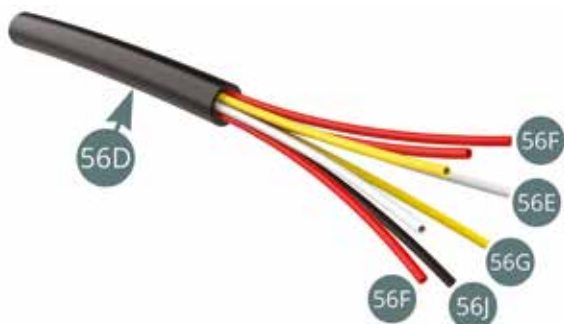
STEP 3

Position the rev limiter relay (56M) on the cabin's partition (54A). Position the ignition box (56K) on the cabin's partition (54A).



STEP 4

Insert the remaining white (56E), red (56F), yellow (56G) cables previously cut, as well as the black cable (56J), into the black jacket.



Pass the sheath (56D) - with the coloured cables inside - through the opening in the cockpit bulkhead (54A) as shown above.

STEP 5

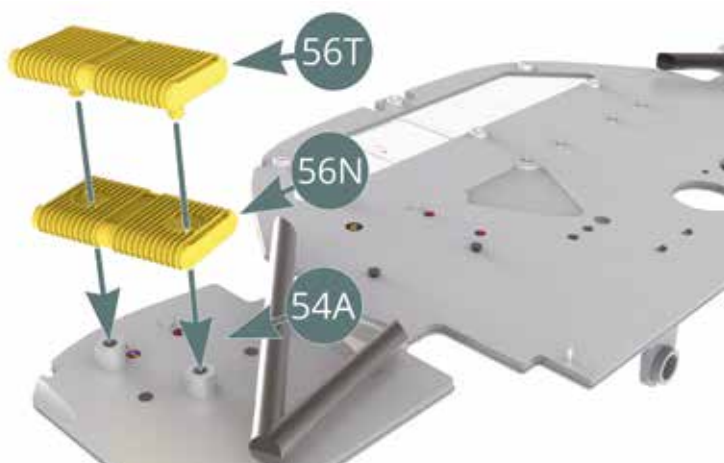
Connect the ends of the yellow, white, red and black cables to the slots above the ignition box (56K) as shown below.



Flush cut the wires (red arrows) protruding from the other side of the cabin's partition (54A) - silver side.

STEP 6

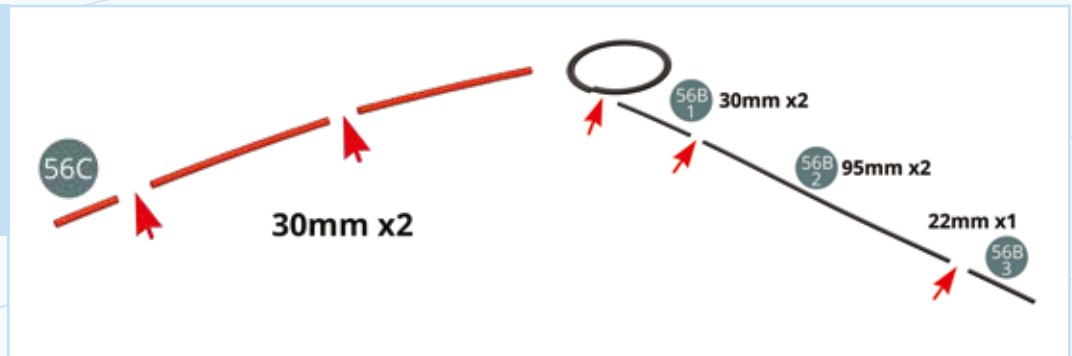
Position the regulator housing (56N and 56T) on the cabin's bulkhead (54A). Position the two ignition coils (56A) on the cabin's bulkhead (54A).





STEP 7

Cut two lengths of 30 mm of the red cable (56C). Cut the quantities and lengths of the black cable (56B) as detailed opposite.



STEP 8

Connect the two red cables (56C) and the two black wires (56B-1), previously cut, to the nipples on the sides above the ignition coils (56A) as shown, then feed the ends through the left opening in the cockpit partition (54A).



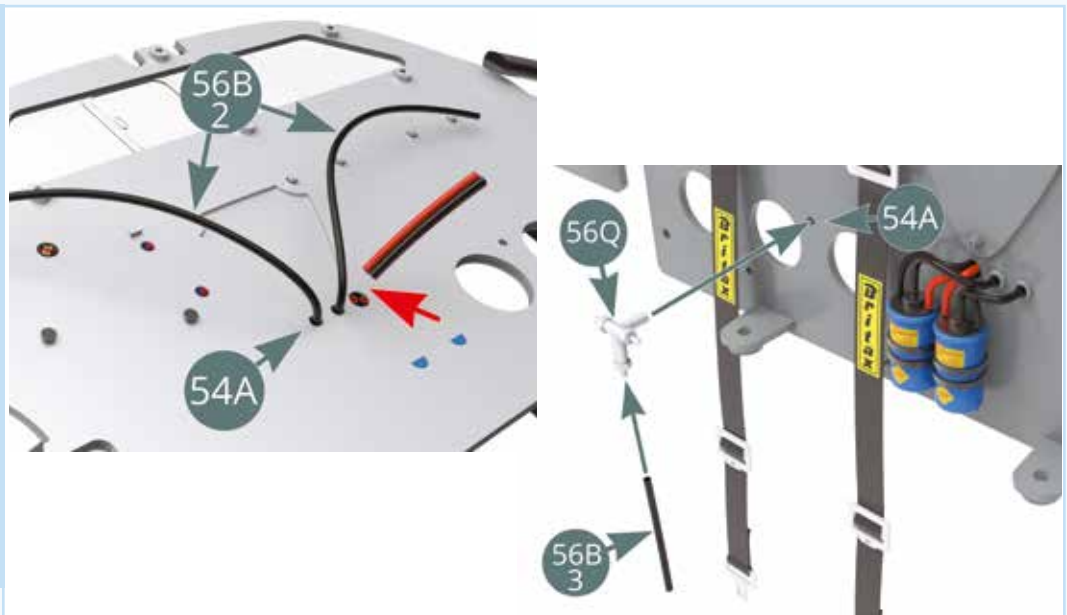
Connect the two black cables (56B-2), previously cut, to the nipples, centrally positioned, above the ignition coils (56A), then feed the ends through the openings (middle and right) in the cockpit partition (54A) as shown below.



STEP 9

Leave the two black cable lengths (56B-2) free for future use. Flush cut the red and black cables (red arrows) protruding from the other side of the cabin's bulkhead (54A).

Connect the black cable (56B-3), cut previously, to the underside of the branch connector (56Q), then position it on the cabin's bulkhead (54A).



STEP 10

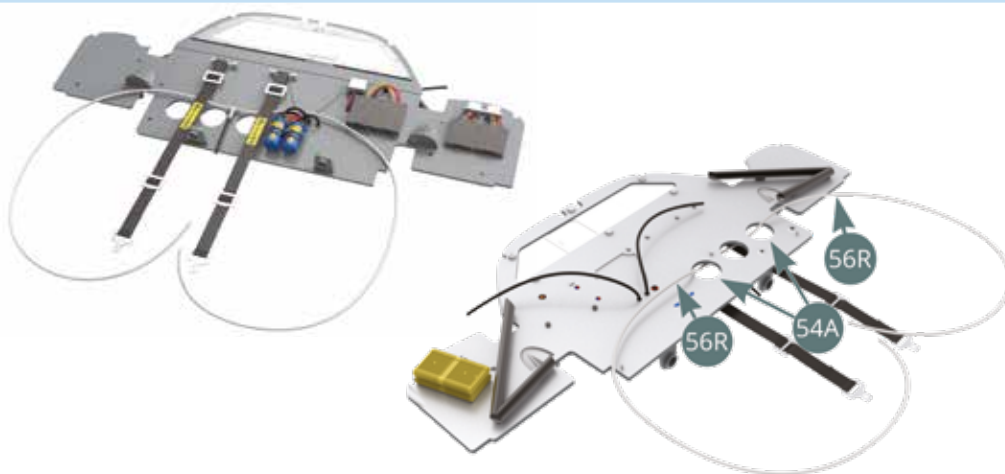
Cut two lengths of 250 mm from the fire extinguisher hose (56R).



Connect the two fire extinguisher hoses (56R), cut previously, to the sides of the branch connector (56Q).

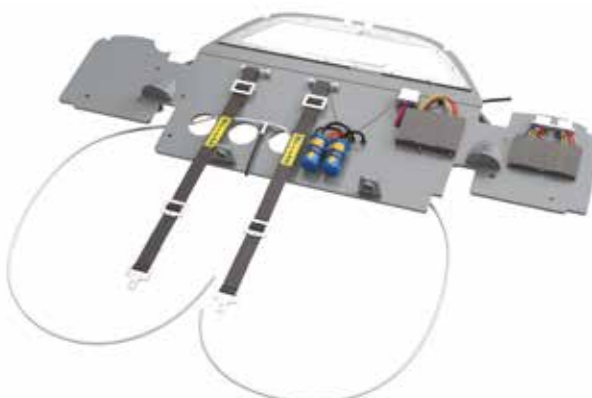
STEP 11

The two fire extinguisher hoses (56R) are attached to the bypass connector (56Q). Pass the two fire extinguisher hoses (56R) through the two large openings at the bottom of the cabin's partition (54A) so that they exit on the other side.



STEP 12

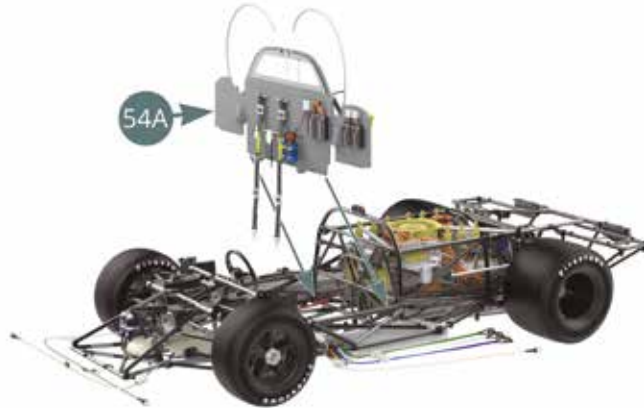
The cabin's bulkhead (54A) is ready to be installed on the chassis.





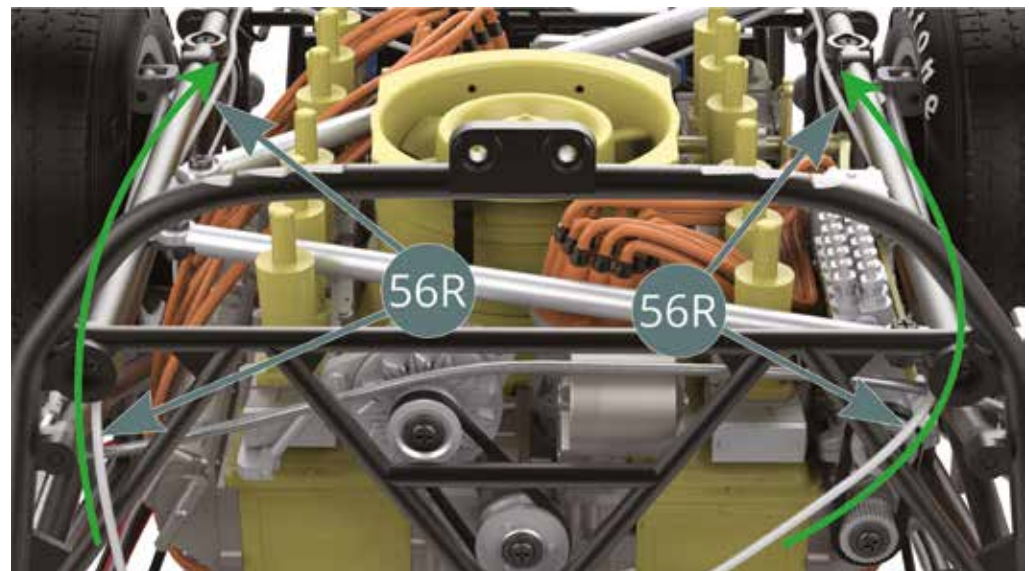
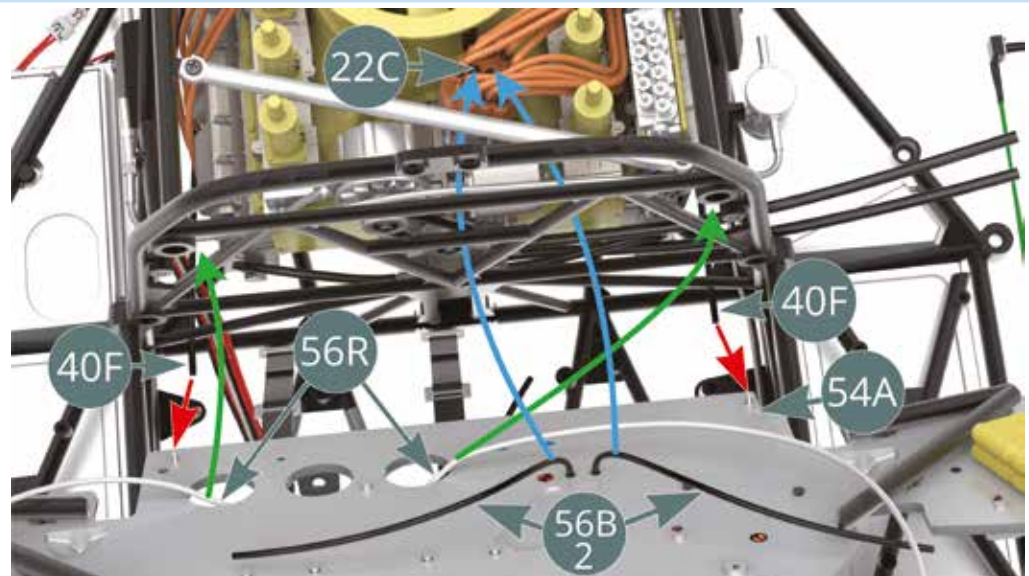
STEP 13

Start by aligning the cabin's bulkhead (54A) above the location it is to be integrated into the chassis.



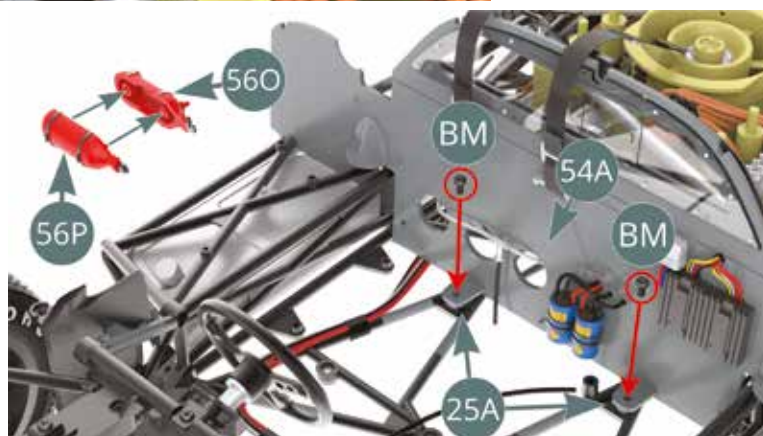
STEP 14

Before attaching the cabin's bulkhead (54A) to the chassis, connect the two brake lines (40F) to the two nipples at the bottom of the partition (red arrows). Then run the two fire extinguisher hoses (56R) along the upper side tubes of the engine cradle, as indicated by the green arrows in the illustrations opposite. Finally, connect the ends of the two black cables (56B-2) to the two loose ignition wire connectors (22C) on the igniter head as shown by the blue arrows in the illustration above.



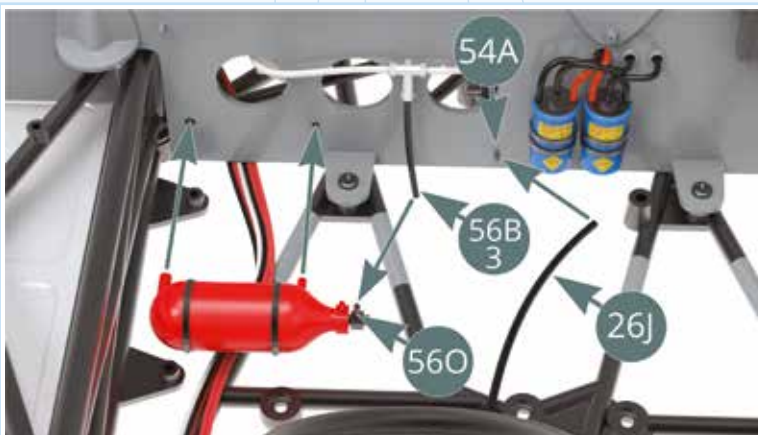
STEP 15

The two black wires (56B-2) are connected to the two free ignition wire connectors (22C). Attach the cabin's partition (54A) to the lower frame (25A) with two BM screws. Assemble the two fire extinguisher halves (56O and 56P).



STEP 16

Position the fire extinguisher (56O) on the cabin's bulkhead (54A) and connect the end of the black cable (56B-3) to the fire extinguisher head (56O). Attach the clutch cable (26J) to the bottom of the cabin's bulkhead (54A).

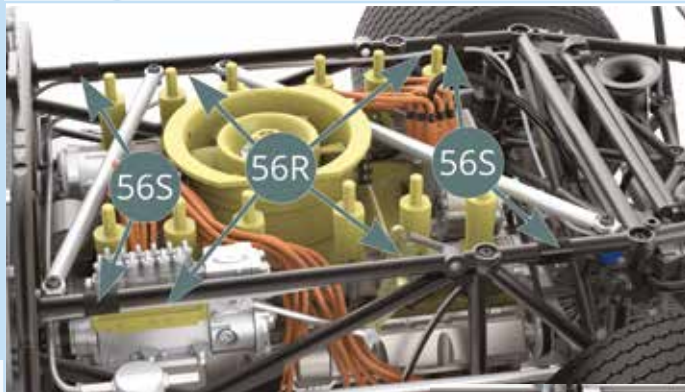


The cabin's bulk-head is attached to the chassis.



STEP 17

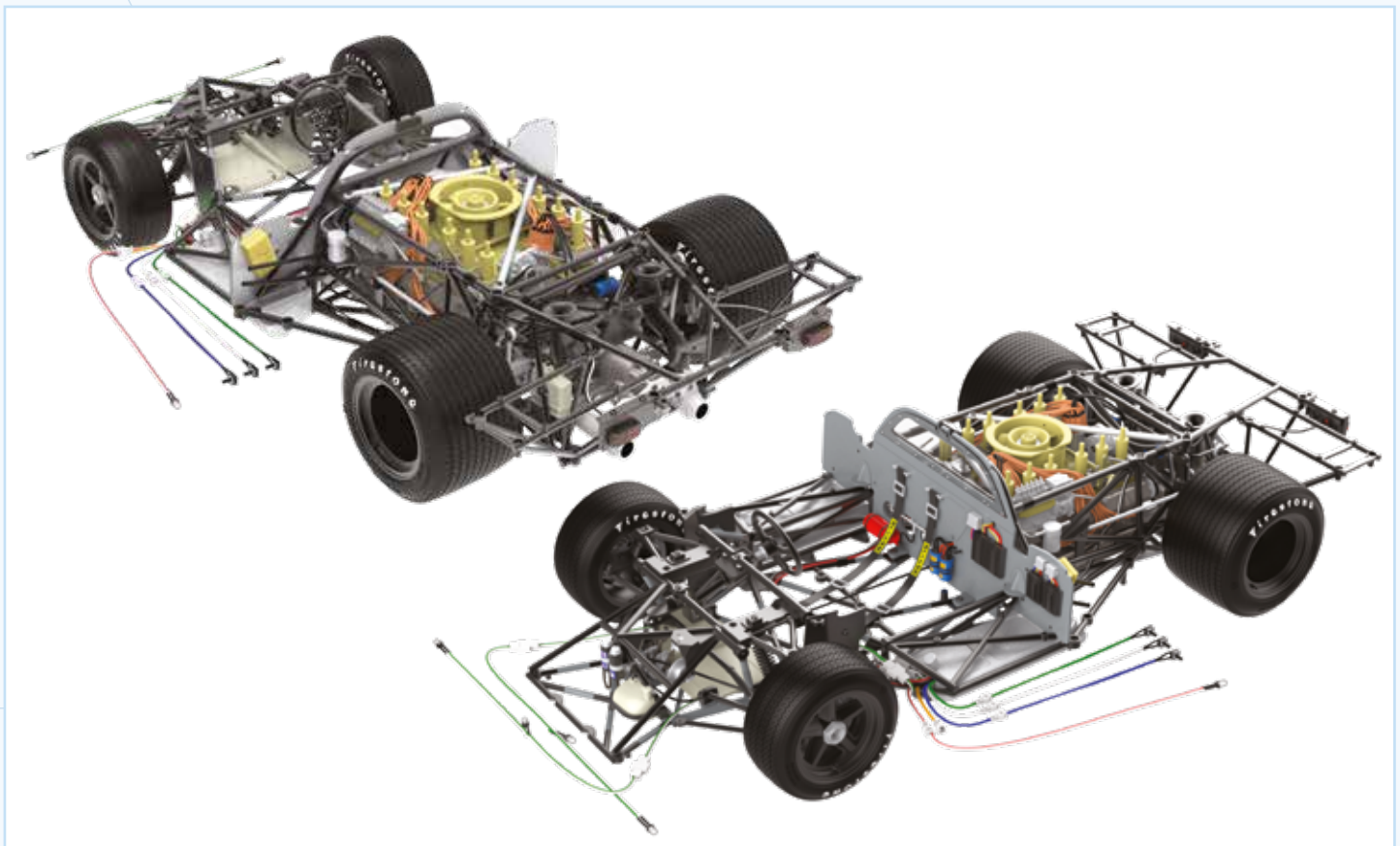
Attach the fire extinguisher hoses (56R), along the two upper lateral tubes of the engine cradle, with four pieces of tape (56S) - illustrations opposite and below.



Leave both ends of the fire extinguisher hoses (56R) free at the rear and top of the engine.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 57

57A Trumpet panel right

57B Trumpet cap (x 6)

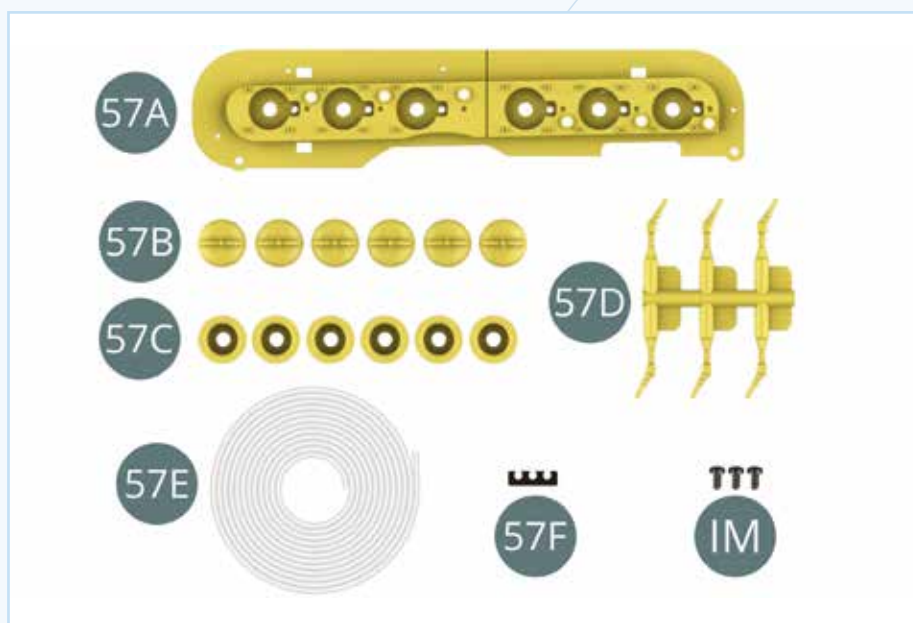
57C Trumpet collar (x 6)

57D Intake nozzle

57E Fuel line

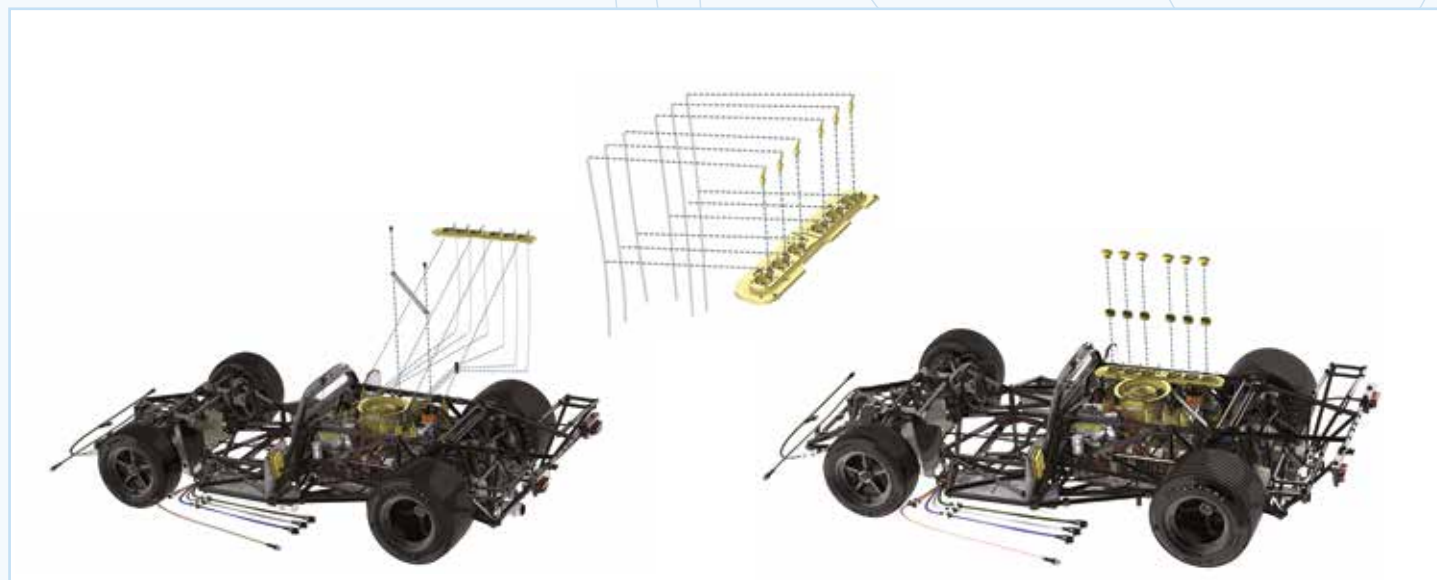
57F Guide to Fuel line

IM M Screw 1.7 x 3.5 mm (x 3)



Assembly and mounting
of the right intake trumpet
panel and fuel lines to the
engine

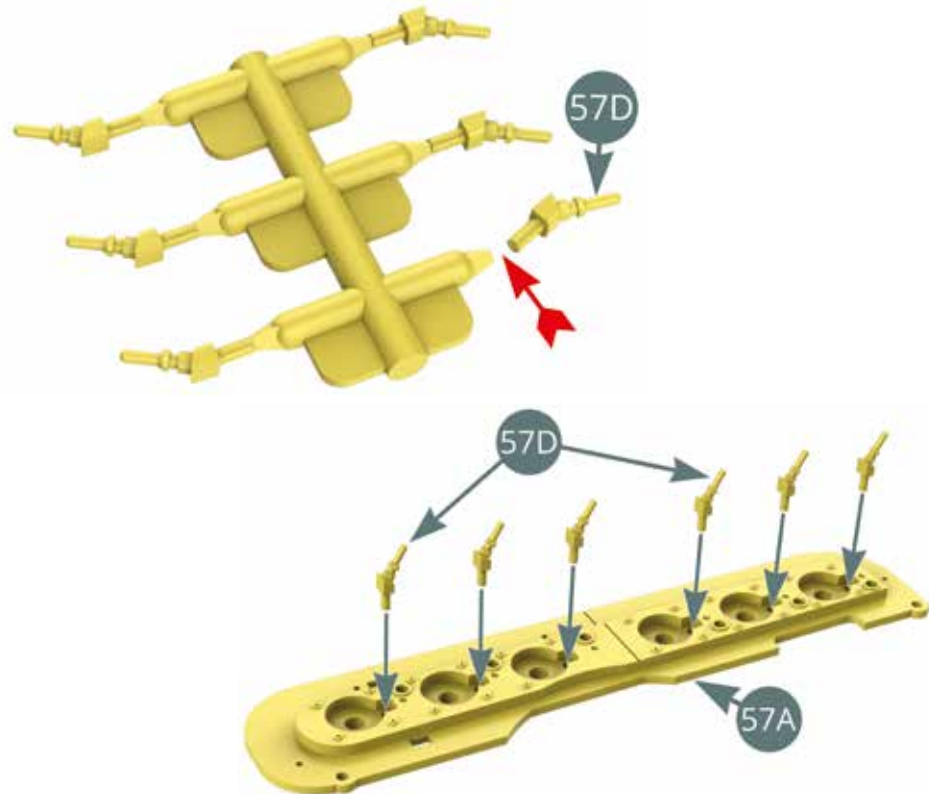
ASSEMBLY DIAGRAM





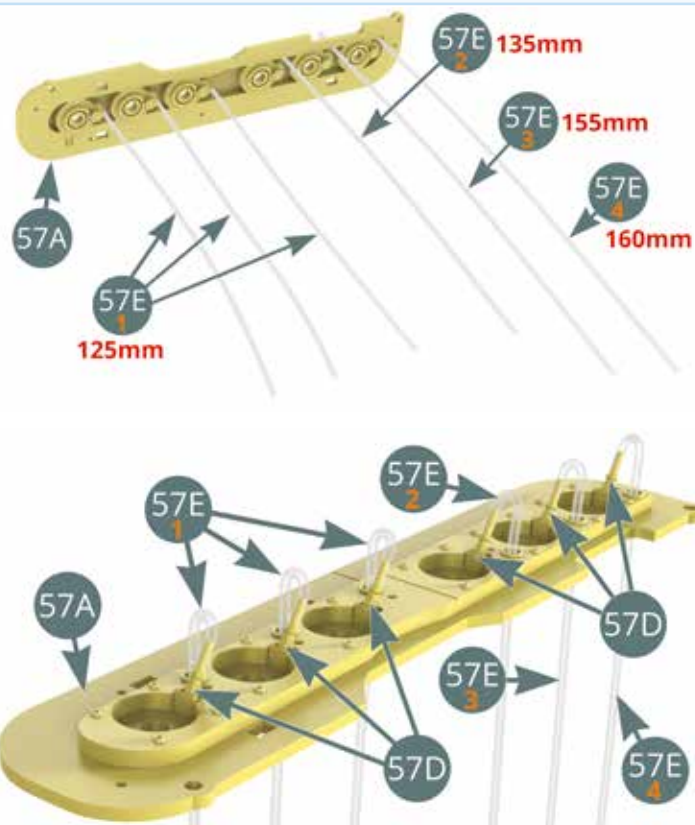
STEP 1

Detach the six intake nozzles (57D) from the sprue and position them on the right-hand trumpet panel (57A) - illustrations opposite.



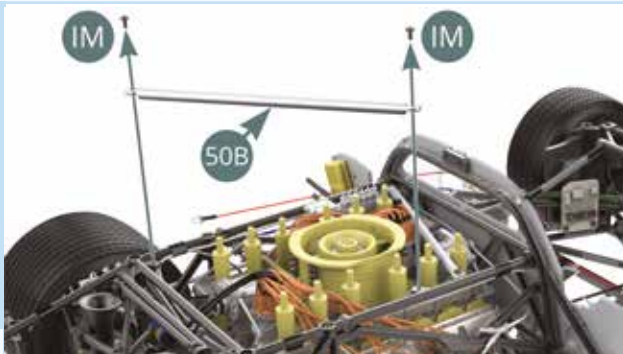
STEP 2

Cut the fuel line (57E) into three lengths: 57E-1 (125 mm), 57E-2 (135 mm), 57E-3 (155 mm) and 57E-4 (160 mm). Pass them through the right-hand trumpet panel (57A) and attach them to their respective nozzles (57D) - see illustrations opposite.

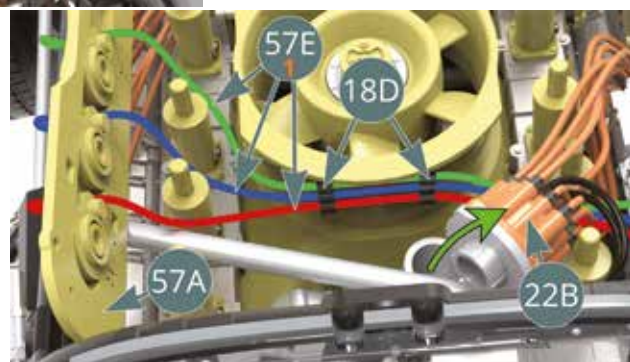


STEP 3

Undo the two IM screws and remove the reinforcement bar (50B). Carefully lift the igniter head (22B) to facilitate the passage of the three fuel lines 57E-1 through the two guide lines (18D).

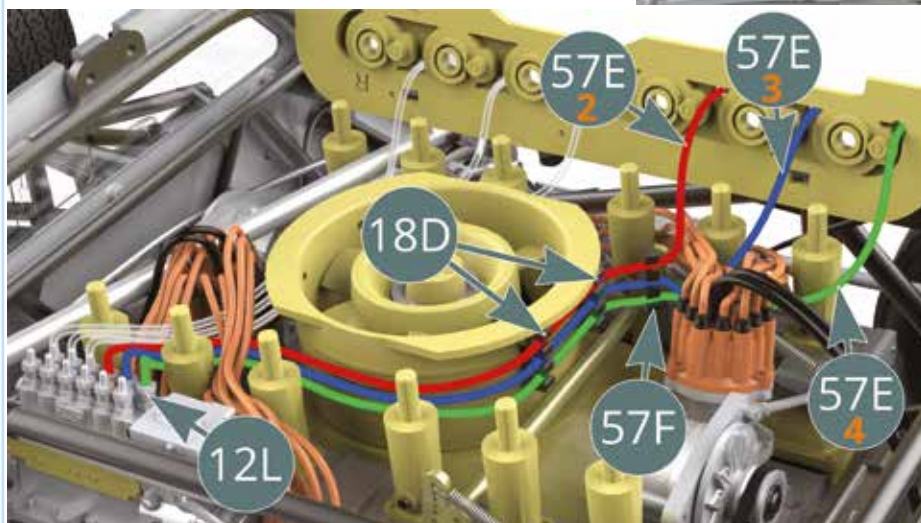
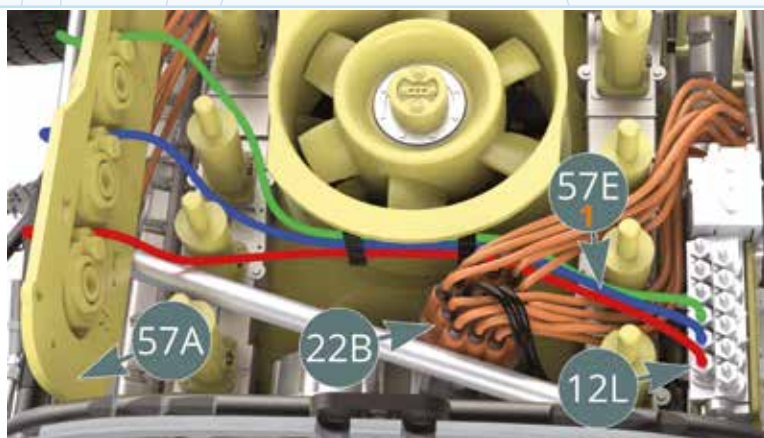


Follow the flow sequence as indicated by the red, blue and green wires.



STEP 4

Replace the ignition head (22B). Position the three 57E-1 fuel lines on three injector nozzles (12L) on the inside row. Follow the red, blue and green order as shown.

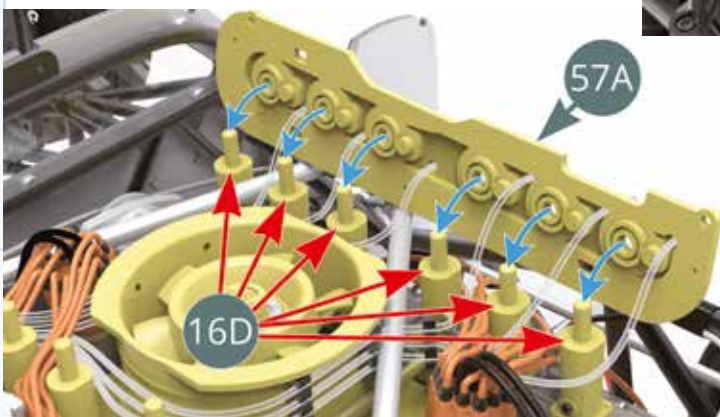
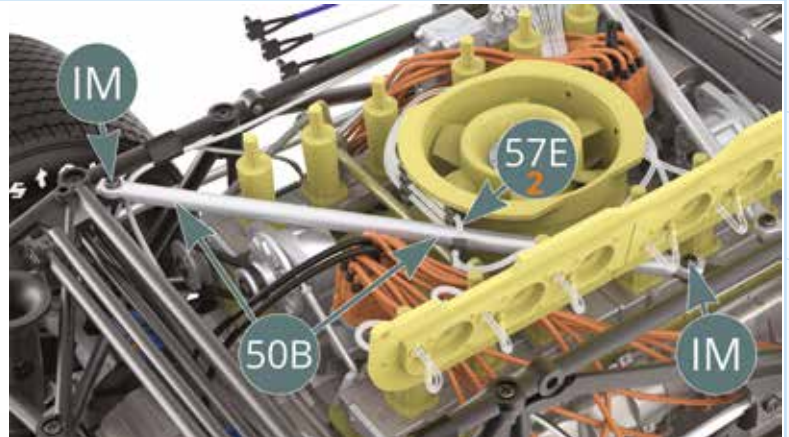


Pass the fuel lines (57E-2, 57E-3 and 57E-4) through the guide line (57F) and the two guide lines (18D) and position them on the three remaining injector nozzles (12L) of the inner row. Follow the red, blue and green order shown.



STEP 5

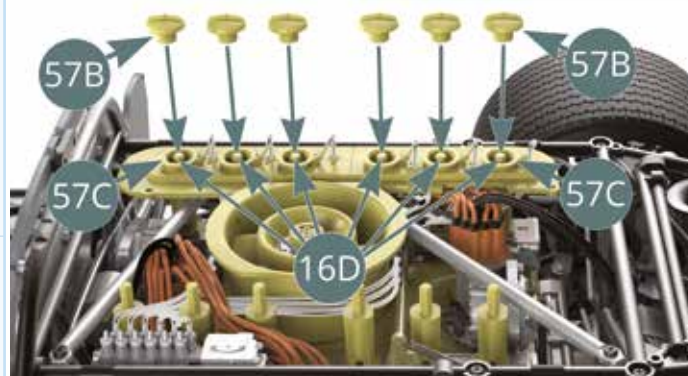
Replace the reinforcement bar (50B) by passing it under the fuel line (57E-2) - the highest one - and reattach it with two IM screws to the engine cradle.



Check that no fuel lines run over the inlet trumpets (16D) - red arrow - and attach the right-hand panel (57A) to them.

STEP 6

Place the six trumpet caps (57C) on the inlet trumpets (16D) and onto the right-hand panel (57A).



Fit the six trumpet collars (57B) on the inlet trumpets (16D) above the six trumpet caps (57C).

GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 58

58A Left trumpets panel

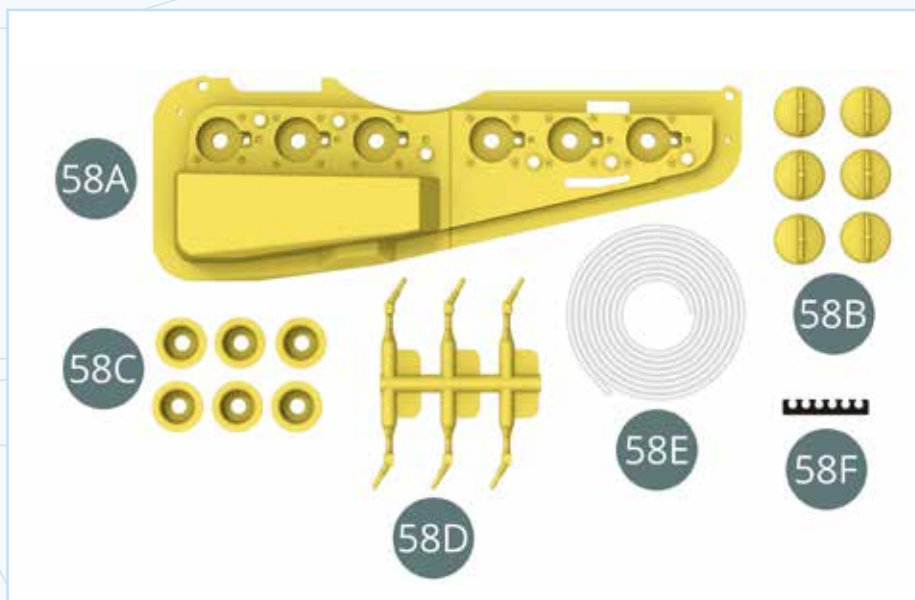
58B Trumpet cap (x6)

58C Trumpet flare (x6)

58D Nozzles (x6)

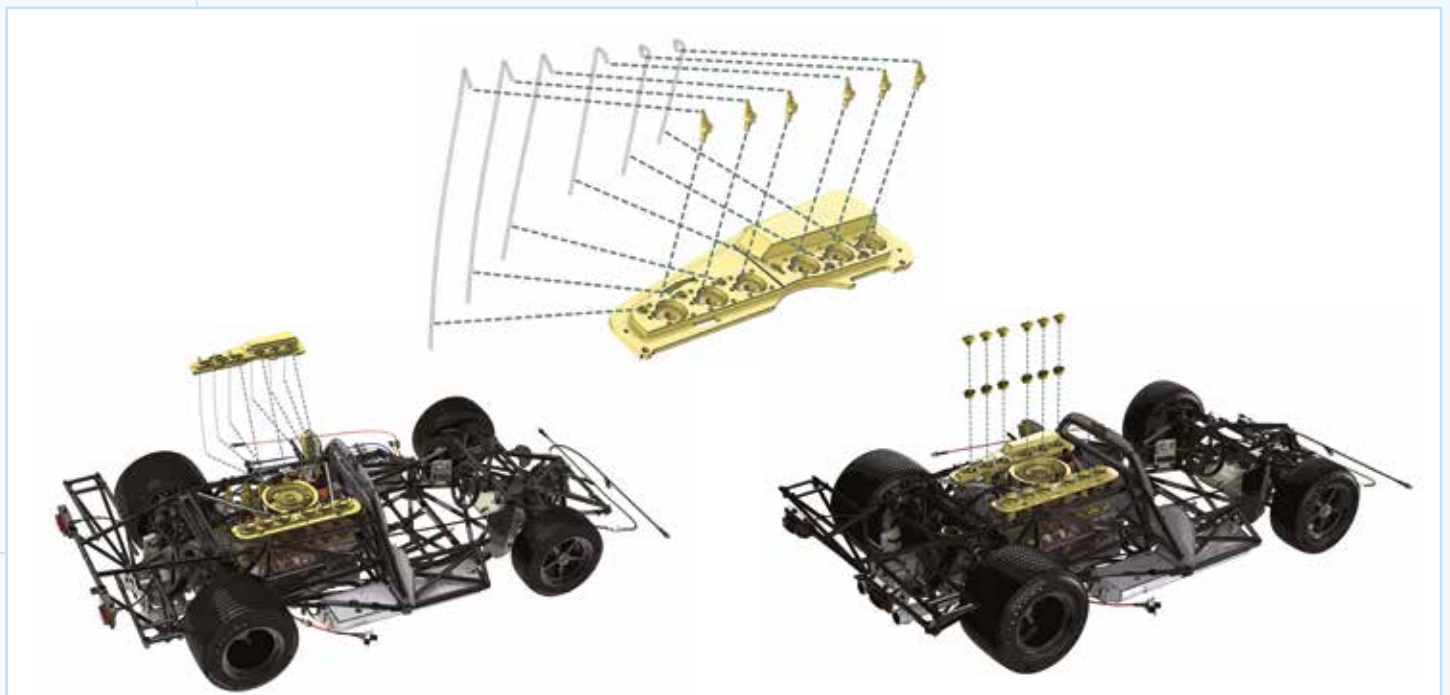
58E Fuel line

58F Spacer bar



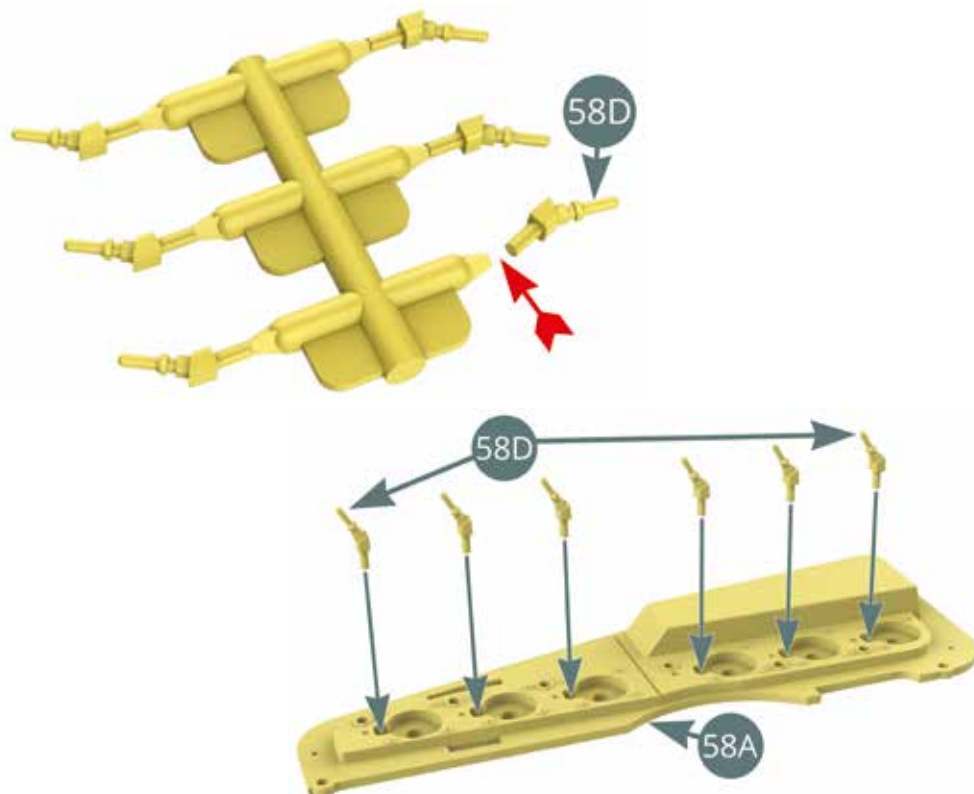
Left Intake trumpets panel and fuel lines assembly and attachment to engine

ASSEMBLY DIAGRAM



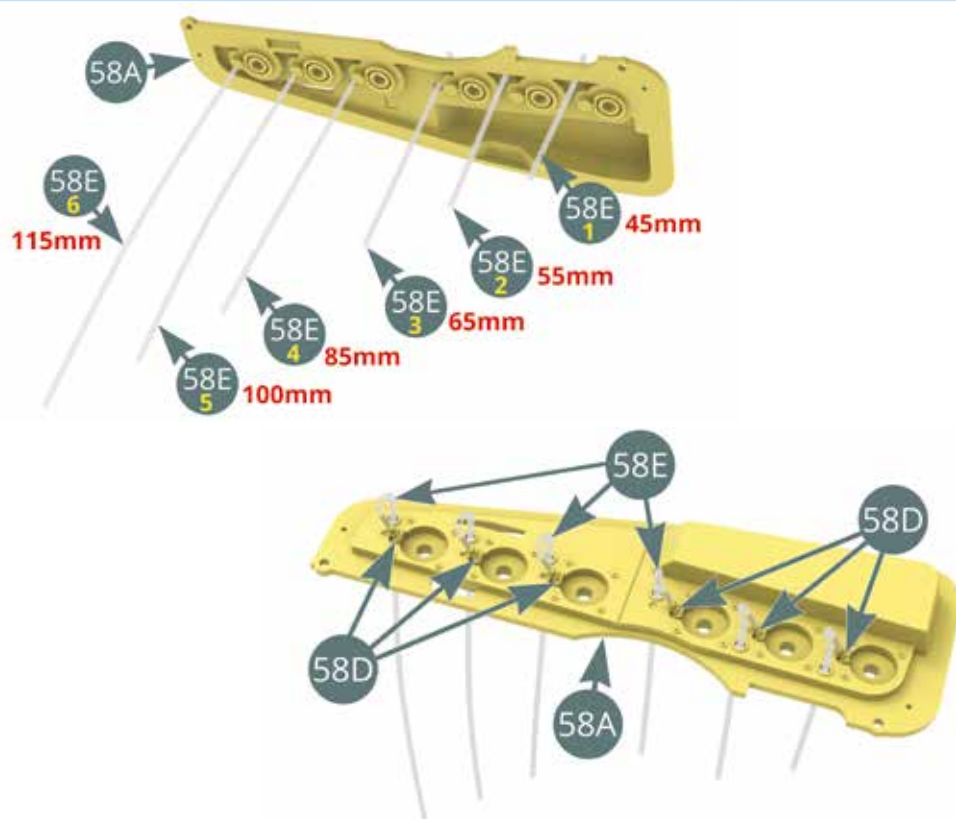
STEP 1

Nip away six 58D Nozzles from molded fret and fit them to 58A Left trumpets panel (upper and lower illustrations).



STEP 2

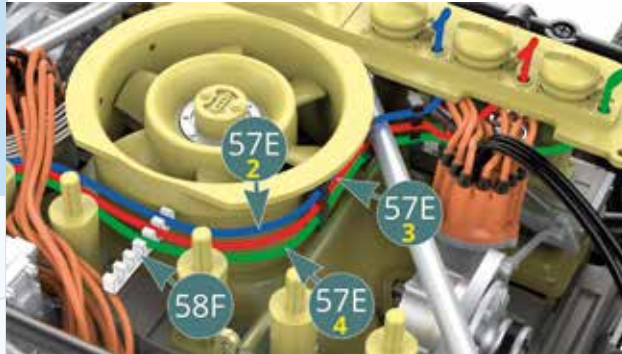
Cut 58E Fuel line to 58E-1, 58E-2, 58E-3, 58E-4, 58E-5, 58E-6 lengths, passing them through 58A Left trumpets panel and fitting on six respective 58D Nozzles (upper and lower illustrations).



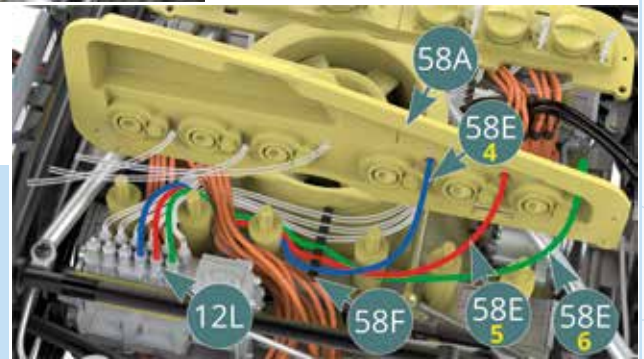


STEP 3

Pass 57E-2, 57E-3 and 57E-4 Fuel lines through 58F Spacer bar. Observe red, blue, green indicated order.

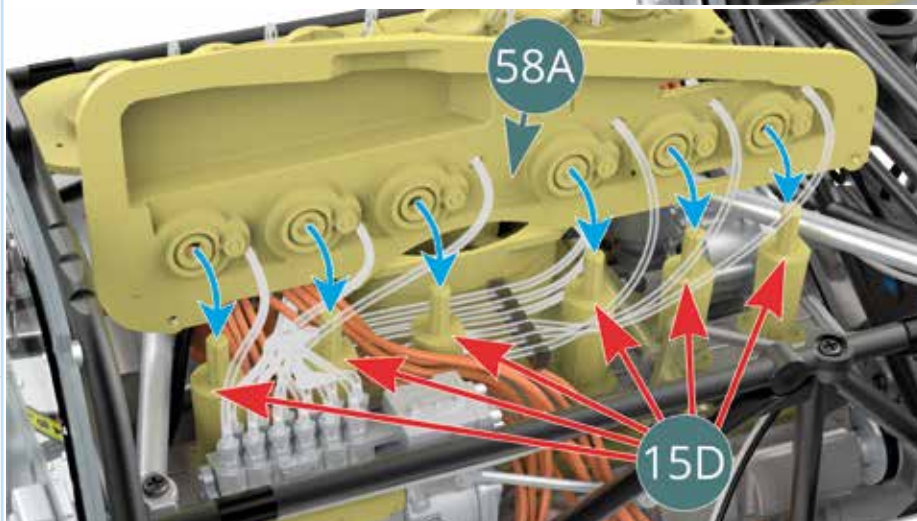
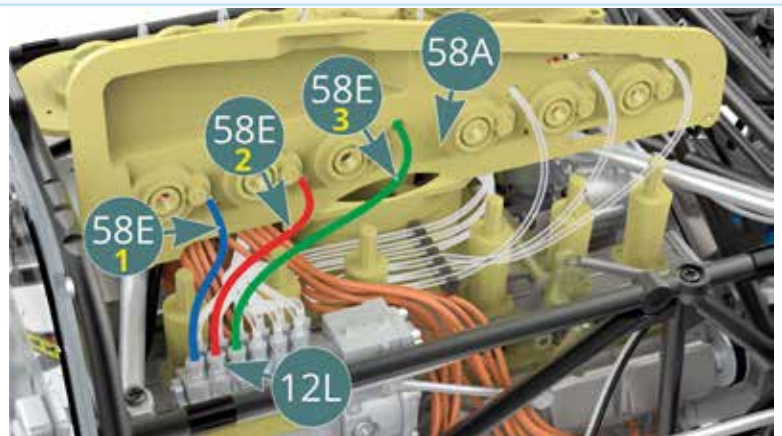


Fit three 58E-4, 58E-5 and 58E-6 Fuel lines to three 12L Injector nozzles of the outer row. Observe red, blue, green indicated order.



STEP 4

Fit three 58E-1, 58E-2 and 58E-3 Fuel lines to three 12L Injector nozzles of the outer row. Observe red, blue, green indicated order.

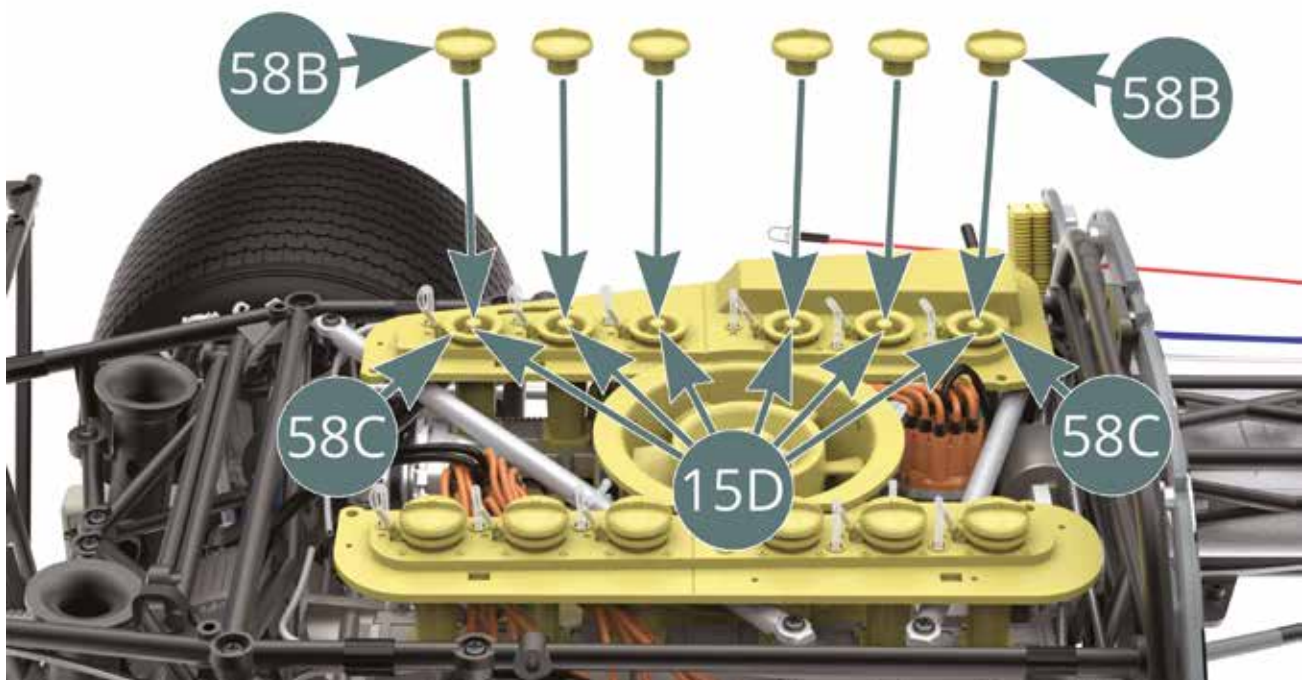
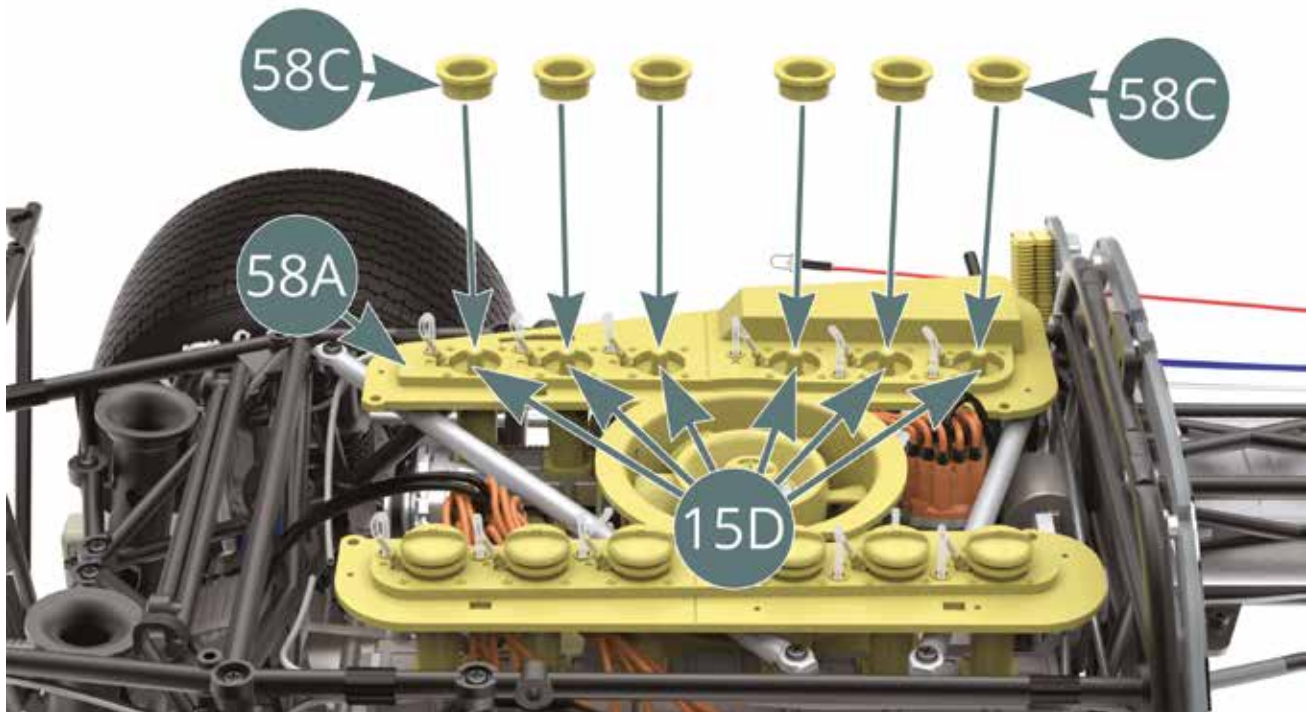


Make sure there are no wires crossing tops of 15D Intake trumpets (red arrows) and fit 58A Left trumpets panel on them.

STEP 5

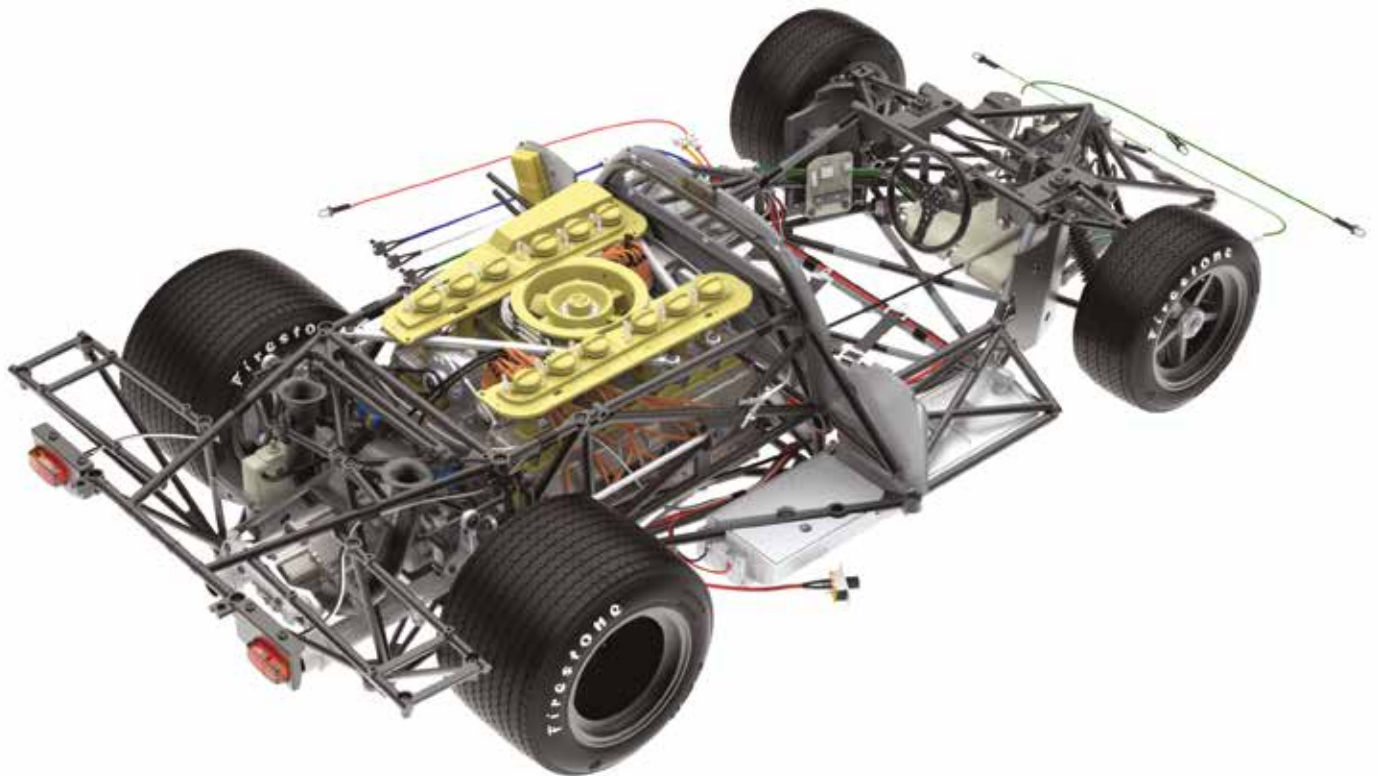
Fit six 58C Trumpet flares on 15D Intake trumpets and 58A Left trumpets panel.

Fit six 58B Trumpet caps to 15D Intake trumpets over 58C Trumpet flares.





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 59

59A Left air intake cover

59B Right air intake cover

59C Engine cover

LP M Screw 1.2 x 3.5 mm (x 13)



*Mounting of engine and
air intake covers*

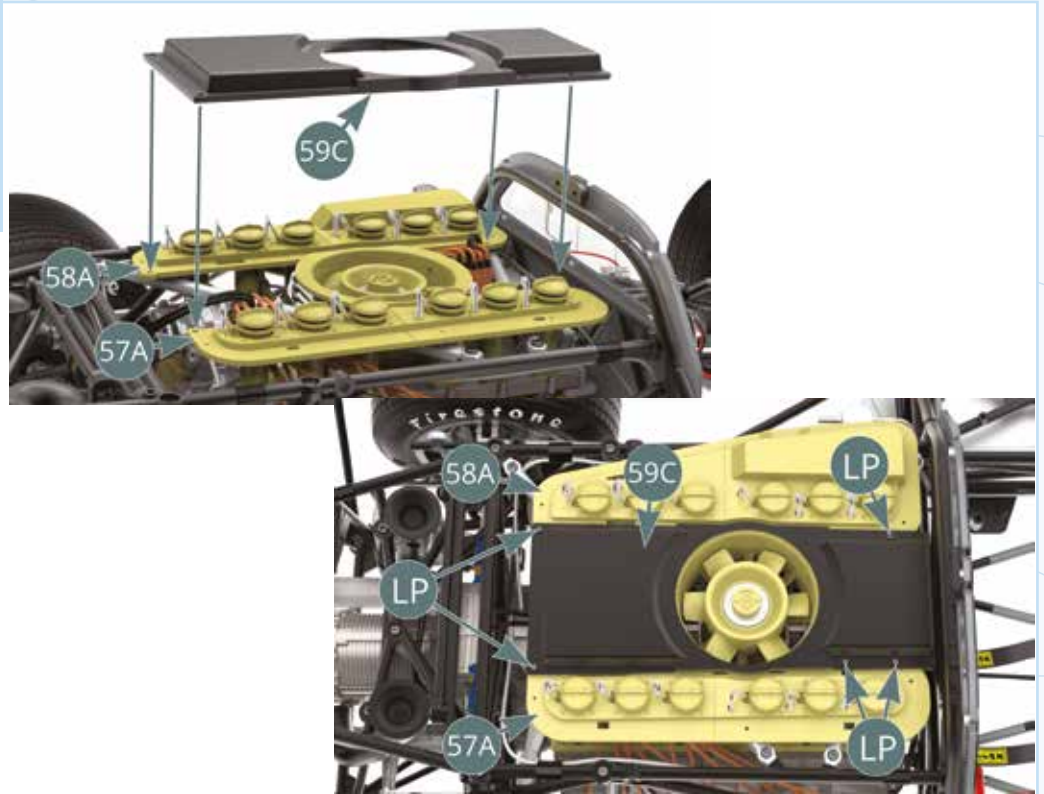
ASSEMBLY DIAGRAM





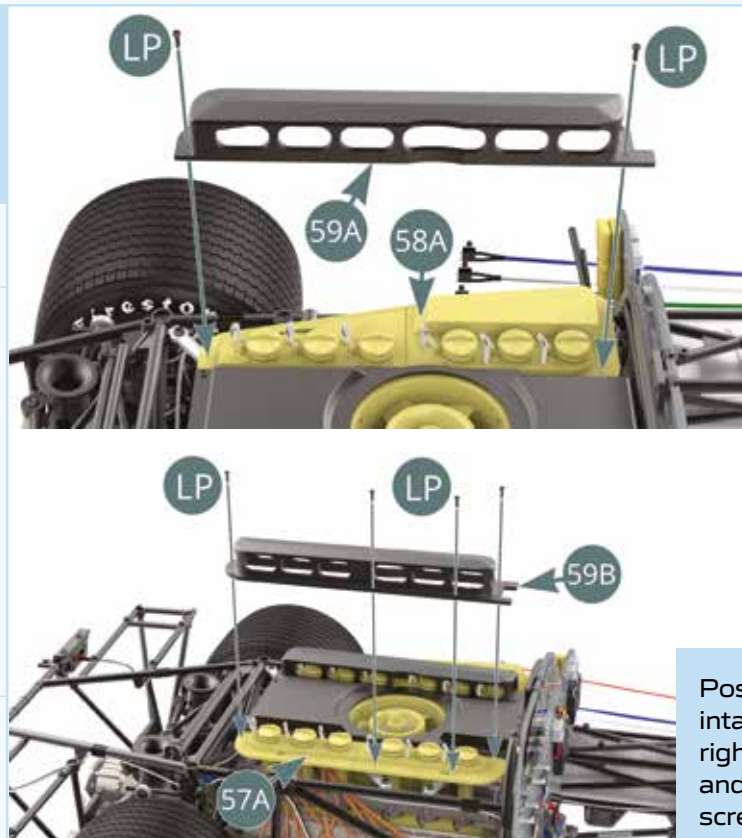
STEP 1

Fit the engine cover (59C) over the left (58A) and right (57A) intake trumpet panels and secure with five LP screws (see illustrations).



STEP 2

Position the left air intake cover (59A) on the left trumpet panel (58A) and secure it with two LP screws.



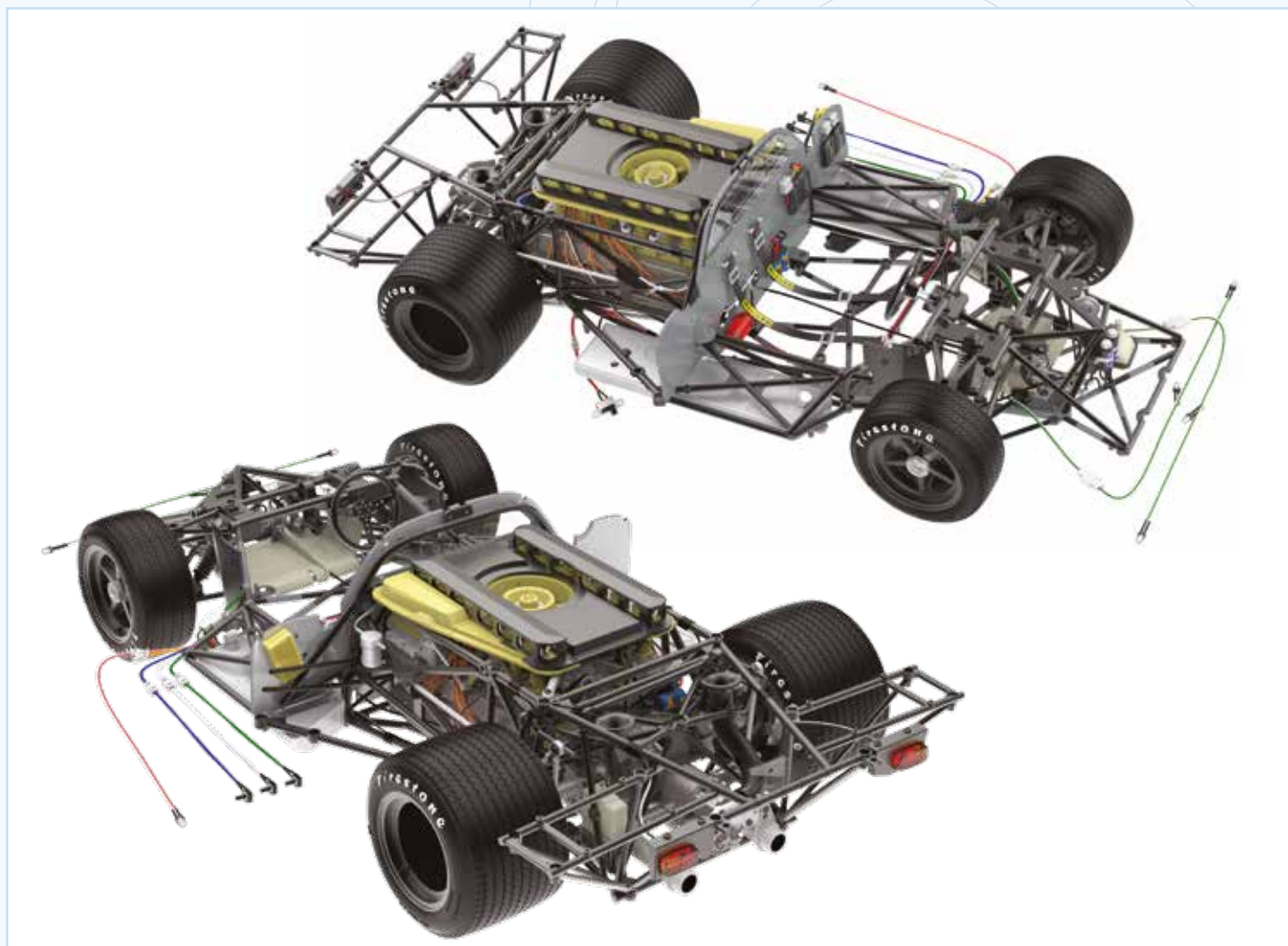
Position the right air intake cover (59B) on the right trumpet panel (57A) and secure with four LP screws.

STEP 3

All covers are mounted on the engine.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 60

60A Battery

60B Battery cover

60C Battery terminal (x 2)

60D Battery cable

60E Battery cable

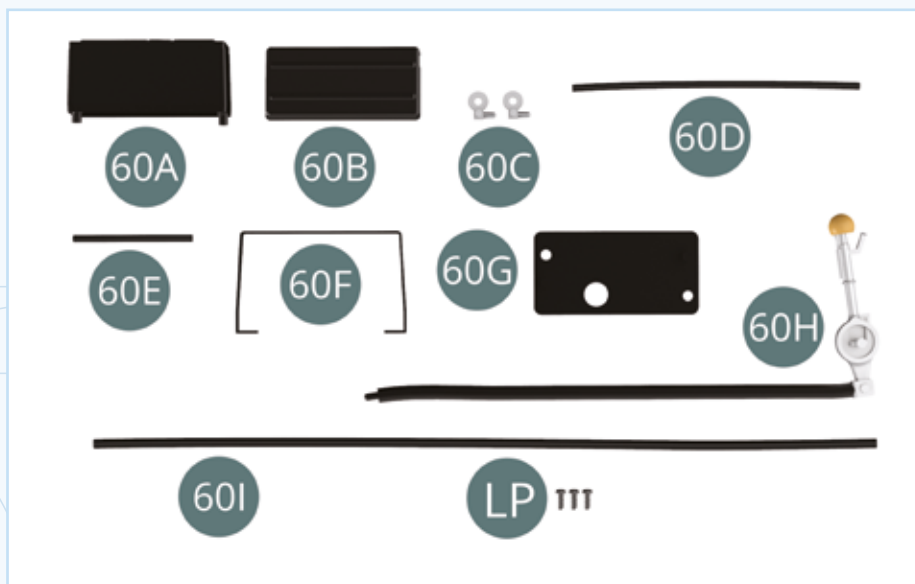
60F Strap

60G Battery holder

60H Gear lever with gear rod

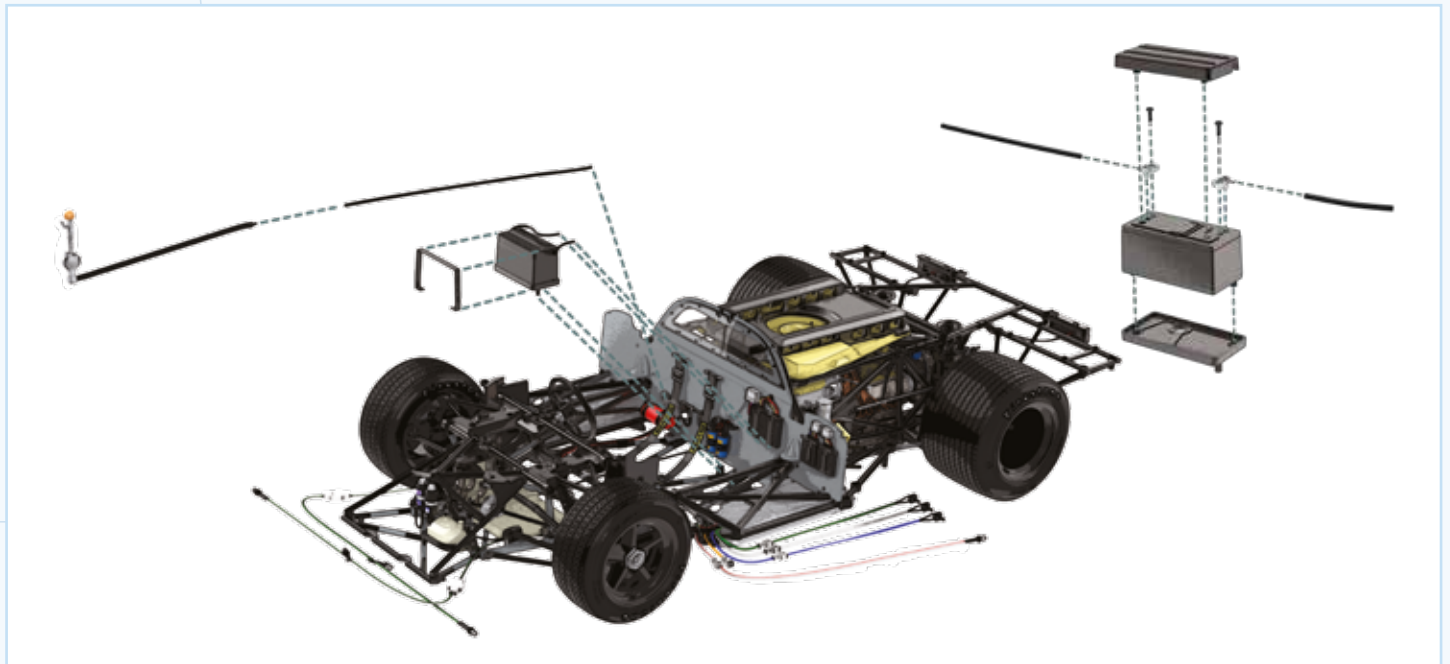
60I Gearbox rod

LP M Screw 1.2 x 3.5 mm (x 3)



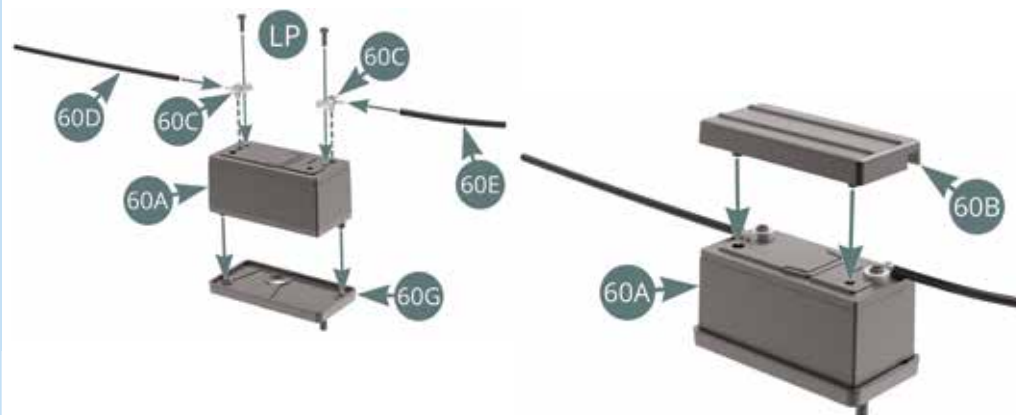
Assembly and mounting of the battery and gear lever

ASSEMBLY DIAGRAM



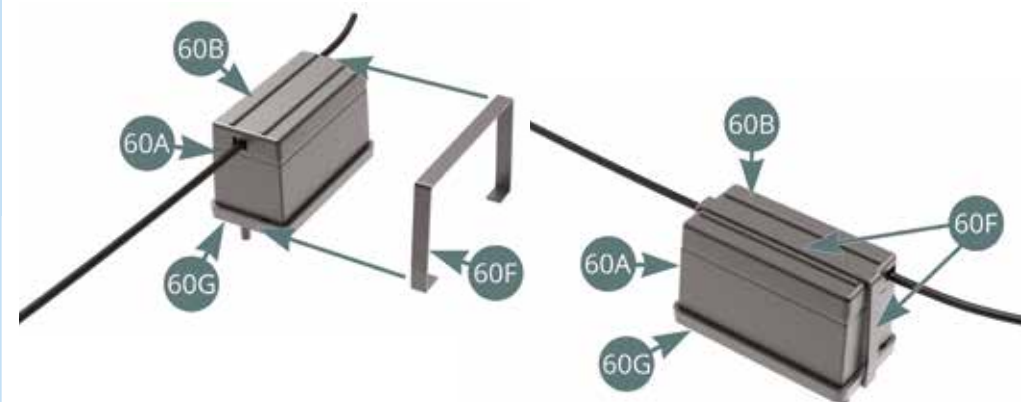
STEP 1

Position the cables (60D and 60E) on the two battery terminals (60C). Position the terminals (60C) onto the battery (60A) and secure with two LP screws. Position the battery (60A) on the holder (60G).



STEP 2

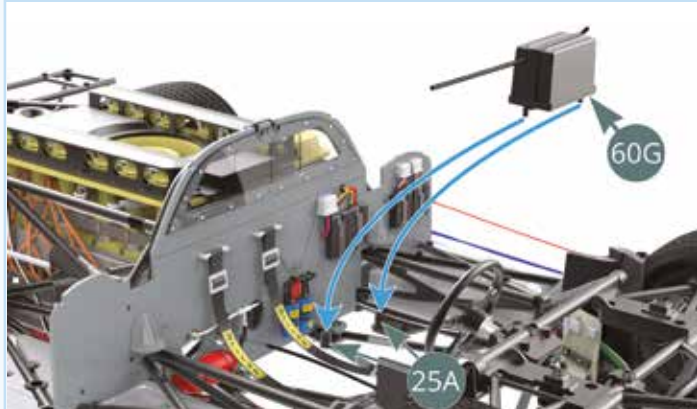
Place the strap (60F) on top of the cover (60B) and battery (60A), and underneath the holder (60G) - see illustrations opposite.



STEP 3

Position the battery holder (60G) on the lower frame (25A) using its two lugs/pins.

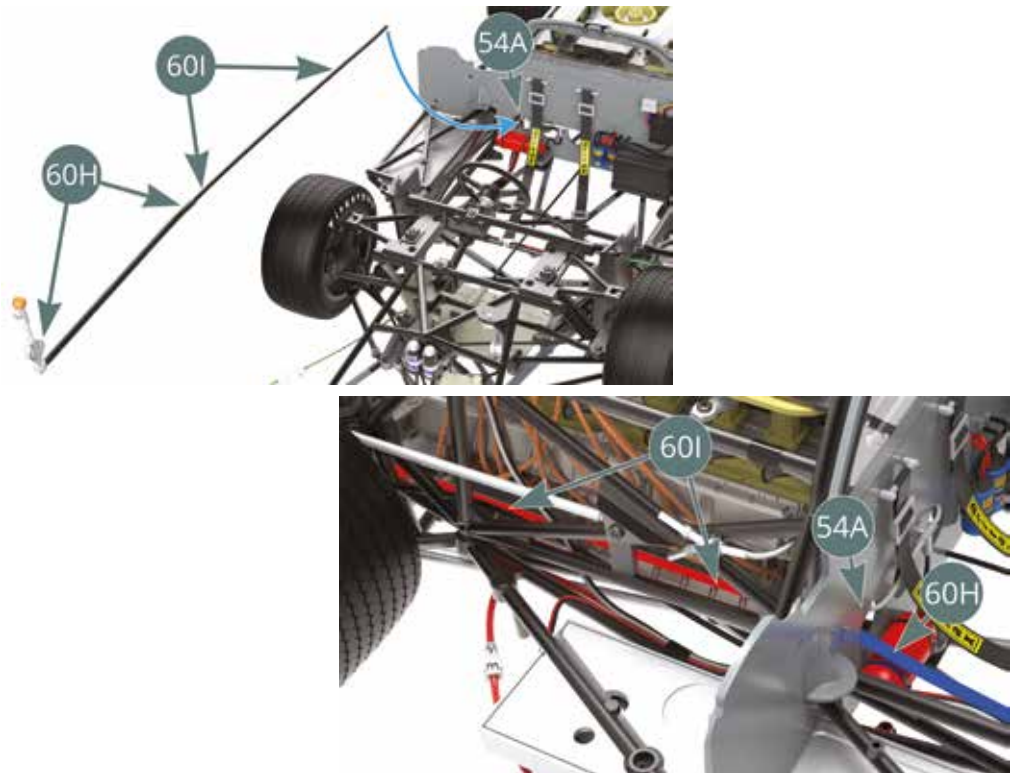
Connect the cables (60D and 60E) to the lugs on the cockpit bulkhead (54A), just below the ignition box (56K).





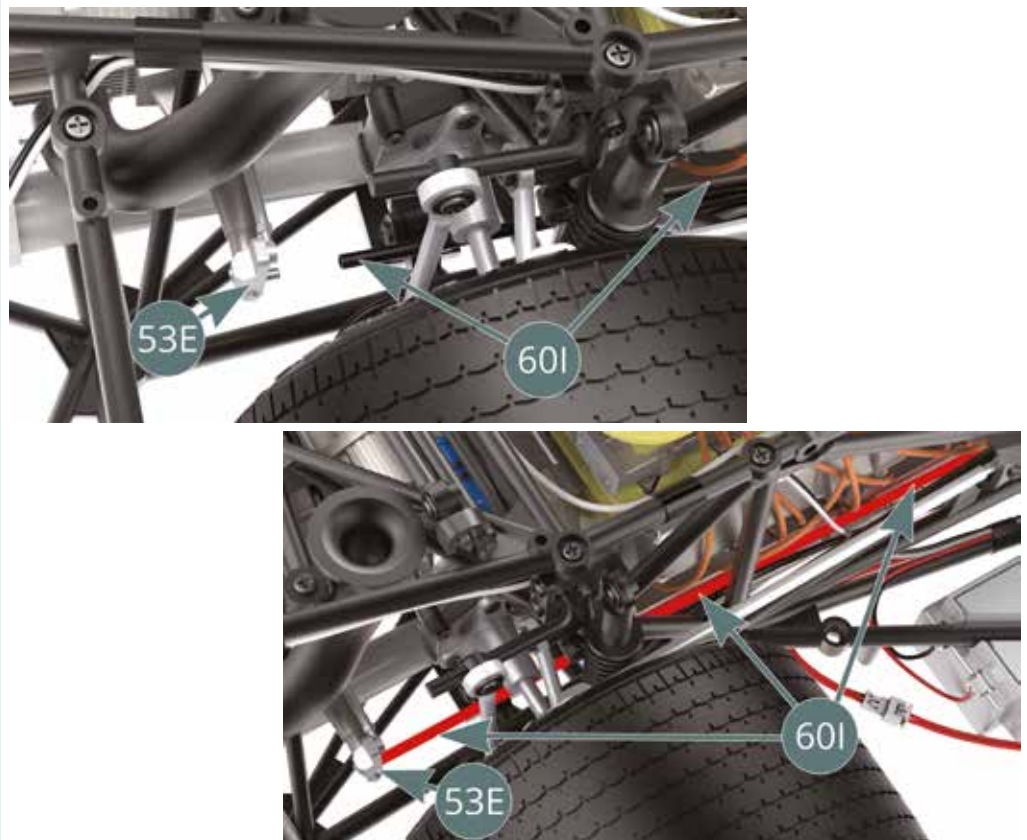
STEP 4

Connect the gear lever (60H) and the gearbox rod (60I), then pass the latter through the opening in the cockpit bulkhead (54A) - see illustrations opposite.



STEP 5

Guide the gearbox rod (60I) to the gearbox support (53E) and connect it to it (see illustrations).

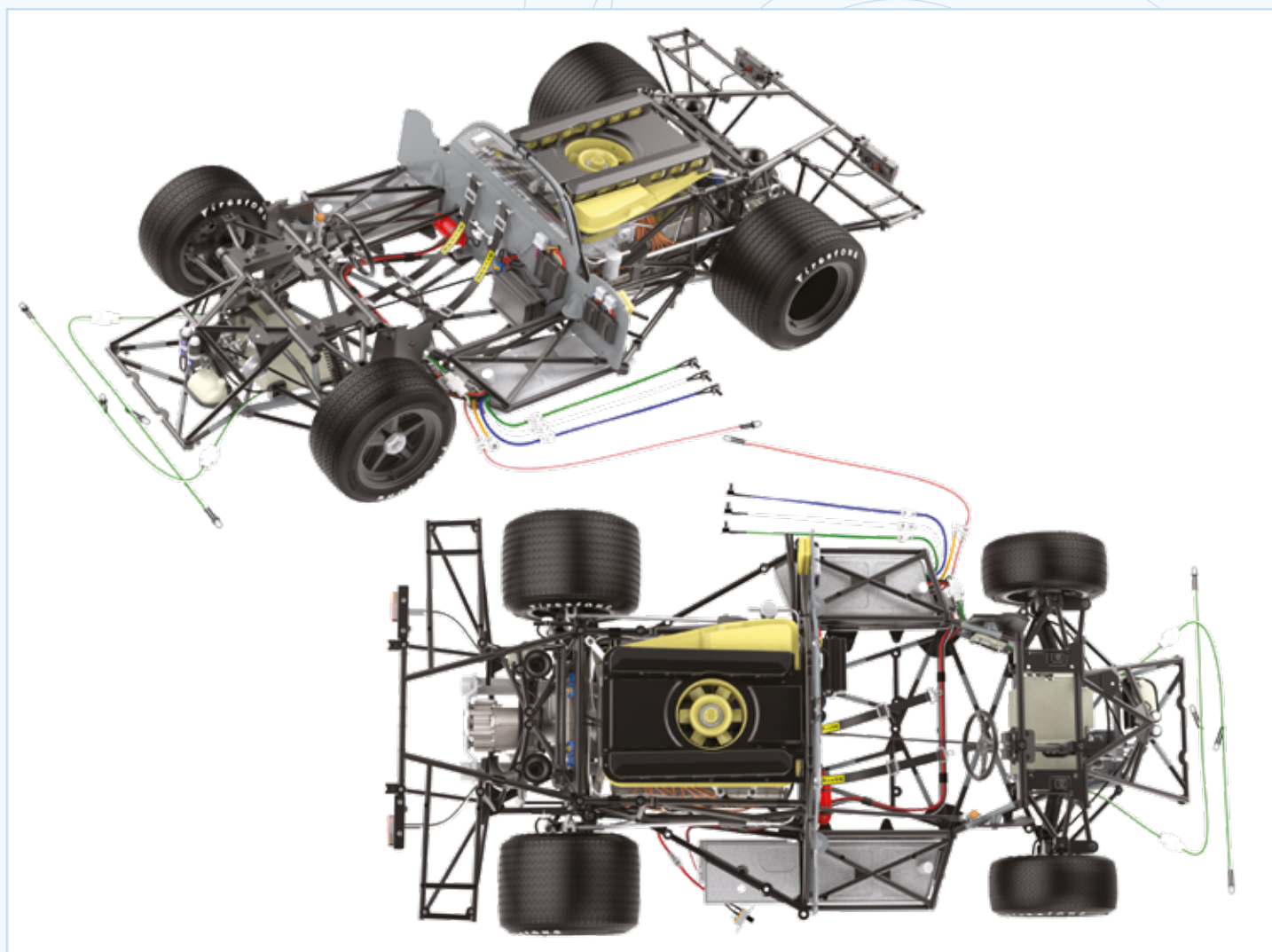


STEP 6

Position the gear lever (60H) on the right side of the chassis (34A) in the cockpit.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 61

61A Driver's seat upholstery

61B Driver's seat

61C Lower safety belt

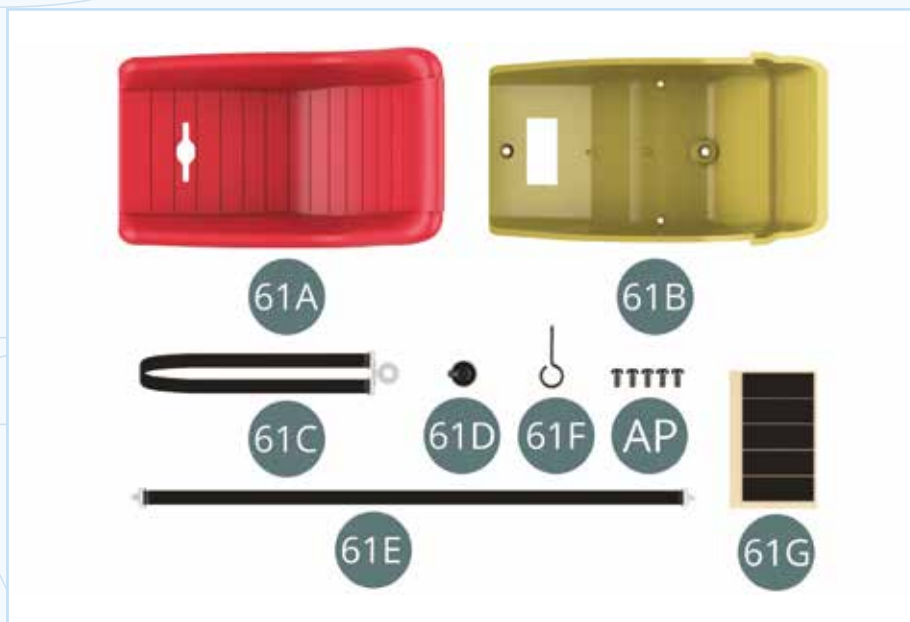
61D Buckle lock

61E Upper safety belt

61F Seat adjustment lever

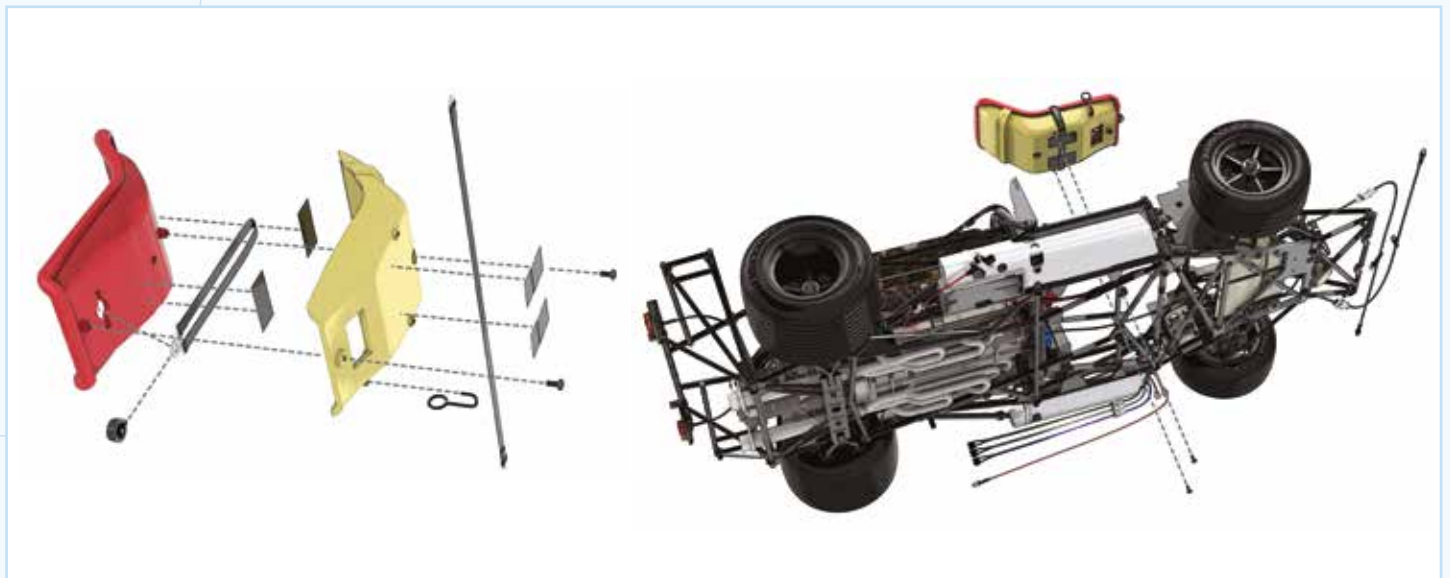
61G Adhesive tape (x5)

AP screw M 1.7 x 4 mm screw (x 5)



Driver's seat assembly and installation

ASSEMBLY DIAGRAM

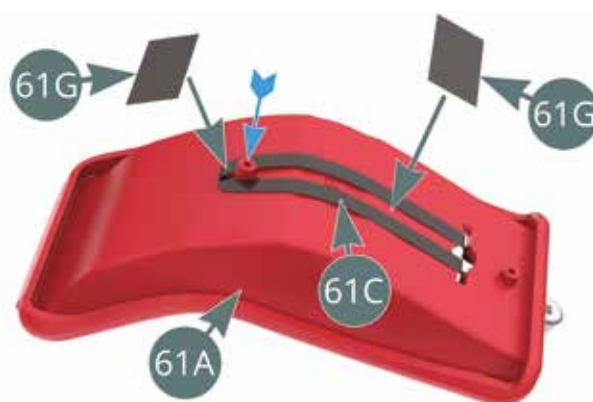


STEP 1

Pass the lower safety belt (61C) through the slot in the driver's seat upholstery (61A) and fit the lock (61D) in its buckle.

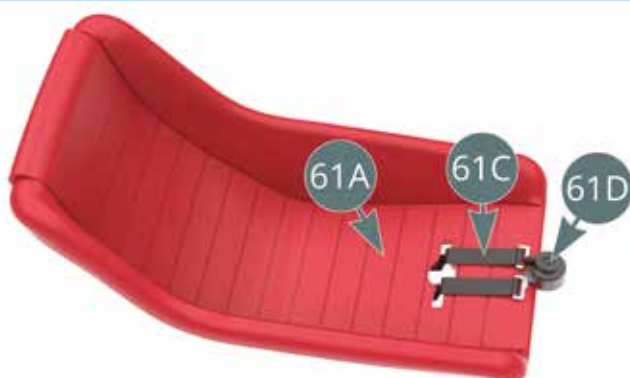


Route the opposite end of the lower safety belt (61C) around the pin on the driver's seat upholstery (61A) - blue arrow - and secure with two strips of tape (61G).

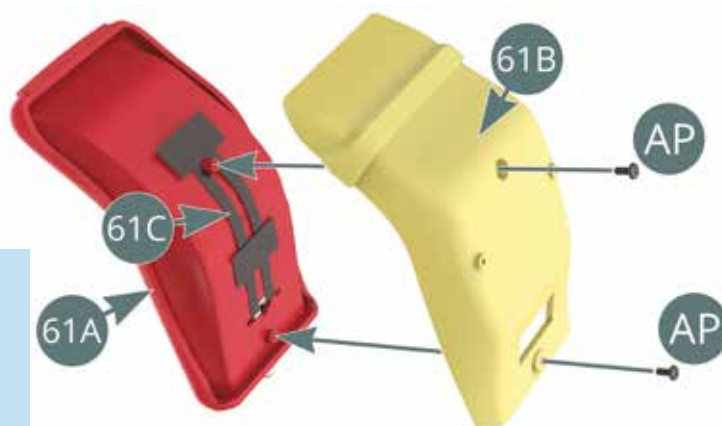


STEP 2

Lower safety belt (61C) with buckle lock (61D) attached to the driver's seat upholstery (61A).



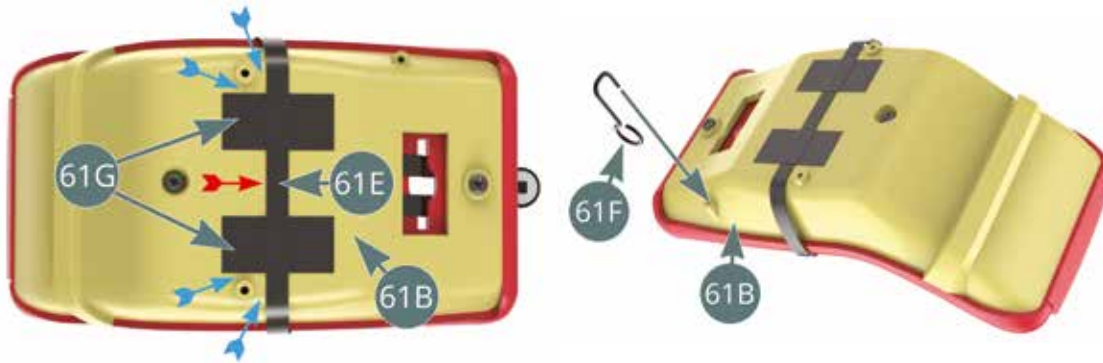
Place the driver's seat upholstery (61A) on the driver's seat (61B) and secure with two AP screws.





STEP 3

Position the midpoint of the upper safety belt (61E) halfway across the base of the driver's seat (61B) - red arrow - and secure with two pieces of tape (61G). Ensure the tapes are a minimum of 2 mm from the mounting holes (blue arrows). Fit the seat adjustment lever (61F) to the base of the driver's seat (61B).



STEP 4

Move the clutch cable (26J) slightly to the left side and mount the driver's seat (61B) on the lower chassis (25A). Secure the driver's seat (61B) to the lower chassis (25A) with two AP screws.

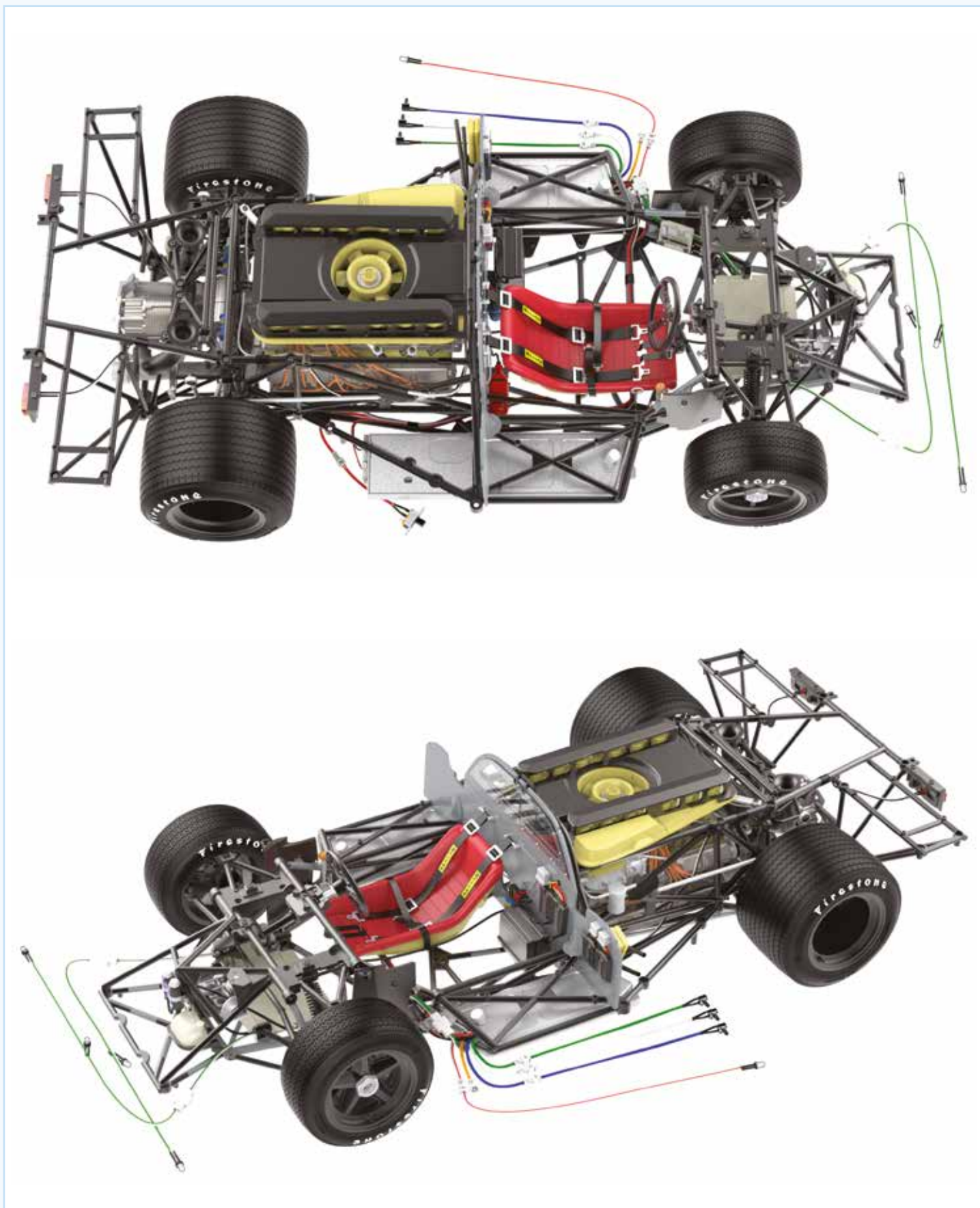


STEP 5

The driver's seat is installed on the chassis.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 62

62A Passenger seat upholstery

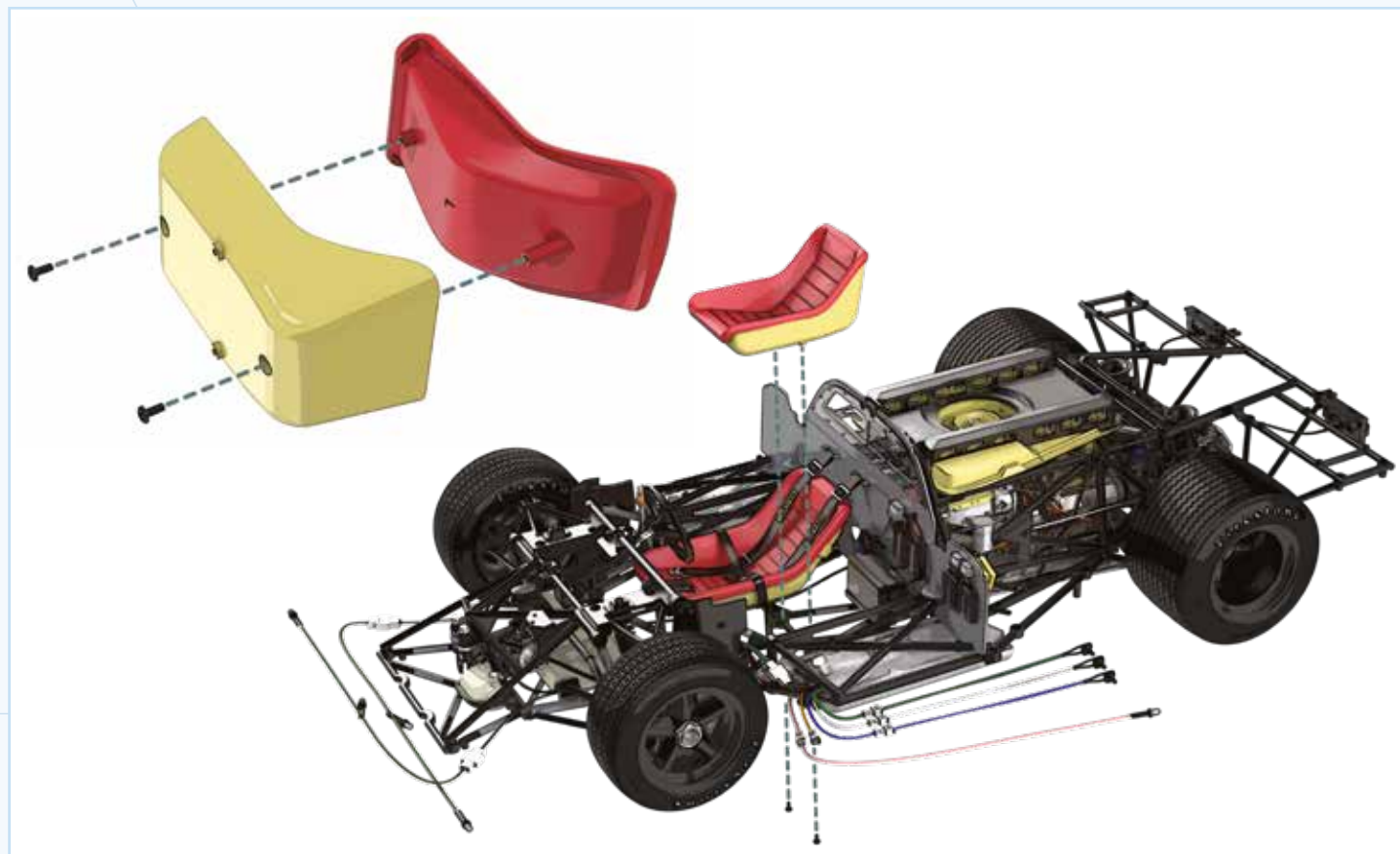
AP Screw M 1.7 x 4 mm (x 5)

62B Passenger seat



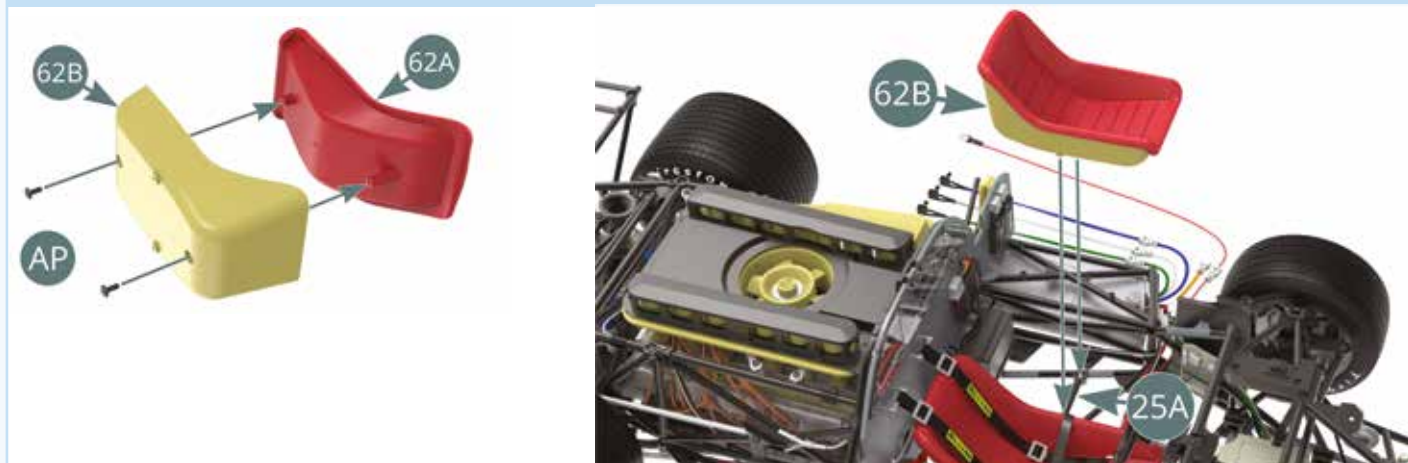
Passenger seat assembly and installation

ASSEMBLY DIAGRAM



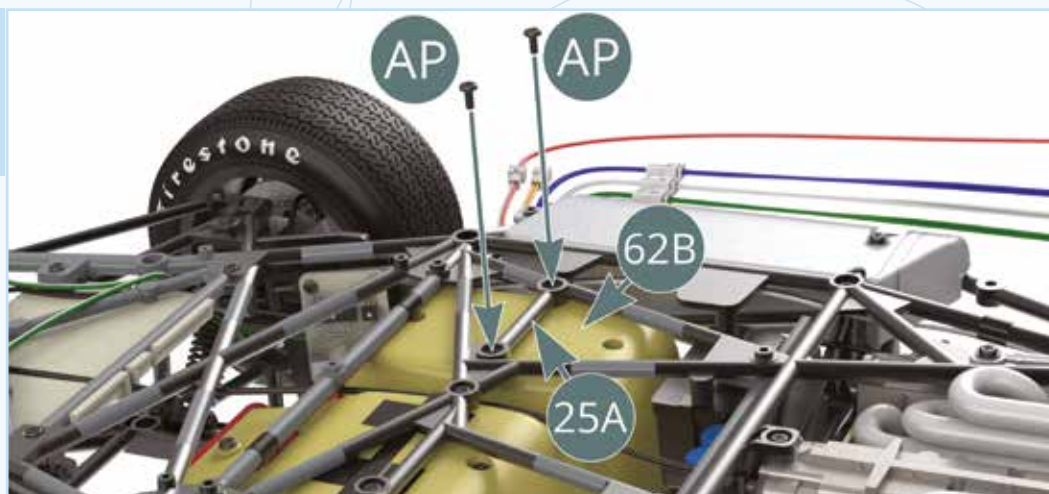
STEP 1

Mount the passenger seat upholstery (62A) to the passenger seat (62B) and secure with two AP screws. Position the passenger seat (62B) on the lower chassis (25A).



STEP 2

Secure the passenger seat (62B) to the lower chassis (25A) with two AP screws.



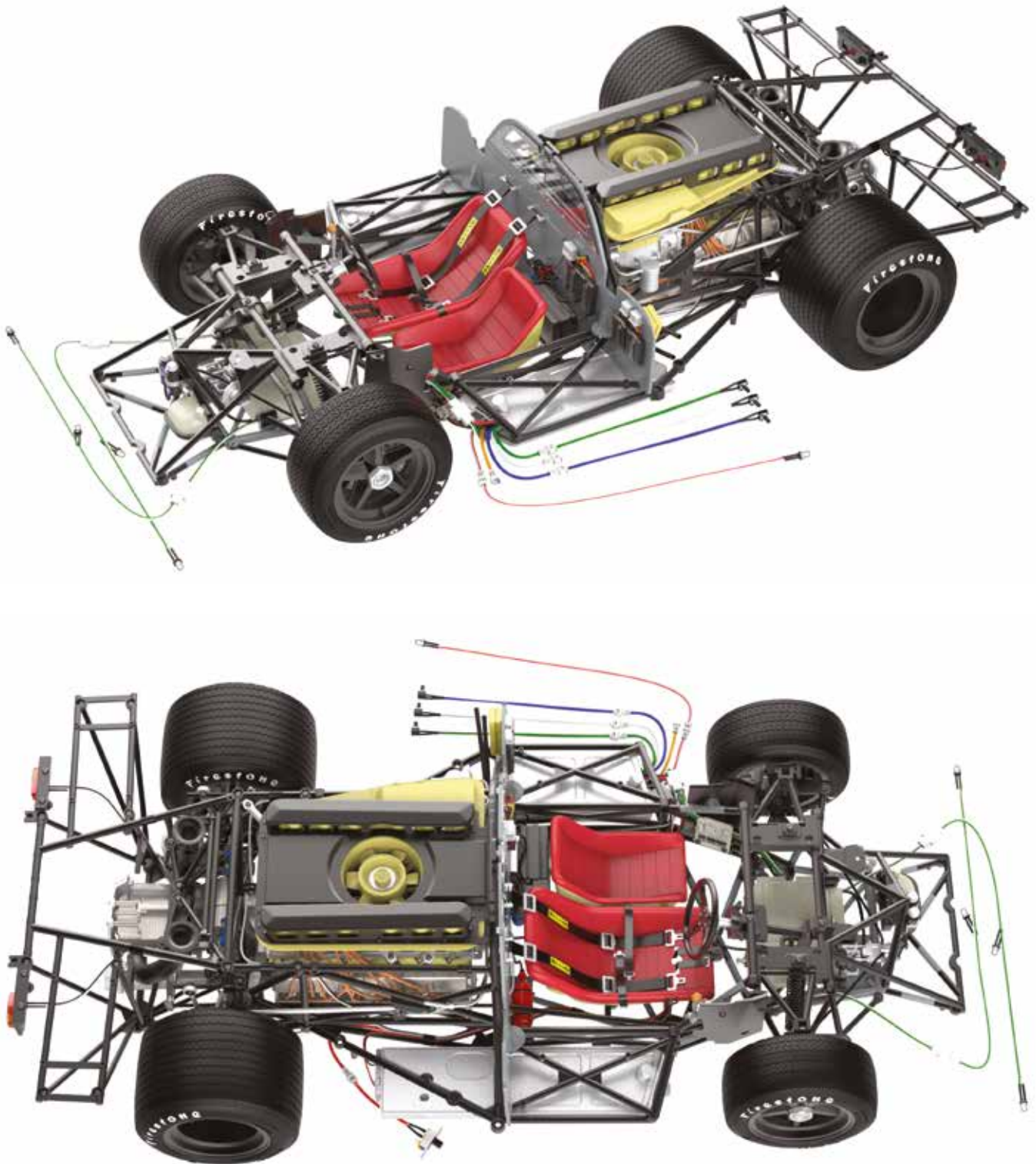
STEP 3

The driver and passenger seats are fastened to the chassis





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 63

63A Dashboard

63B Lever

63C Starter switch

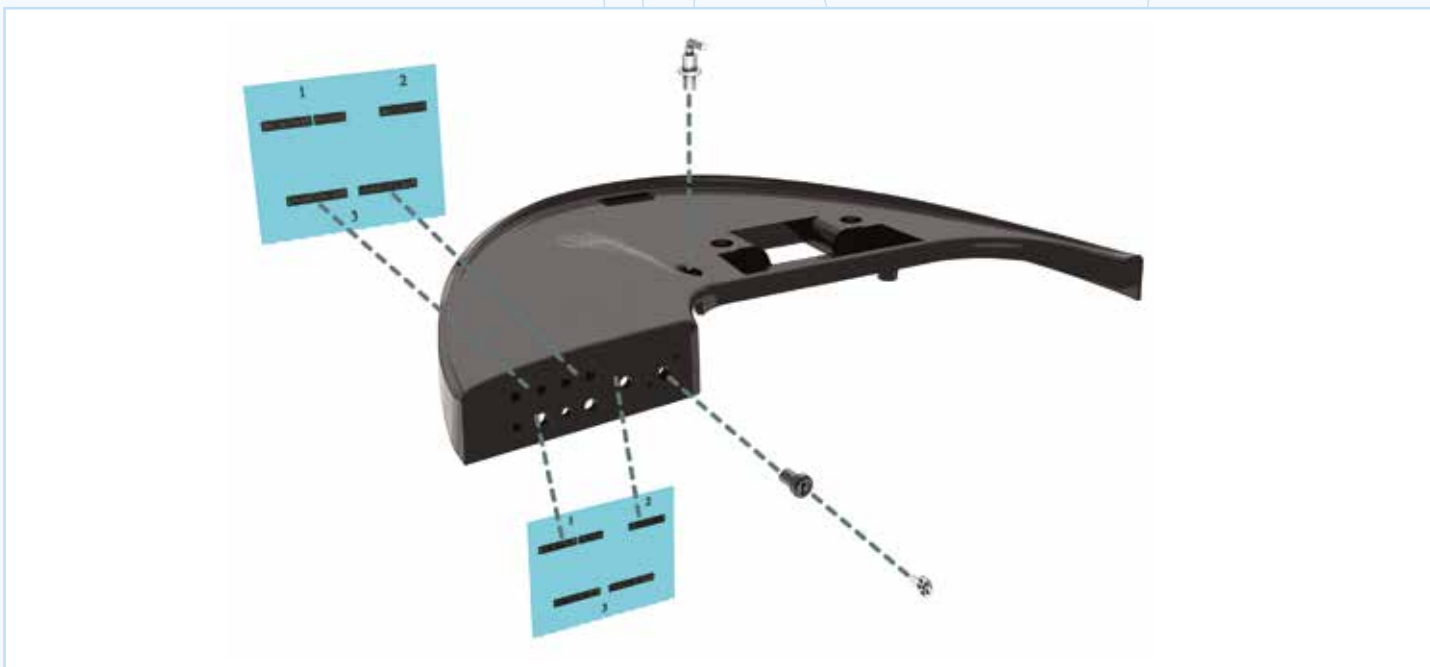
63D Ignition key

63E Dashboard decal (x2)



Assembly of the dashboard

ASSEMBLY DIAGRAM





STEP 1

Fit the lever (63B) to the dashboard (63A). Detach the starter switch (63C) from its support.



STEP 2

Install the starter switch (63C) on the dashboard (63A). Separate two sets of the dashboard decals (63E) and start using one of them.



STEP 3

Dip the decals (63E-3) in water for 15 seconds and then peel off the decals and apply them to the dashboard (63A) as shown.

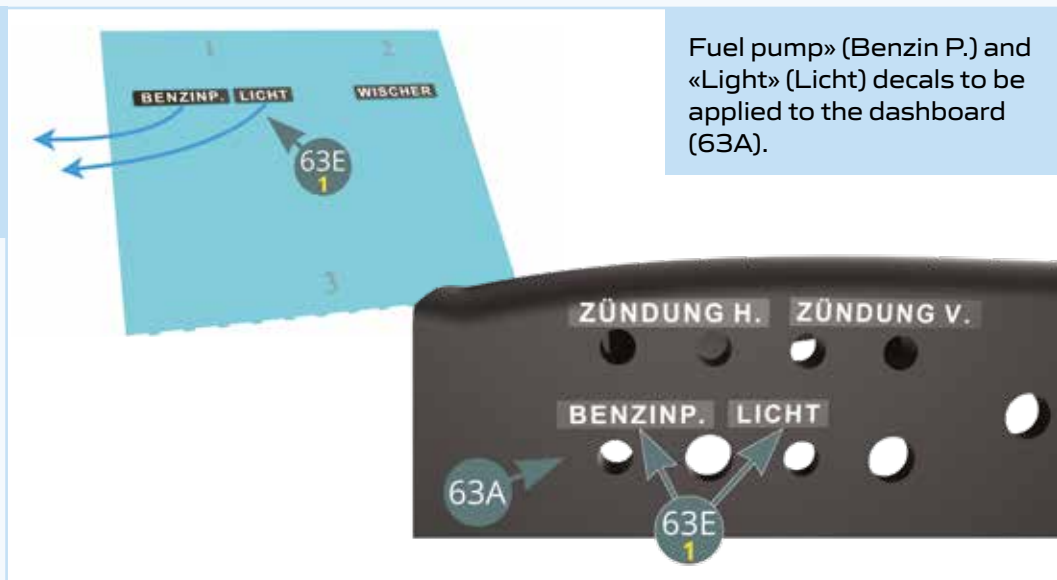


Decals (63E-3) «On tail lights» (Zündung H) and «On headlights» (Zündung V) to be applied to the dashboard (63A).



STEP 4

Dip decals (63E-1) in water for 15 seconds and then peel off the decals and apply them to the dashboard (63A) as shown.



STEP 5

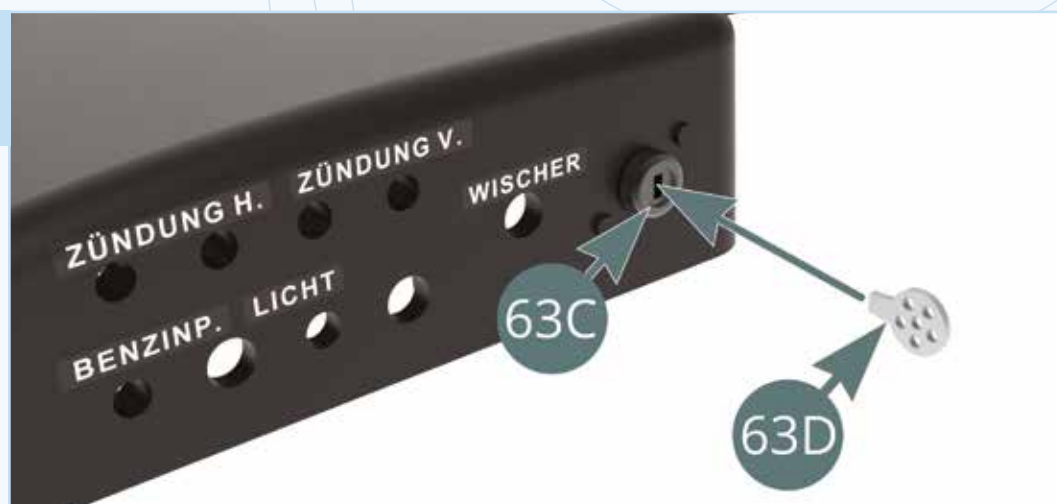
Dip decal (63E-2) in water for 15 seconds, peel off decal and apply to dashboard (63A) as shown below.

The decal «Windscreen Wiper» (Wischer) (63E-2) to be applied on the dashboard (63A).



STEP 6

Insert the ignition key (63D) into the starter switch (63C).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 64

64A Instrument panel cover

64B Instrument panel

64C Dials

64D Reflector panel

64E Switch panel

64F Switch panel

64G Interrupters

64H Interrupters

64I Interrupters (x 6)

64J Interrupters (x 2)

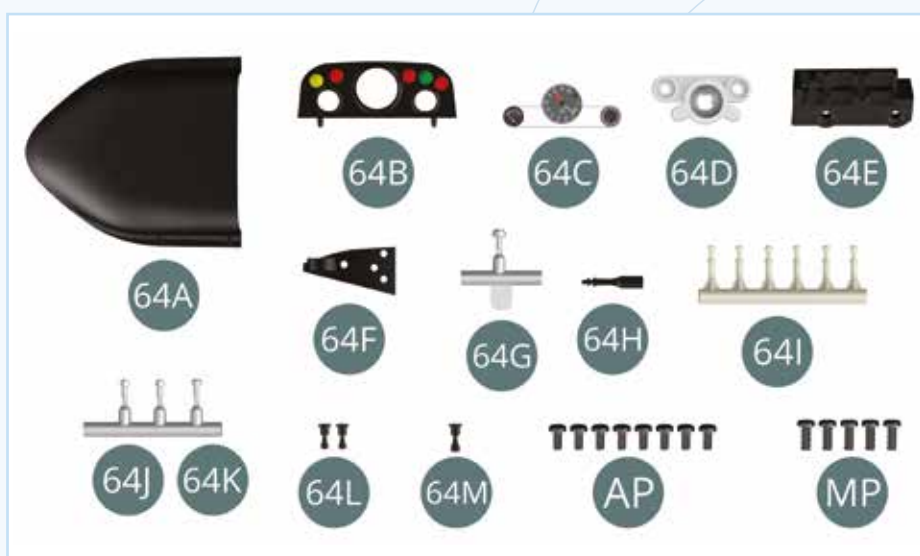
64K Fuel pump contactor

64L Switch (x 2)

64M Switch

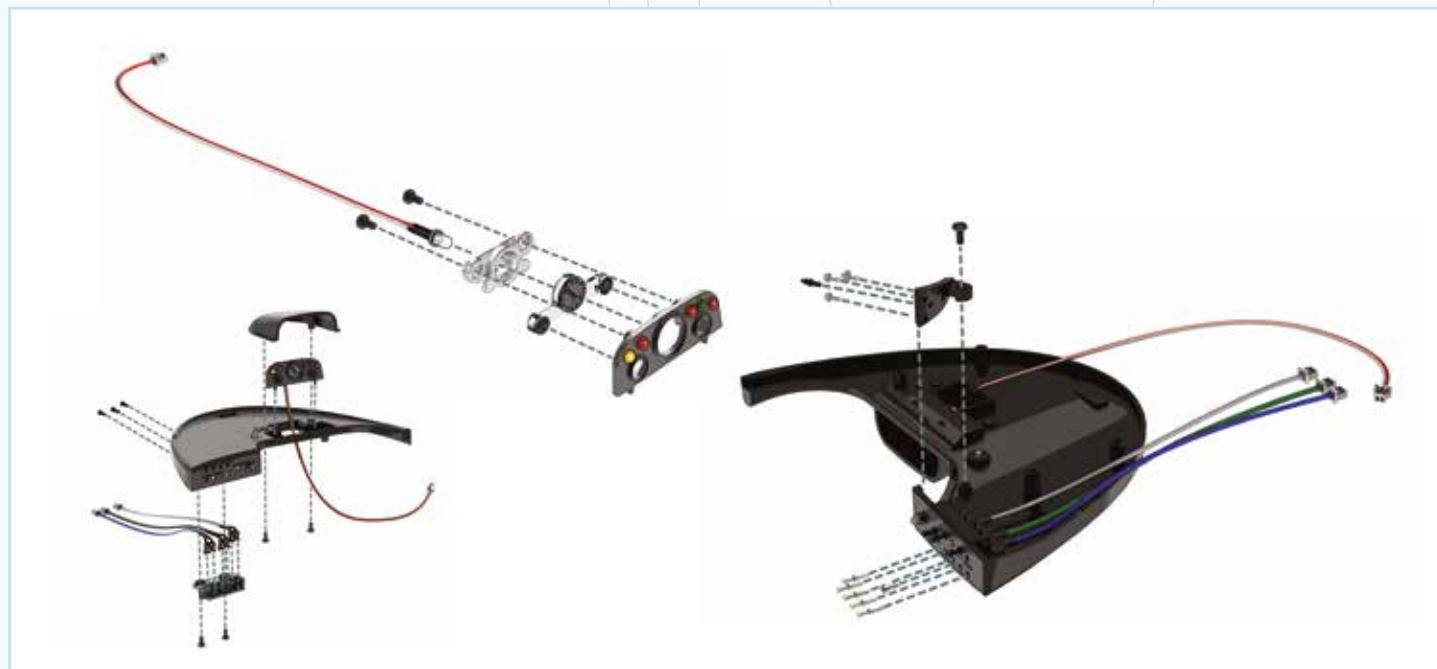
AP screw M 1,7 x4mm (x8)

MP screw M 2,0 x5mm (x5)



Instrument panel and dashboard assembly

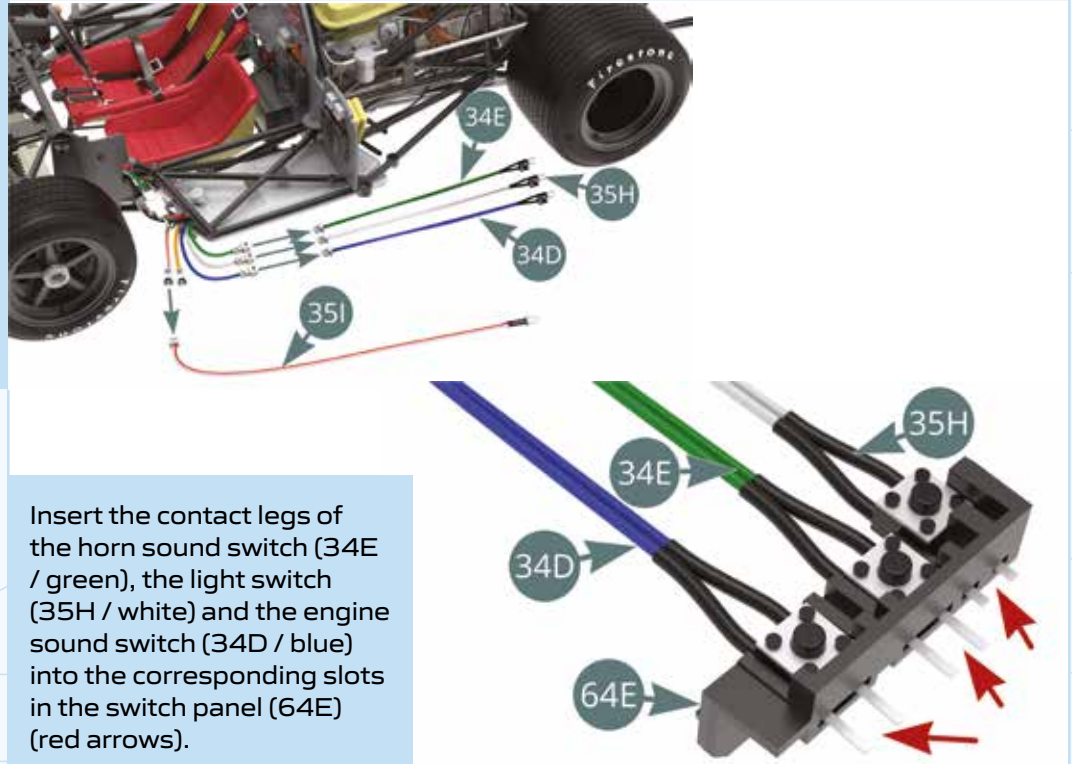
ASSEMBLY DIAGRAM





STEP 1

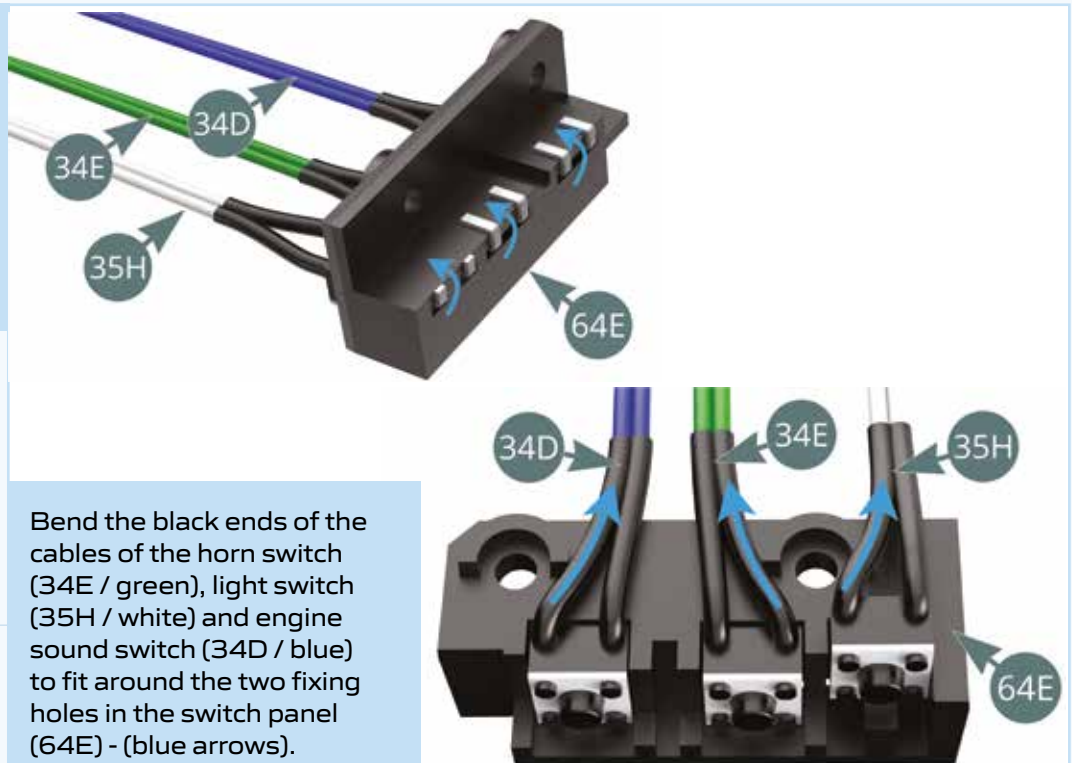
Disconnect the cable from the horn sound switch (34E / green), the cable from the light switch (35H / white), the cable from the engine sound switch (34D / blue) and the cable from the instrument light LED (35I / red-white).



Insert the contact legs of the horn sound switch (34E / green), the light switch (35H / white) and the engine sound switch (34D / blue) into the corresponding slots in the switch panel (64E) (red arrows).

STEP 2

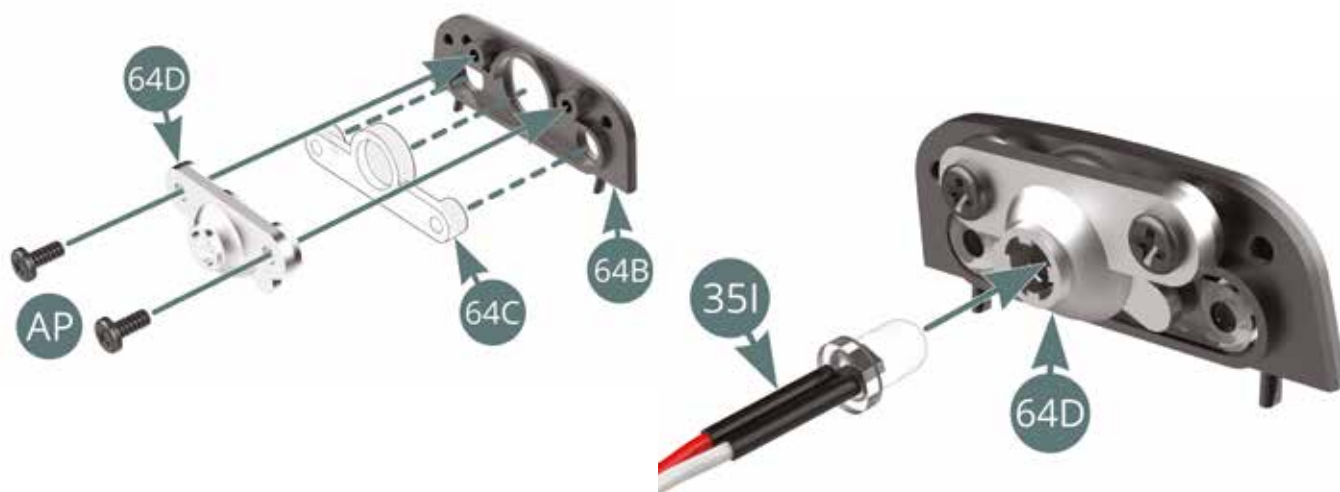
Bend the contact legs of the cables belonging to the horn switch (34E / green), light switch (35H / white) and engine sound switch (34D / blue) over the top edge of the switch panel (64E) - (blue arrows).



Bend the black ends of the cables of the horn switch (34E / green), light switch (35H / white) and engine sound switch (34D / blue) to fit around the two fixing holes in the switch panel (64E) - (blue arrows).

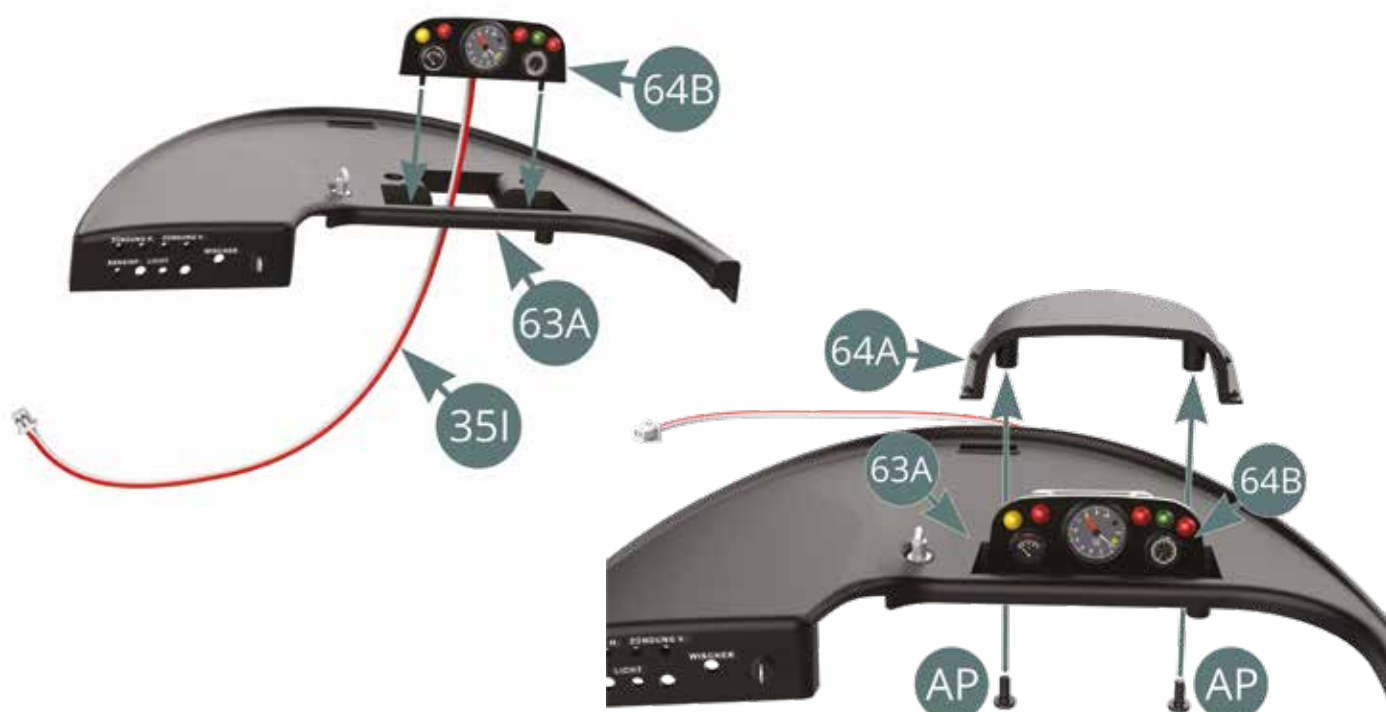
STEP 3

Position the reflector panel (64D) on the instrument panel (64B), with the dial block (64C) in the middle and fix with two AP screws. Mount the instrument LED light (35I) on the reflector panel (64D).



STEP 4

Position the instrument panel (64B) on the dashboard (63A) by passing the instrument backlight LED cable (35I) through the opening provided. Position the instrument panel cover (64A) over the instrument panel (64B) and onto dashboard (63A) and secure it from below with two screws AP.





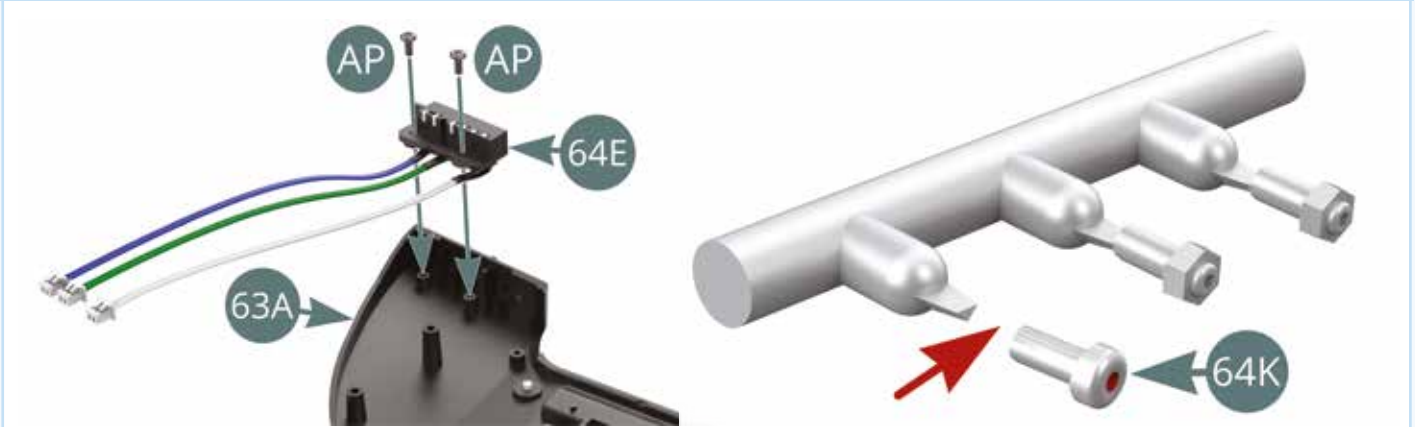
STEP 5

Position switches (64L & 64M) on the instrument panel (63A) as shown below. Position the switch panel (64E) on the instrument panel (63A), ensuring that the contactors can be pressed with their respective switches (64L & 64M).



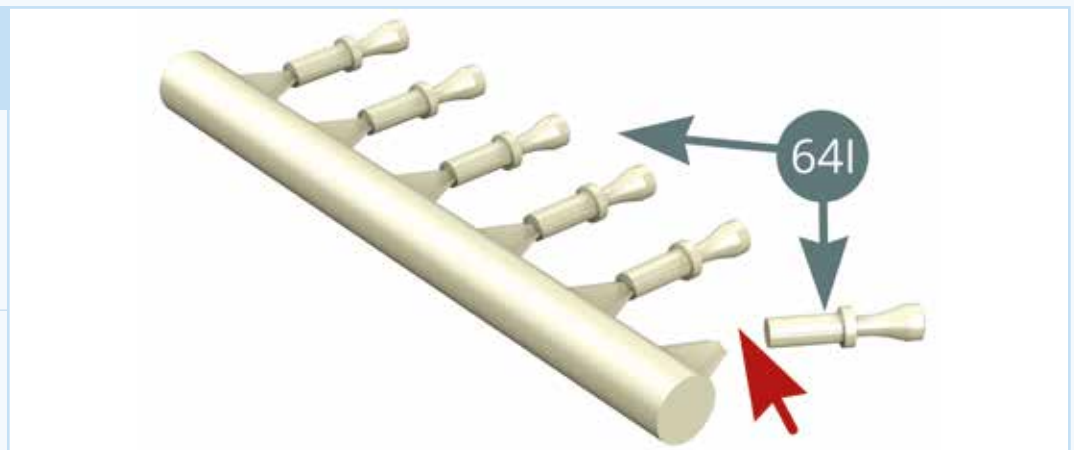
STEP 6

Secure the switch panel (64E) to the dashboard (63A) with two AP screws. Detach the fuel pump contactor (64K) from its sprue.



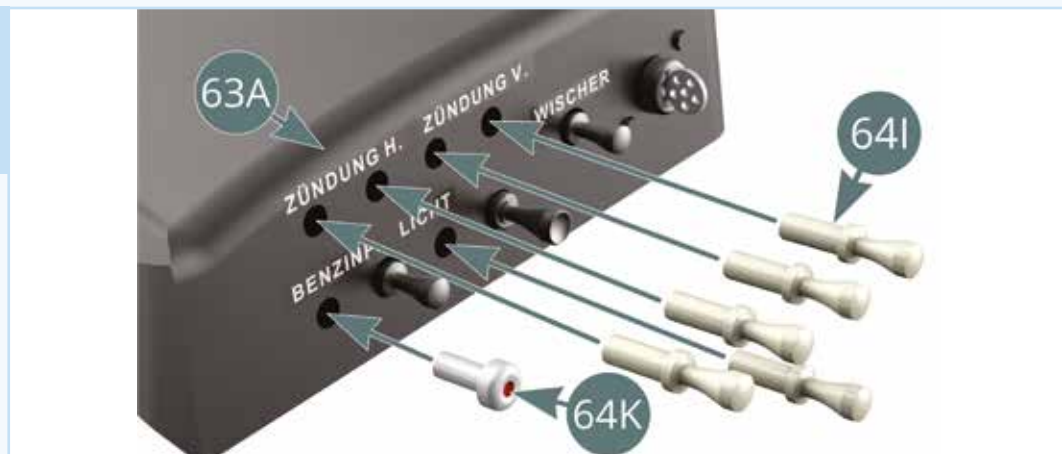
STEP 7

Detach five interrupters (64I) from the sprue.



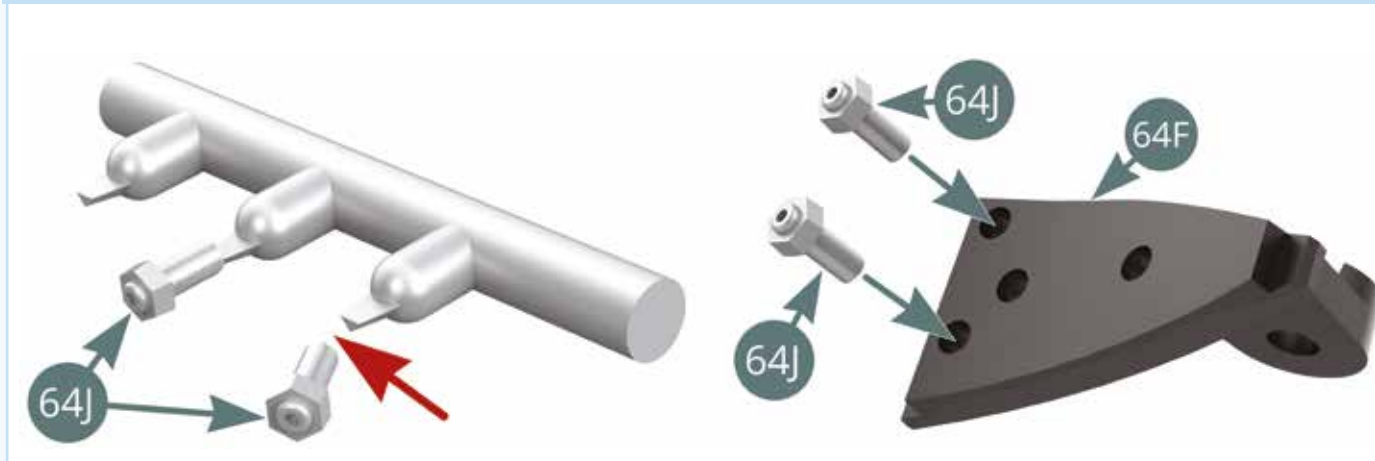
STEP 8

Install the fuel pump contactor (64K) and the five interrupters (64I) on the dashboard (63A).



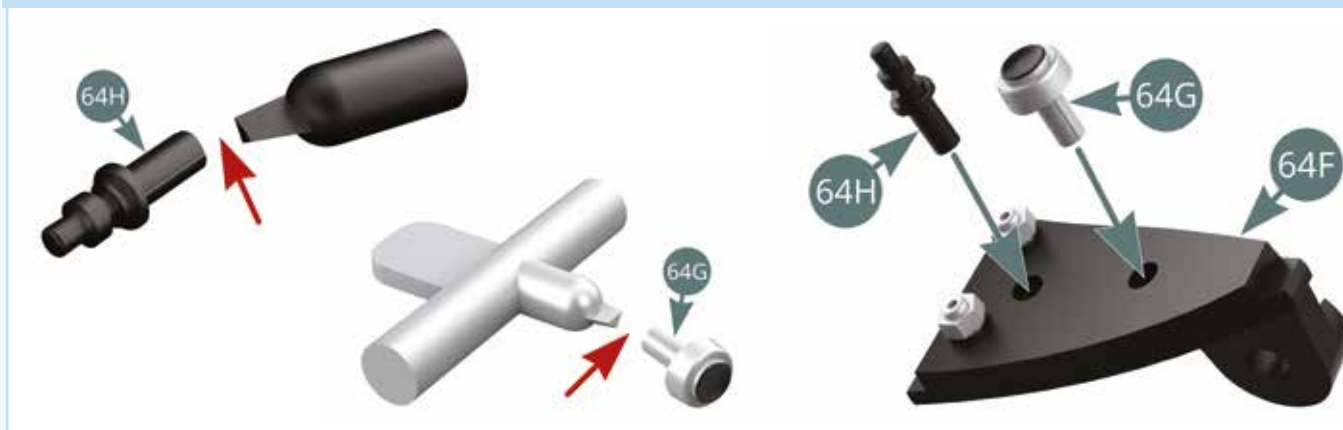
STEP 9

Detach two interrupters (64J) from the sprue. Install the two interrupters (64J) into the switch panel (64F).



STEP 10

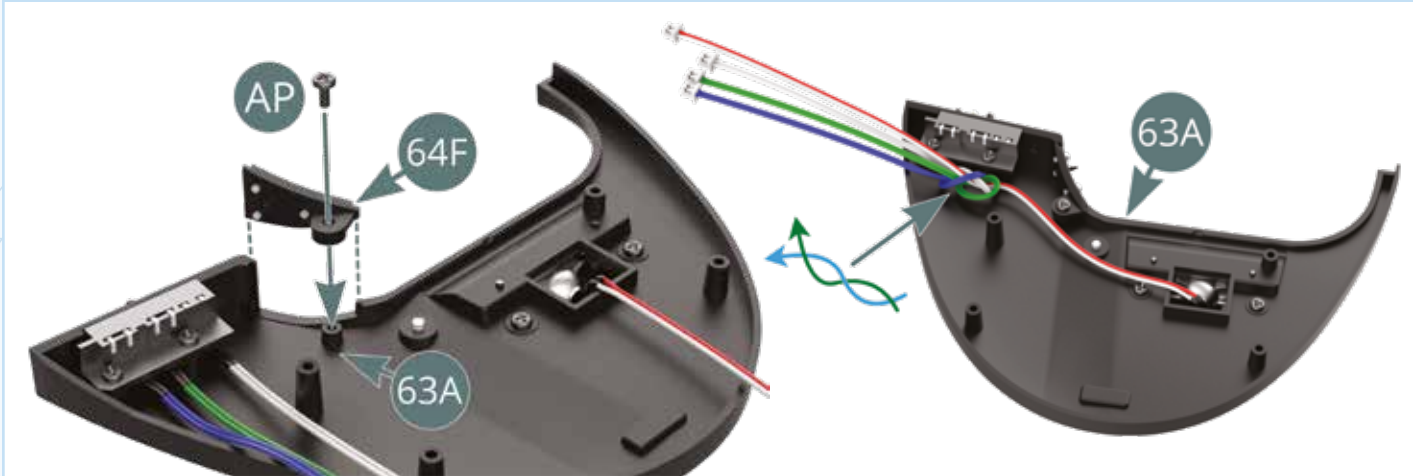
Detach the Interrupters (64H & 64G) from the sprue. Install the Interrupters (64H & 64G) into the switch panel (64F).





STEP 11

Mount the switch panel (64F) on the dashboard (63A) and secure with an AP screw. Bundle the blue, green, white and red-white cables and route them towards the left-hand side of the dashboard (63A).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 65

65A Flat front floor

PM Screw M 2,0 x 4 mm (x 5)



*Installation of the
dashboard and front flat
base*

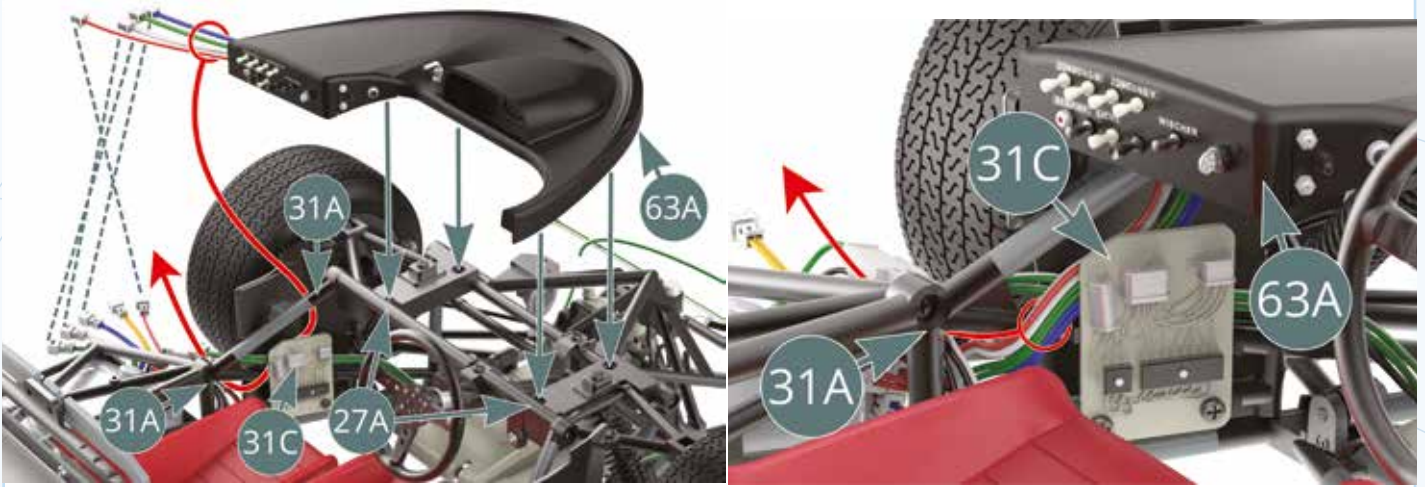
ASSEMBLY DIAGRAM





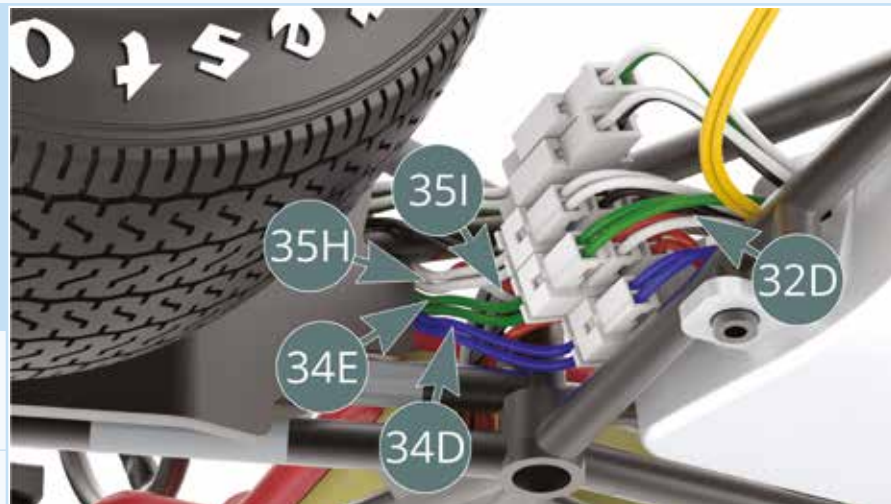
STEP 1

Before installing the dashboard (63A) onto the dashboard frame (27A), route the four dashboard cables (blue, green, white and red-white) between the frame (31A) and the connection panel (31C) as indicated by the red arrow (illustrations below).

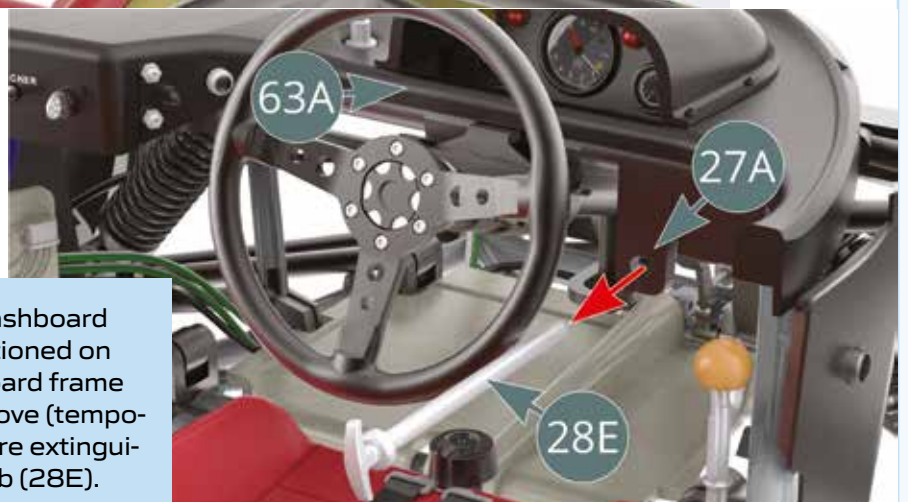


STEP 2

Connect the wires (35I - red-white), (35H - white), (34E - green) and (34D - blue) from the dashboard to the four wires of the corresponding colour from the PCB (32D). At present, only the yellow wire is not connected.

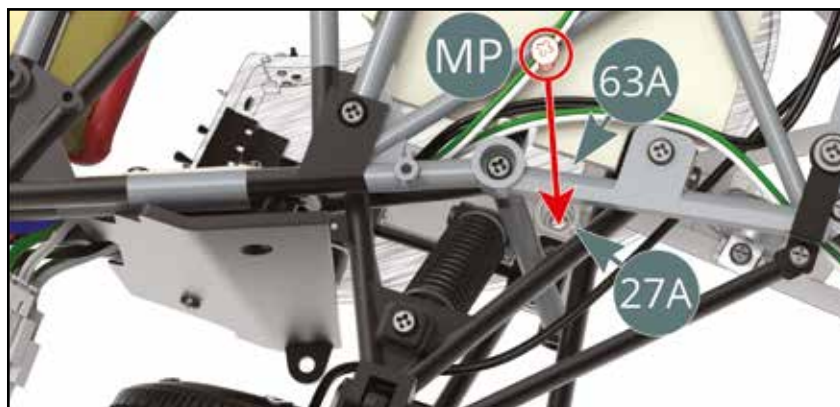
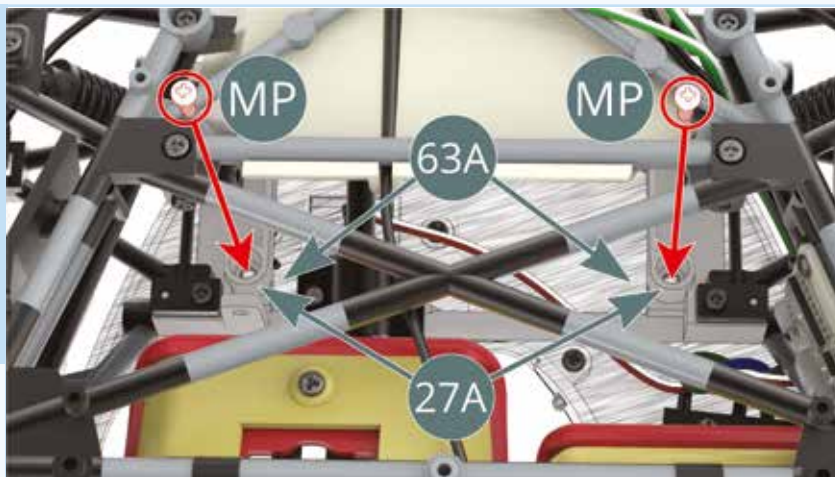


With the dashboard (63A) positioned on the dashboard frame (27A), remove (temporarily) the fire extinguisher pull tab (28E).



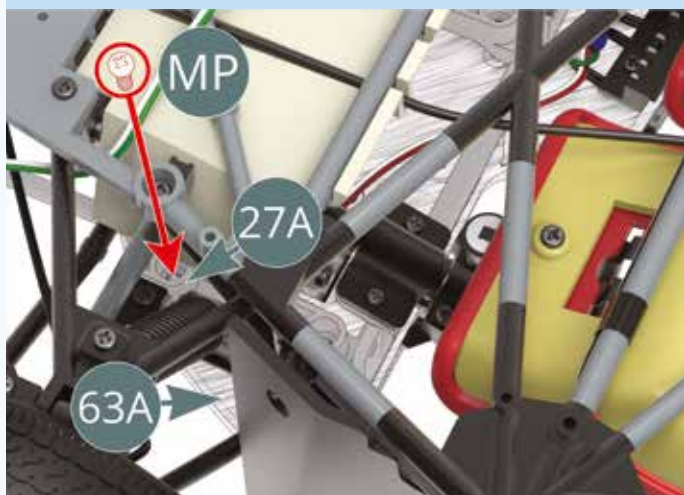
STEP 3

Attach the dashboard (63A) to the dashboard frame (27A) from underneath the car with two MP screws. Attach the instrument panel (63A) to the instrument panel frame (27A) - at the front left wheel - with a PM screw.



STEP 4

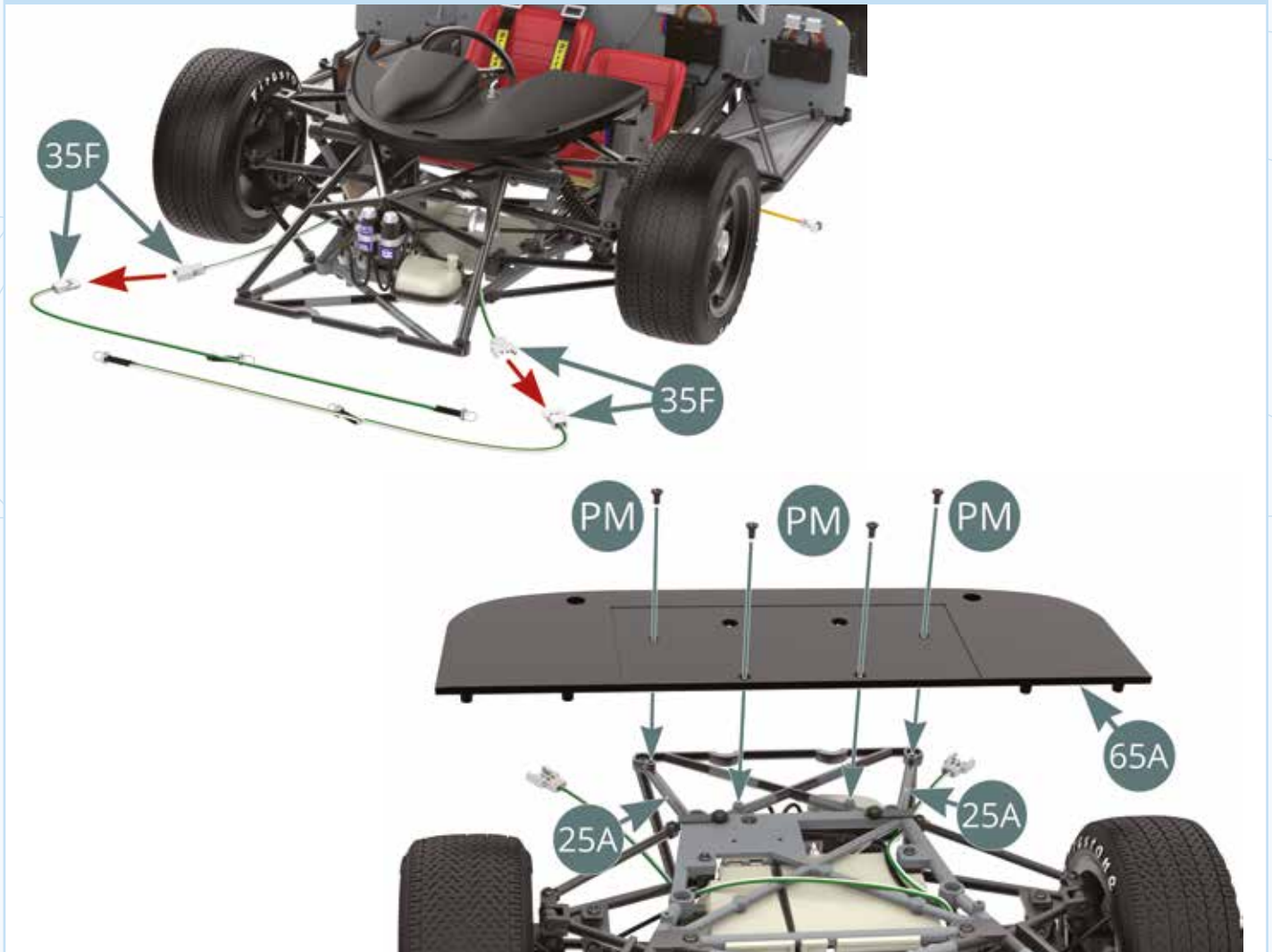
Attach the dashboard (63A) to the dashboard frame (27A) at the right front wheel with an MP screw. Replace the fire extinguisher pull tab (28E) on the dash frame (27A).





STEP 5

Disconnect the headlight LED cables (35F) on the right and left. Put them aside for future use. Position the front flat bottom (65A) onto the lower frame (25A) and secure with four PM screws.

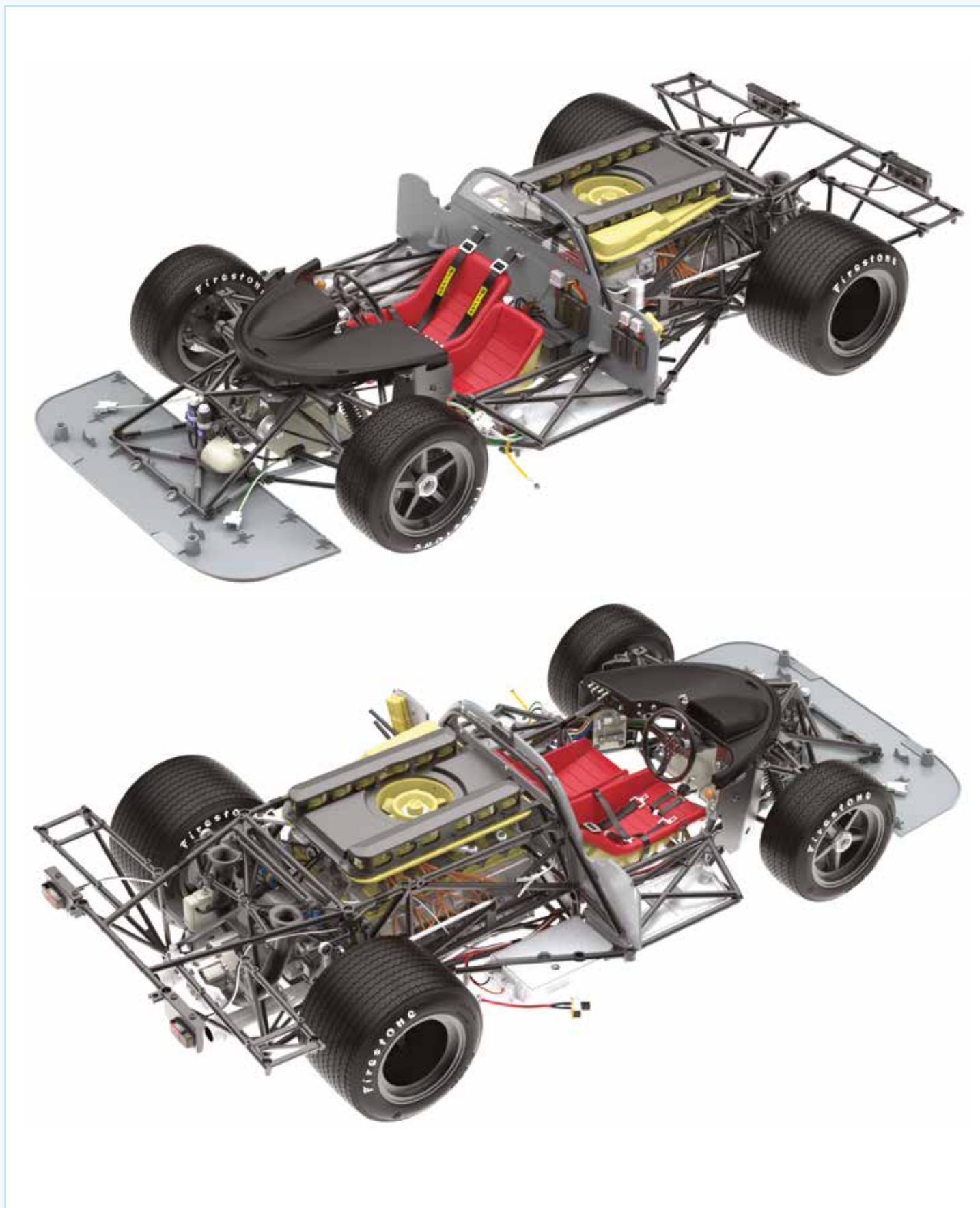


STEP 6

The front flat base (65A) is installed on the chassis



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 66

66A Water radiator

66B Radiator front panel

66C Radiator left side

66D Coupling (x 4)

66E Radiator right side

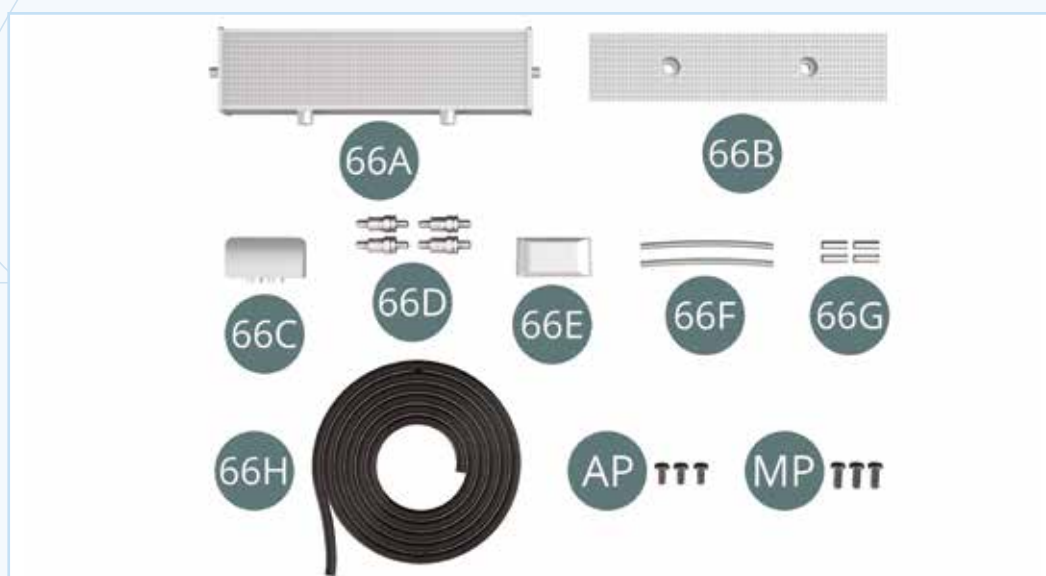
66F Metal hose (x 2)

66G Connector (x 4)

66H Water pipe

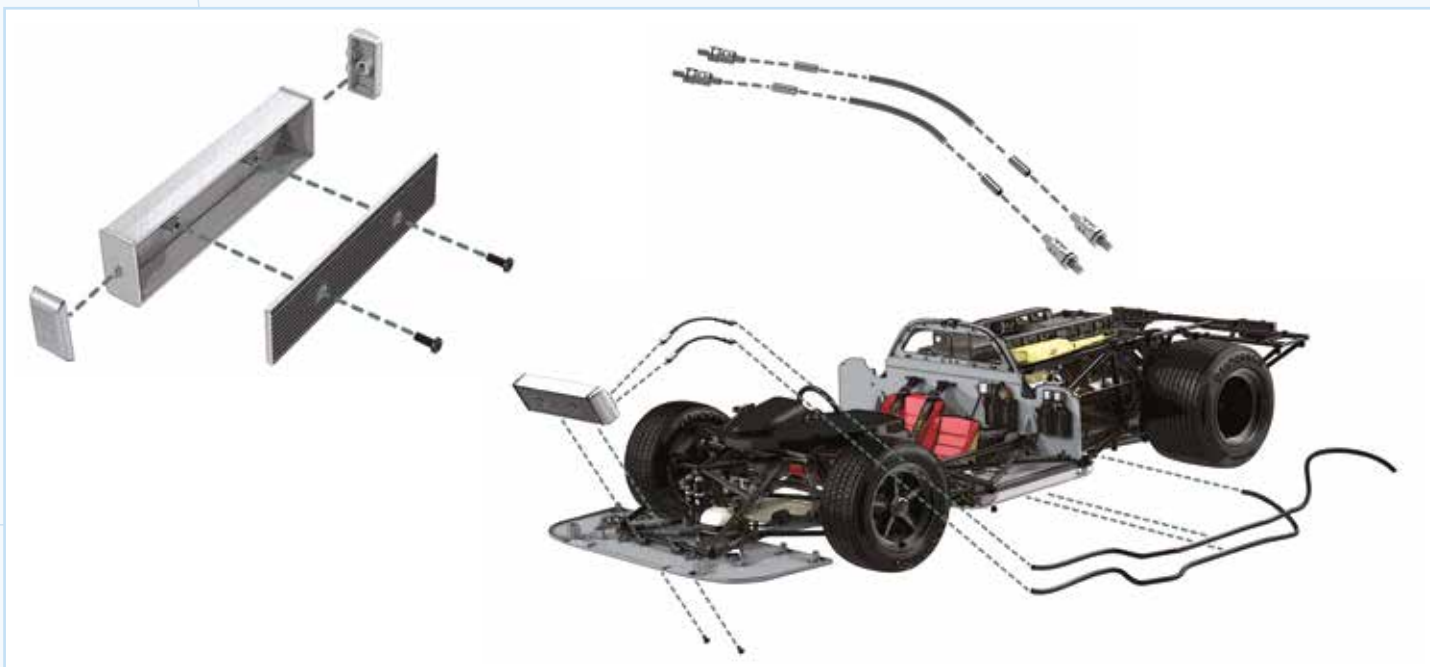
AP Screw M 1,7 x 4 mm (x 3)

MP Screw M 2,0 x 5 mm (x 3)



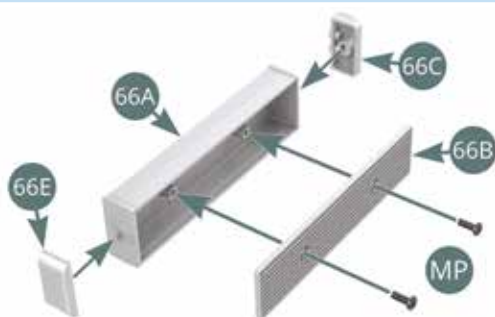
Assembly and
installation of the
water radiator

ASSEMBLY DIAGRAM

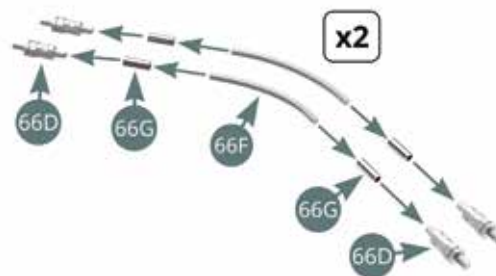


STEP 1

Position the radiator front panel (66B) on the water radiator (66A) and secure it with two MP screws. Position the left (66C) and right (66E) sides onto the water radiator (66A).

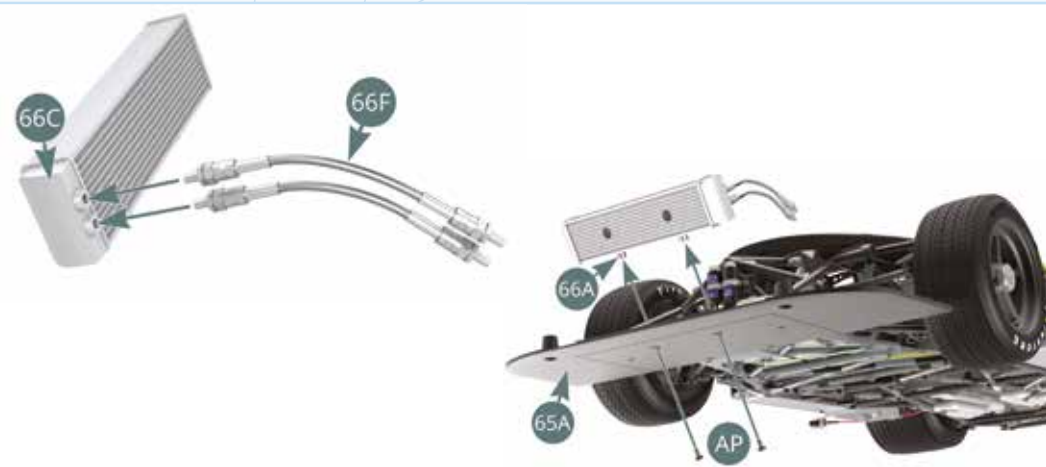


Attach a coupling (66D) and a connector (66G) to each end of the metal hose (66F). Make a second identical assembly.



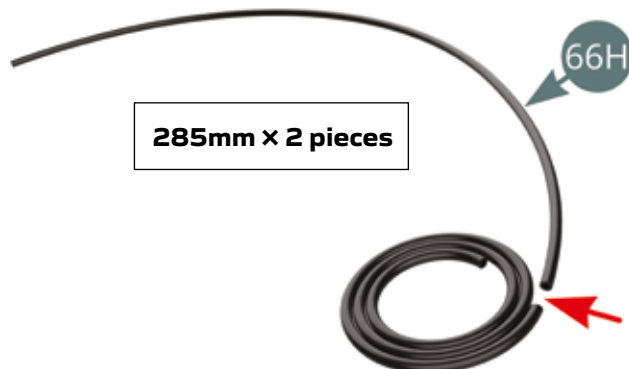
STEP 2

Connect the two metal hoses (66F) to the water radiator (66A) using the two couplings (66D). Position the water radiator (66A) onto the front flat bottom (65A) and secure it with two AP screws.



STEP 3

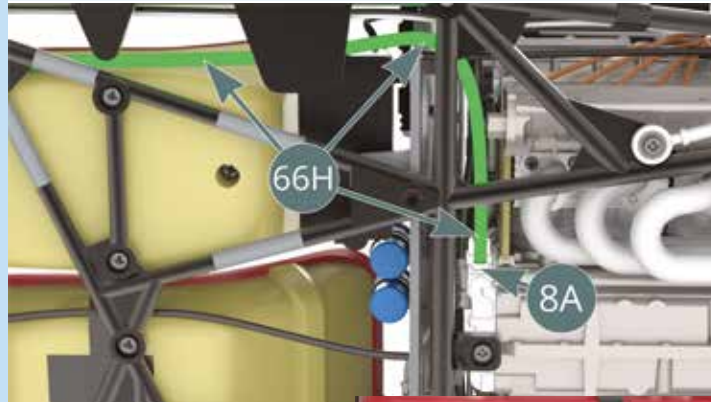
Turn the car upside down and detach the water hose (37B) from the nozzle of the water pump housing (8A) - red arrow - DO NOT remove the second hose (green arrow), as it will be used to connect to the Oil Tank in a later stage. Then cut two lengths each of 285 mm from the water pipe roll (66H).





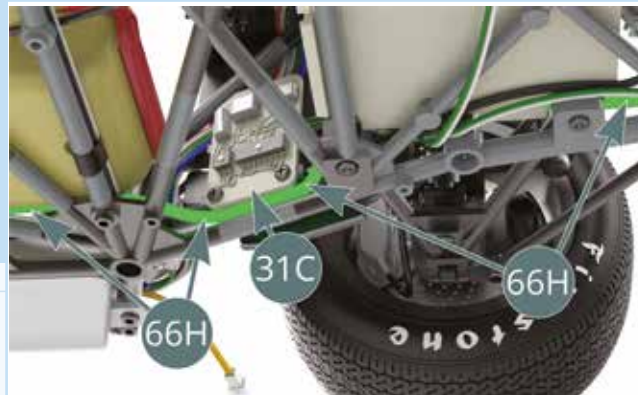
STEP 4

Position one of the two cutted lengths of water hose (66H) over the nozzle of the water pump housing (8A) - from which the oil hose (37B) has just been removed - and then run it under the edge of the cockpit bulkhead (54A) - illustrations opposite and below.



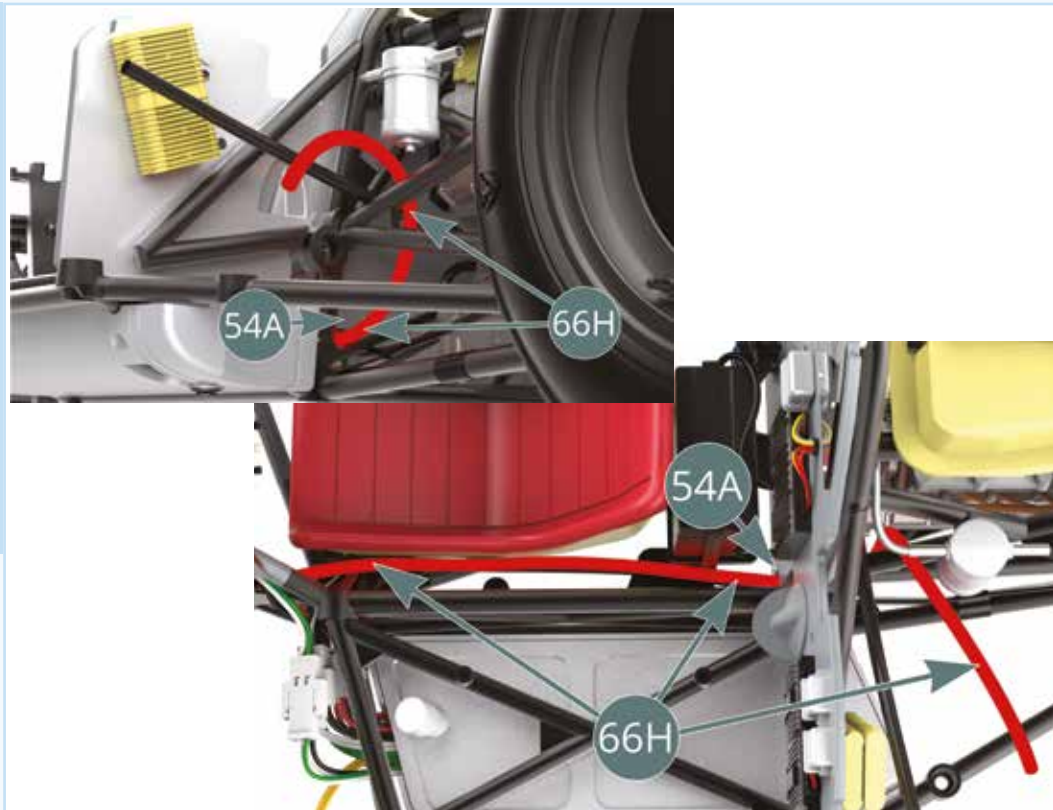
STEP 5

Slide the water hose (66H) underneath the wiring board (31C) before passing it any further. Position the water hose (66H) onto the bottom coupling (66D).



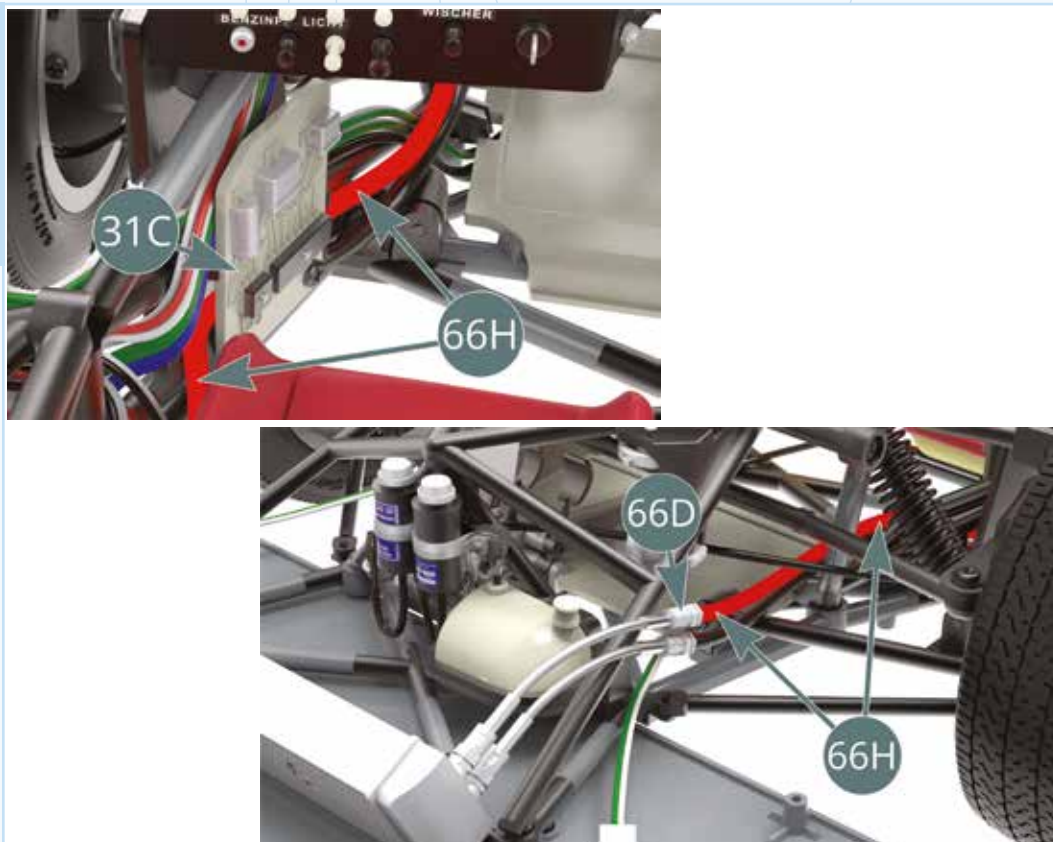
STEP 6

Run the second cut length of the water hose (66H) under the left lower side of the cockpit bulkhead (54A). Leave the end hanging loose, as this will be connected in a later stage. There should be two free water pipes (66H and 37B) as shown. Continue running the water pipe (66H) alongside the passenger seat (shown opposite and below).



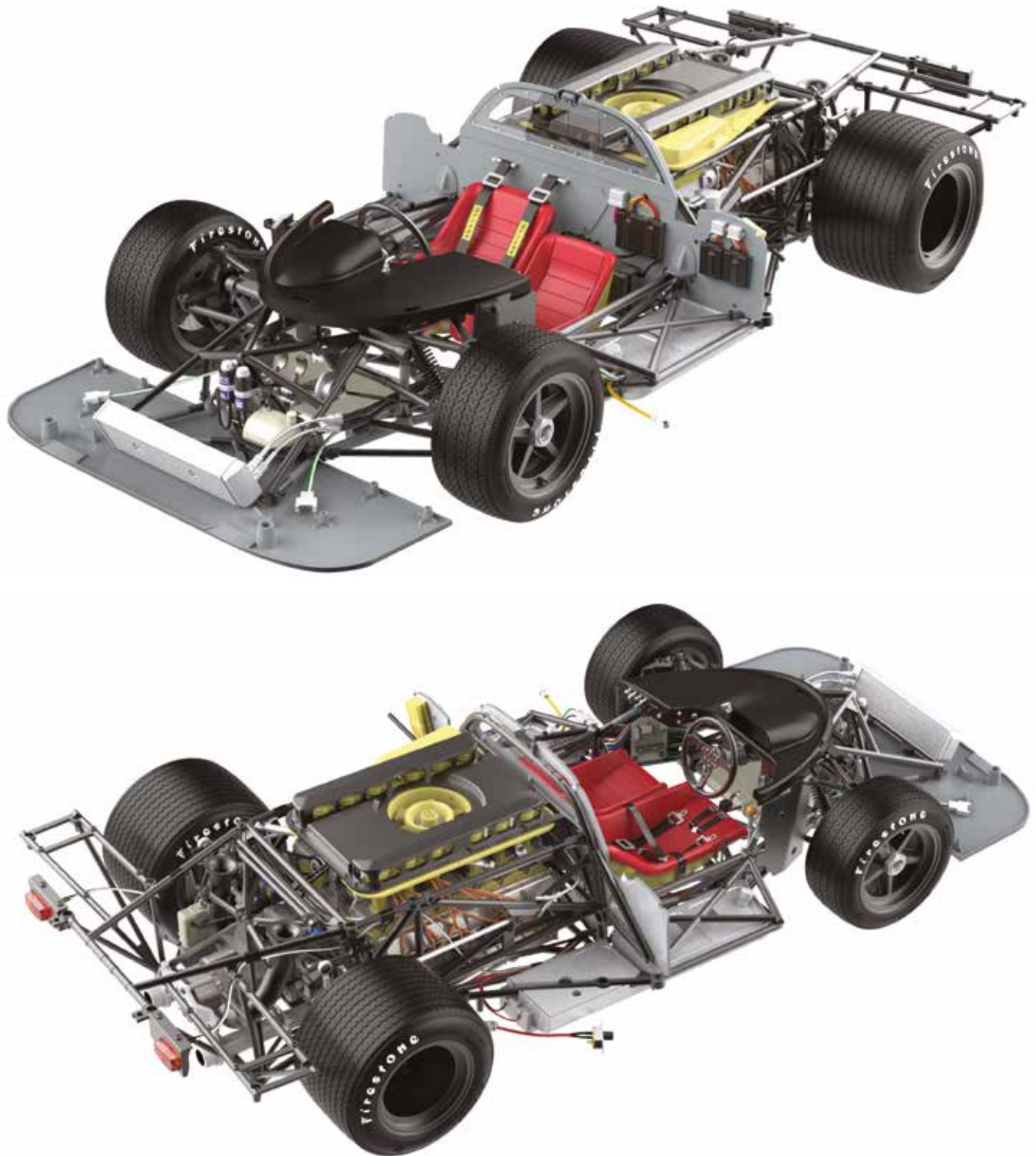
STEP 7

Slide the water hose (66H) behind the wiring board (31C) before extending it further. Position the water hose (66H) onto the top coupling (66D).





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 67

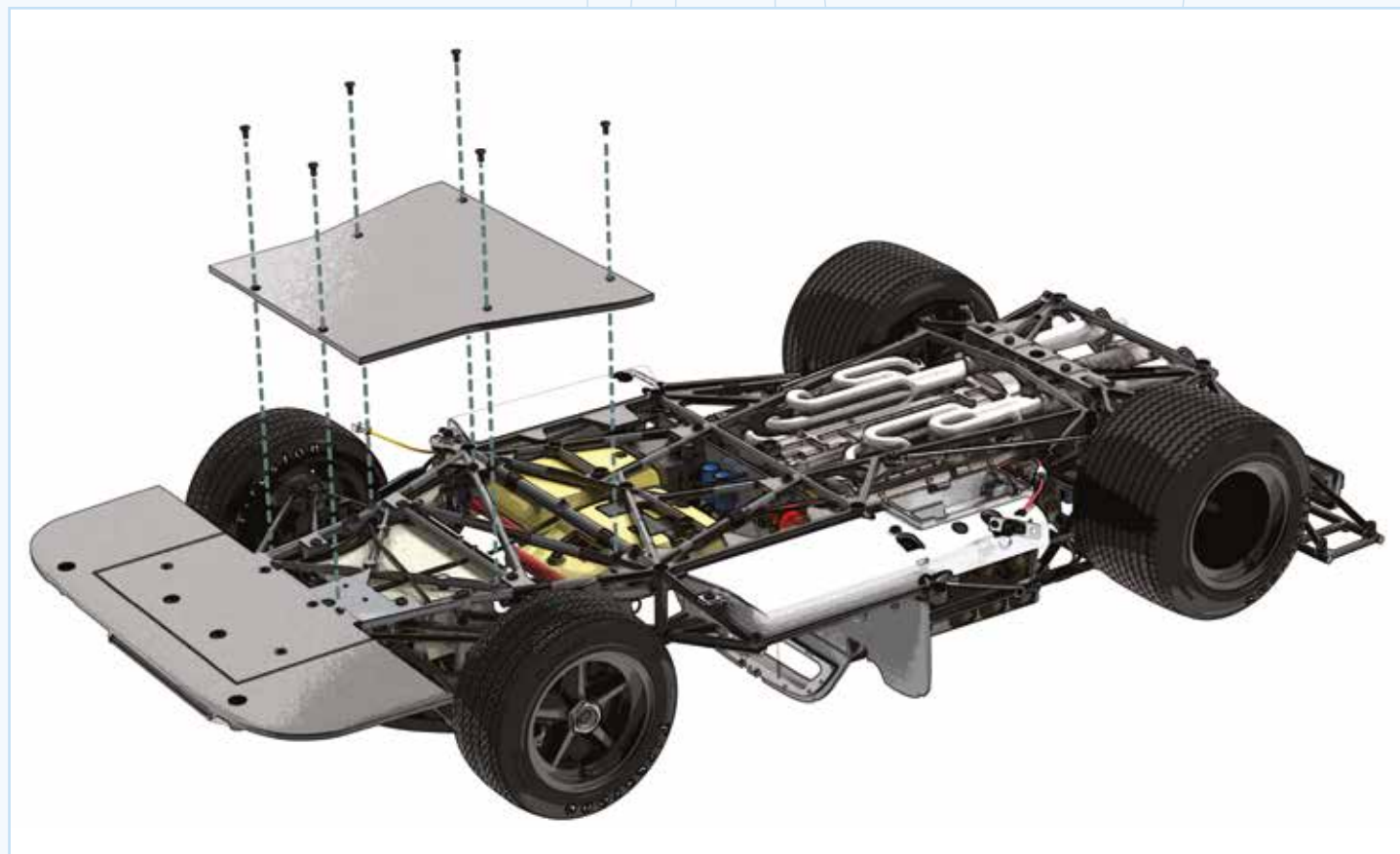
67A Flat cockpit floor

PM Screw M 2,0 x 4 mm (x 7)



Installation of the flat cockpit floor

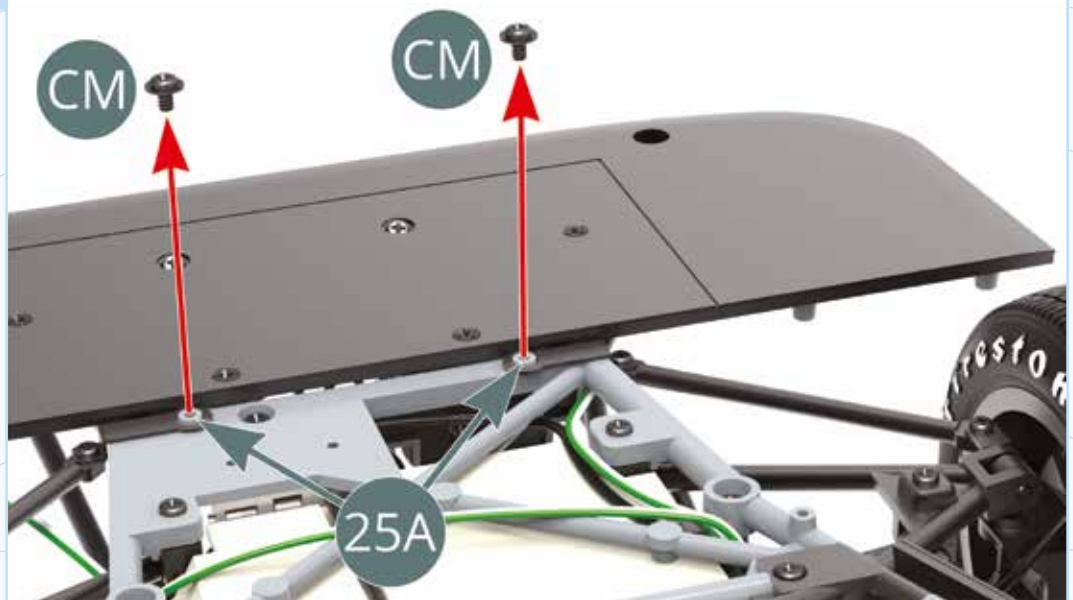
ASSEMBLY DIAGRAM





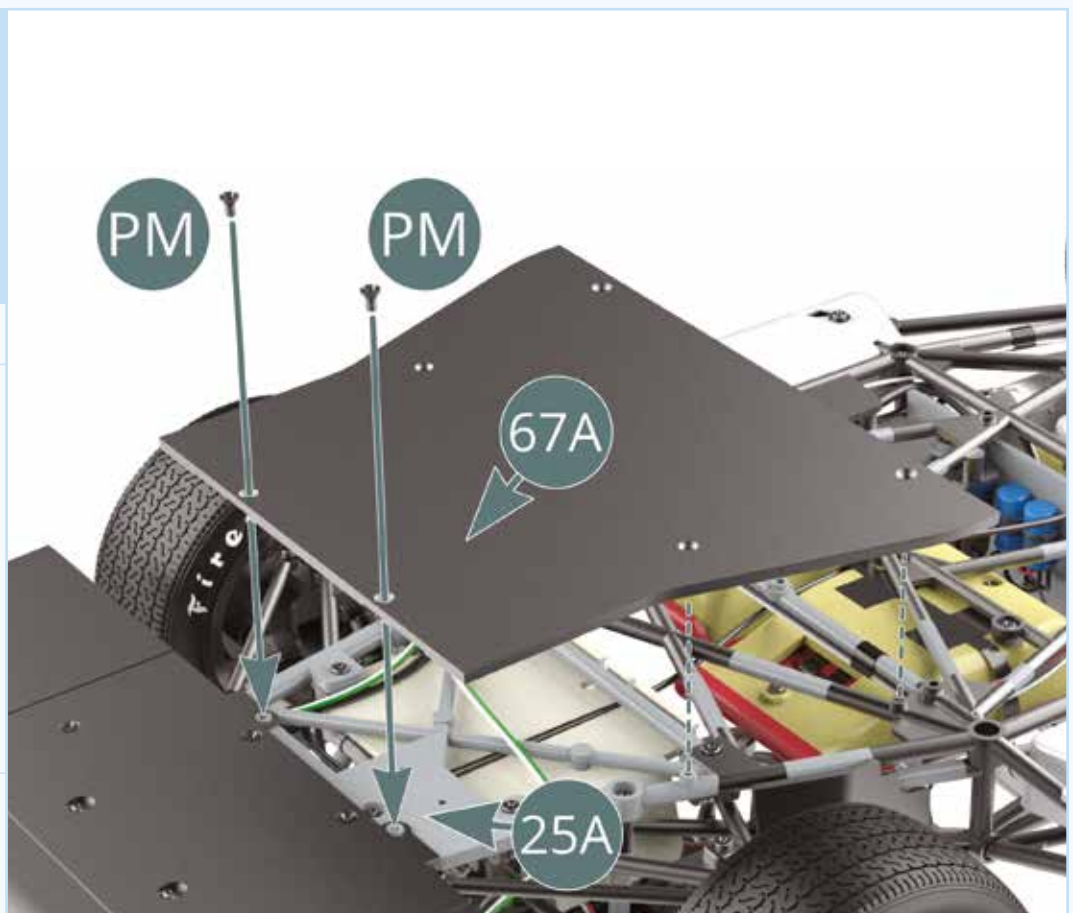
STEP 1

Unscrew the two marked CM screws from lower frame (25A).



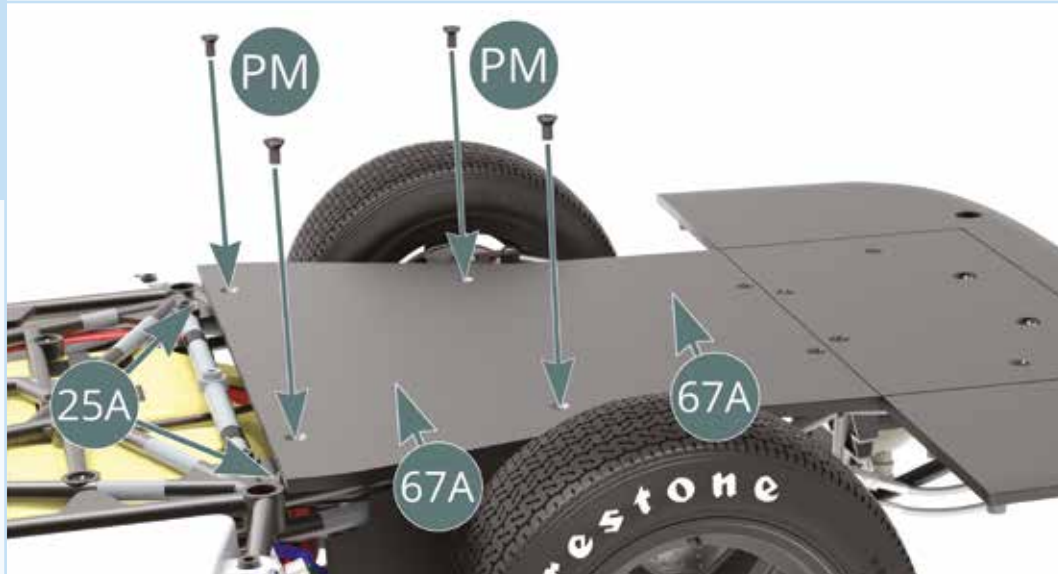
STEP 2

Align and position the flat floor of the cockpit (67A) on the lower frame (25A) and secure it with two PM screws replacing the two CM screws that were just removed.

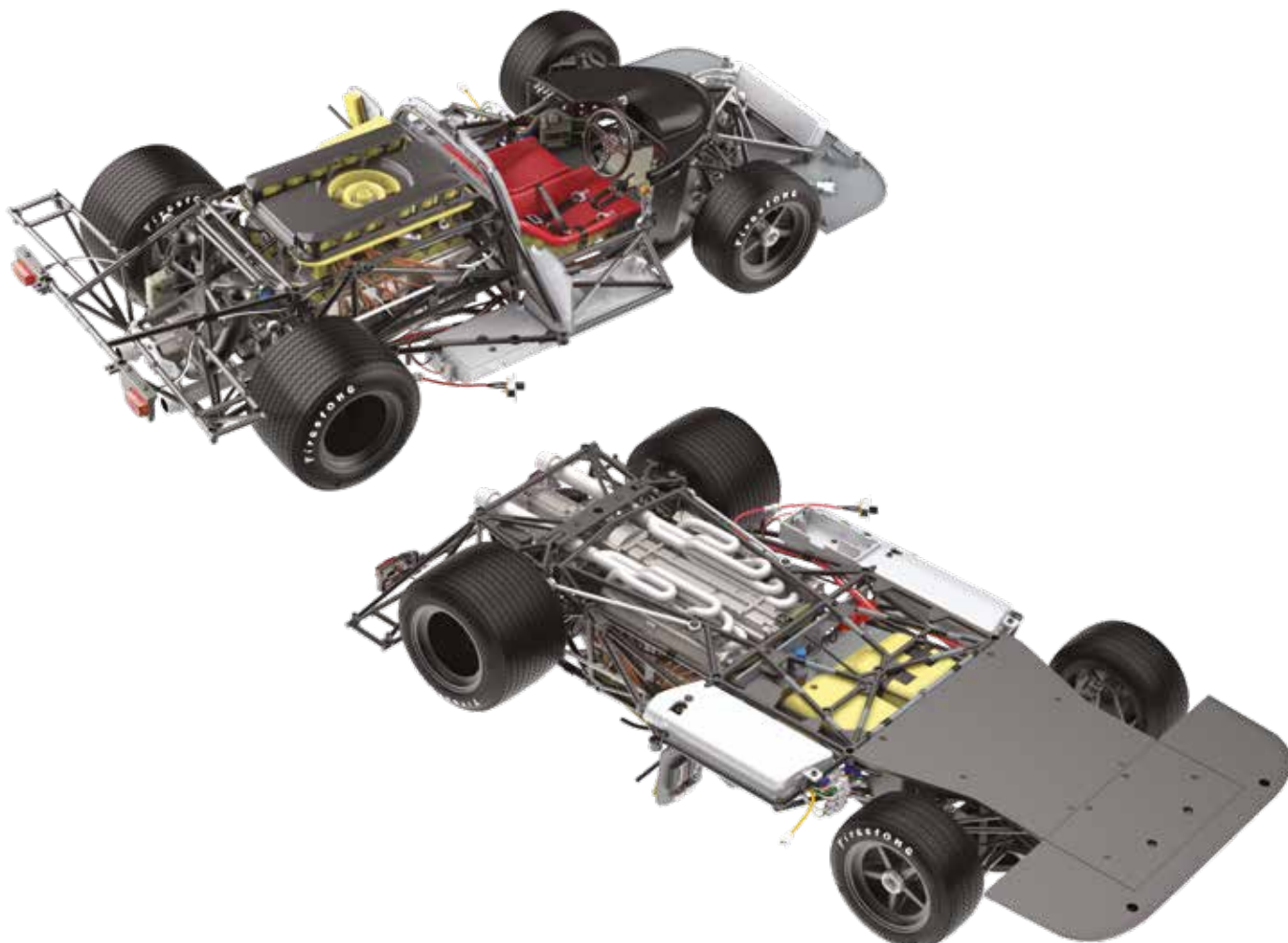


STEP 3

Complete the fixation of the flat cockpit floor (67A) to the lower frame (25A) with four additional PM screws.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 68

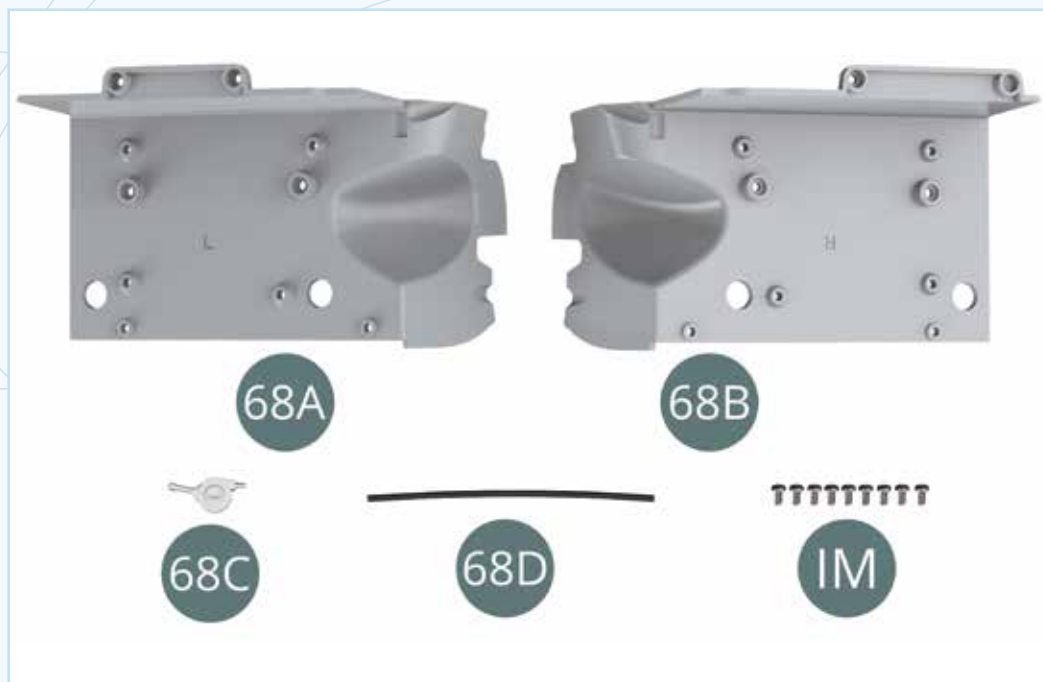
68A Left cockpit housing

68B Right cockpit housing

68C Handbrake

68D Handbrake cable

IM Screw M 1,7 x 3,5 mm (x 9)



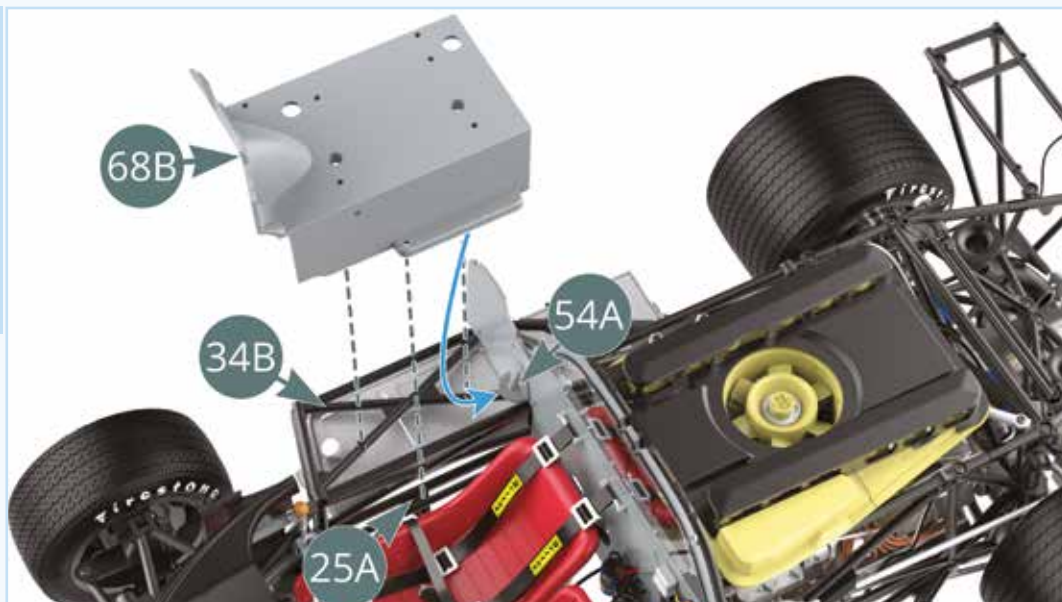
Installation of the lateral cockpit housings and hand brake

ASSEMBLY DIAGRAM



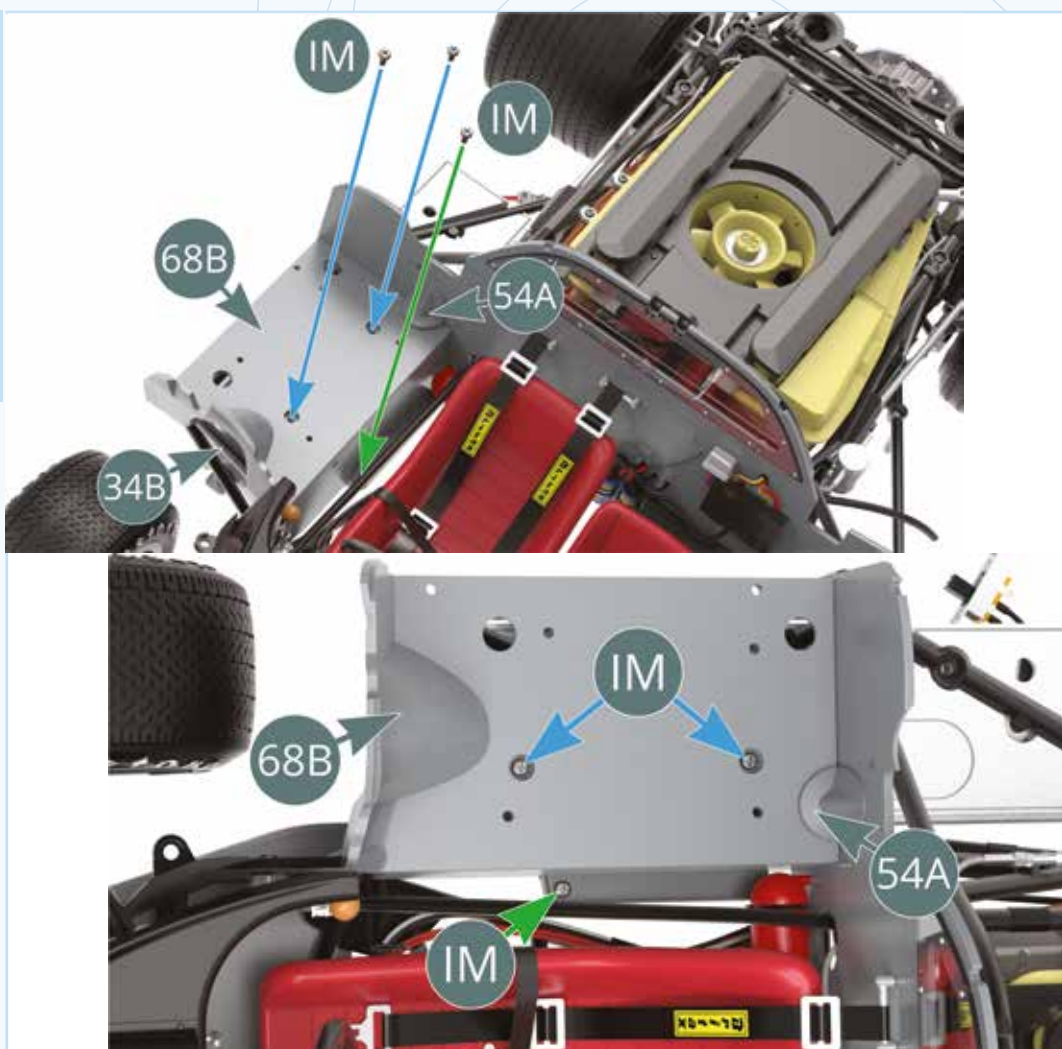
STEP 1

Position the right cockpit housing (68B) on the lower frame (25A) and onto the chassis (34B) ensuring that the rear edge slides under the reinforcement of the cockpit bulkhead (54A) - blue arrow.



STEP 2

Attach the right cockpit housing (68B) to the chassis (34B) with two IM screws (blue arrows) and to the lower frame (25A) with one IM screw (green arrow). Please refer to the illustrations on the right and in the previous step.





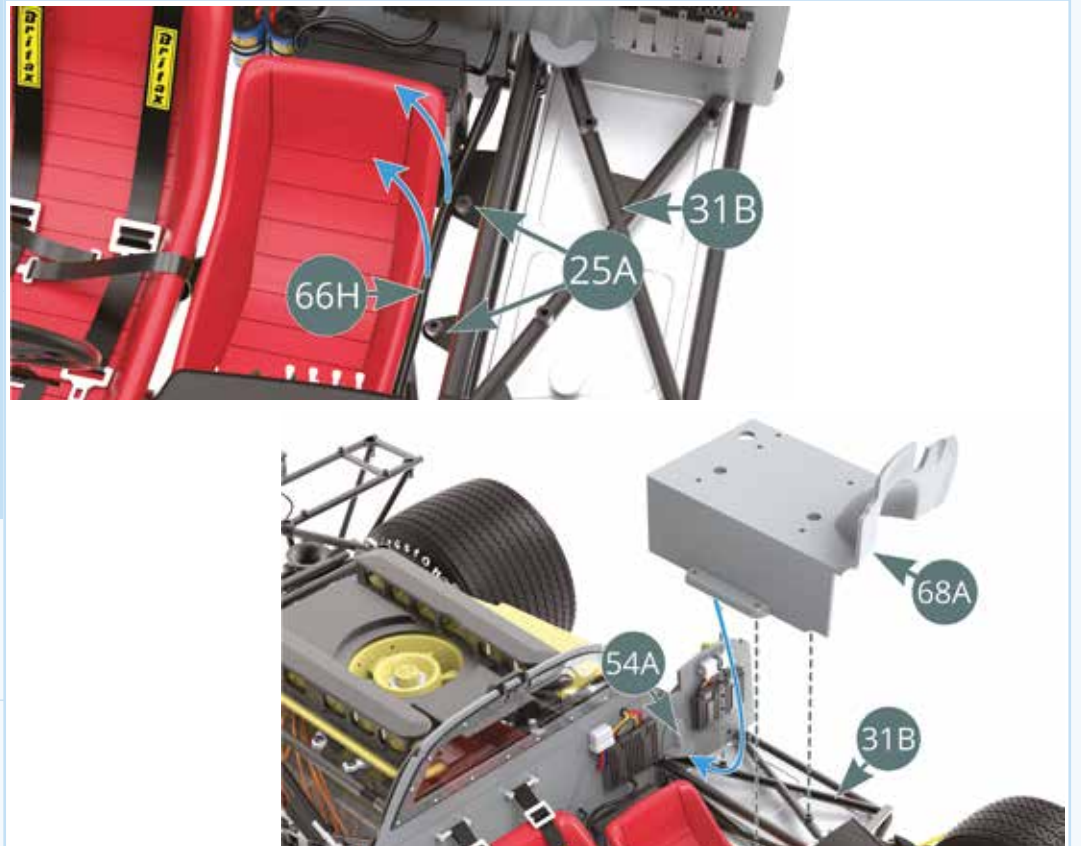
STEP 3

Position the handbrake cable (68D) onto the handbrake (68C), then position the assembly onto the right-hand cockpit housing (68B). Position the free end of the handbrake cable on the pin situated on the cockpit bulkhead (54A).



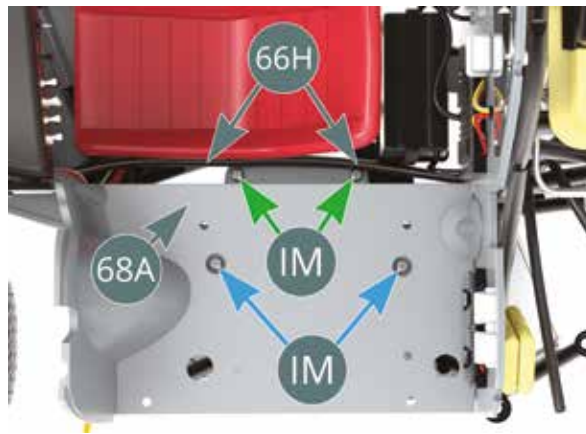
STEP 4

Before installing the left cockpit housing (68A) - shown next - tighten the two water hoses (66H) along the passenger seat. Position the left cockpit housing (68A) onto the lower frame (25A) and chassis (31B), ensuring that the rear edge slides under the reinforcement of the cockpit bulkhead (54A) - blue arrow.

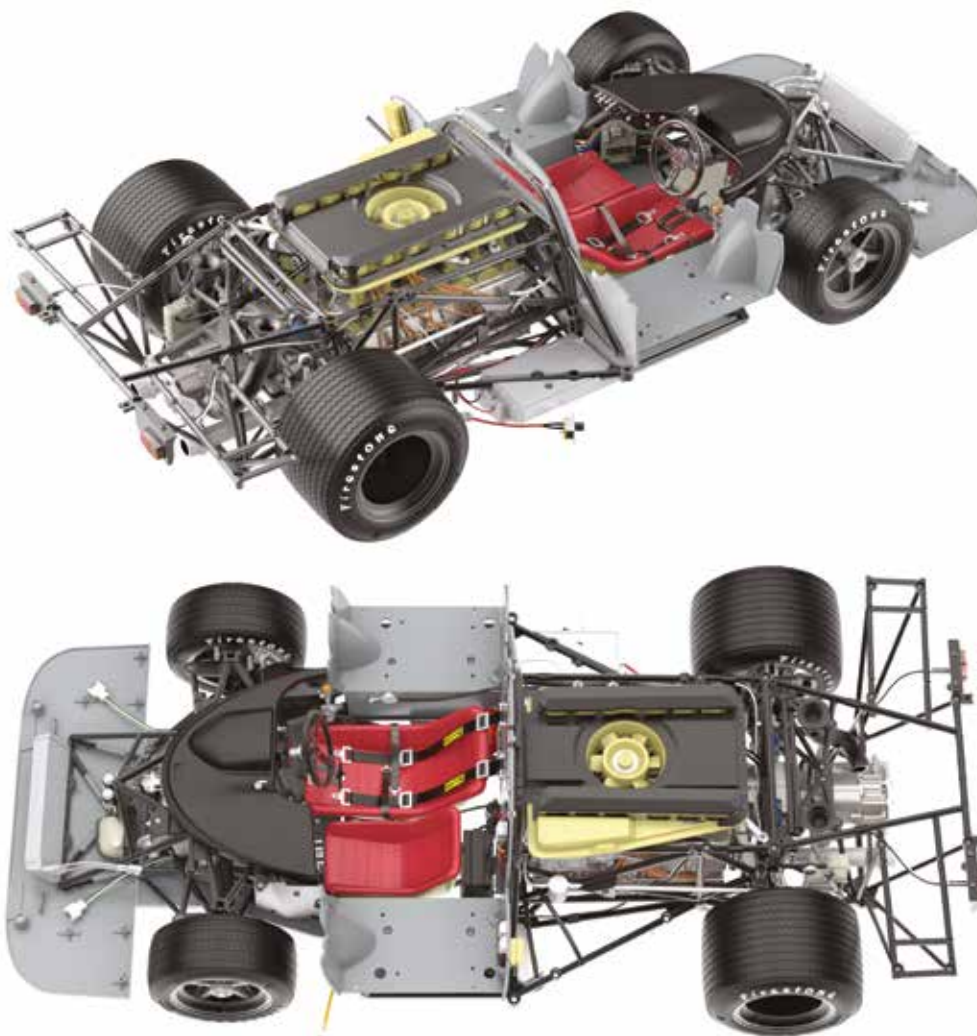


STEP 5

Attach the left cockpit housing (68A) onto the chassis (31B) with two IM screws (blue arrows) and onto the lower frame (25A) with one IM screw (green arrows). Consult the illustrations below and in the previous step. Replace the two water hoses (66H) against the left cockpit housing (68A).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 69

69A Platform left side

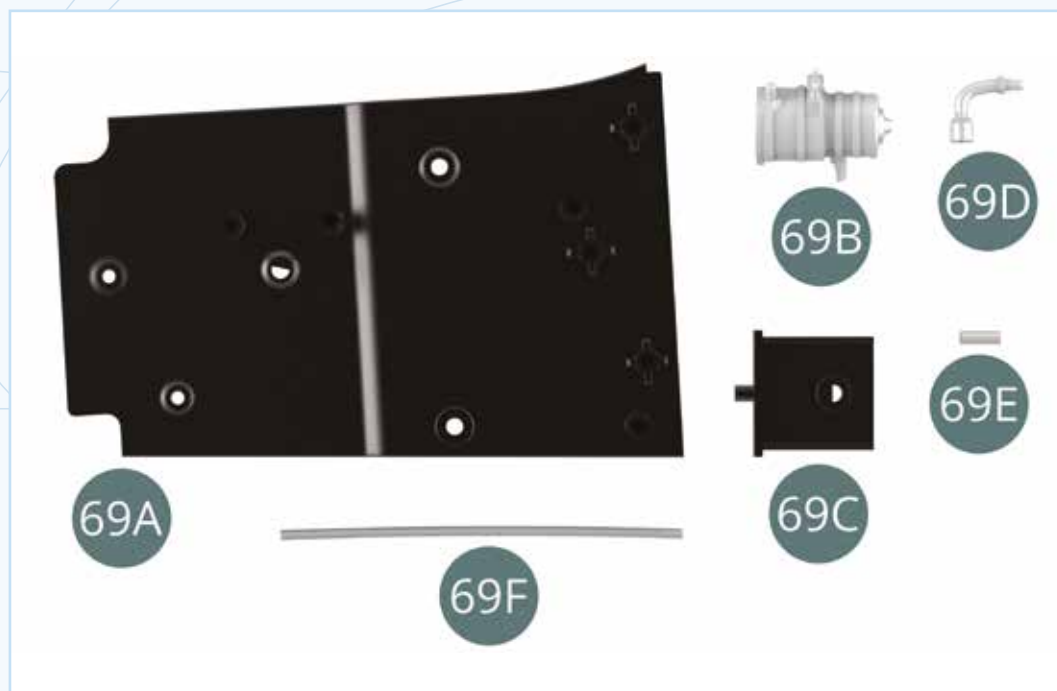
69B Fuel pump

69C Protective shield

69D Pump coupling

69E Connector

69F Shielded/Protected fuel line



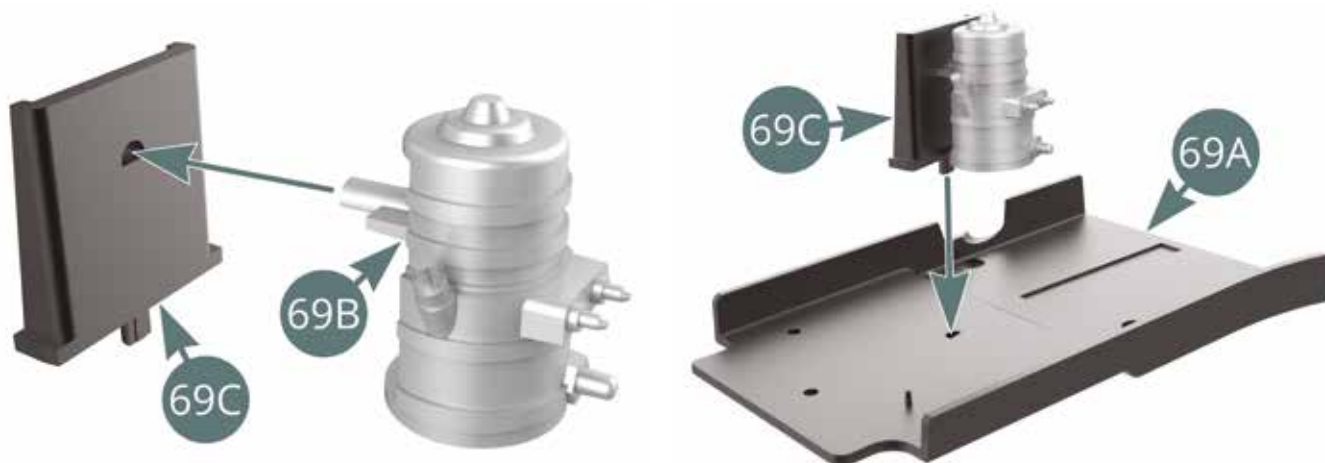
Assembly of the left side platform and fuel pump

ASSEMBLY DIAGRAM



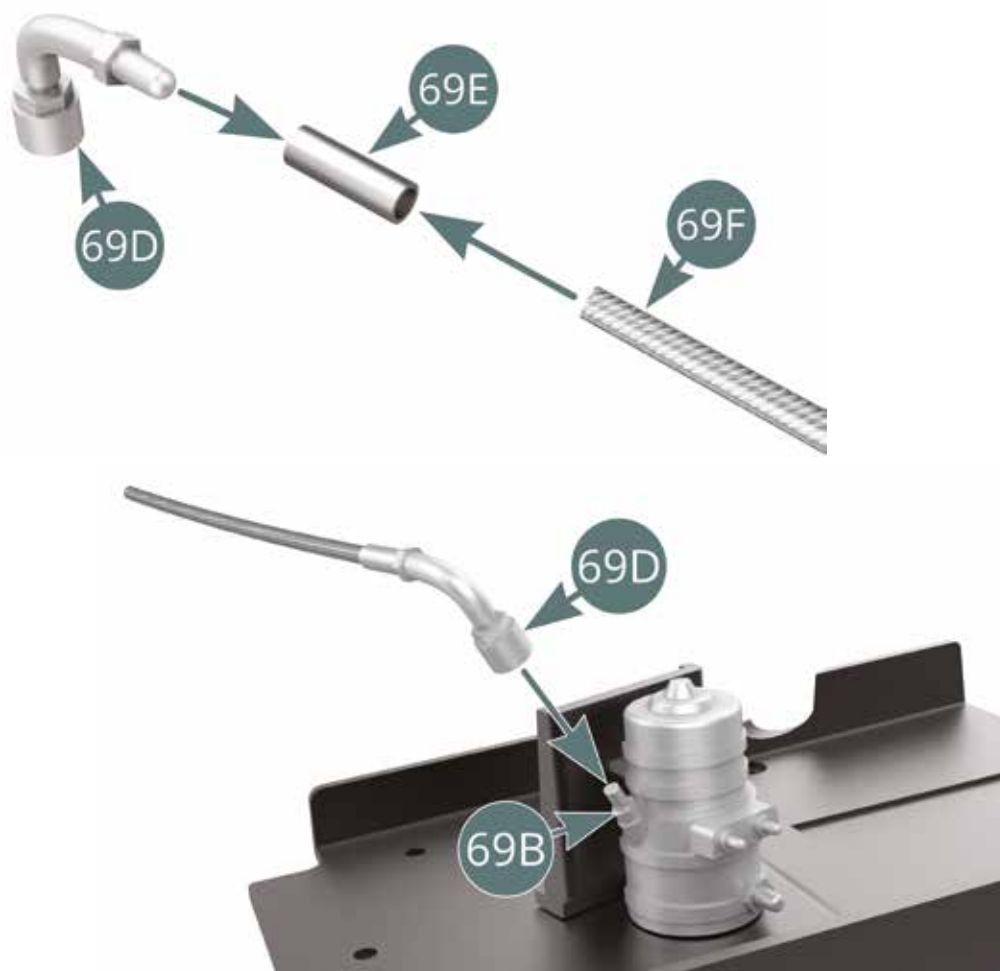
STEP 1

Position the fuel pump (69B) on the protective shield (69C). Position the shield (69C) and pump onto the left side platform (69A).



STEP 2

Position the shielded fuel line (69F) onto the pump coupling (69D) via the connector (69E). Position the pump connector (69D) onto the fuel pump (69B).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 70

70A Oil tank support frame

70B Fuel manifold

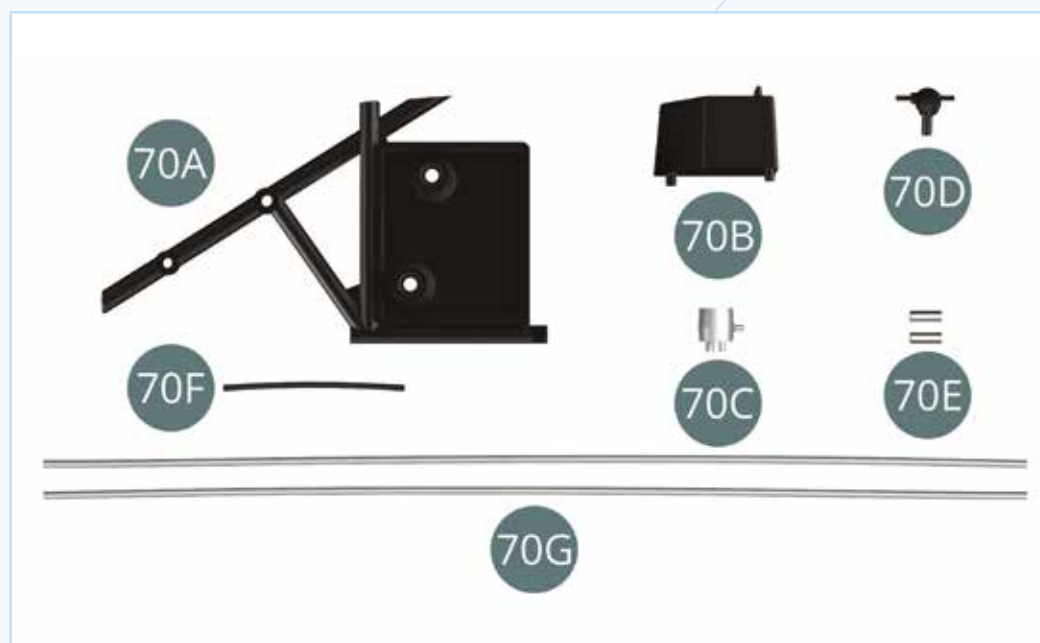
70C Cap

70D Electrical switch

70E Fitting (x 2)

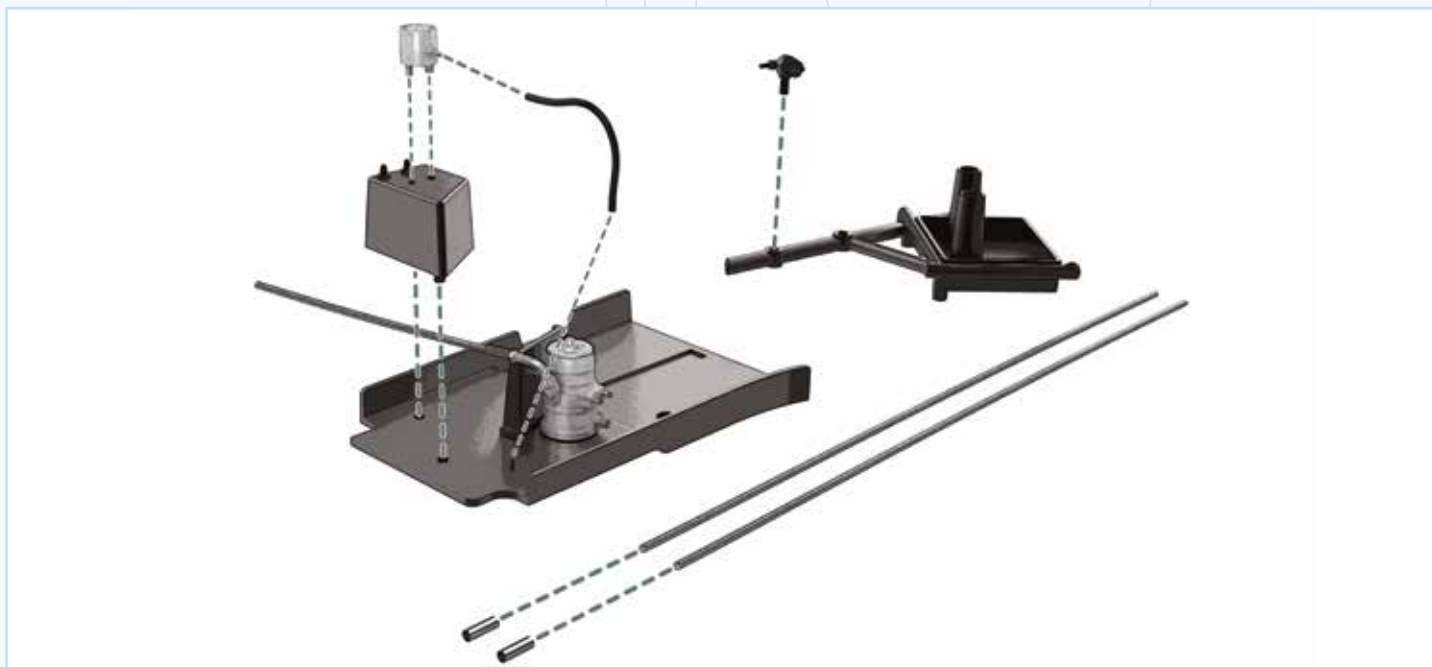
70F Fuel hose

70G Shielded fuel line (x 2)



Installation of the fuel manifold on the left side platform, assembly of the fuel lines

ASSEMBLY DIAGRAM





STEP 1

Position the fuel hose (70F) onto the fuel cap (70C). Position the cap (70C) onto the fuel manifold (70B). Position the fuel manifold (70B) on the left side platform (69A). Connect the fuel hose (70F) to the pin positioned on the left side platform (69A).



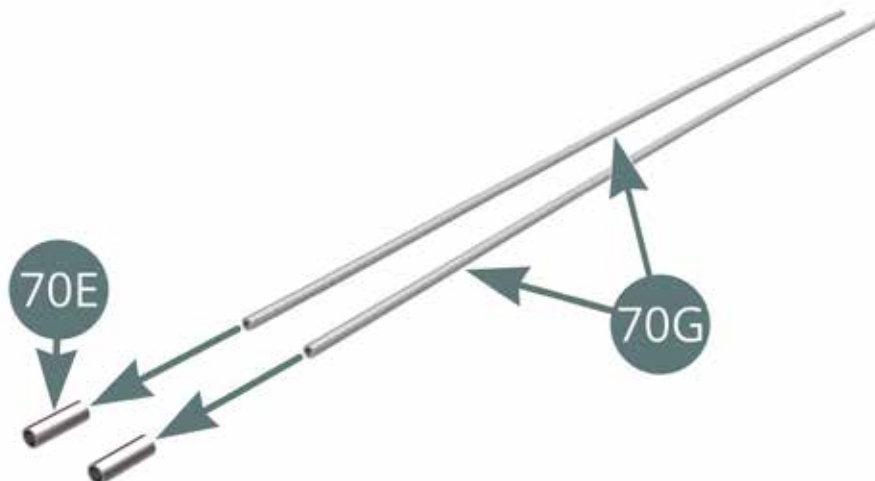
STEP 2

The fuel manifold (70B) and fuel hose (70F) are attached to the left side platform (69A). Position the electrical switch (70D) on the oil tank support frame (70A).

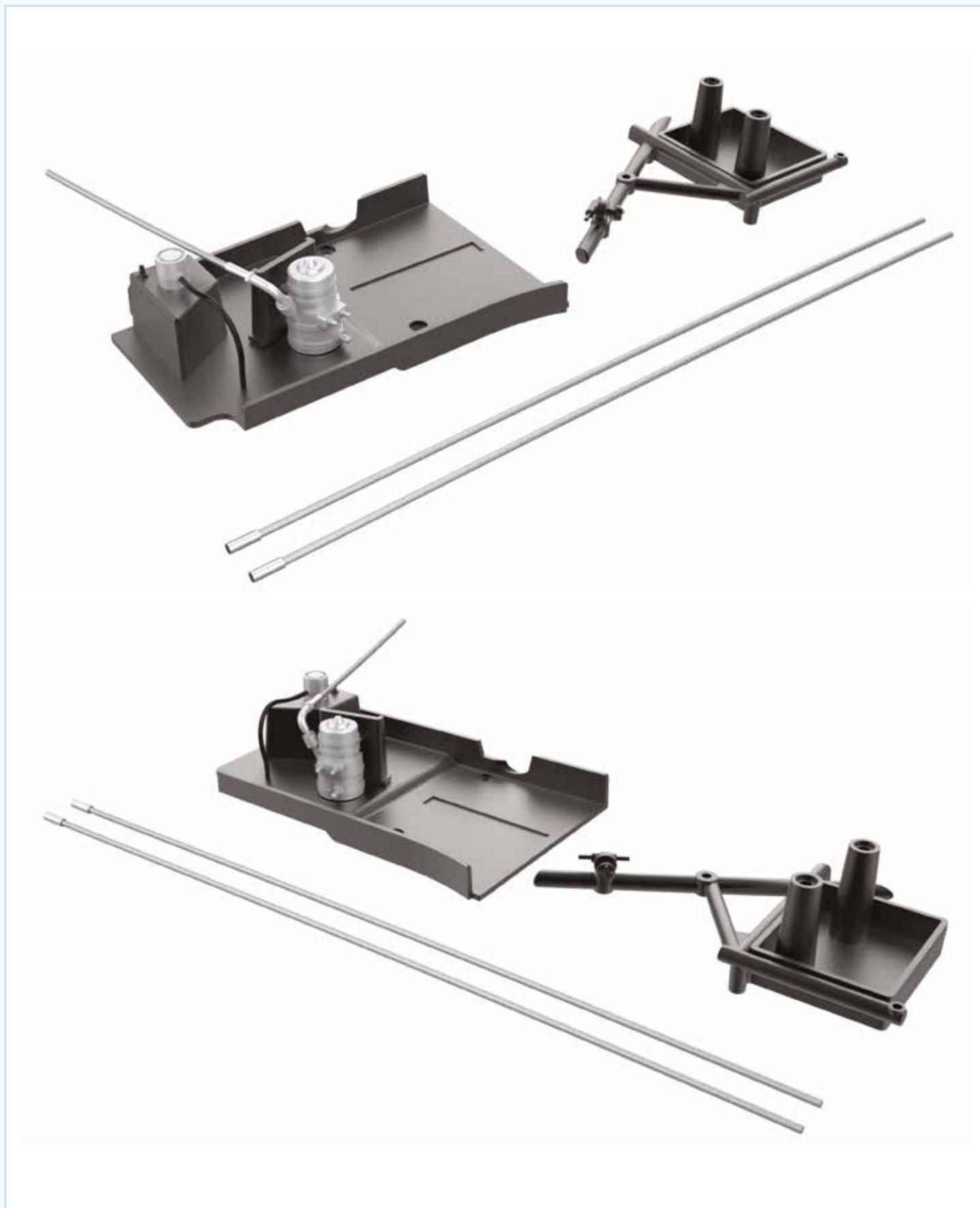


STEP 3

Position the two connectors (70E) on the two shielded fuel lines (70G).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 71

71A Oil filler cap

71B Handle

71C Oil tank body

71D Oil tank body

71E Bracket

71F Strap

71G Thermostat

71H Oil hose

71I Oil hose

71J Arm

AP Screw M 1.7 x 4 mm (x 5)

MP Screw M 2.0 x 5 mm (x 3)

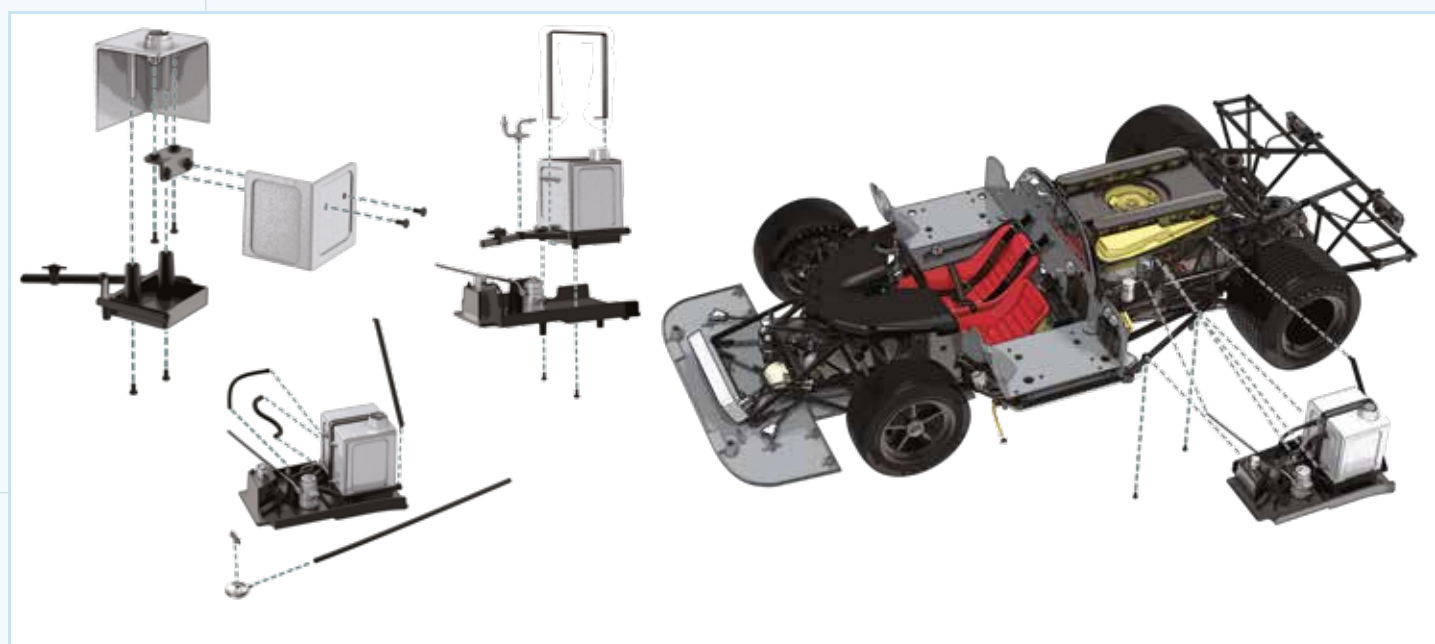
IM Screw M 1.7 x 3.5 mm (x 3)

BM Screw M 2.0 x 4 mm (x 3)



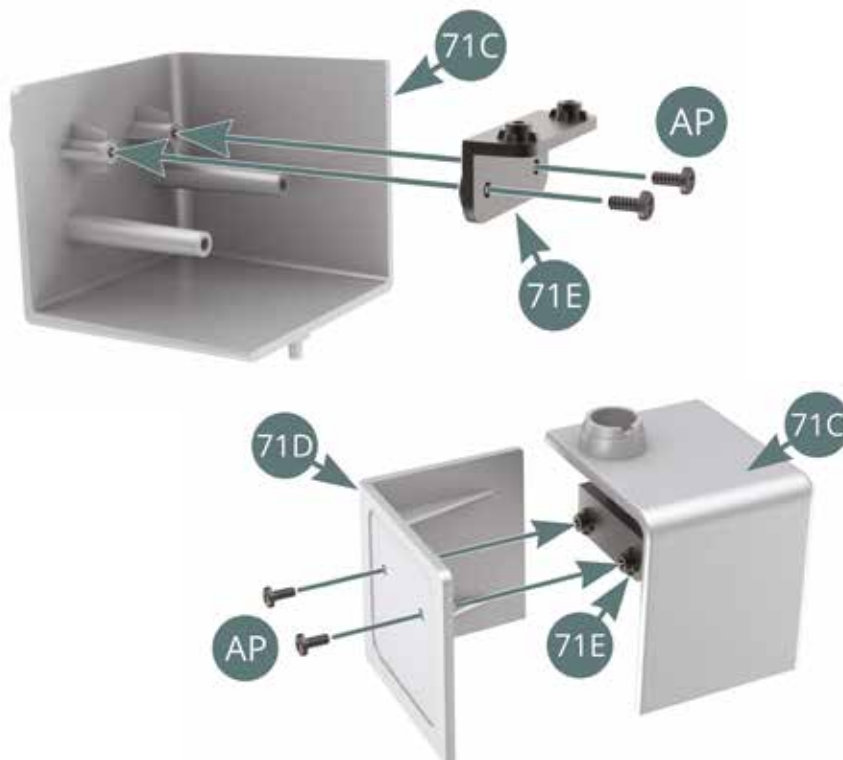
Assembly of the oil tank and installation on the left side platform. Installation of the unit on the chassis

ASSEMBLY DIAGRAM



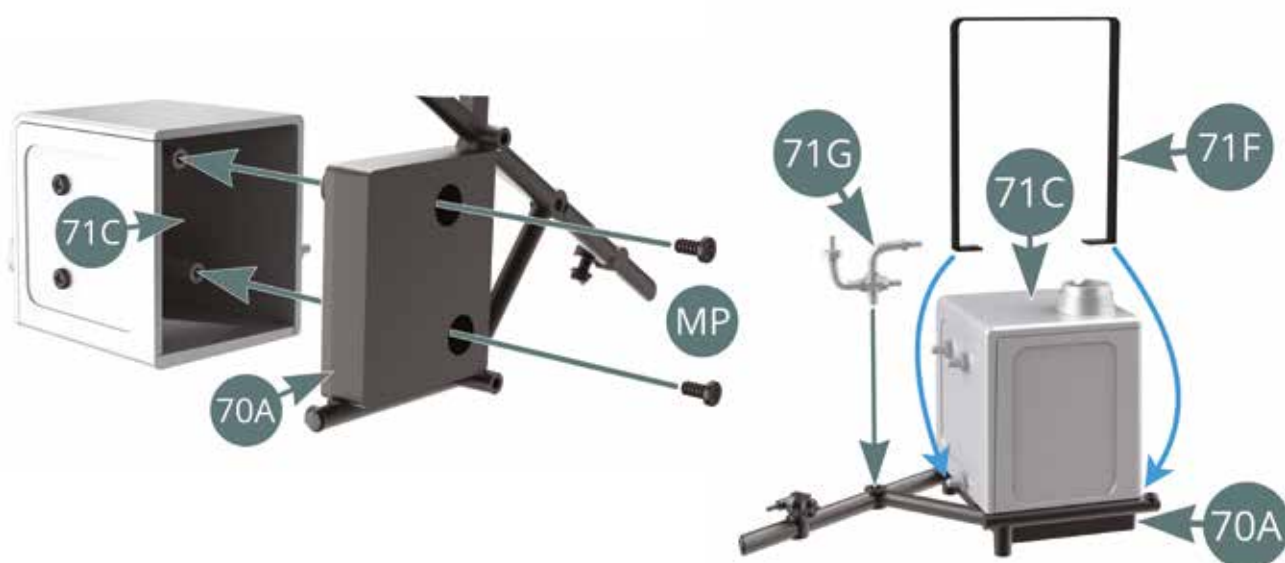
STEP 1

Position the bracket (71E) on the oil tank body (71C) and secure it with two AP screws. Position the oil tank body (71D) on the bracket (71E) and secure with two AP screws.



STEP 2

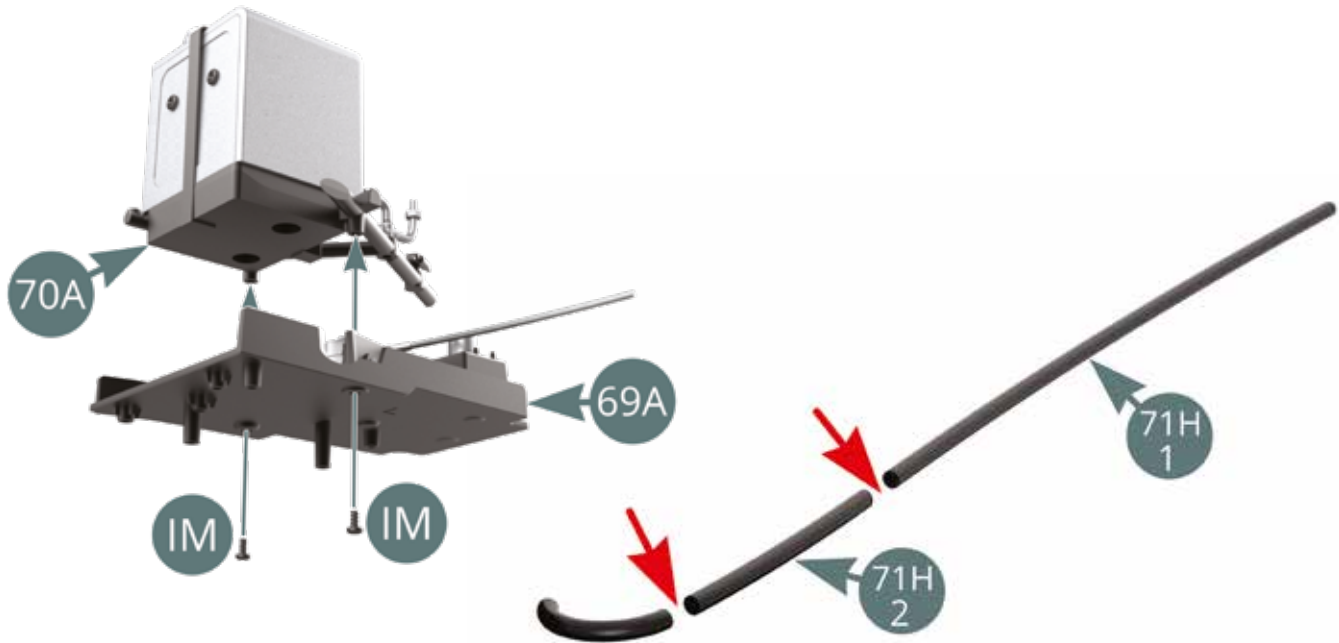
Position the oil tank support frame (70A) on the oil tank body (71C) and secure with two MP screws. Position the thermostat (71G) on the tubular bar of the oil tank support frame (70A). Place the strap (71F) over the oil tank (71C) and the oil tank support frame (70A).





STEP 3

Position the oil tank support frame (70A) on the left side platform (69A) and fix with two IM screws. Cut two sections of oil hose 71H: 71H-1 = 140 mm and 71H-2 = 40 mm.



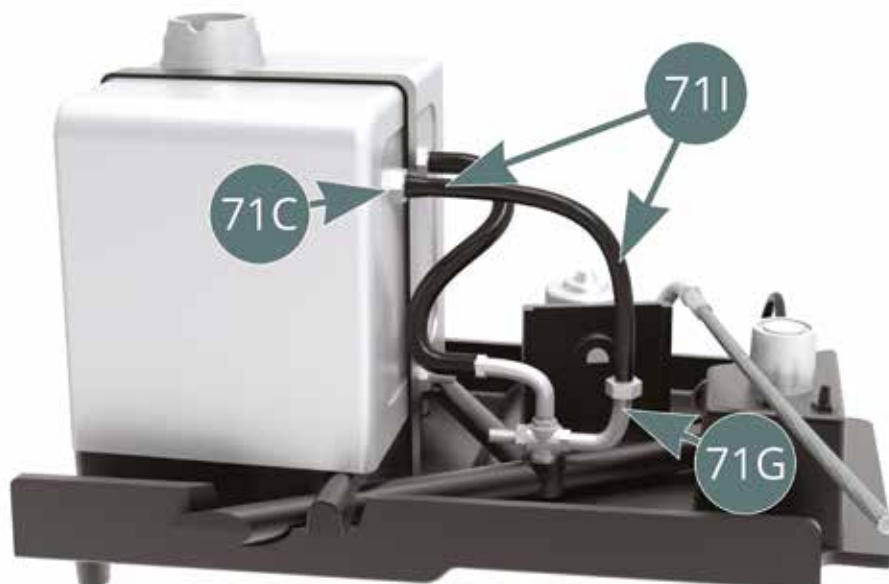
STEP 4

Position the oil hose (71H-1) and handle (71B) on the filler cap (71A). Position the oil hose (71H-2) between the oil tank nozzle (71C) and the thermostat (71G).



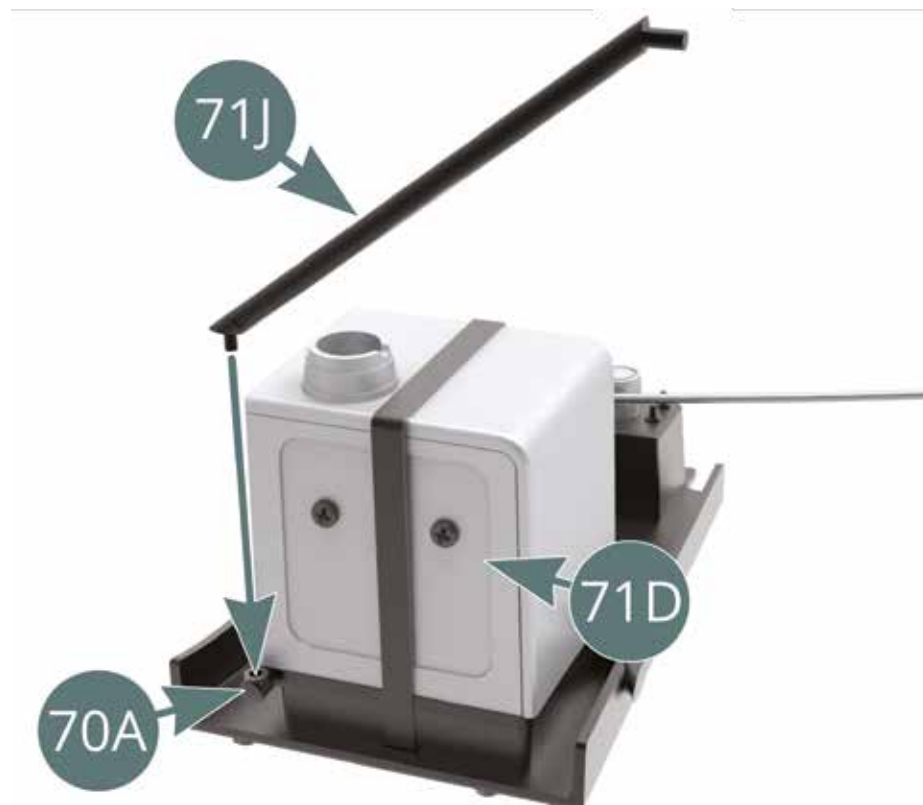
STEP 5

Position the oil hose (71I) between the oil tank nozzle (71C) and the thermostat (71G).



STEP 6

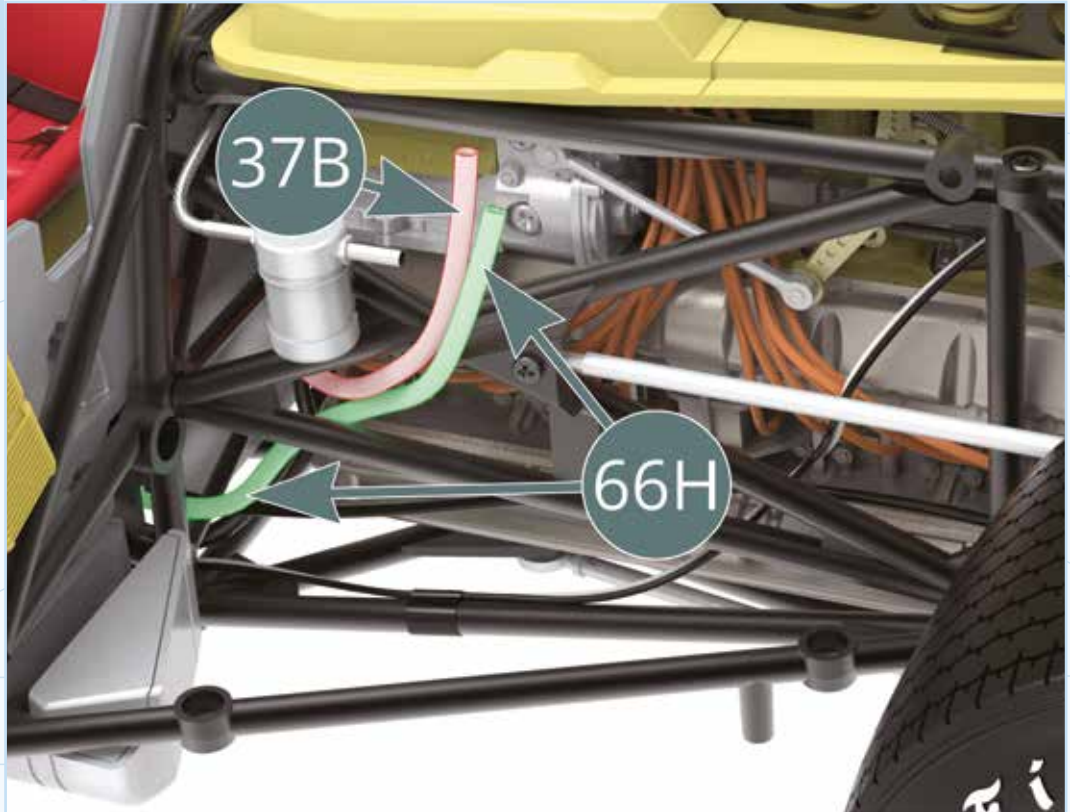
Position the arm (71J) - the end with the smallest peg - over the oil tank support frame (70A) and along the oil tank (71D).





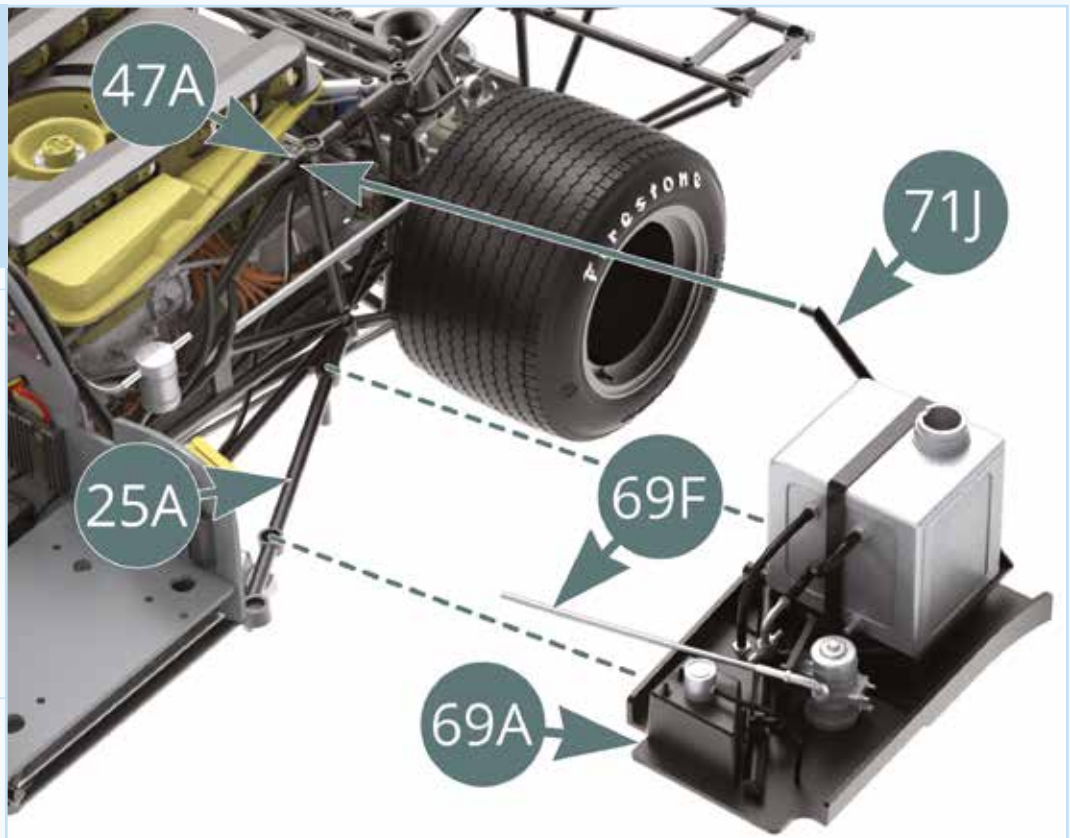
STEP 7

Point the oil line (37B) - highlighted in red - and the water line (66H) - highlighted in green - upwards as shown.



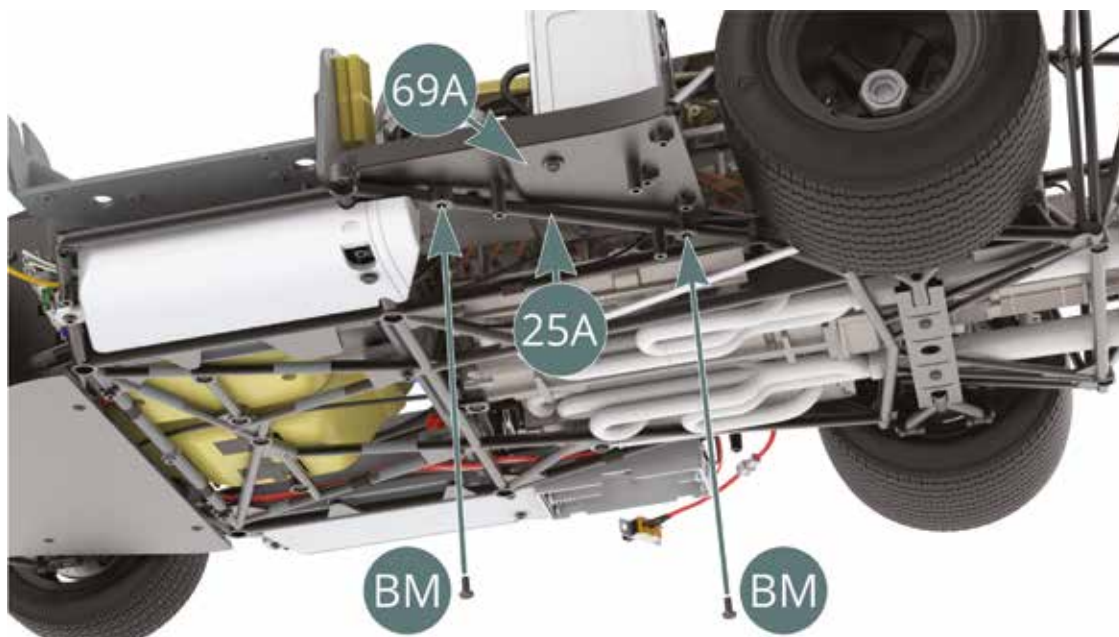
STEP 8

Position the left side platform (69A) on the lower frame (25A), placing the end of the arm (71J) in the slot located on the upper frame (47A).



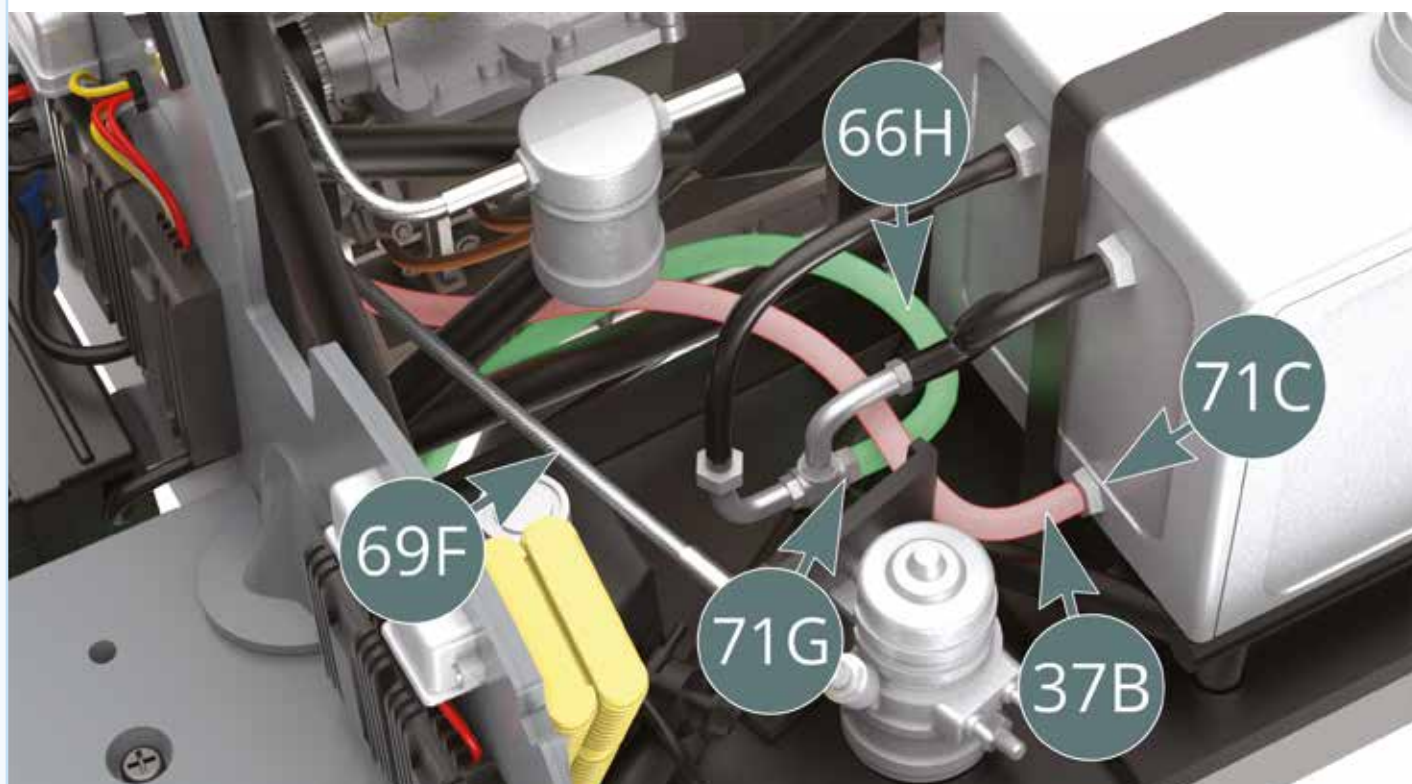
STEP 9

Attach the left side platform (69A) to the lower frame (25A) with two screws BM.



STEP 10

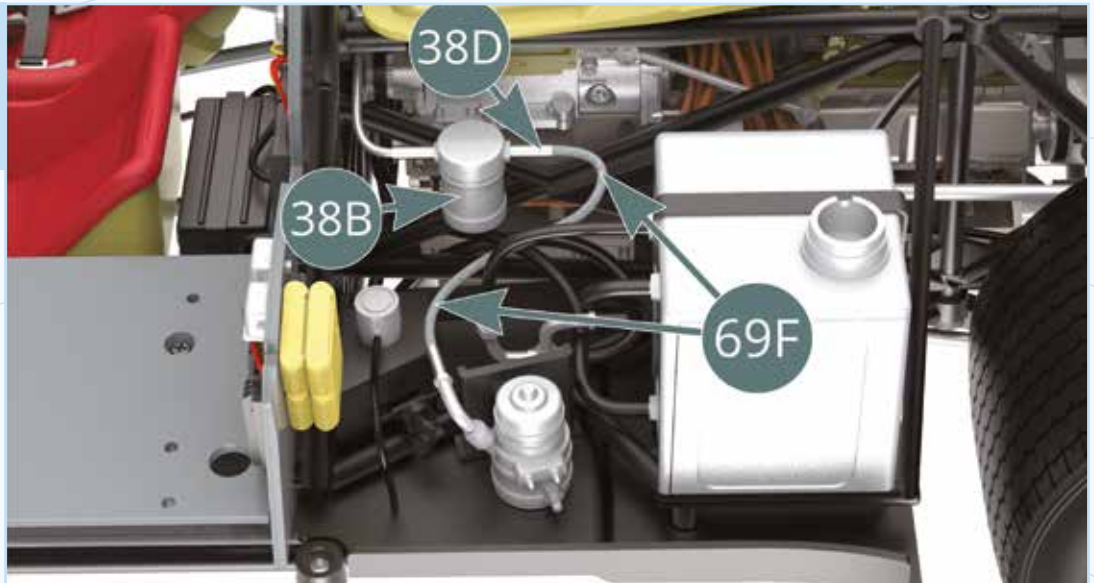
Position the water hose (66H) - highlighted in green - on the thermostat (71G) and the oil hose (37B) - highlighted in red - on the oil tank nozzle.



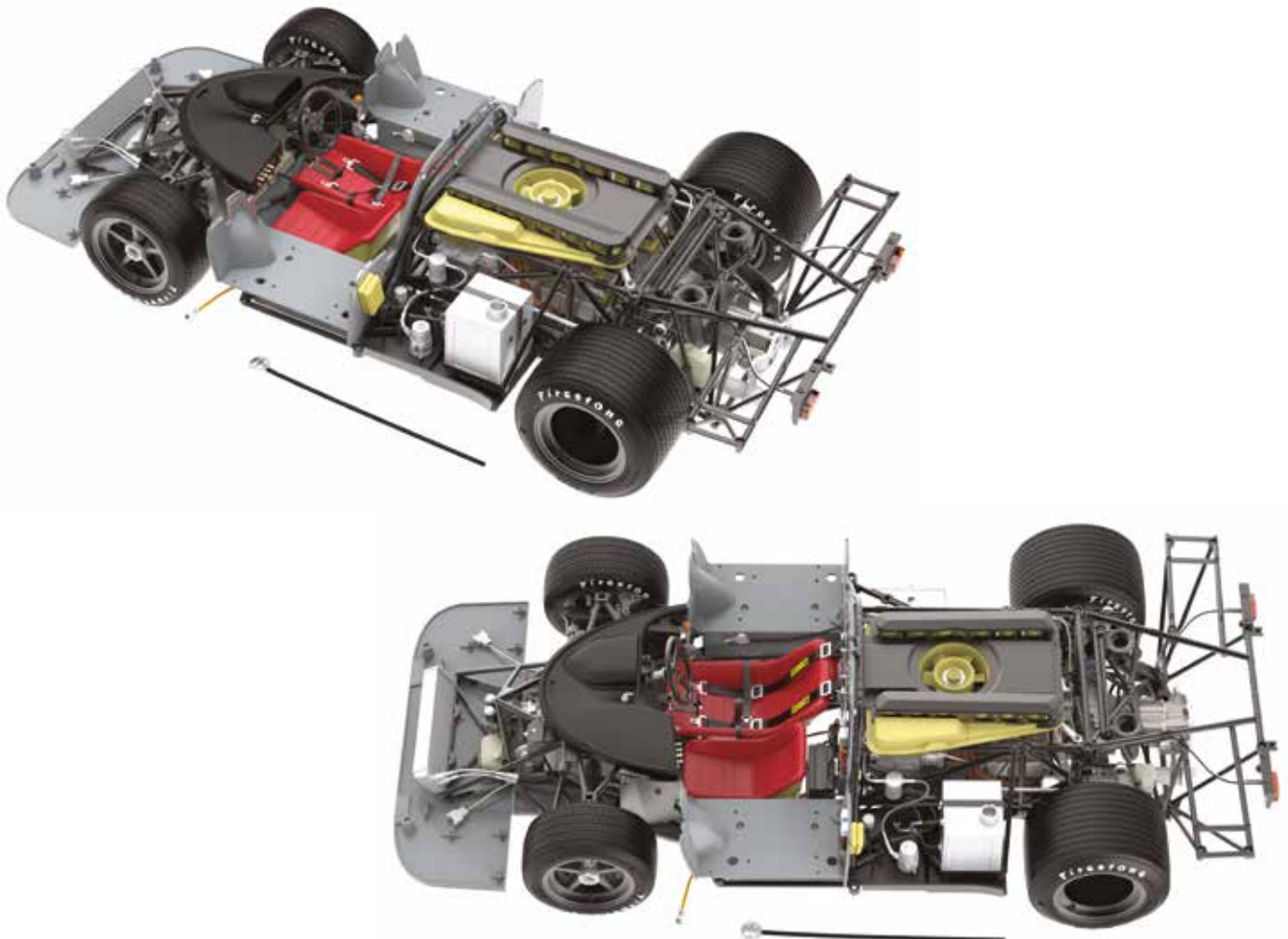


STEP 11

Position the shielded fuel line (69F) onto the connector (38D) of the fuel filter (38B).



GENERAL VIEW





PARTS OF THE ISSUE 72

72A Left rear wheel arch

72B Rear brake cooling valve

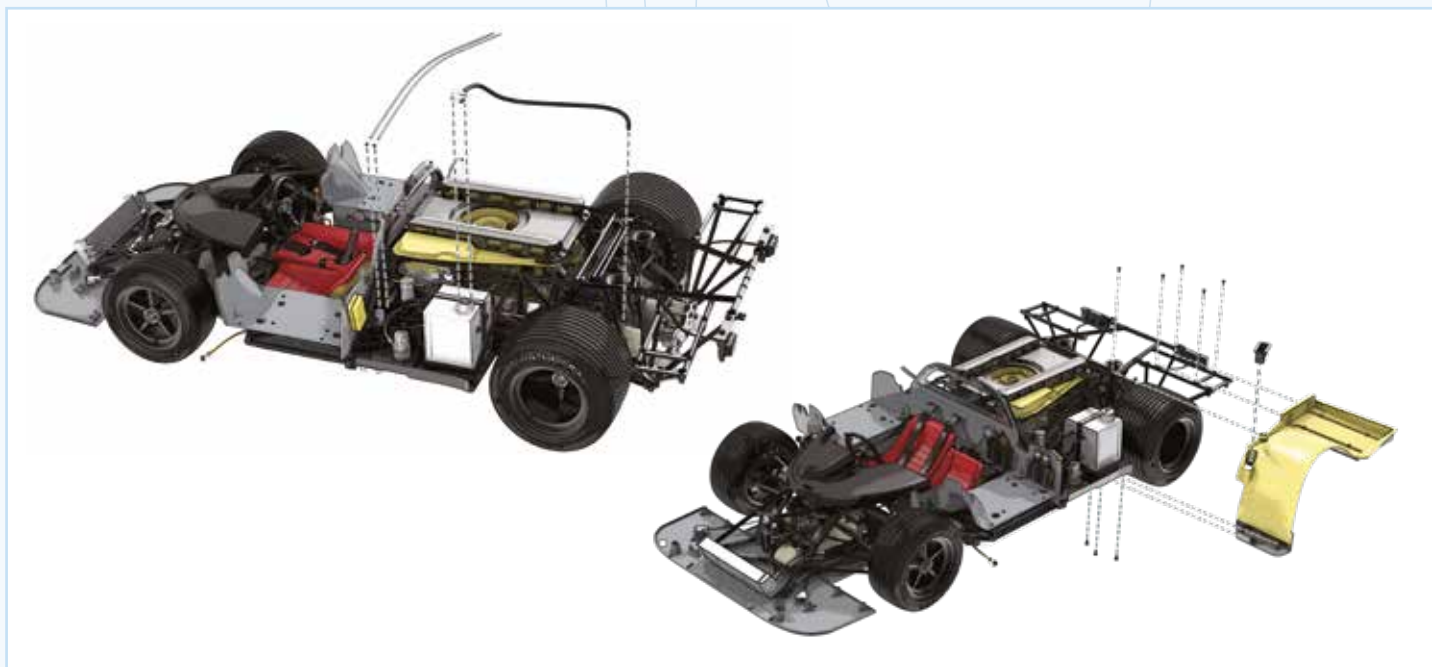
IM Screw M 1.7 x 3.5 mm (x 6)

BM Screw M 2.0 x 4 mm (x 4)



Installation of fuel
and oil lines, instal-
lation of left rear
wheel arch

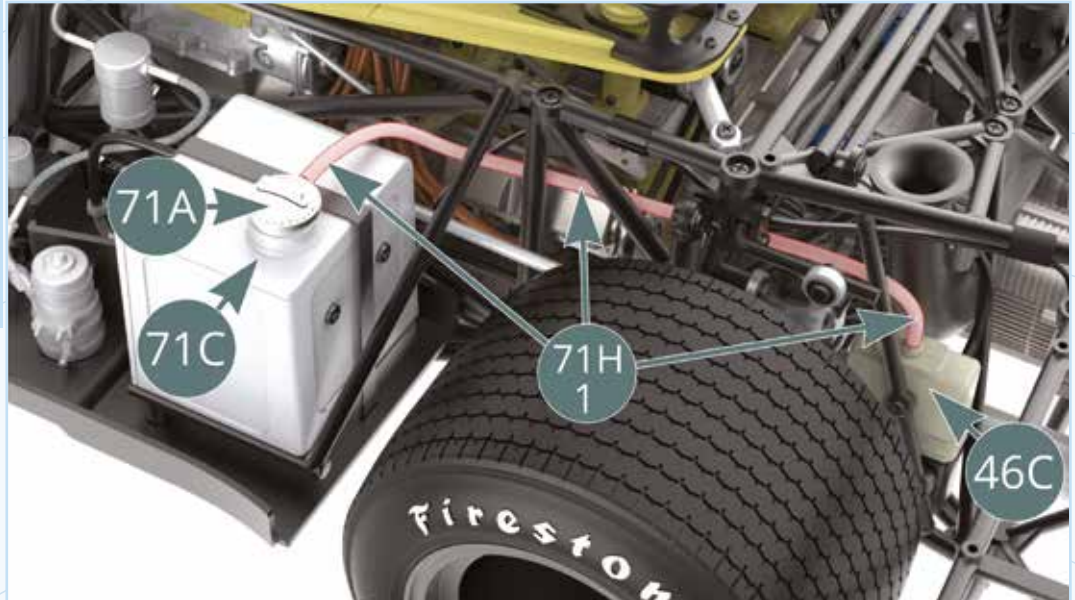
ASSEMBLY DIAGRAM





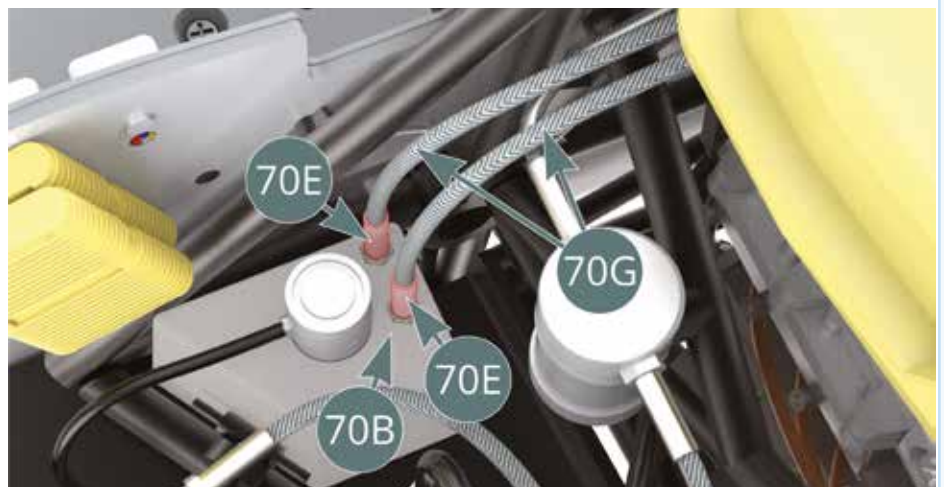
STEP 1

Position the oil filler cap (71A) on the oil tank (71C) and guide the oil hose (71H-1) - highlighted in red - through the engine tube frame to secure it above the engine oil tank cover (46C).



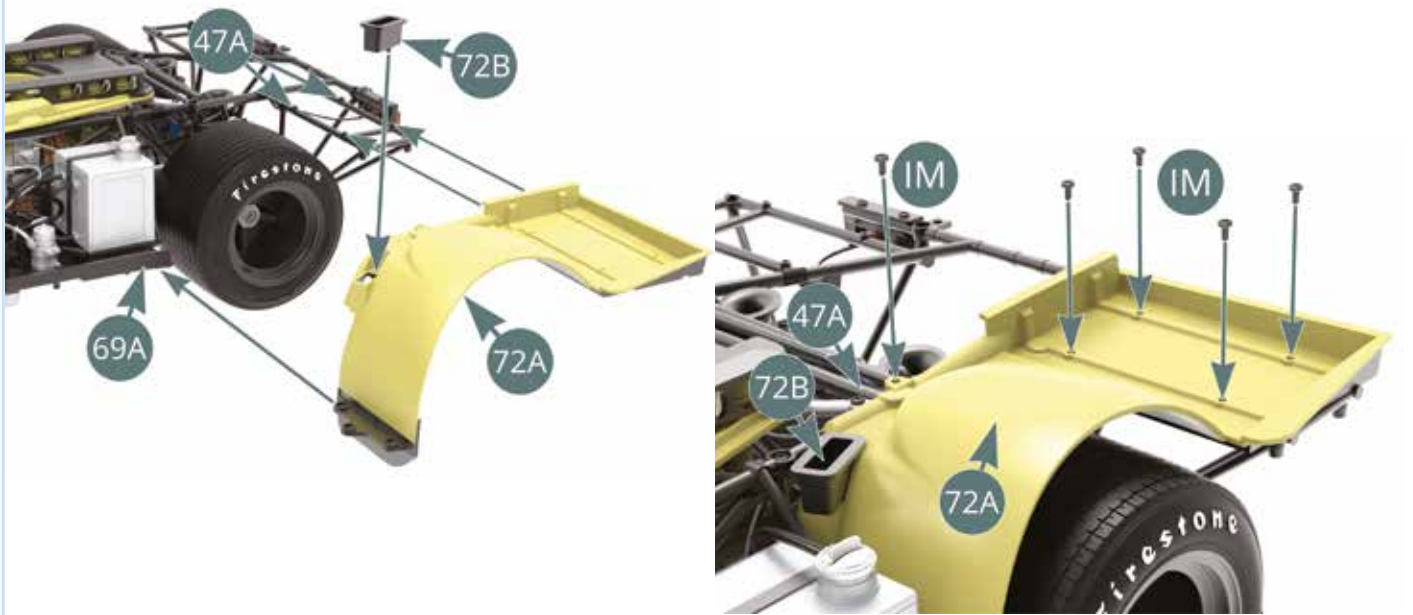
STEP 2

Guide the two shielded fuel lines (70G) (with their 70E fittings) to the left side and front of the engine, passing over the tubular bars of the upper frame (47A). Position the two fittings (70E) - highlighted in red - of the shielded fuel lines (70G) on the fuel manifold (70B) - highlighted in grey.



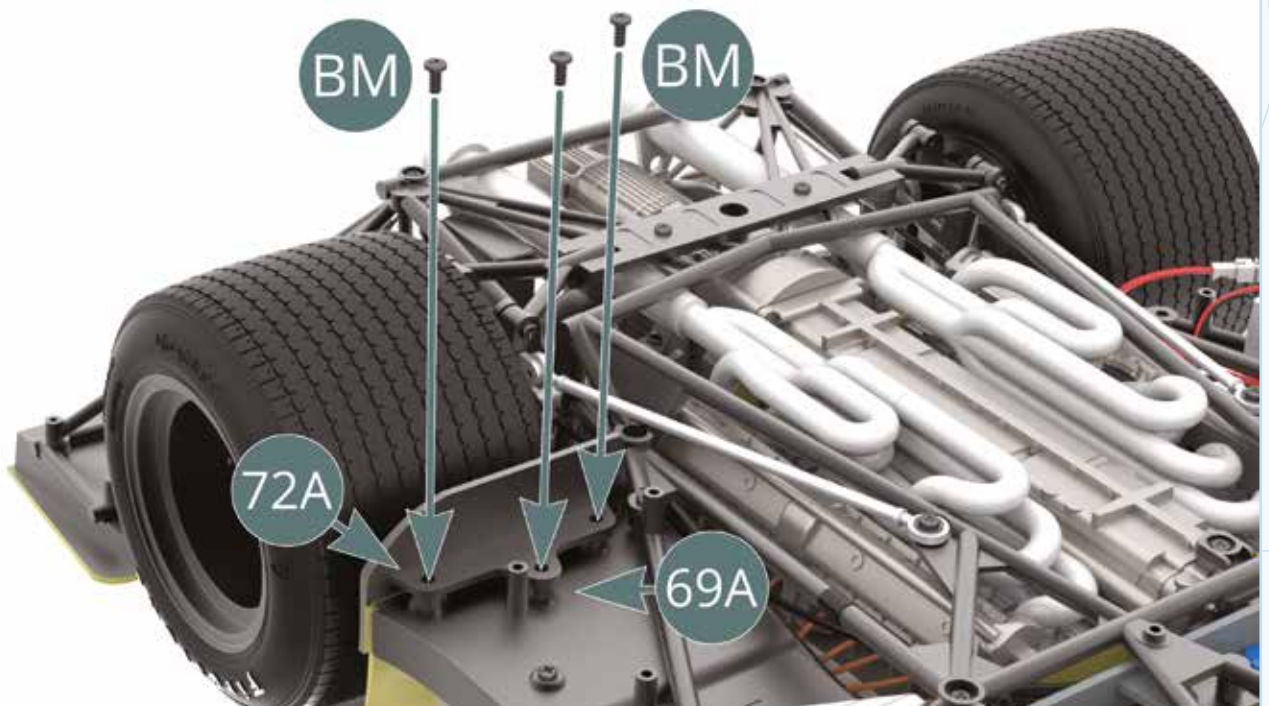
STEP 3

Position the rear brake cooling valve (72B) on the left rear wheel arch (72A). Position the left rear wheel arch (72A) on the upper frame (47A), placing its front bracket under the left lateral platform (69A). Secure the left rear wheel arch (72A) to the upper frame (47A) with five IM screws.



STEP 4

Flip the car over and secure the front left rear wheel arch support (72A) to the left side platform (69A) with three BM screws.





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 73

73A Platform right side

73B Fuel pump

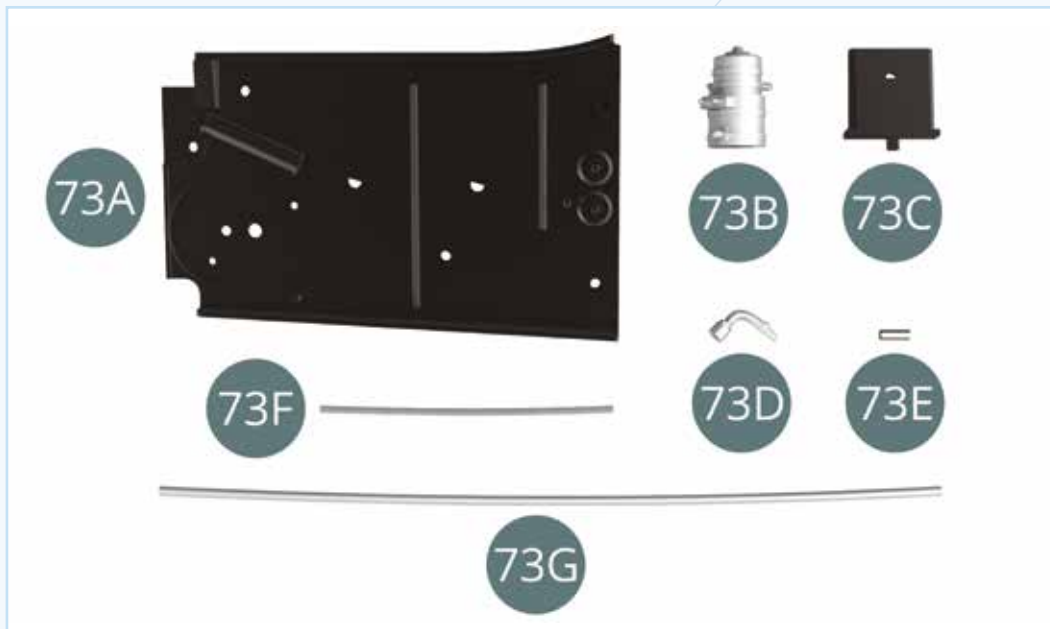
73C Protective shield

73D Pump coupling

73E Connector

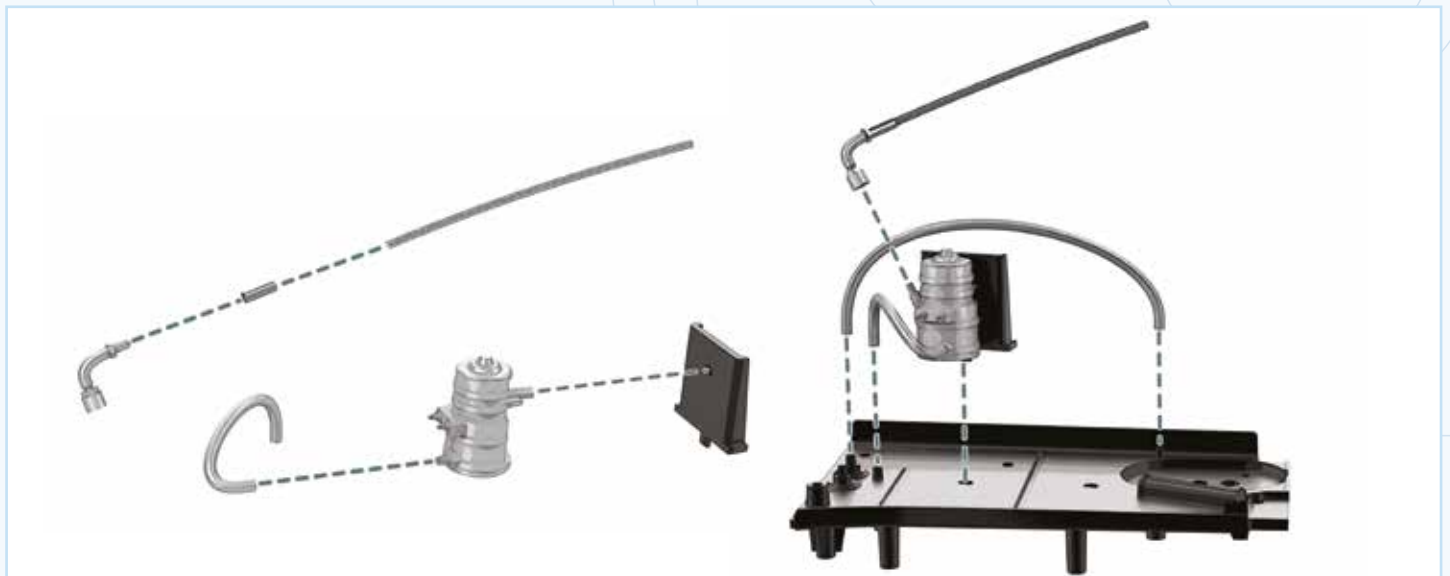
73F Shielded fuel line

73G Fuel line



Assembly of the right side platform and fuel pump

ASSEMBLY DIAGRAM



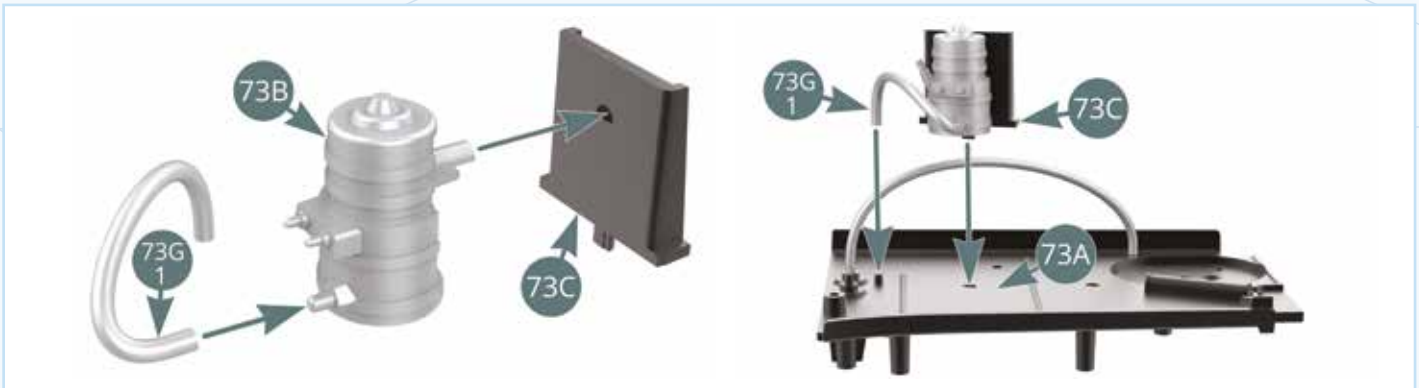


STEP 1

Cut two sections from the fuel line (73G): 73G-2 90 mm and 73G-1 50 mm. Connect the fuel line (73G-2) onto the nipples of the right side platform (73A).



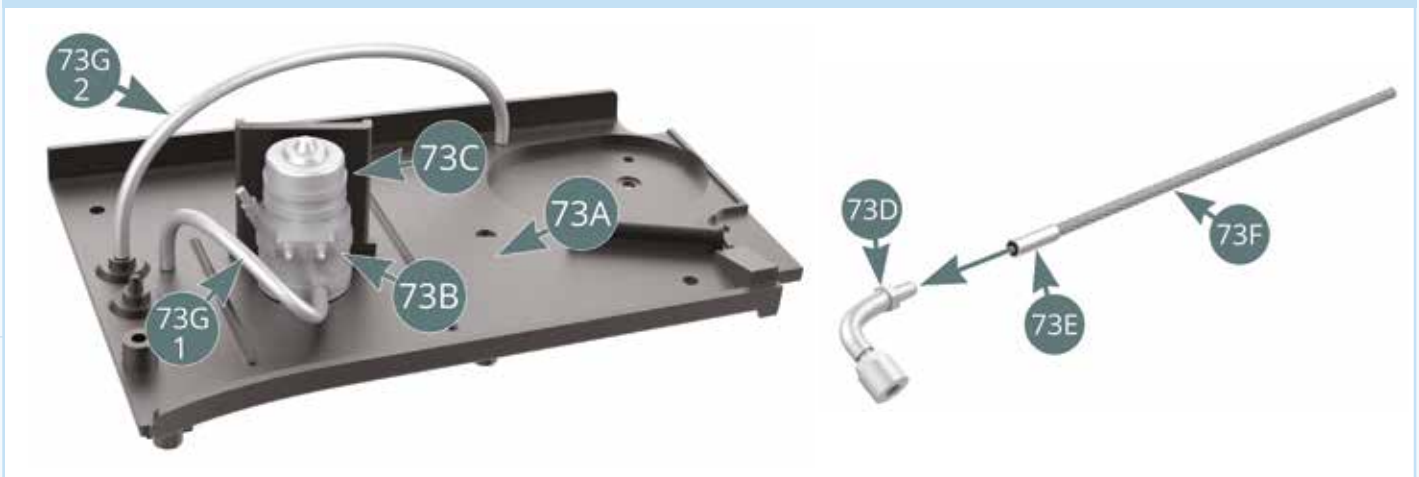
STEP 2



Position the fuel pump (73B) on the protective shield (73C) after connecting the fuel line (73G-1) to the nipple located at the bottom of the pump. Position the protective shield (73C) on the right side platform (73A) and connect the fuel line (73G-1) to the nipple shown.

STEP 3

The fuel pump (73B) is installed onto the right side platform (73A). Position the shielded fuel line (73F) onto the pump coupling (73D) via the coupling (73E).

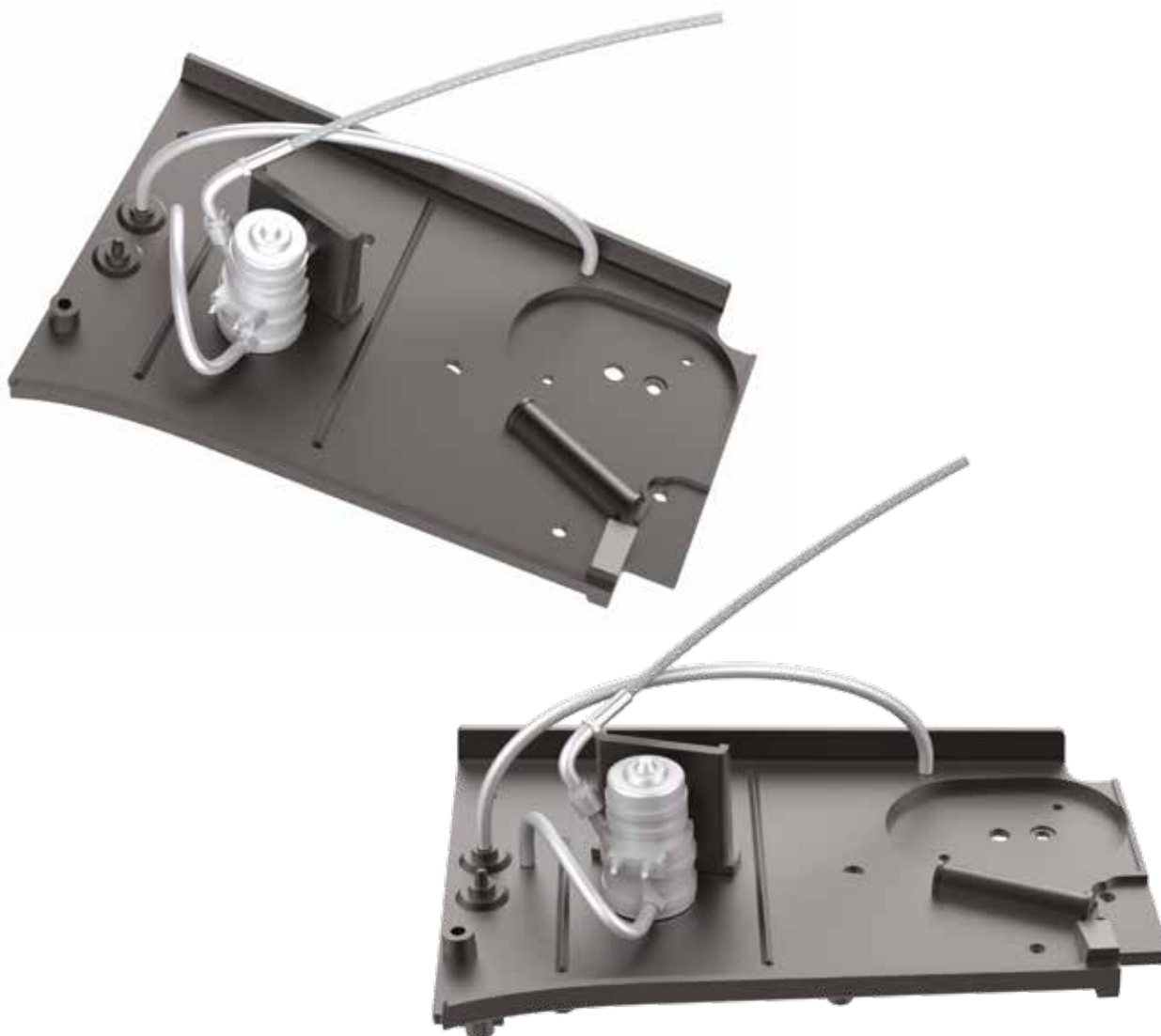


STEP 4

Position the pump coupling (73D) on the fuel pump (73B).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 74

74A Battery

74B Battery holder

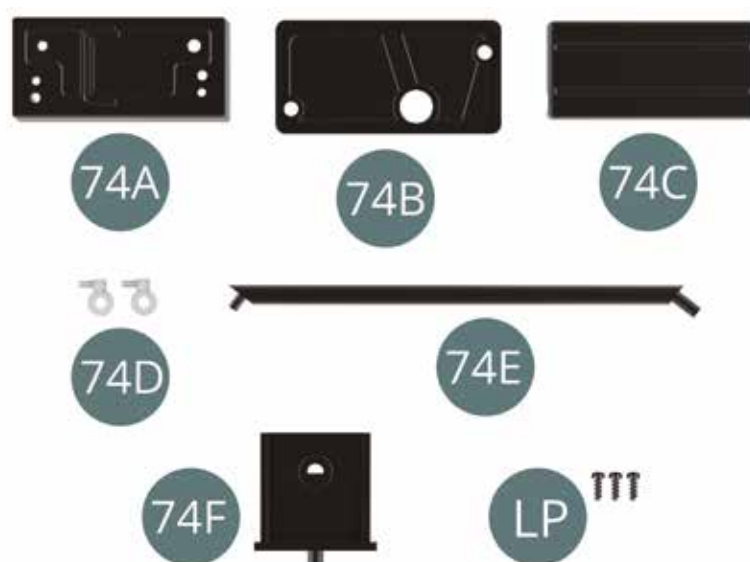
74C Battery cover

74D Battery terminal (x 2)

74E Arm

74F Protective shield

LP Screw M 1.2 x 3.5 mm (x 3)

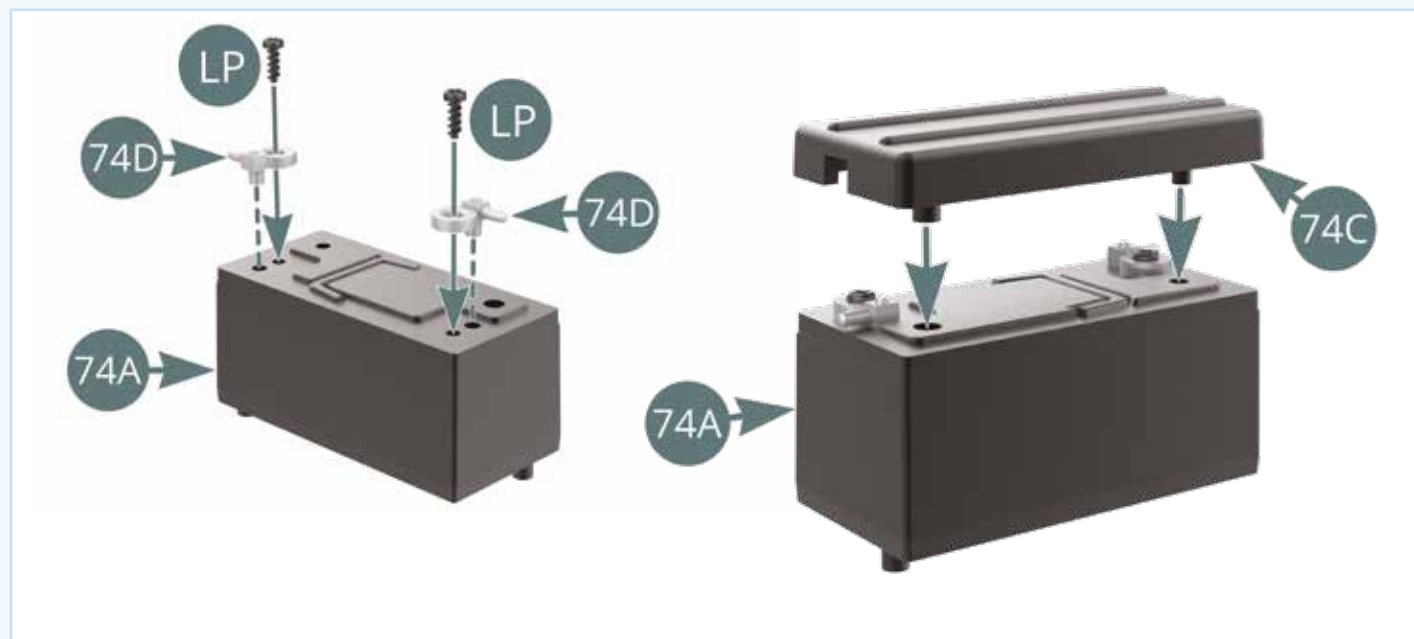


Assembly and
mounting of the
emergency battery

ASSEMBLY DIAGRAM



STEP 1

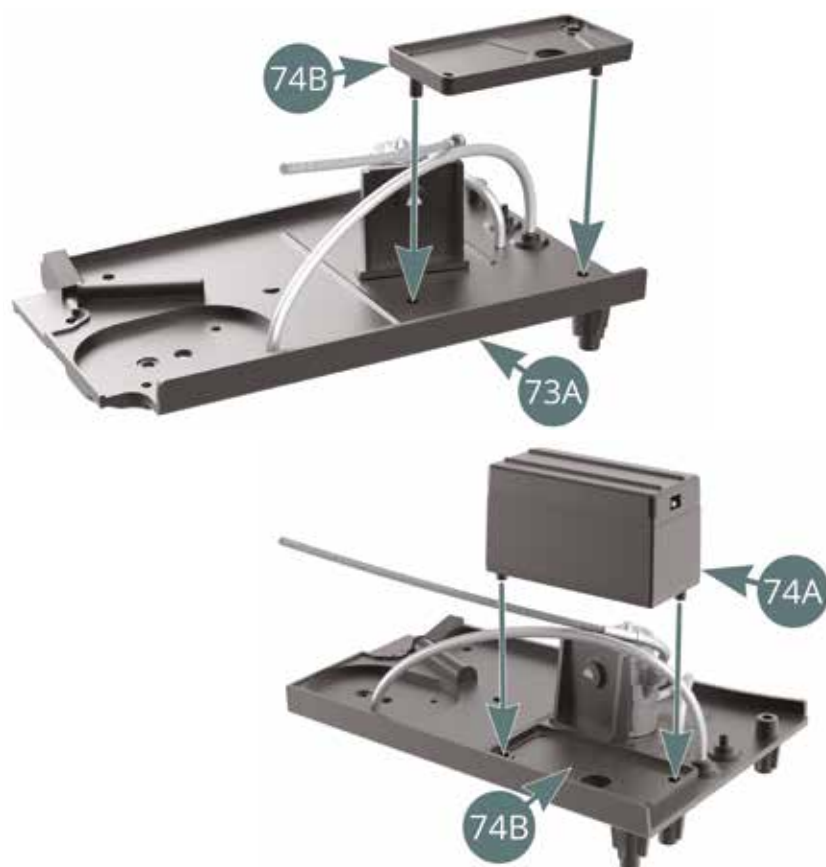


Position the two battery terminals (74D) on top of the battery (74A) and secure with two LP screws. Place the cover (74C) on the battery (74A).

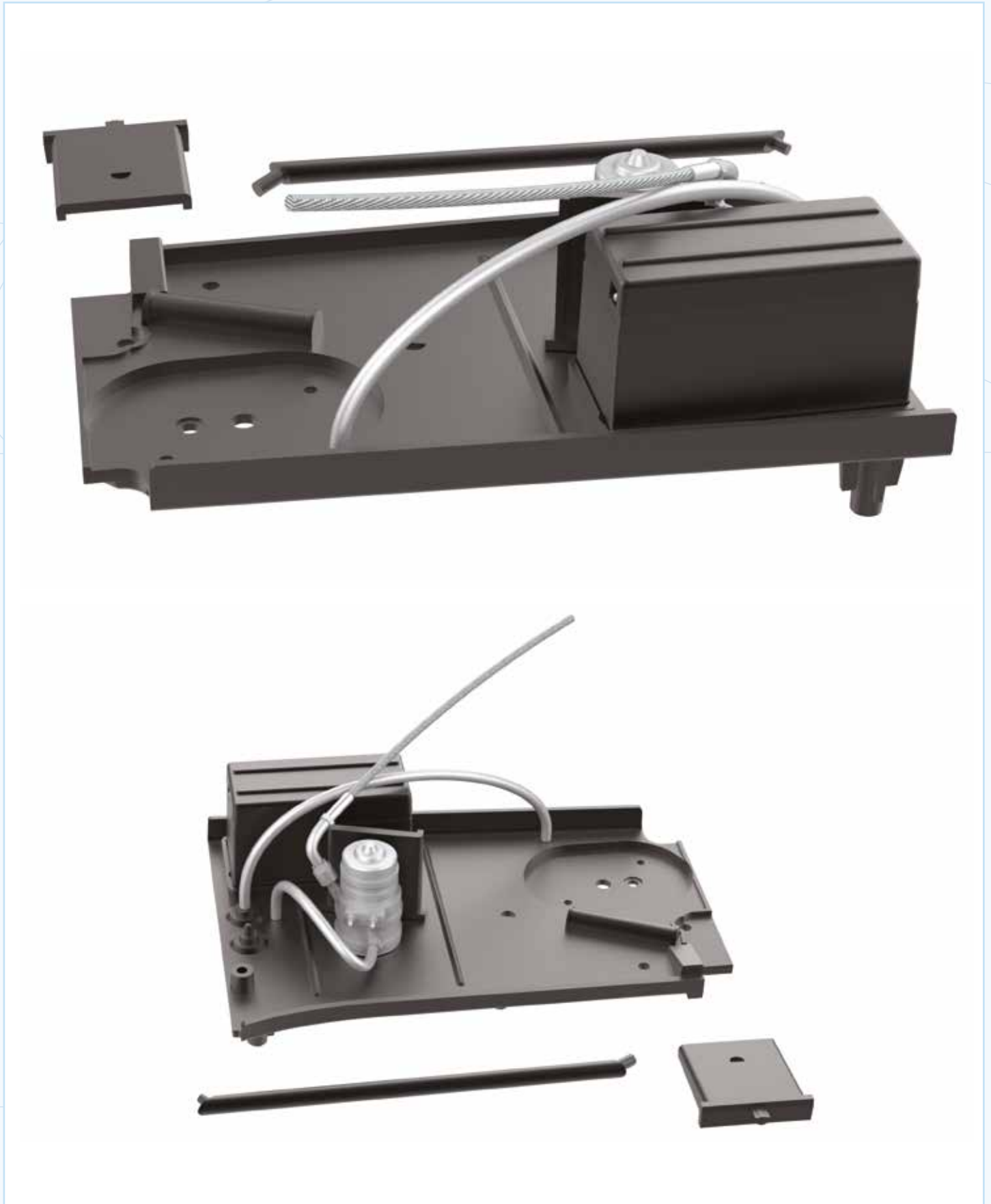
STEP 2

Position the battery holder (74B) on the right side platform (73A).

Position the battery (74A) on the battery holder (74B).



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 75

75A Fuel filler neck

75B Fuel filler neck

75C Fuel filler cap

75D Handle

75E Tray

75F Discharge pipe

75G Discharge pipe

75H Fuel pump

75I Connector (x 3)

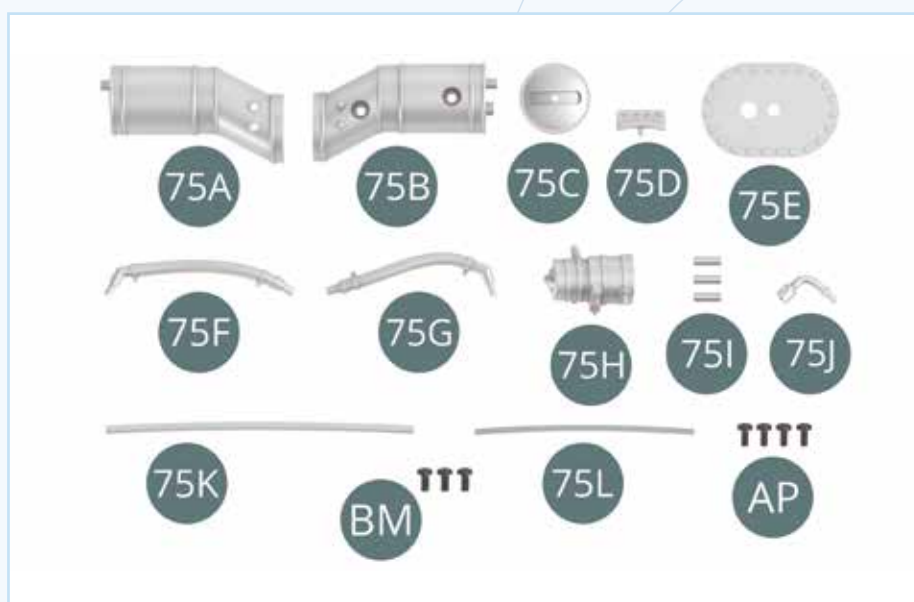
75J Pump connector

75K Fuel line

75L Shielded fuel line

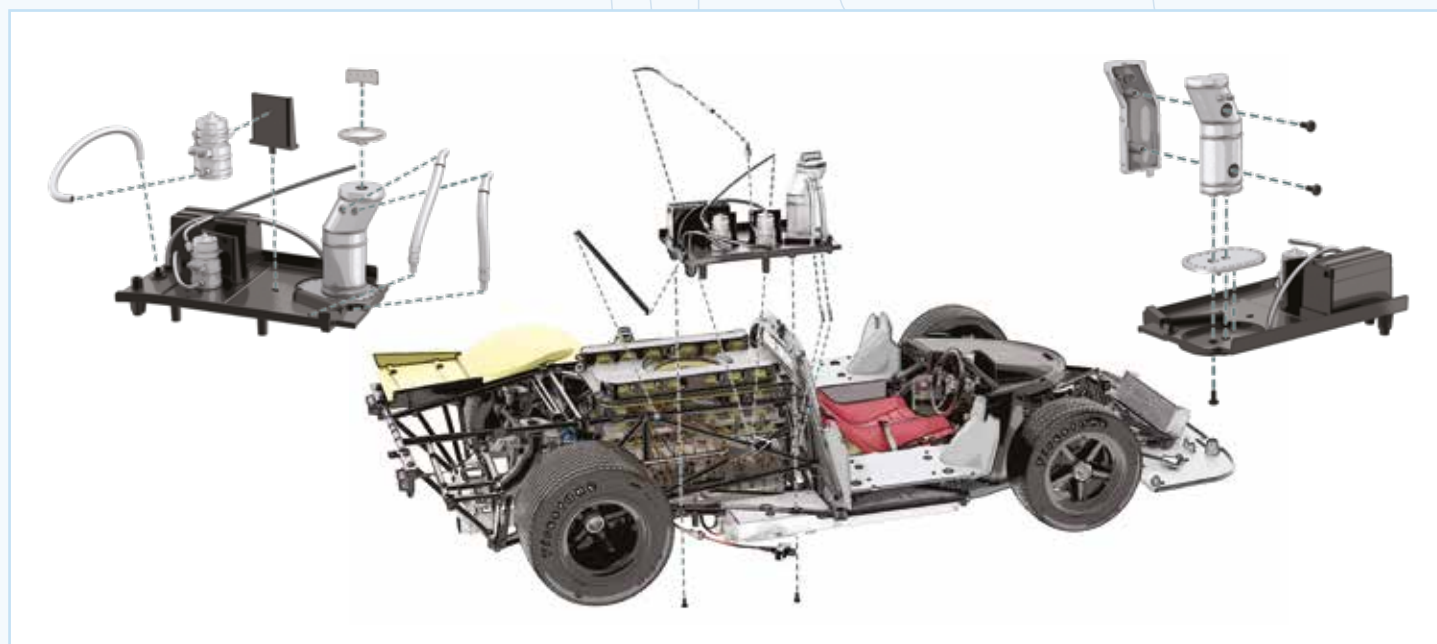
BM Screw M 2.0 x 4 mm (x 3)

AP Screw M 1.7 x 4 mm (x 4)



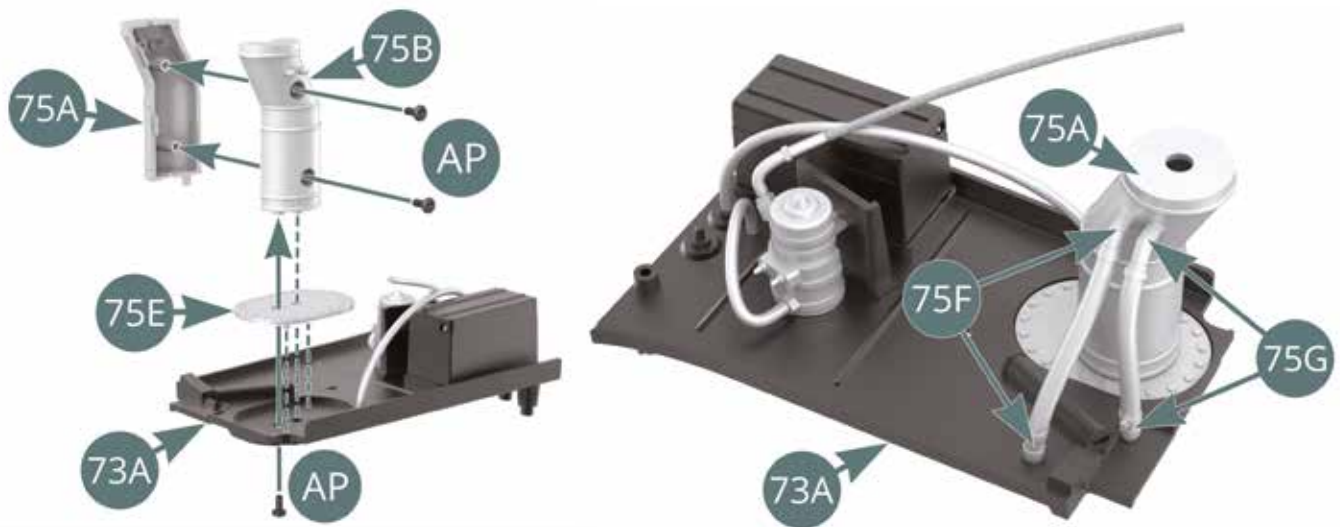
Assembly and mounting of the fuel pump and filler neck to the platform on the right side

ASSEMBLY DIAGRAM





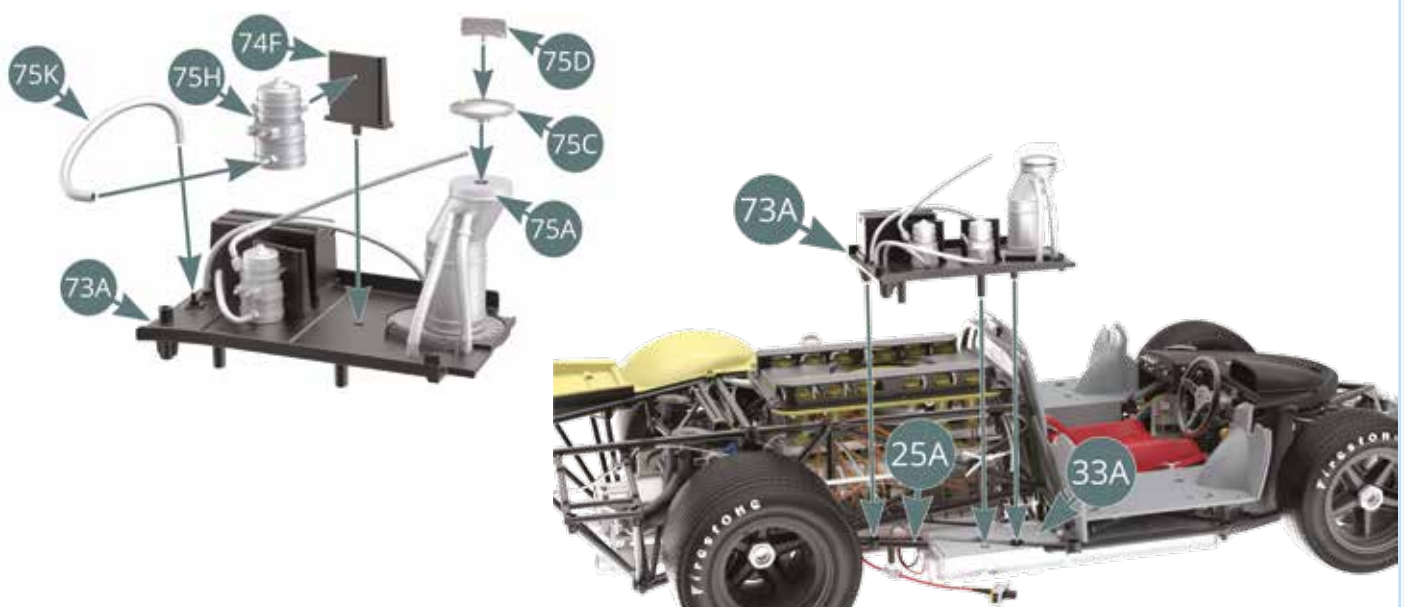
STEP 1



Assemble the two filler neck halves (75A & 75B) and secure with two AP screws. Position the filler neck (75B) on the right side platform (73A), inserting the tray (75E), and secure with an AP screw. Connect the discharge hoses (75F & 75G) to the filler neck (75A) and the nipples on the side platform.

STEP 2

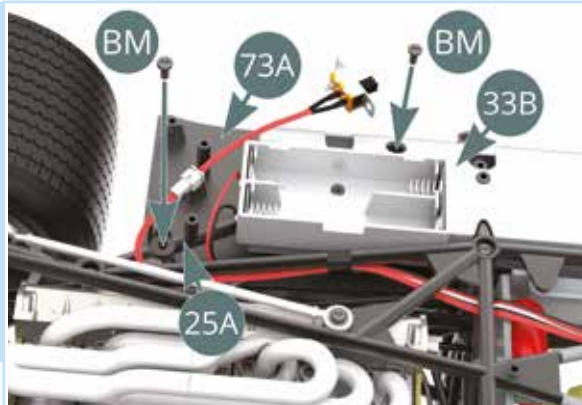
Position the handle (75D) on the filler cap (75C), then position the filler cap onto the filler neck (75A). Position the fuel pump (75H) on the protective shield (74F). Connect the fuel line (75K) to the pump (75H). Position the protective shield (74F) on the right side platform (73A) and connect the free end of the fuel line (75K) to the designated nipple. Position the right side platform (73A) on the crossbar of the lower frame (25A) and the top panel (33A) of the right fuel tank.



STEP 3

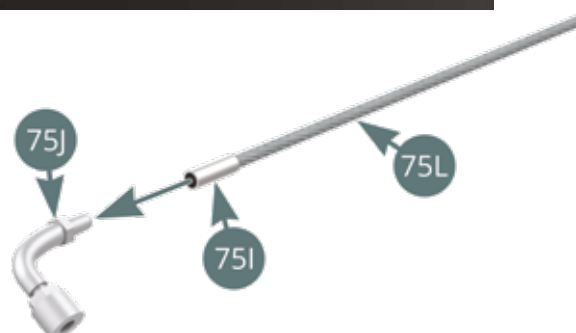
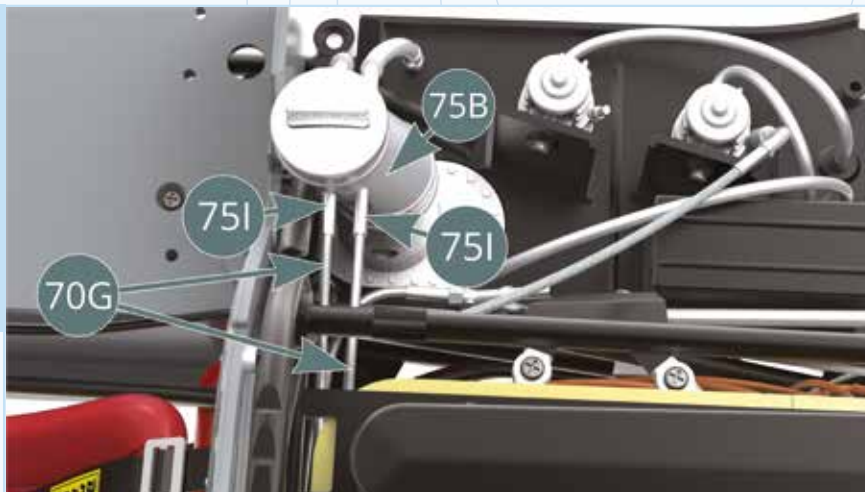
Position the oil hose (71H-1) and handle (71B) on the filler cap (71A).

Position the oil hose (71H-2) between the nozzle of the oil tank (71C) and the thermostat (71G).



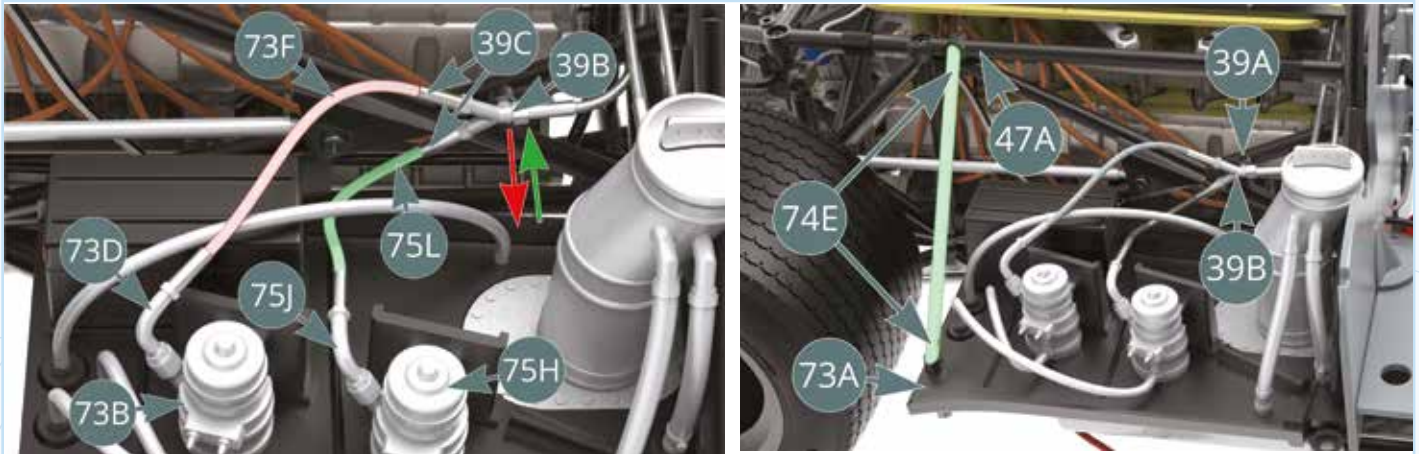
STEP 4

Connect the two shielded fuel lines (70G) to the nipples at the filler neck (75B) via the connectors (75I). Position the shielded fuel line (75L) onto the pump connector (75J) via the connector (75I).





STEP 5



Detach the oil hose (39B) from the frame (39A) - red arrow - to facilitate connection of the shielded fuel lines (73F & 75L) to the two connectors (39C). Position the pump connector (75J) onto the fuel pump (75H). Replace the hose (39B) on the frame bar (39A) - green arrow, illustrations above. Position the arm (74E) between the upper frame bar (47A) and the corner of the right side platform (73A) using the nipples provided.

GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 76

76A Right rear wheel arch

76B Rear brake cooling bailer

IM Screw M 1.7 x 3.5 mm (x 6)

BM Screw M 2.0 x 4 mm (x 4)



Installation of the right rear wheel arch

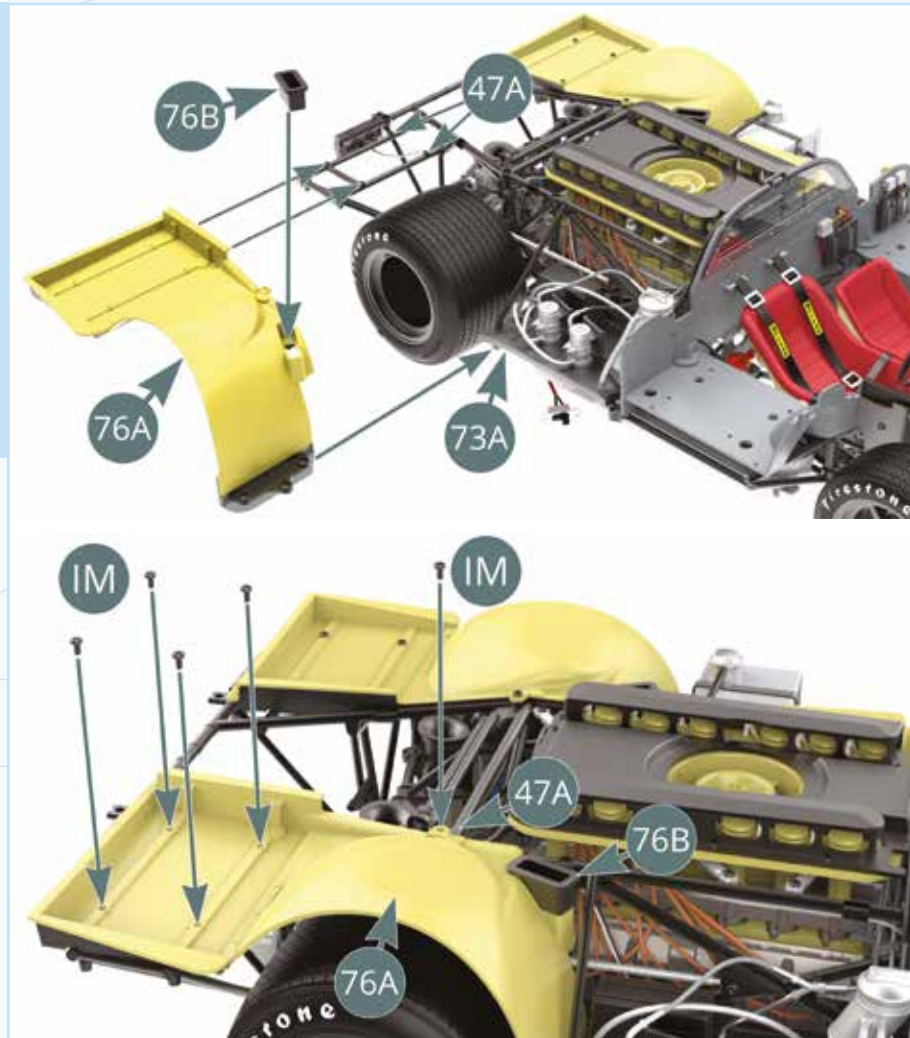
ASSEMBLY DIAGRAM





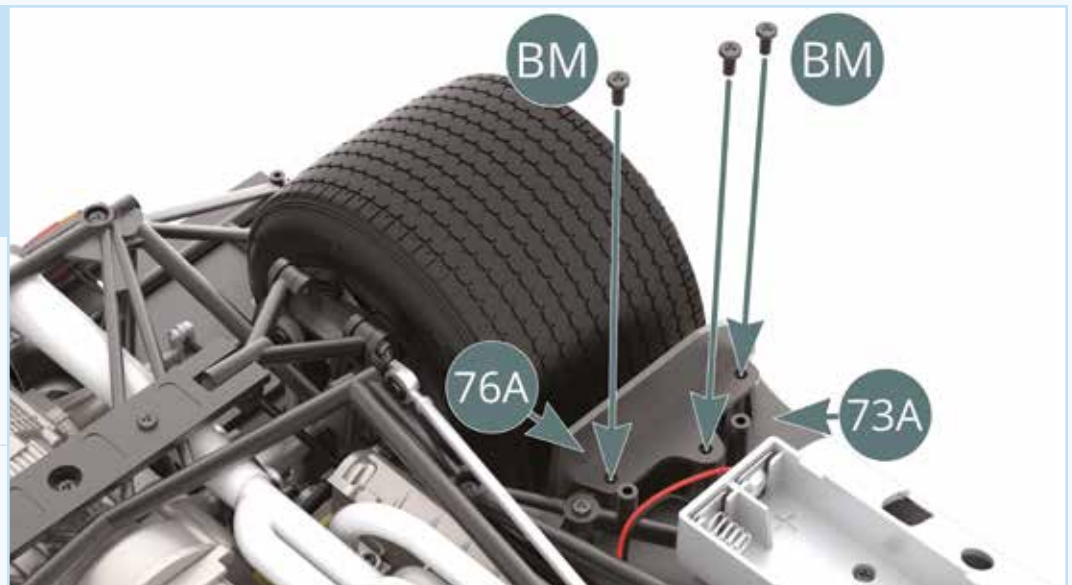
STEP 1

Position the rear brake cooling bailer (76B) on the right rear wheel arch (76A). Position the right rear wheel arch (76A) on the upper frame (47A), placing its front support under the right side platform (73A). Secure the right rear wheel arch (76A) to the upper frame (47A) with five IM screws.

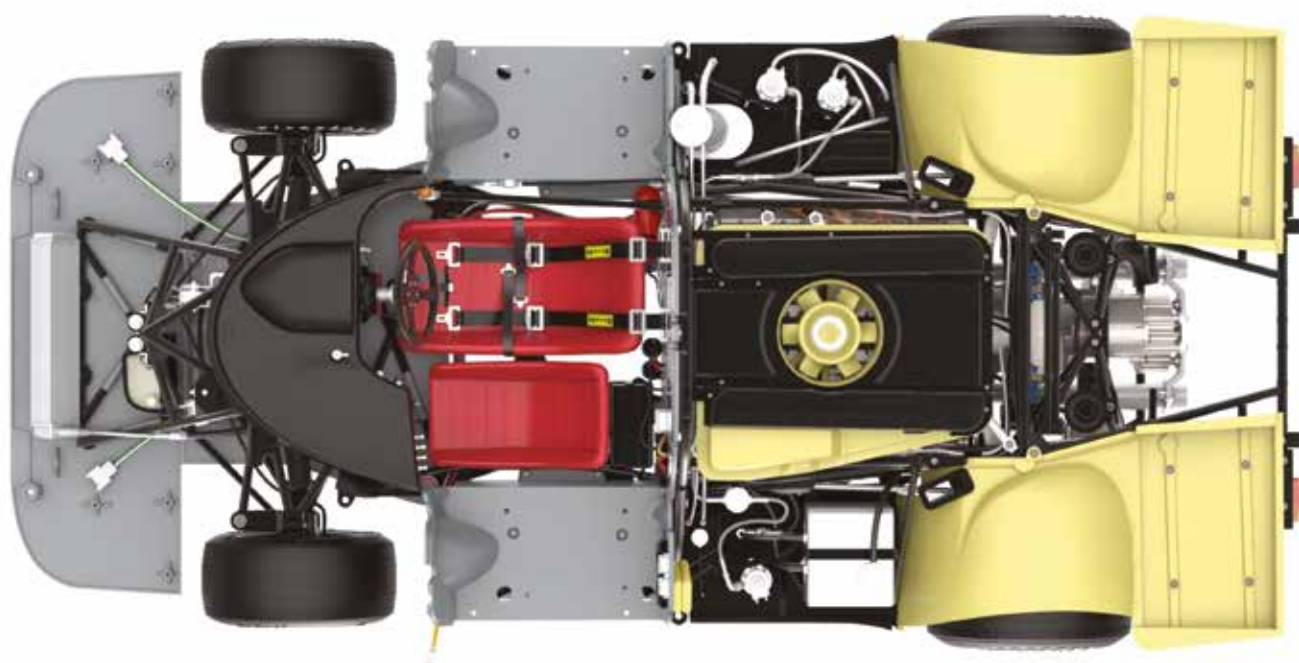


STEP 2

Flip the car over and attach the right rear wheel arch front bracket (76A) to the right side platform (73A) with three BM screws.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 77

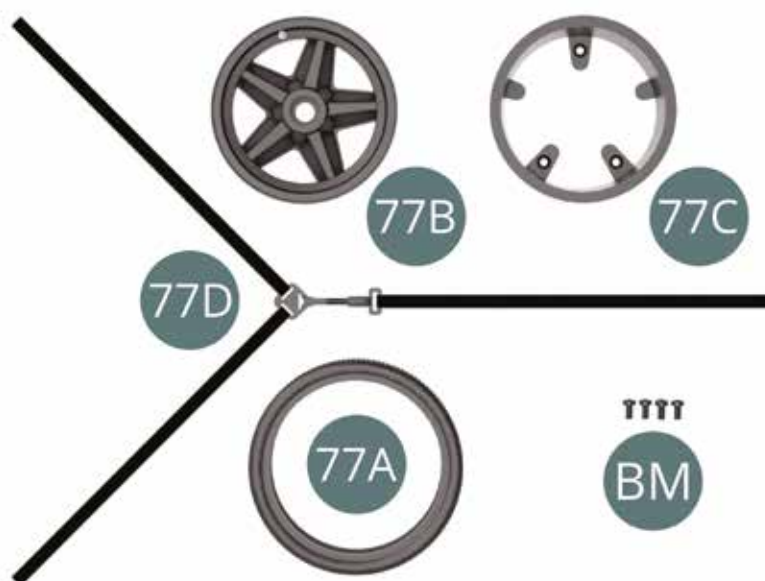
77A Spare tyre

77B Outer rim

77C Inner rim

77D Spare wheel strap

BM Screw M 2.0 x 4 mm (x 4)



Spare wheel assembly and installation

ASSEMBLY DIAGRAM



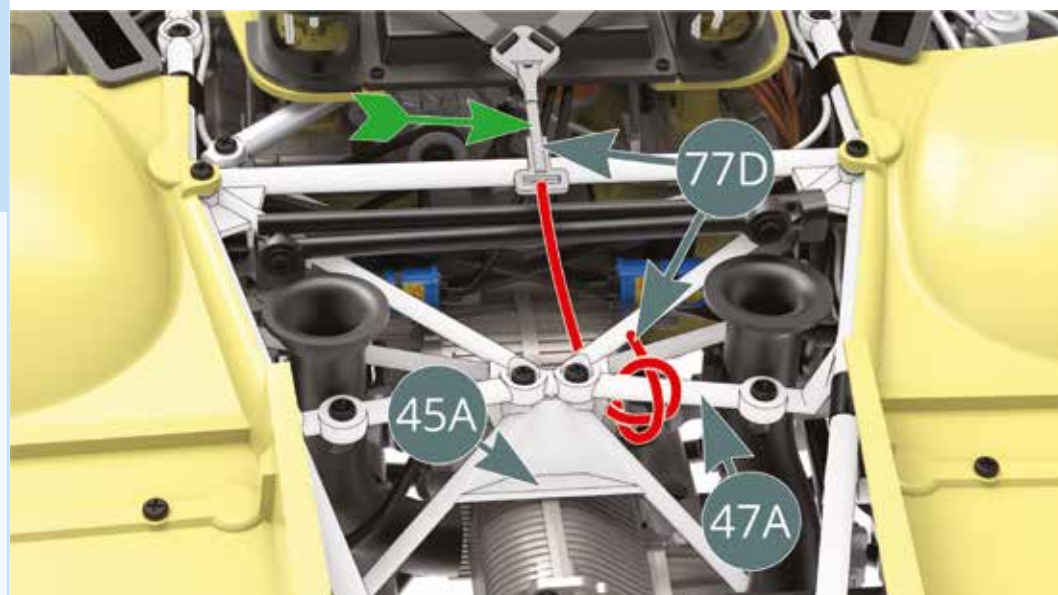
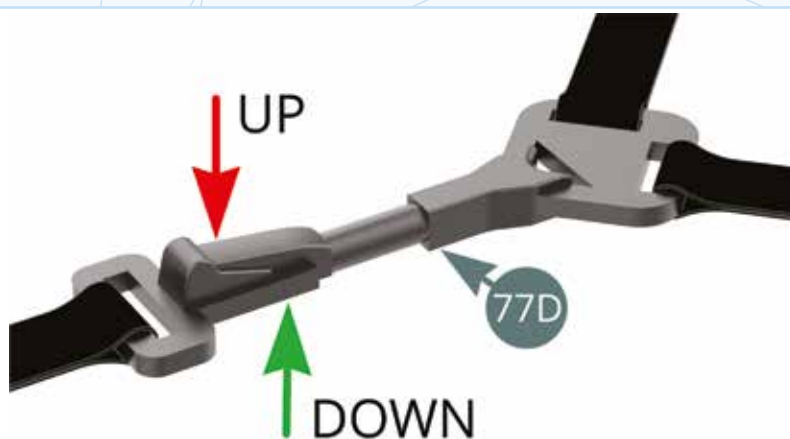
STEP 1



Position the outer wheel rim (77B) into the spare tyre (77A). Position the inner wheel rim (77C) into the spare tyre (77A), aligning it with the outer rim (77B) and secure it with three BM screws.

STEP 2

Check that the quick release lever is pointing upwards when the spare wheel strap (77D) will be attached on top of the spare wheel. Lay the spare wheel strap (77D) backwards with the quick release lever pointing downwards (green arrow) also see the following illustration. Tie the spare wheel strap (77D) to the upper frame bar (47A) - do not tighten the knot fully at this time. Mark the place for the spare wheel on the reinforcement frame (45A).

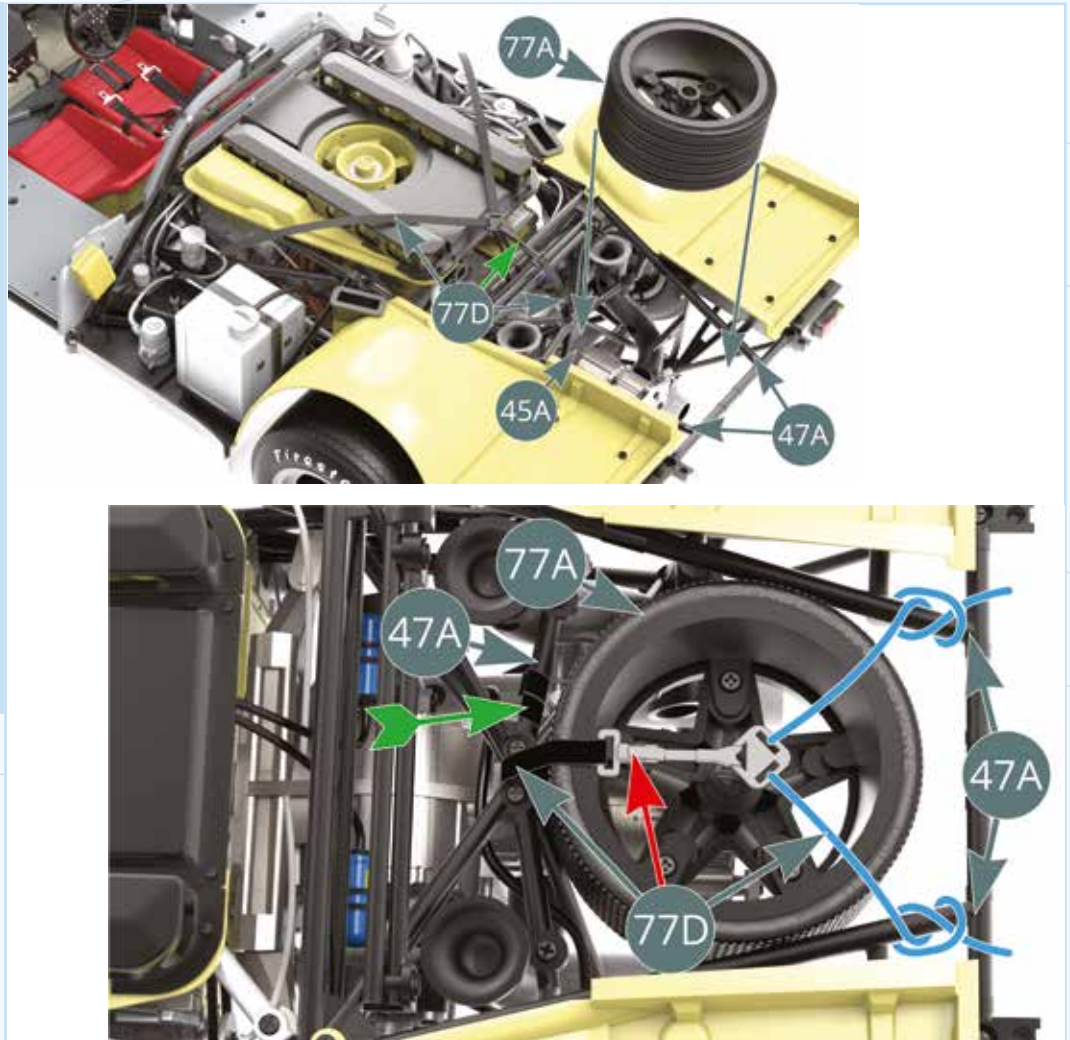




STEP 3

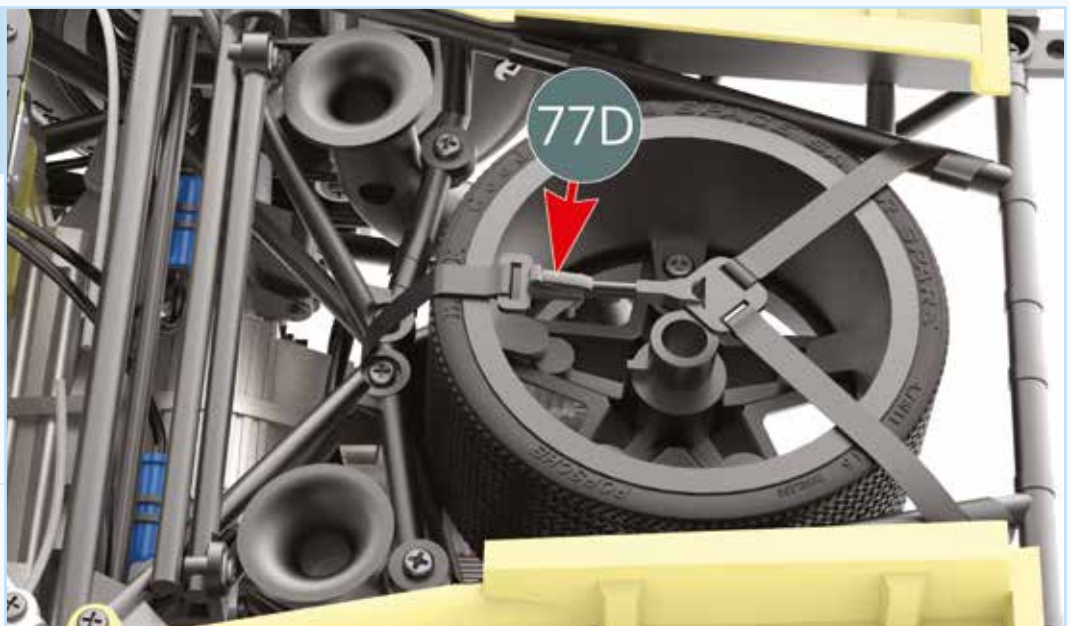
Position the spare wheel on the reinforcement frame (45A) and between the two upper frame bars (47A).

Tilt the spare wheel strap (77D) over the spare tyre (77A), with the quick release lever now pointing upwards - red arrow. Adjust the tightness of the knot on the upper frame bar (47A) - green arrow. Finish securing the spare wheel by tying the two free ends - shown in blue - of the spare wheel strap (77D) to the upper frame bars.



STEP 4

The spare wheel is secured with the spare wheel strap (77D) on top.



GENERAL VIEW





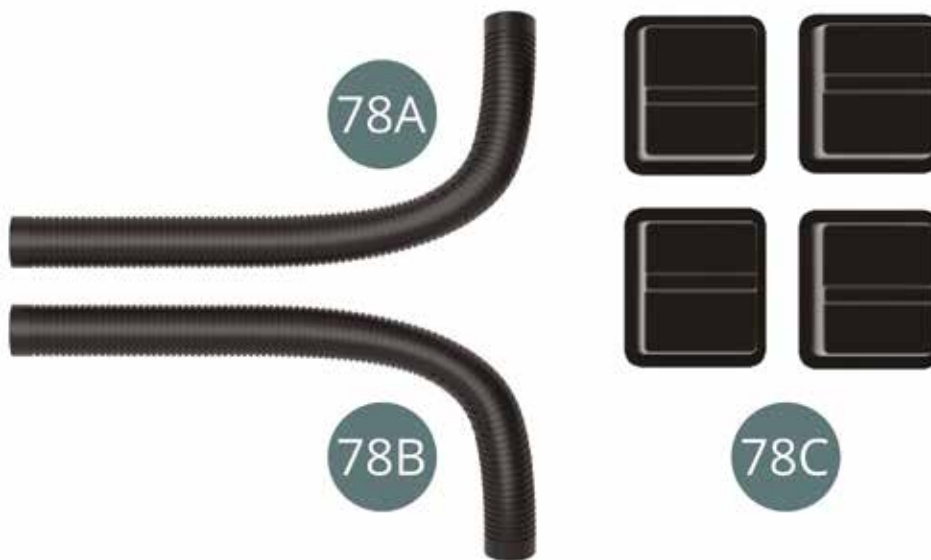
Assembly guide

PARTS OF THE ISSUE 78

78A Front left brake cooling jacket

78C Brake Support (x 4)

78B Front right brake cooling jacket



Fitting of front brake cooling jackets

ASSEMBLY DIAGRAM



STEP 1

Locate the air intake on the right brake bailer (30I) - seen here from below - located in the right front wheel.

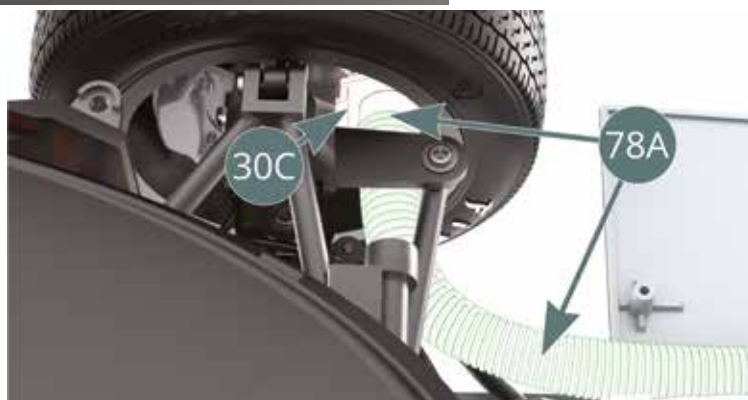
Position the right brake cooling jacket (78B) over the air intake on the right brake bailer (30I) - seen here from above.



STEP 2

Locate the air intake on the left brake scoop (30C) - seen here from below - located in the left front wheel.

Position the left brake cooling jacket (78A) over the air intake on the left brake scoop (30C) - seen here from above.





STEP 3

Adjust the right (78B) and left (78A) brake cooling jackets so that they rest in the right (green arrow) and left (red arrow) slots respectively at the front of the flat front floor (65A).



GENERAL VIEW





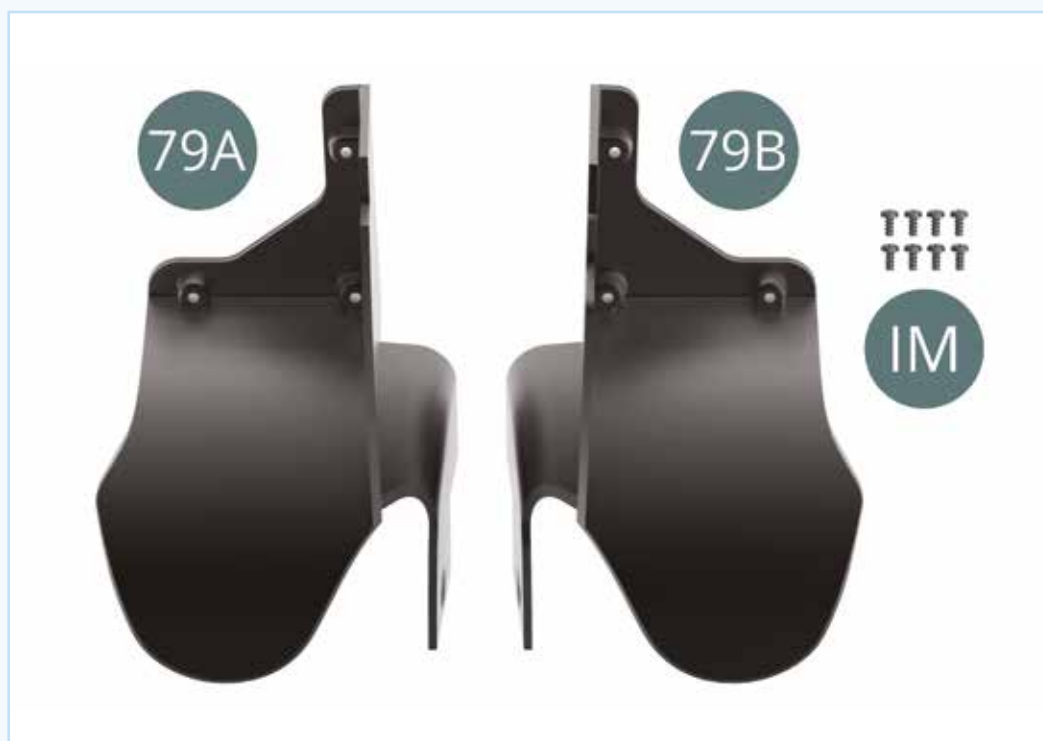
Assembly guide

PARTS OF THE ISSUE 79

79A Wheel arch, left

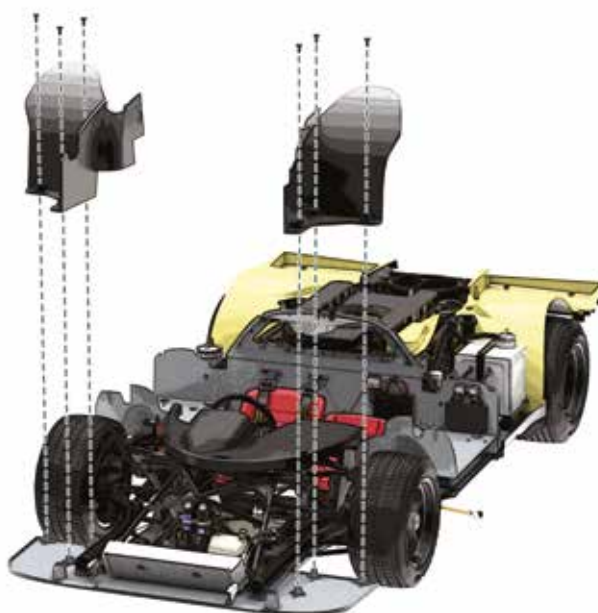
IM Screw M 1.7 x 3.5 mm (x 8)

79B Wheel arch, right



*Installation of front
right and front left
wheel arches*

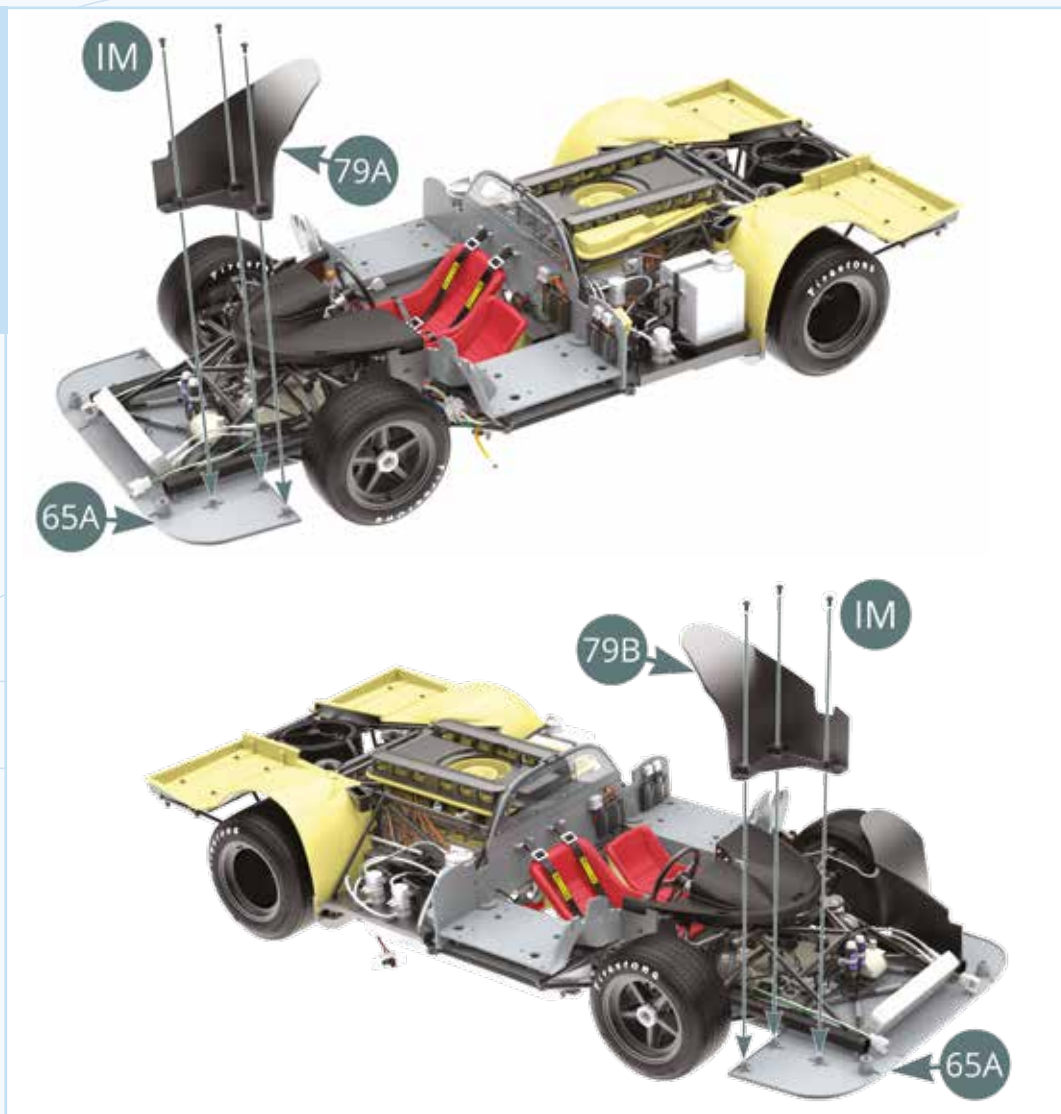
ASSEMBLY DIAGRAM





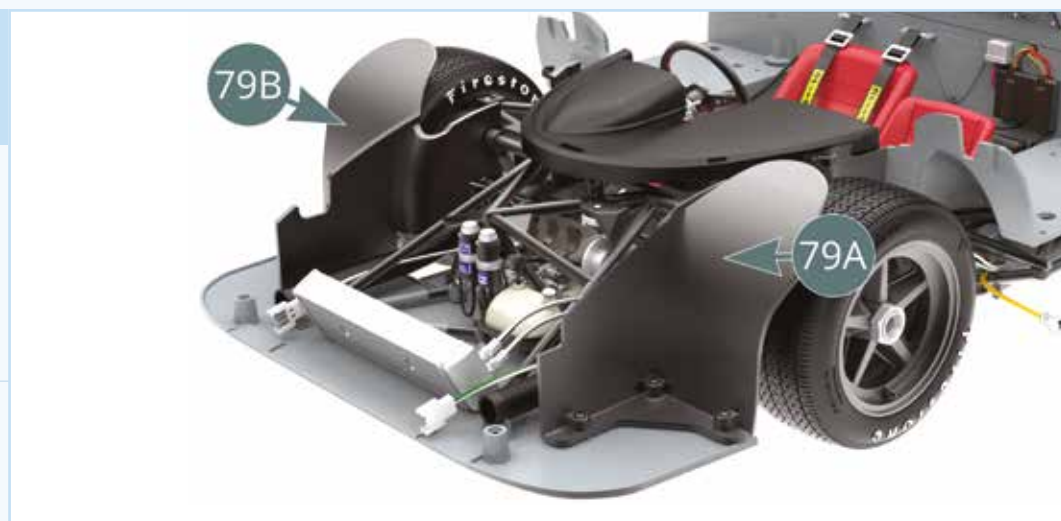
STEP 1

Position the left wheel arch (79A) on the front flat floor (65A) and fix it with three IM screws. Position the right wheel arch (79B) on the front flat floor (65A) and secure with three IM screws.



STEP 2

The right (79B) and left (79A) wheel arches are attached to the frame.



GENERAL VIEW

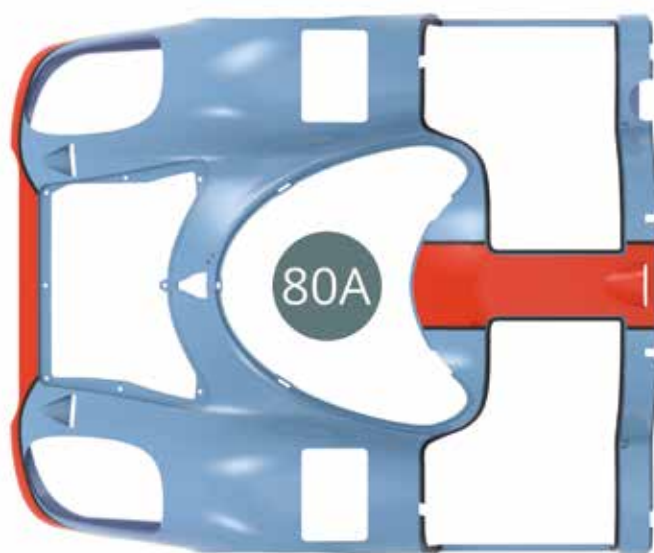




Assembly guide

PARTS OF THE ISSUE 80

80A Bodywork



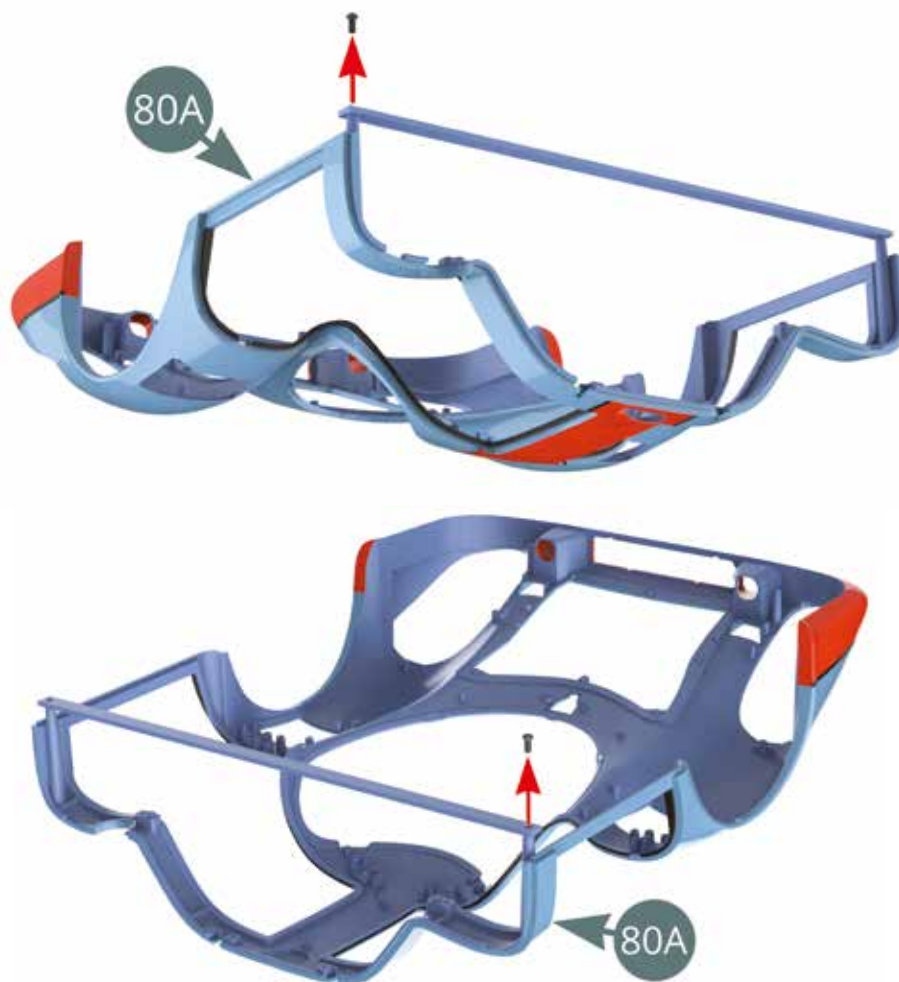
*Bodywork
preparation*

ASSEMBLY DIAGRAM



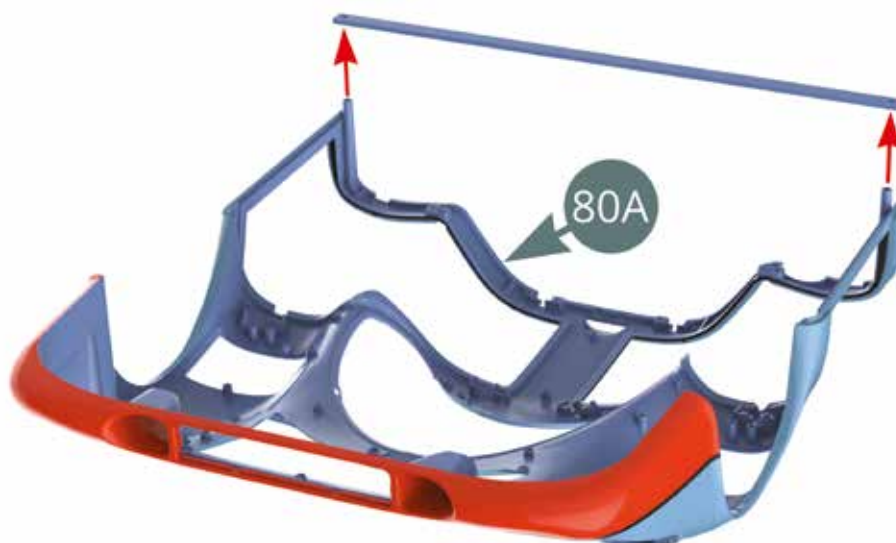
STEP 1

Upturn 80A Bodywork and undo screws on right and left sides of Protection plank (upper and lower illustrations).



STEP 2

Remove Protection plank from 80A Bodywork.





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 81

81A Right headlight plexiglass nacelle

81B Right headlight housing

81C Big headlight bezel

81E Big headlight lens

81F Small headlight housing (R)

81G Small headlight lens

81H Left headlight protection (x2)

81I Right headlight protection (x2)

81D Big headlight reflector

AP M1,7 x4mm (x3)

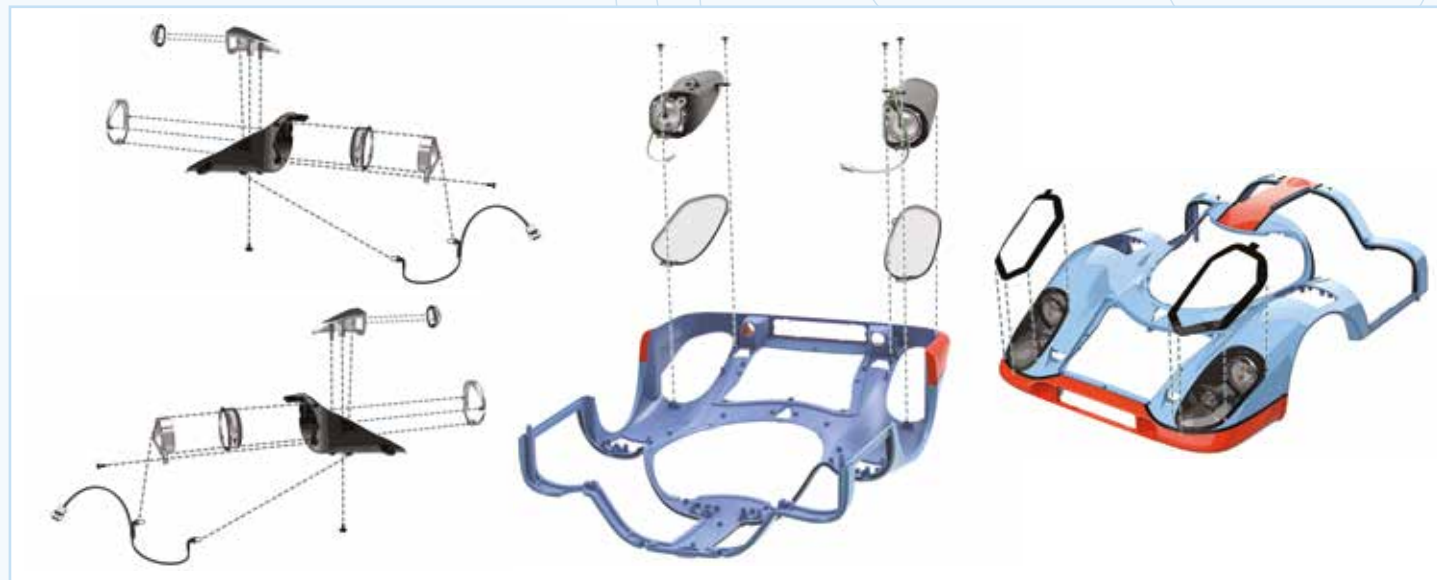
BP M1,7 x4x5mm (x3)

HM M1,7 x4x6mm (x5)



Headlights assembly and attachment

ASSEMBLY DIAGRAM





STEP 1

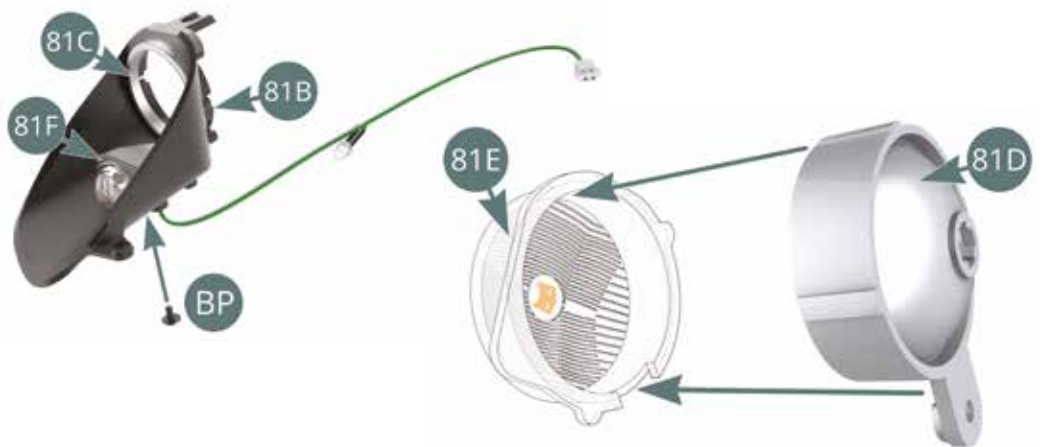
Attach 81G Small headlight lens to 81F Small headlight housing (R).



Take one of two 35F Headlight LED cables, pass its endmost LED through 81B Right headlight housing, and plug it into 81F Small headlight housing (R).

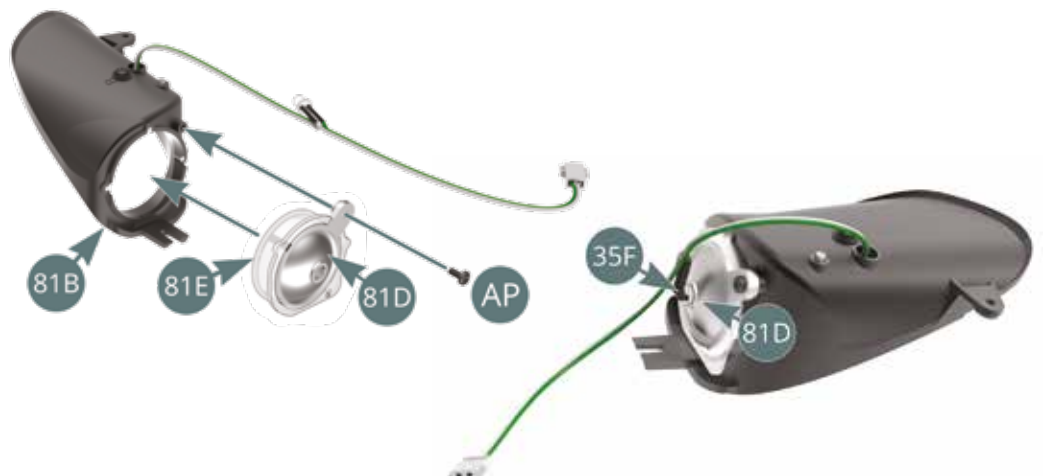
STEP 2

Attach 81F Small headlight housing (R) to 81B Right headlight housing and fasten with BP screw. Fit 81C Big headlight bezel to 81B Right headlight housing. Fit 81D Big headlight reflector into 81E Big headlight lens cup.



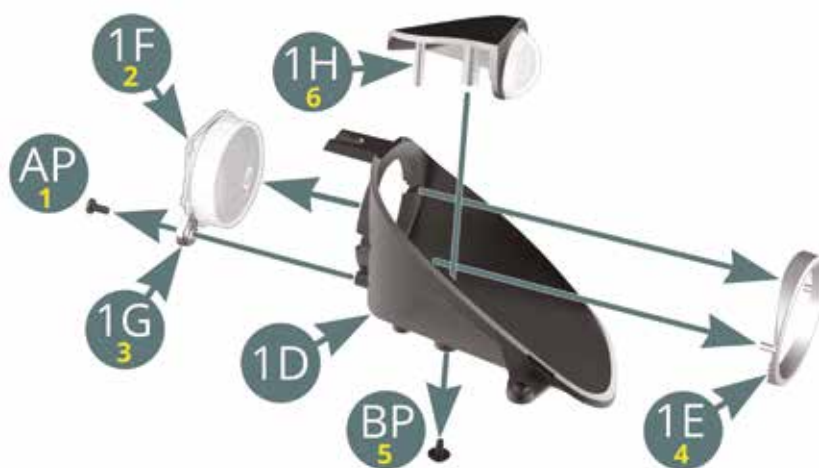
STEP 3

Attach 81D Big headlight reflector (with 81E Big headlight lens on it) to 81B Right headlight housing and fasten with AP screw. Plug the second LED of 35F Headlight LED cable into 81D Big headlight reflector.



STEP 4

Right side Headlight is preassembled



In order to attach LED Cable to Left side Headlight, we need to partially disassemble it first. Disassembly order is marked by yellow digits on the above diagram.

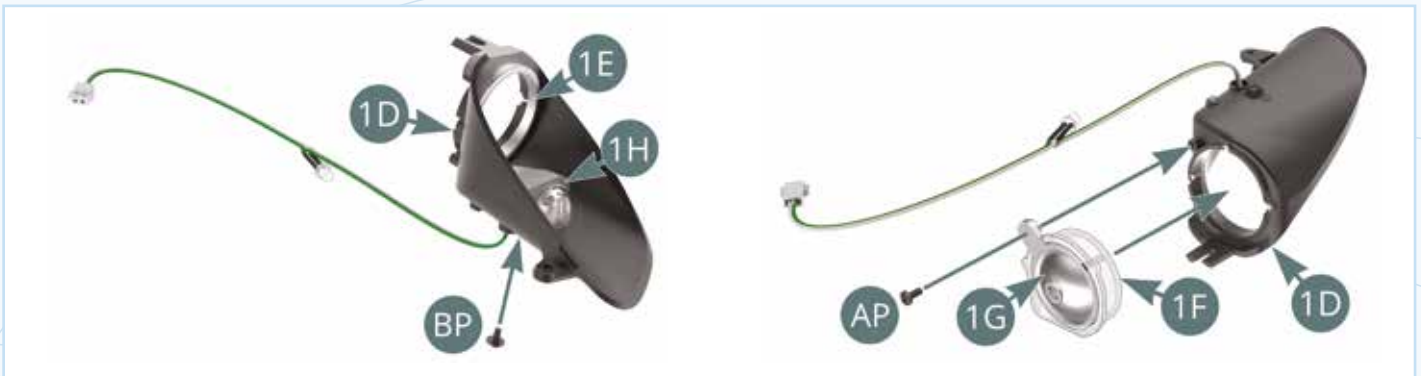
STEP 5



Take remaining 35F Headlight LED cable, pass its endmost LED through new 1D Left headlight housing, and plug it into 1H Small headlight housing.



STEP 6



Attach 1H Small headlight housing to new 1D Left headlight housing and fasten with BP screw. Fit 1E Big headlight bezel to 1D Left headlight housing. Attach 1G Big headlight reflector (with 1F Big headlight lens on it) to 1D Left headlight housing and fasten with AP screw.

STEP 7

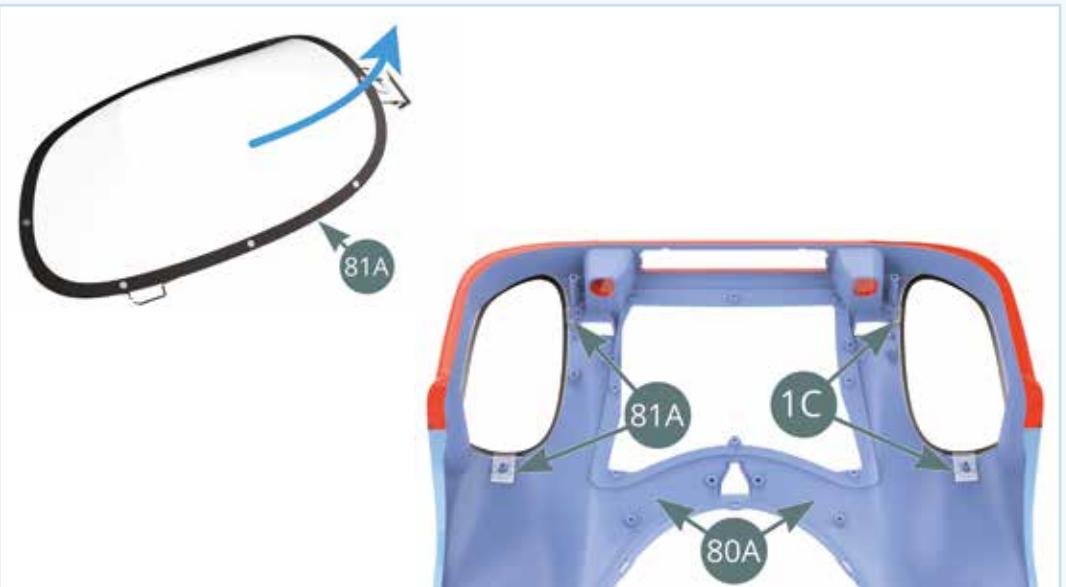
Plug the second LED of 35F Headlight LED cable into 1G Big headlight reflector.



Left side Headlight is preassembled

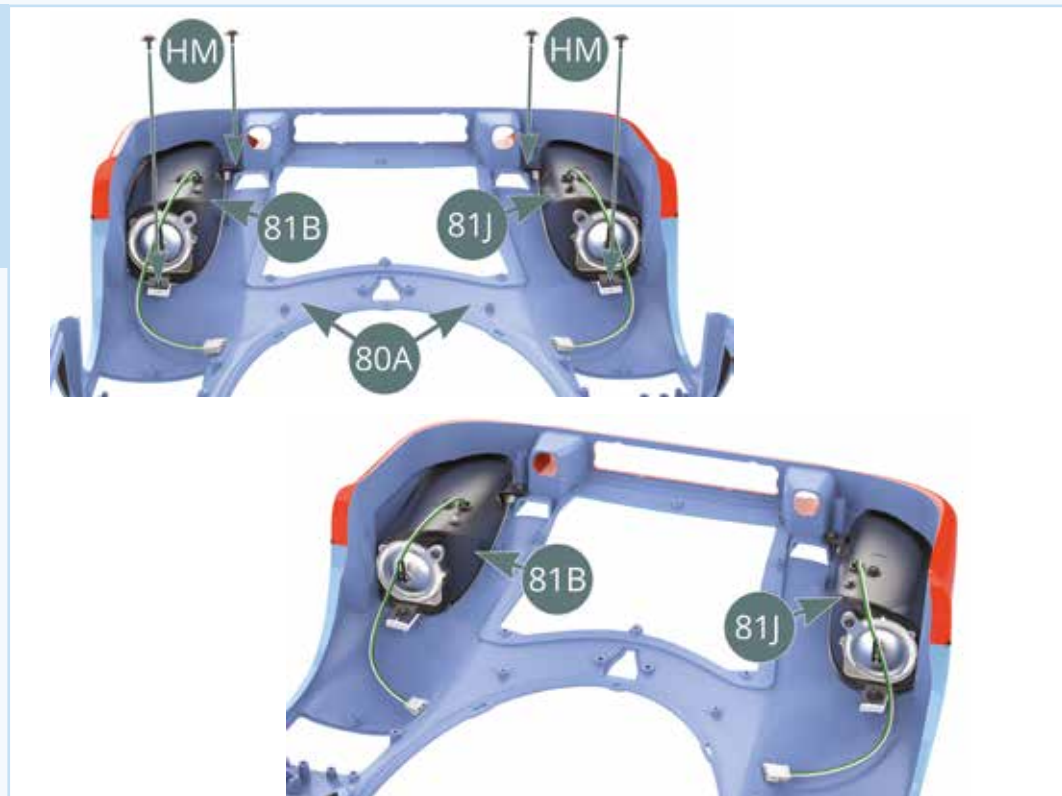
STEP 8

Detach the protective film from 81A Right headlight plexiglass nacelle. Attach 81A Right and 1C Left headlight plexiglass nacelles to their places on the inner side of 80A Bodywork.



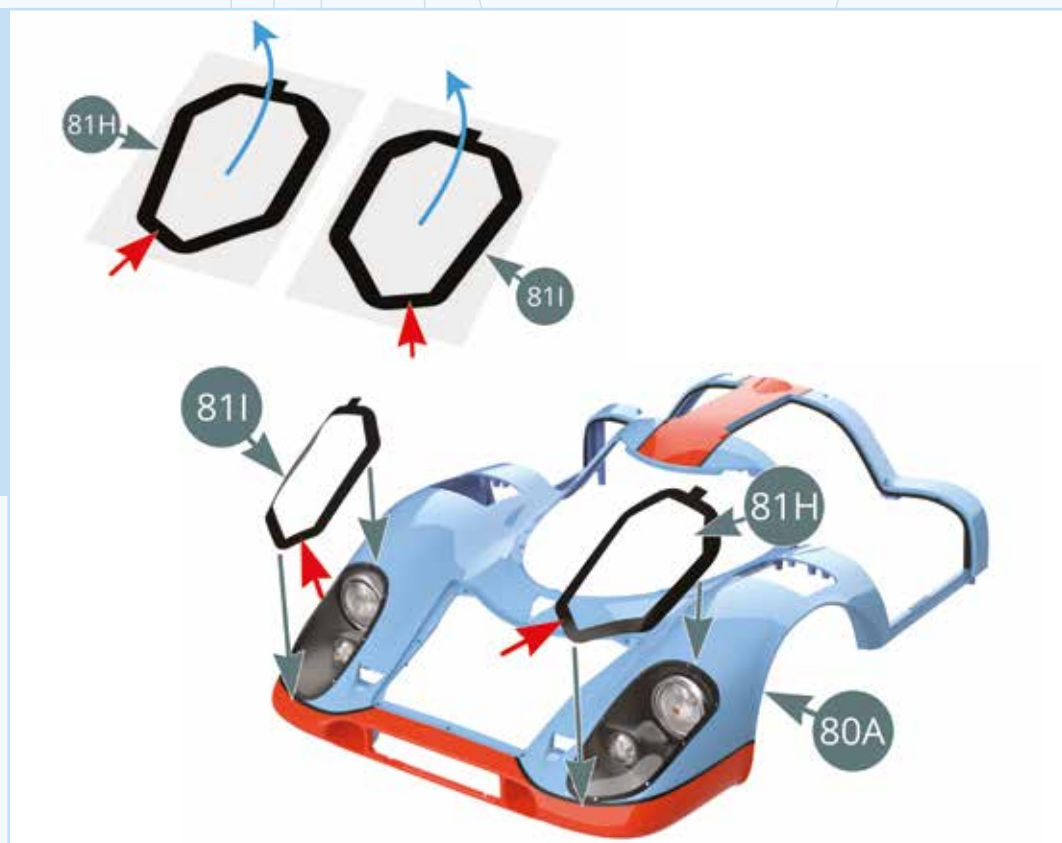
STEP 9

Place 81B Right and 81J Left headlight housings over Plexiglass nacelles and fasten to 80A Bodywork with four HM screws (upper and lower illustrations).



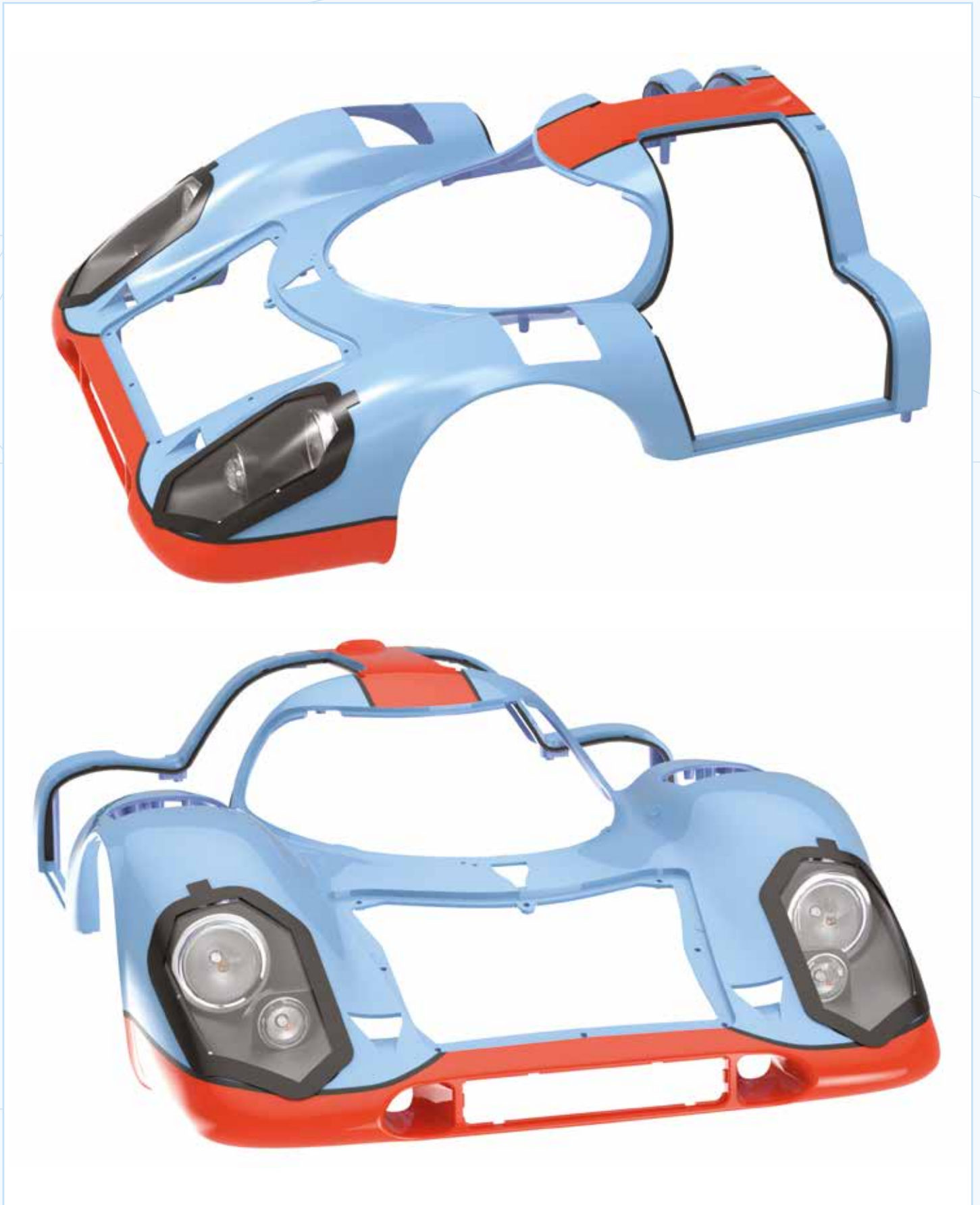
STEP 10

Raise 81H Left headlight protection sticker off the backing paper, orient it over black left Headlight perimeter and apply. Be aware that the transparent film will remain a bit wrinkled over the Headlight surface, as in real life appearance. Repeat same procedure for 81I Right headlight protection sticker.





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 82

82A Air intake mesh

82B Left air scoop

82C Right air scoop

82D Left air build up release grid

82E Right air build up release grid

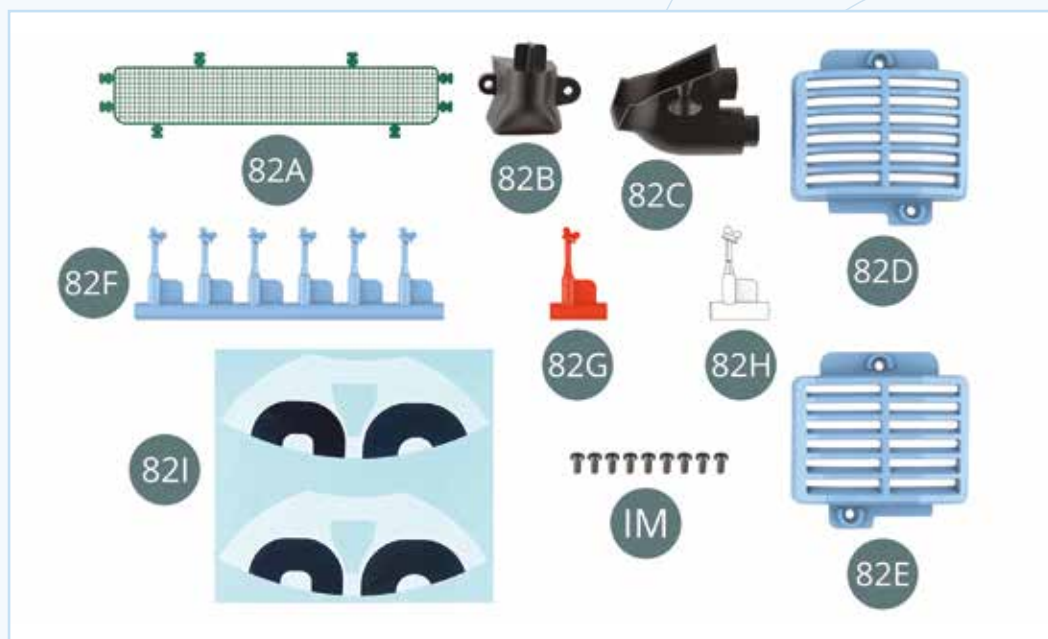
82F Hood cover lock (blue, x6)

82G Hood cover lock (orange)

82H Hood cover lock (white)

82I Decal (x2)

IM M1,7 x3,5mm (x9)



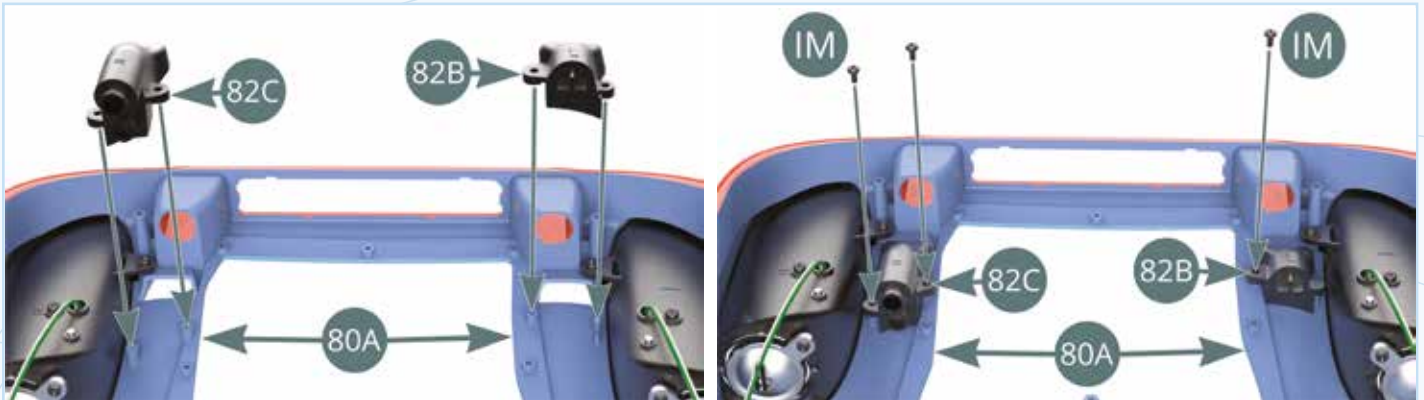
*Bodywork fittings and
decal attachment*

ASSEMBLY DIAGRAM





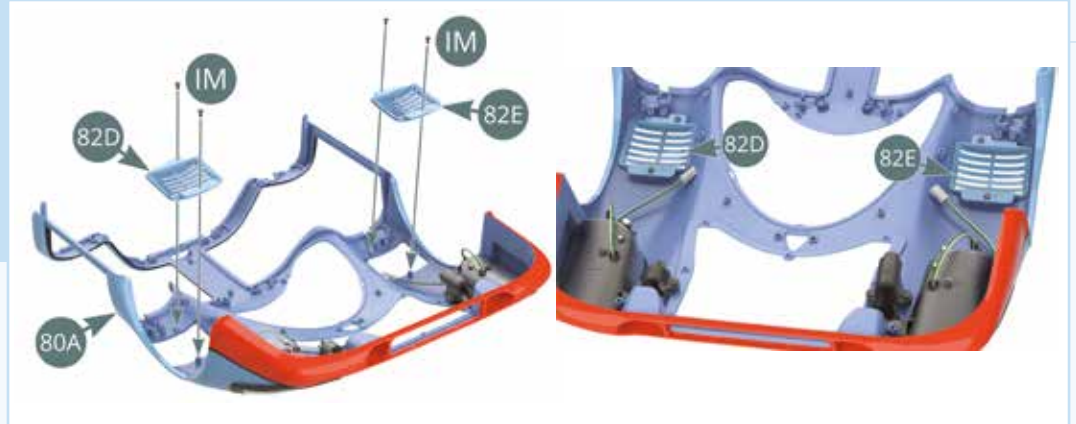
STEP 1



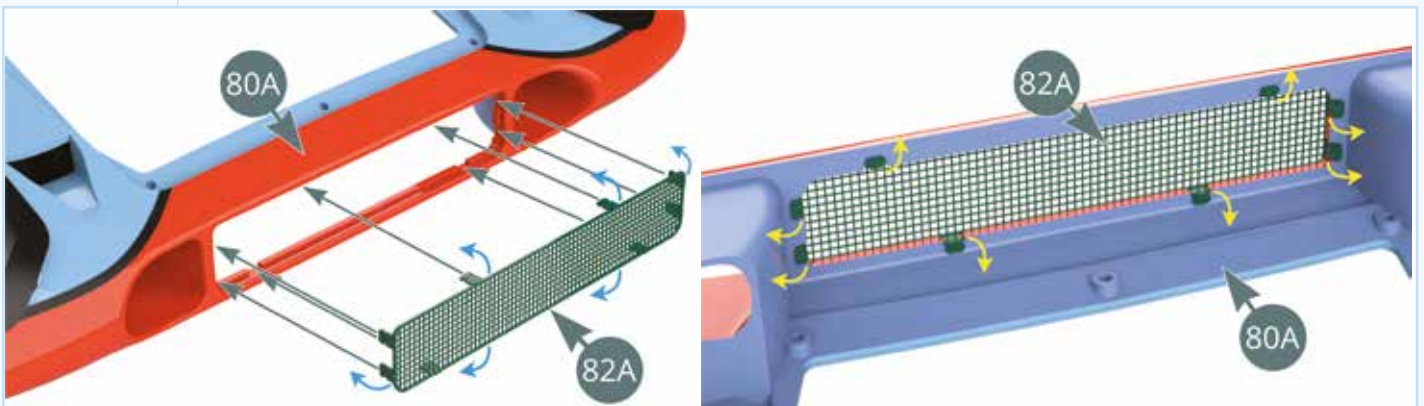
Attach 82C Right and 82B Left air scoops to the front inner side of 80A Bodywork and fasten with three IM screws (upper illustrations).

STEP 2

Attach 82E Right and 82D Left air build up release grids to the inner side of 80A Bodywork and fasten with four IM screws (opposite illustrations.)



STEP 3



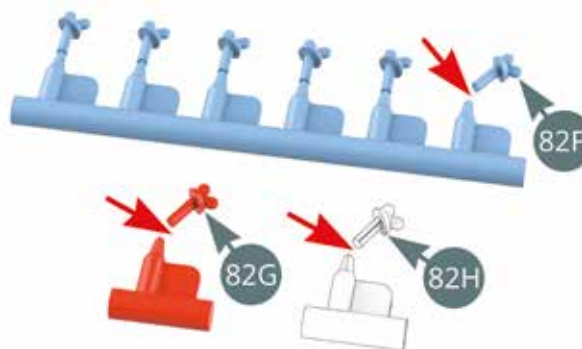
Bend eight perimeter tabs at right angle to 82A Air intake mesh and insert it into 80A Bodywork front opening. From the inner side, again bend eight perimeter tabs at right angle to anchor 82A Air intake mesh to 80A Bodywork front opening.

STEP 4

82A Air intake mesh is attached to the Bodywork



Nip off 82F, 82G and 82H Hood cover locks off the sprues.

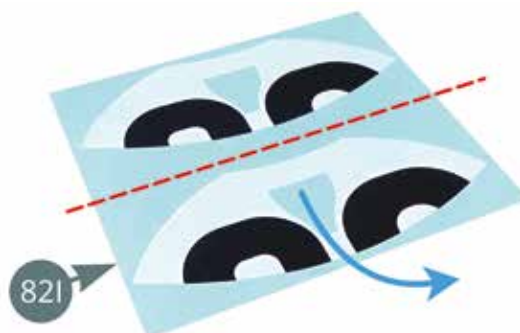


STEP 5

Attach temporarily 1B Hood cover on four 82F Hood cover locks (blue) to 80A Bodywork.



Cut off one set of 82I Decal, put in water for about 60 seconds, and slide carefully on 80A Bodywork to match the number 20 on 1B Hood cover (next illustration).





STEP 6

While 82I Decal is well wet, move it to adjust to the number 20 image below, allowing its lower edge to overlap on 1B Hood cover (dotted red line). Once aligned, remove four 82F Hood cover locks, and lift away 1B Hood cover.



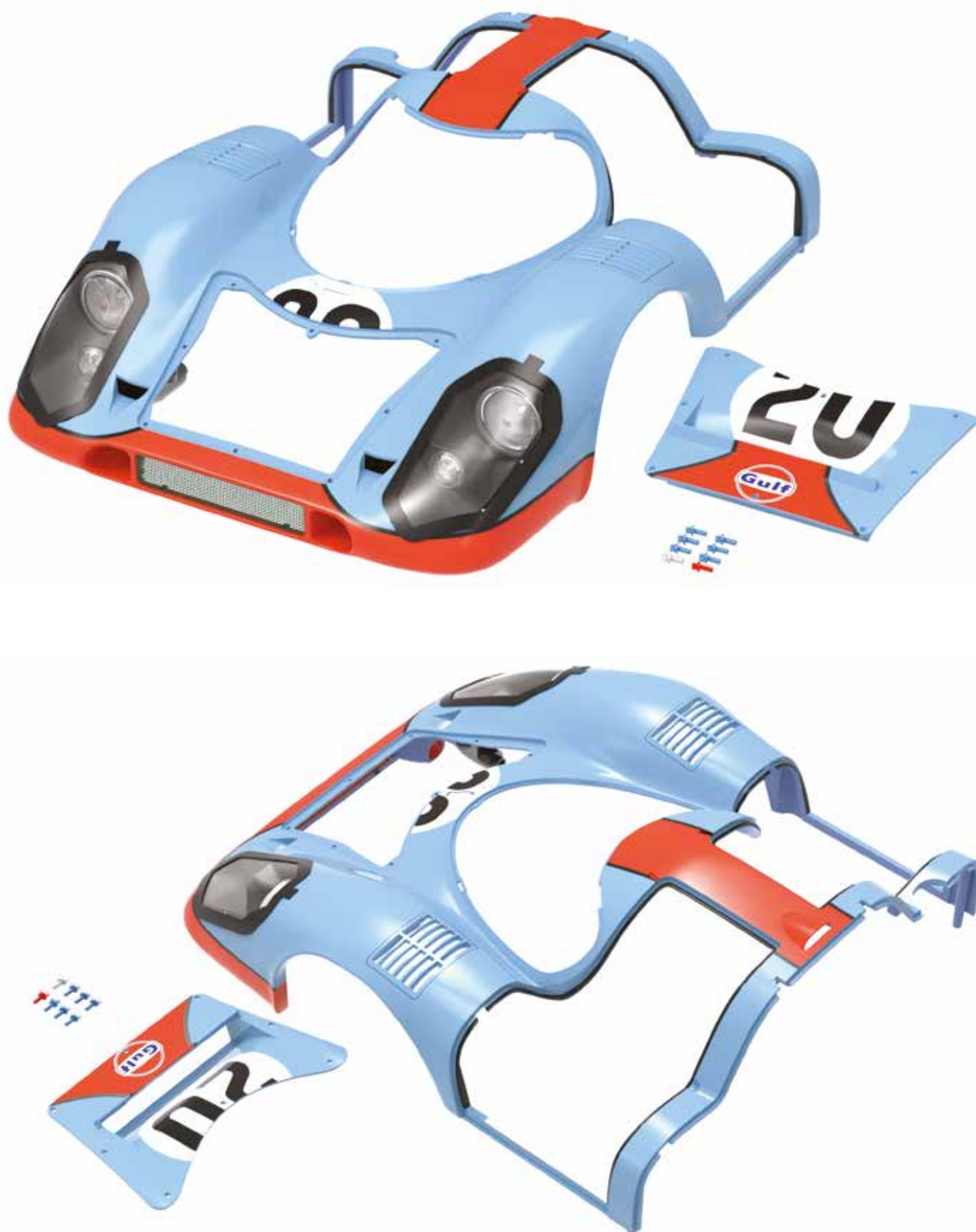
Smooth on 82I Decal lower edge to 80A bodywork and allow 3 minutes for it to set. Using super soft cotton pads remove remaining water from the decal without disturbing its position. Leave decal to set. Puncture with needle two holes in upper area as two red arrows show.

STEP 7

Accessories and decal are attached to the Bodywork (Hood cover is shown temporarily in place)



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 83

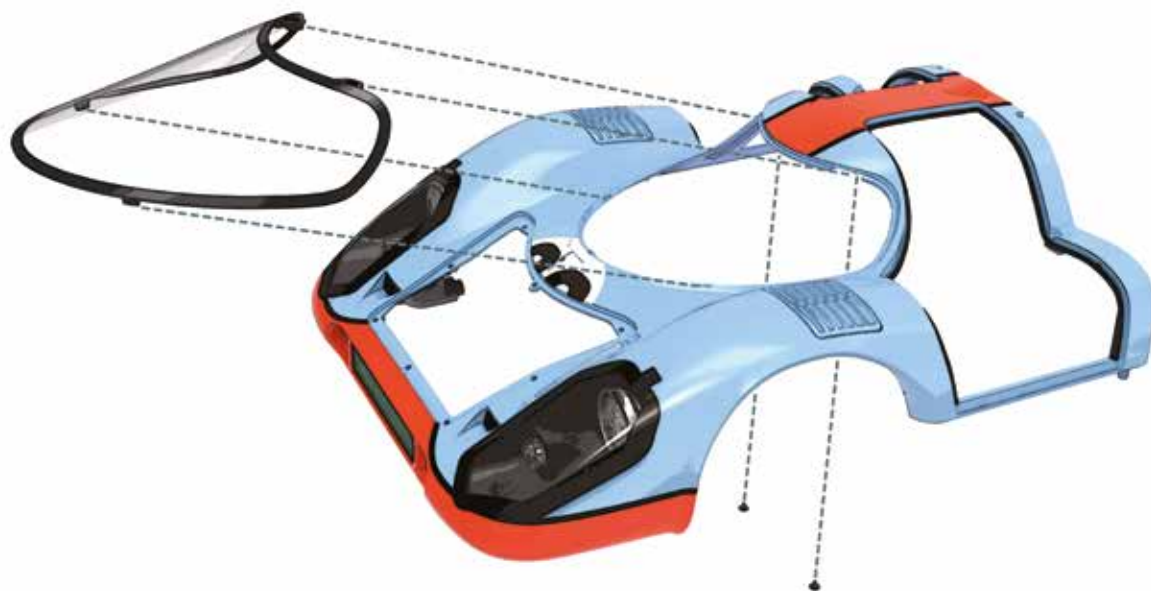
83A Windscreen

KM M1,7 x3x5mm (x3)

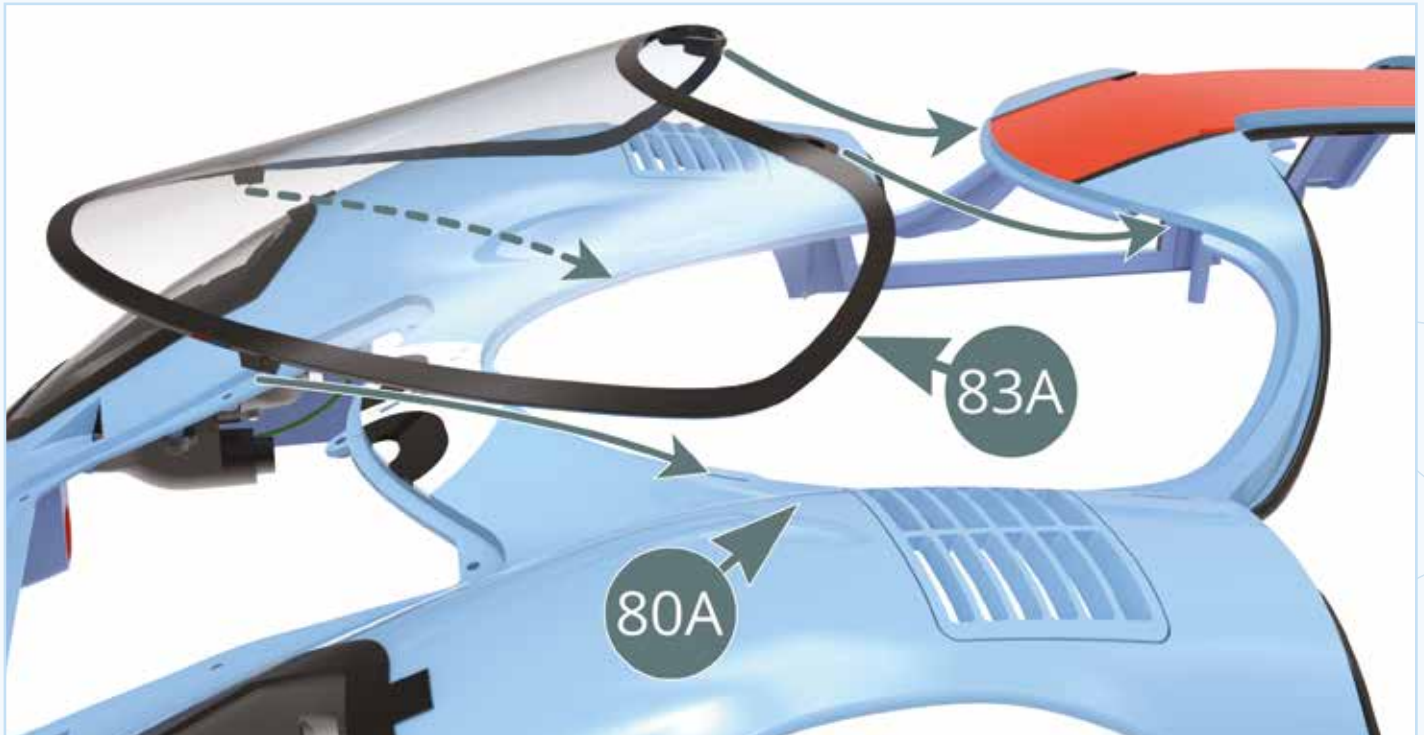


Windscreen
attachment

ASSEMBLY DIAGRAM

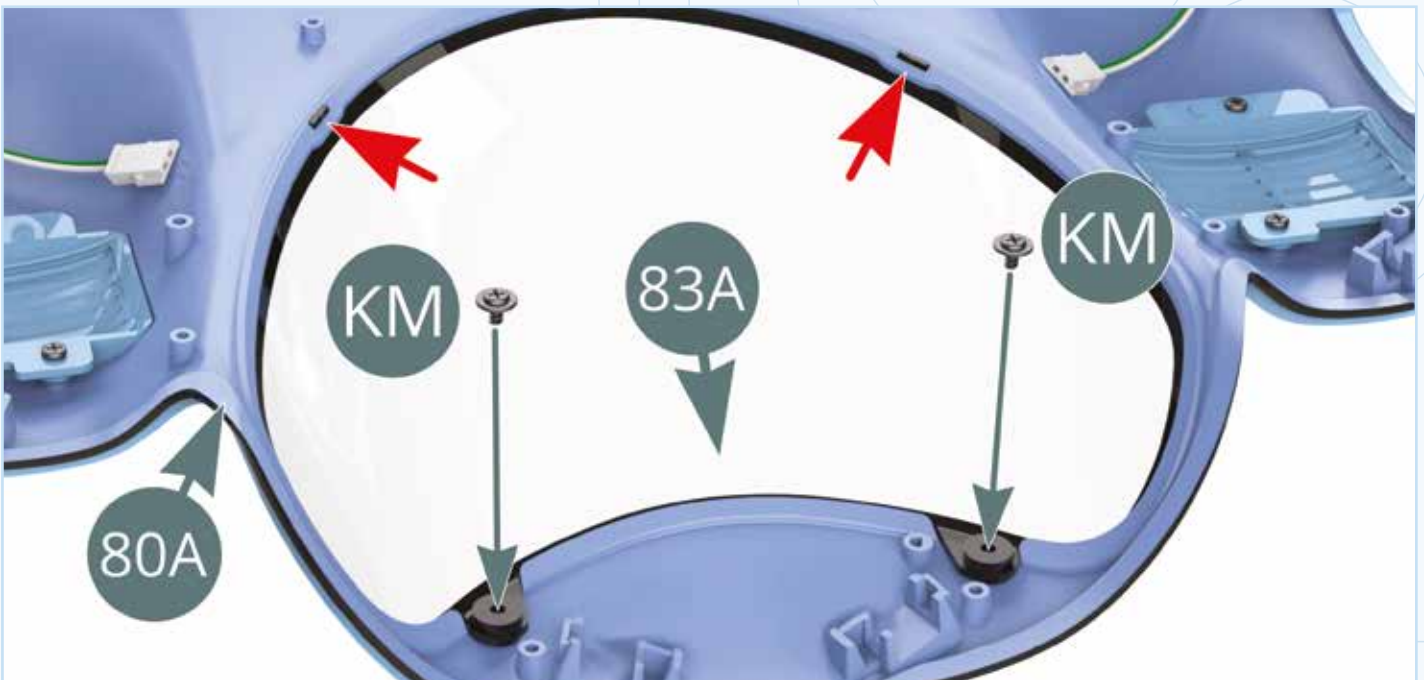


STEP 1



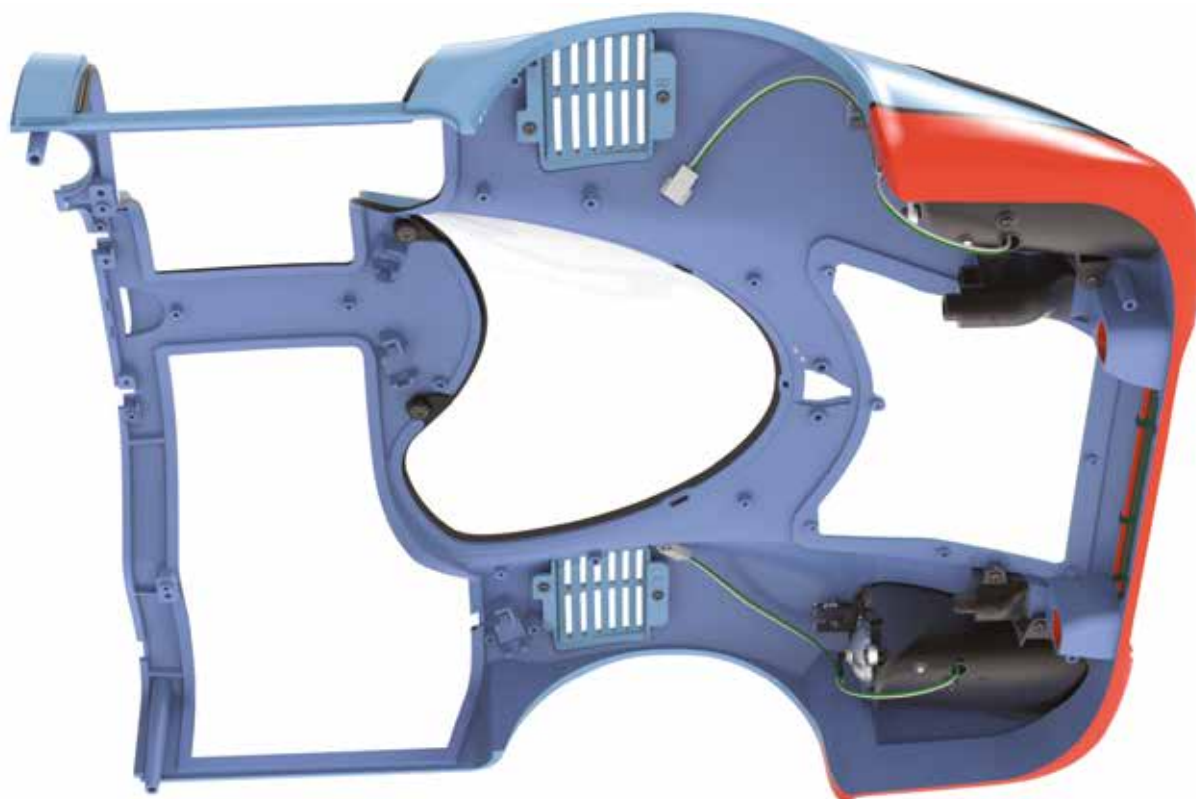
Attach 83A Windscreen to 80A Bodywork.

STEP 2



Make sure that two tabs of 83A Windscreen enter into respective slots on 80A Bodywork (red arrows), and fasten it with two KM screws.

GENERAL VIEW



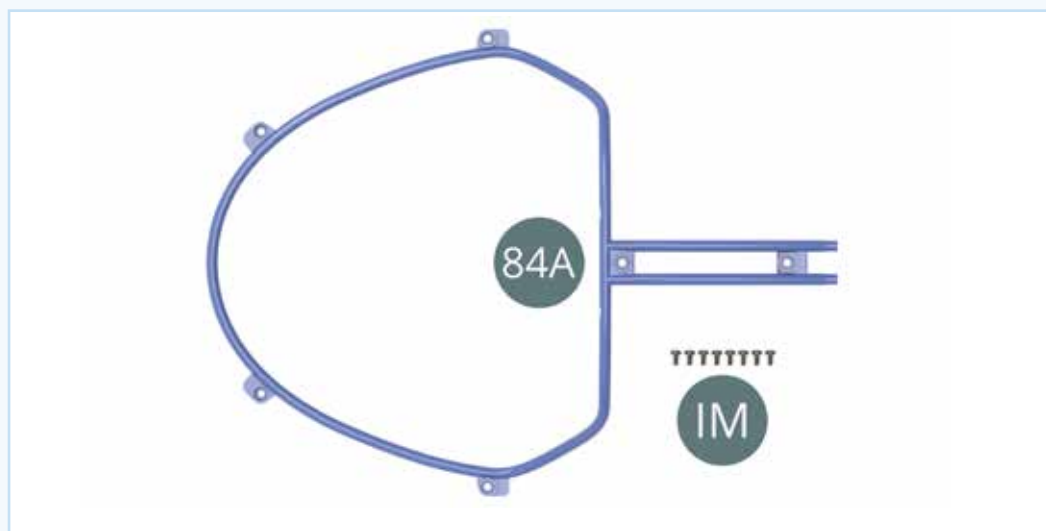


Assembly guide

PARTS OF THE ISSUE 84

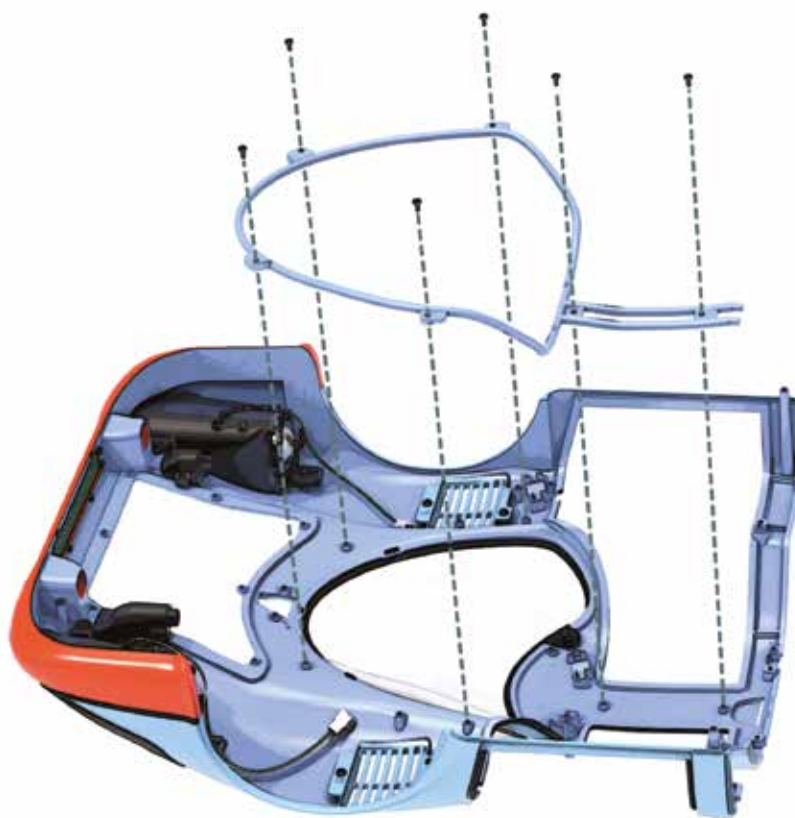
84A Top roll cage

IM M1,7 x3,5mm (x8)



Top roll cage
attachment

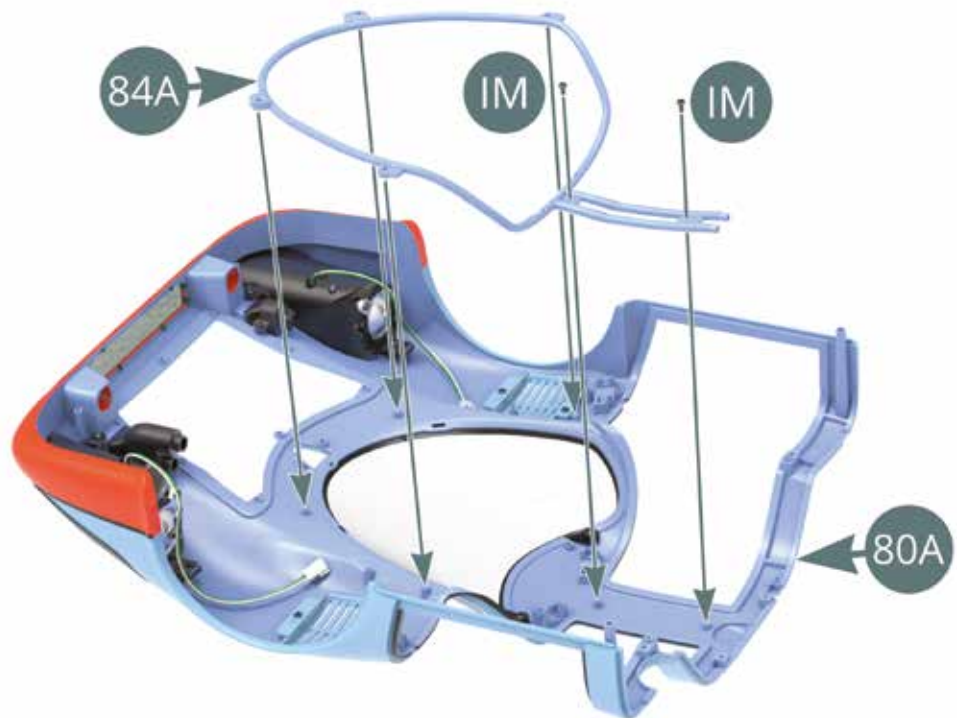
ASSEMBLY DIAGRAM





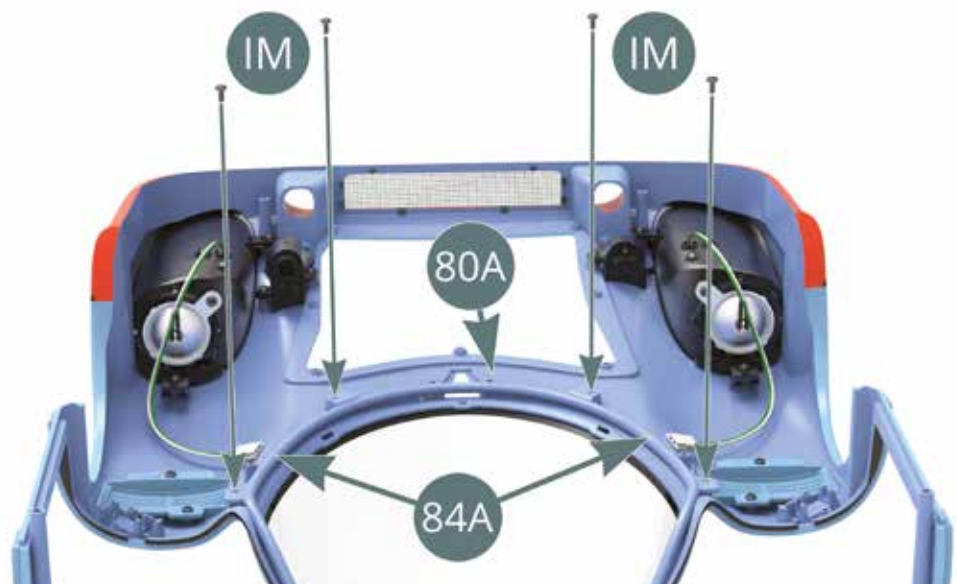
STEP 1

Attach 84A Top roll cage to 80A Bodywork and fasten with two IM screws.



STEP 2

Fasten 84A Top roll cage to 80A Bodywork with four more IM screws.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 85

85A Air scoop

85B Windscreen wiper

85C Rear view mirror housing

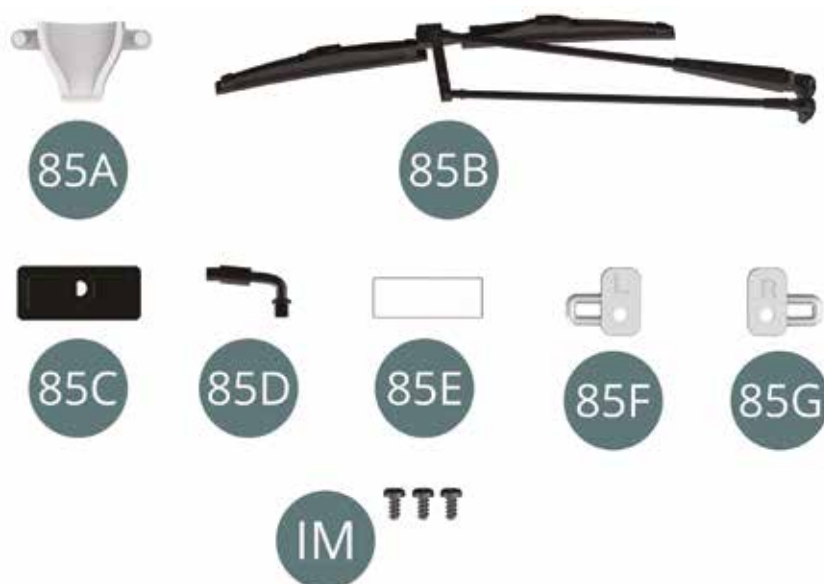
85D Rear view mirror bracket

85E Rear view mirror

85F Left door lock

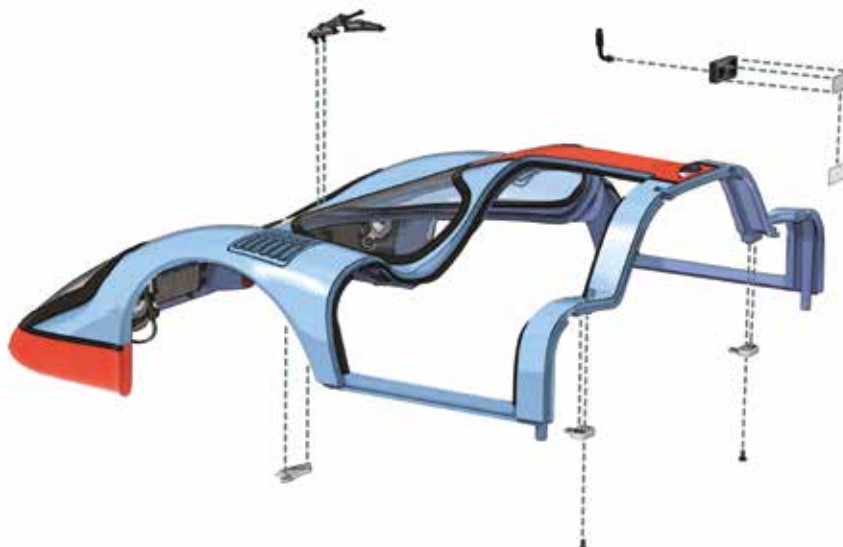
85G Right door lock

IM M1,7 x3,5mm (x3)



Bodywork fittings
attachment and rear
mirror assembly

ASSEMBLY DIAGRAM



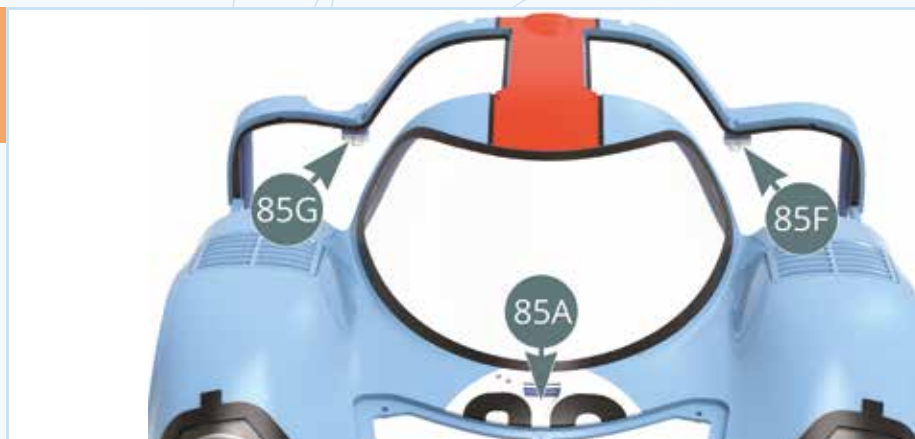
STEP 1



Attach 85A Air scoop to the underside of 80A Bodywork. Attach 85G Right and 85F Left door locks to 80A Bodywork and fasten them with two IM screws.

STEP 2

85G Right and 85F Left door locks are attached to 80A Bodywork



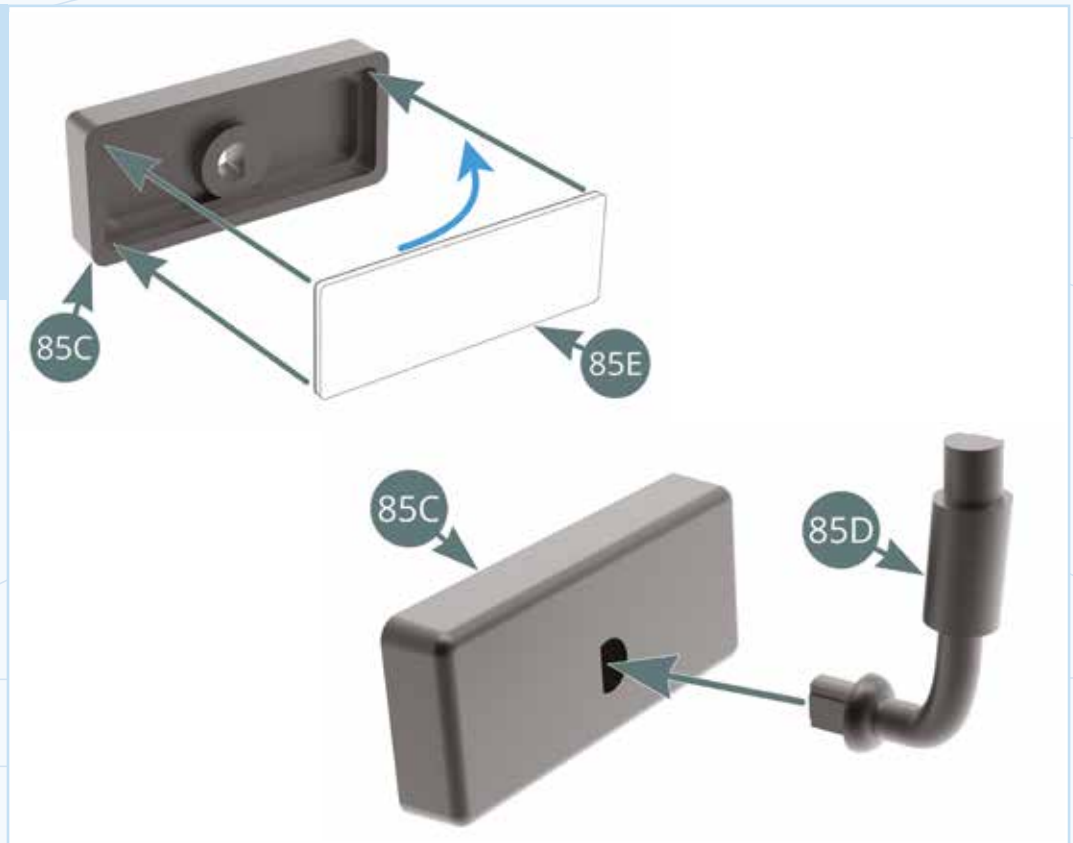
Attach 85B Windscreen wiper to 80A Bodywork.





STEP 3

Peel away (blue arrow) backing paper from 85E Rear view mirror and stick it to 85C Rear view mirror housing. Fit 85D Rear view mirror bracket to 85C Rear view mirror housing.



STEP 4

Sore safely the preassembled Rear view mirror until further assembly in next issues.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 86

86A Lower hinge

86B Top hinge

86C Door light

86D Lock

86E Pin (long)

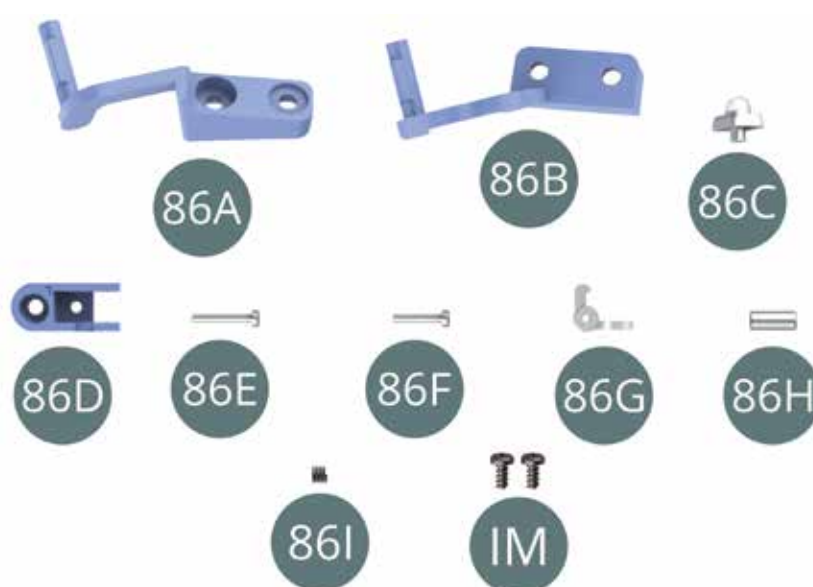
86F Pin (short)

86G Latch

86H Release button

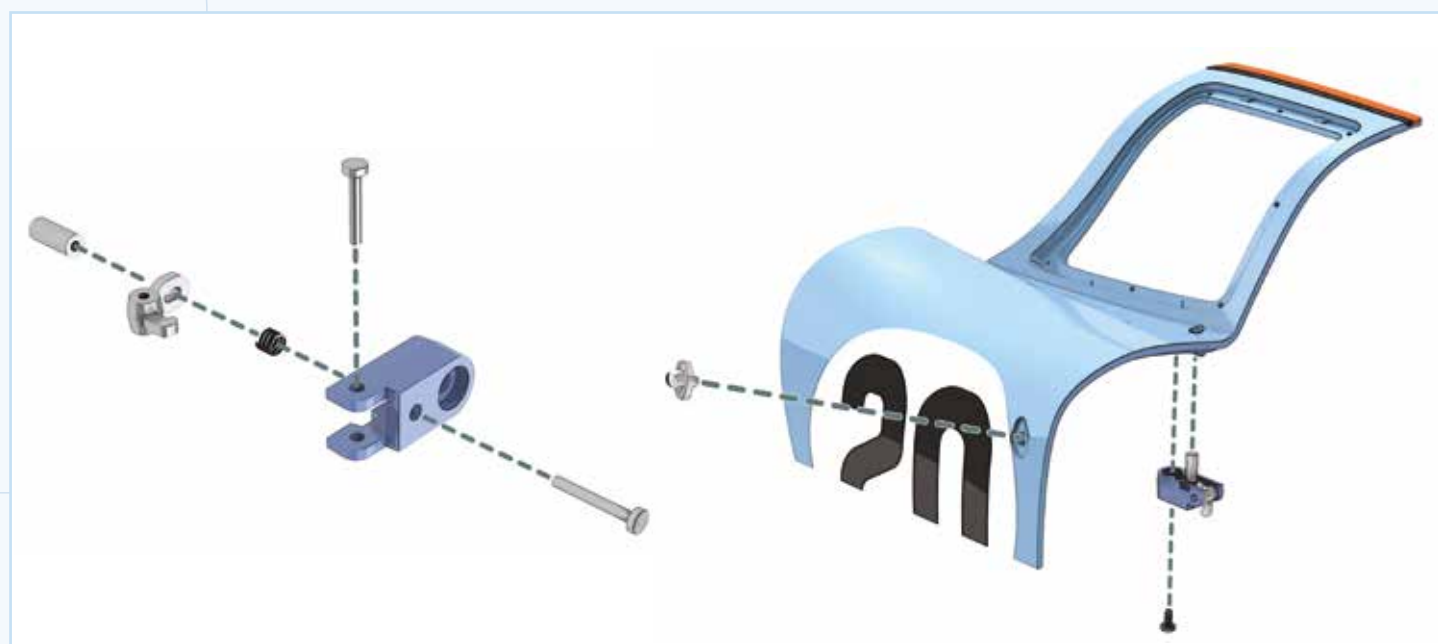
86I Spring

IM Screw M 1.7 x 3.5 mm (x 2)



Assembly and installation
of the left door lock and
door light

ASSEMBLY DIAGRAM



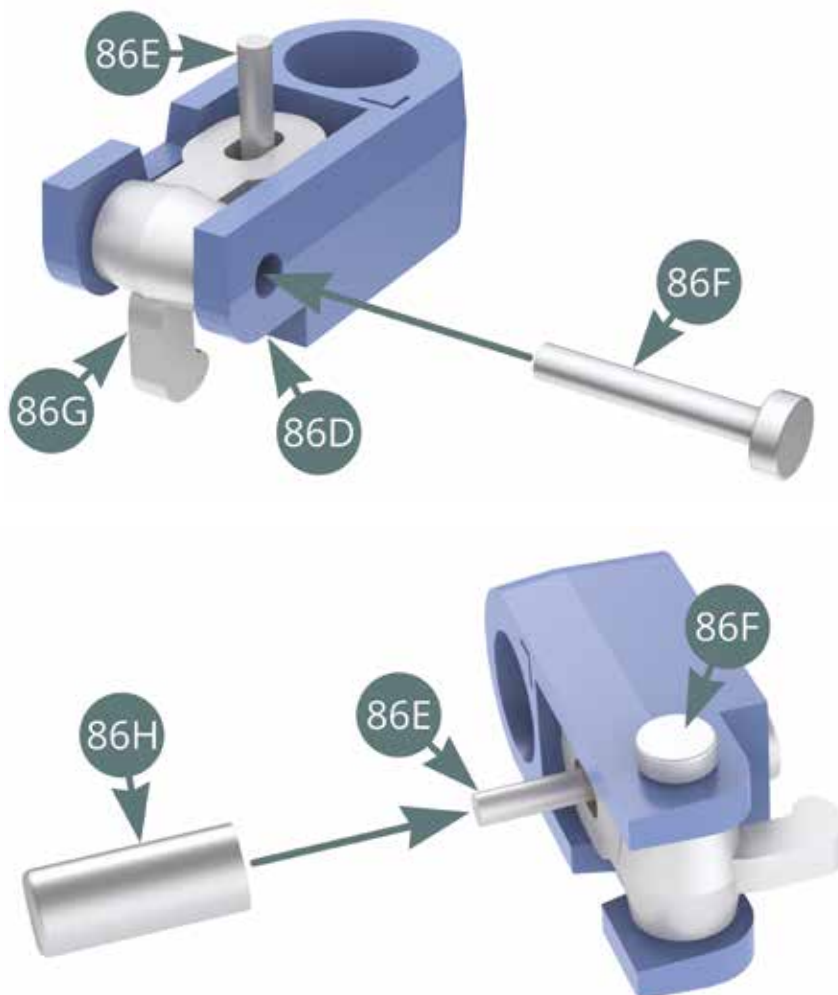
STEP 1

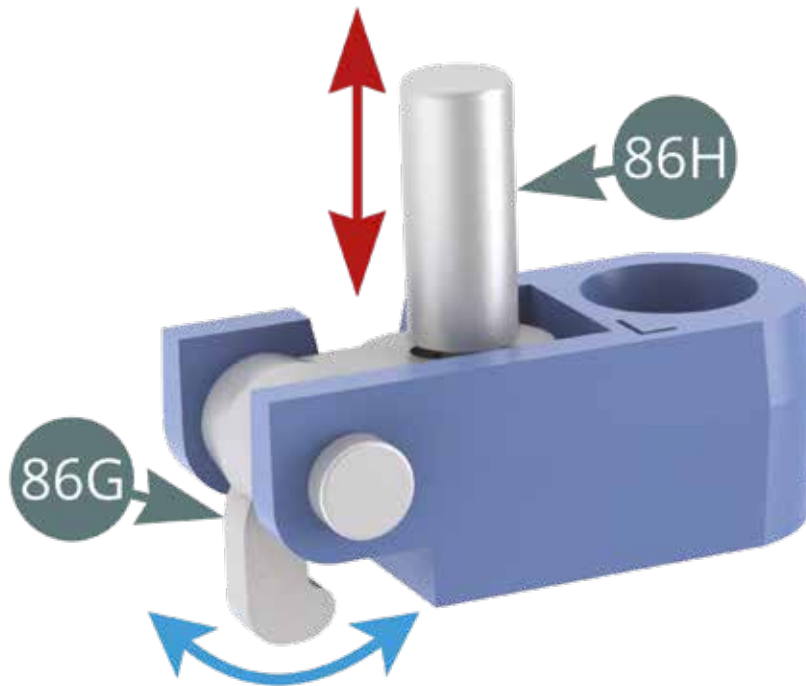


Insert the long pin (86E) into the locking body (86D). Position the spring (86I) and latch (86G) on the long pin (86E).

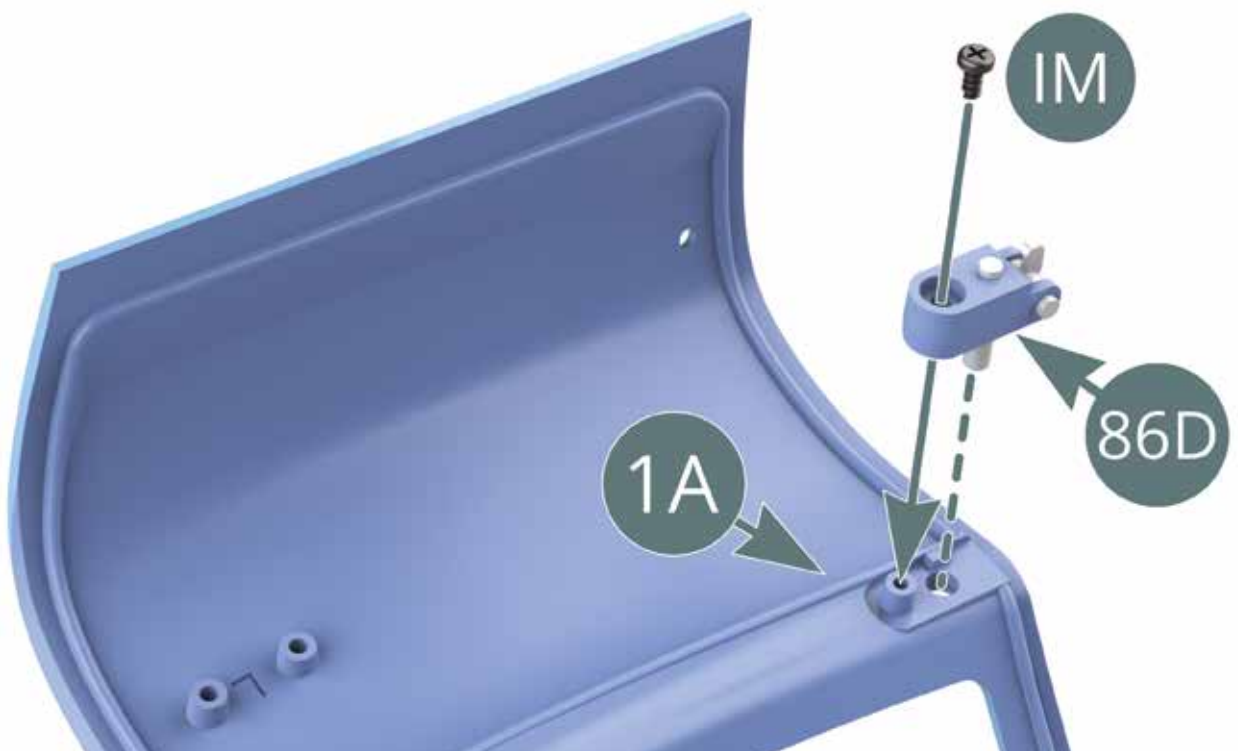
STEP 2

Align the latch pin (86G) with the locks (86D), then insert the short pin (86F). Position the release button (86H) on the long pin (86E).



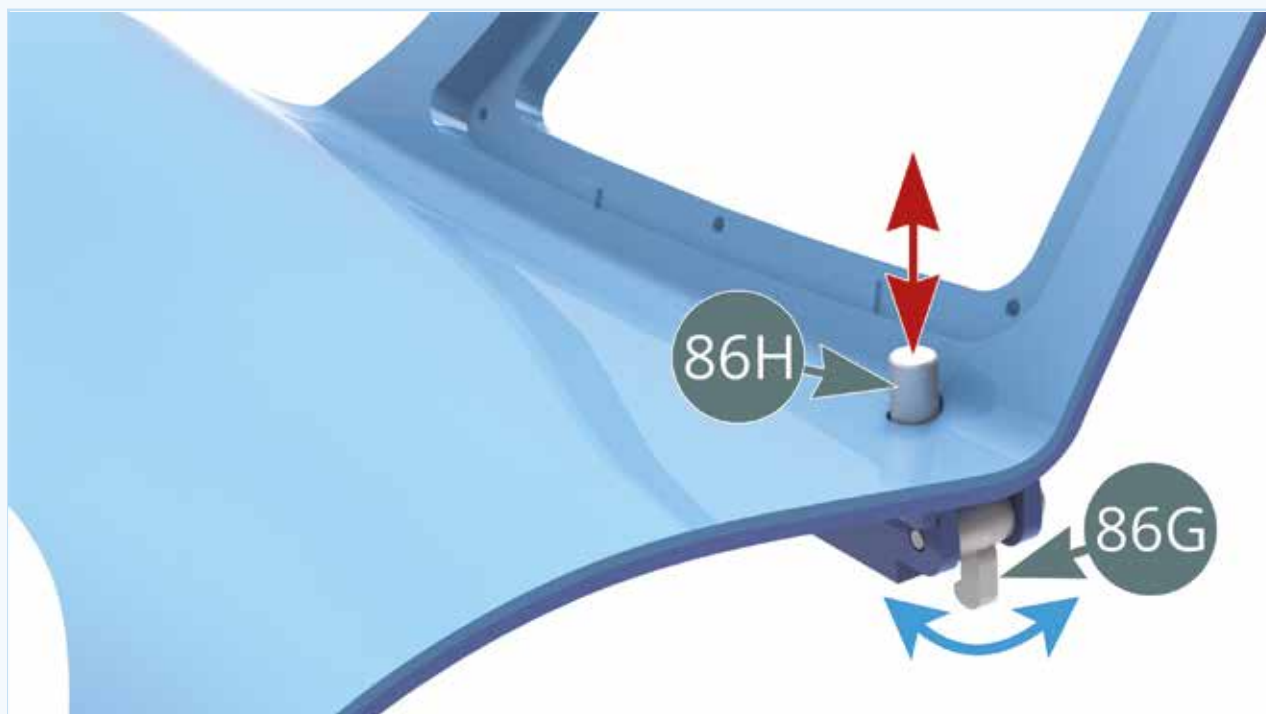
**STEP 3**

Press the release button (86H) to ensure that the latch (86G) swings out.

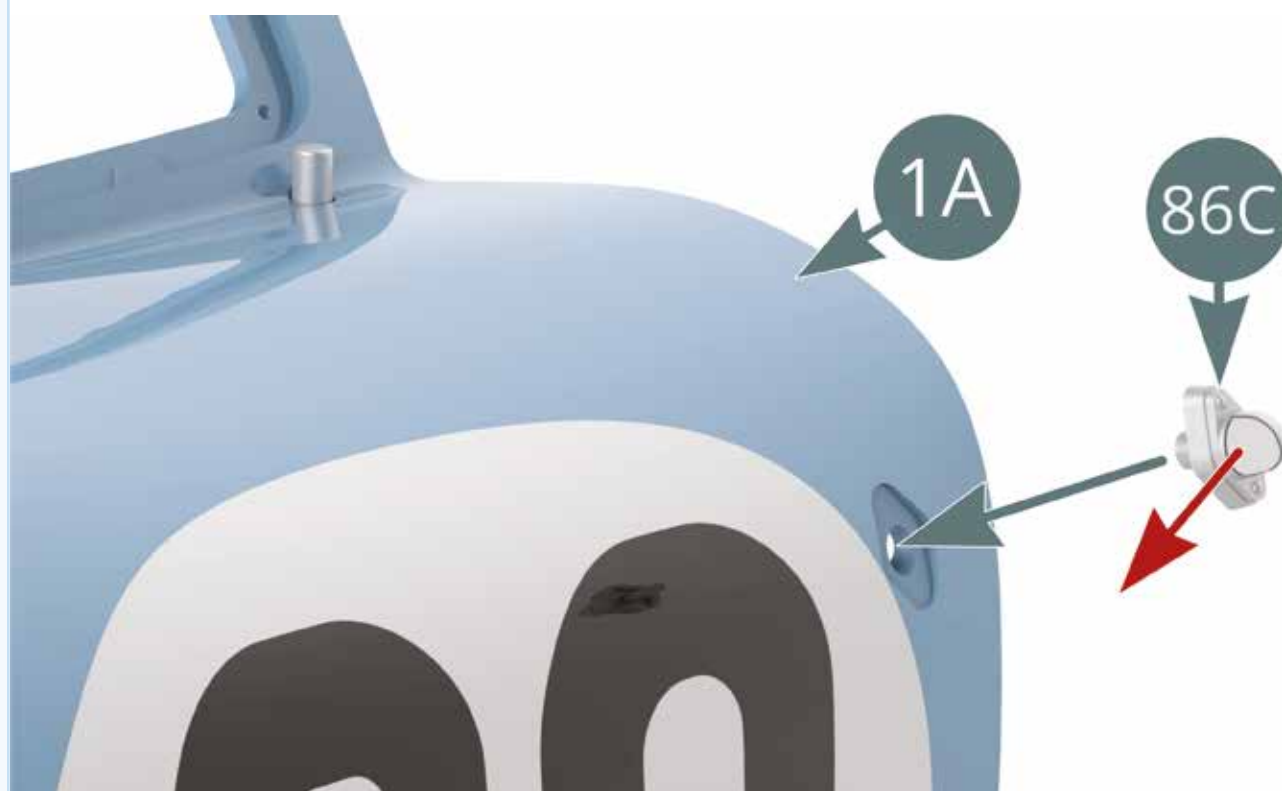


Position the lock assembly (86D) at the rear of the left door (1A) and secure with an IM.

STEP 4



Press the release button (86H) again to ensure that the latch (86G) still swings out correctly.



Position the door light (86C) on the left door (1A) ensuring that the light is pointing forward.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 87

87A Window

87B Vent window

87C Clamp

87E Clamp

87D Spring

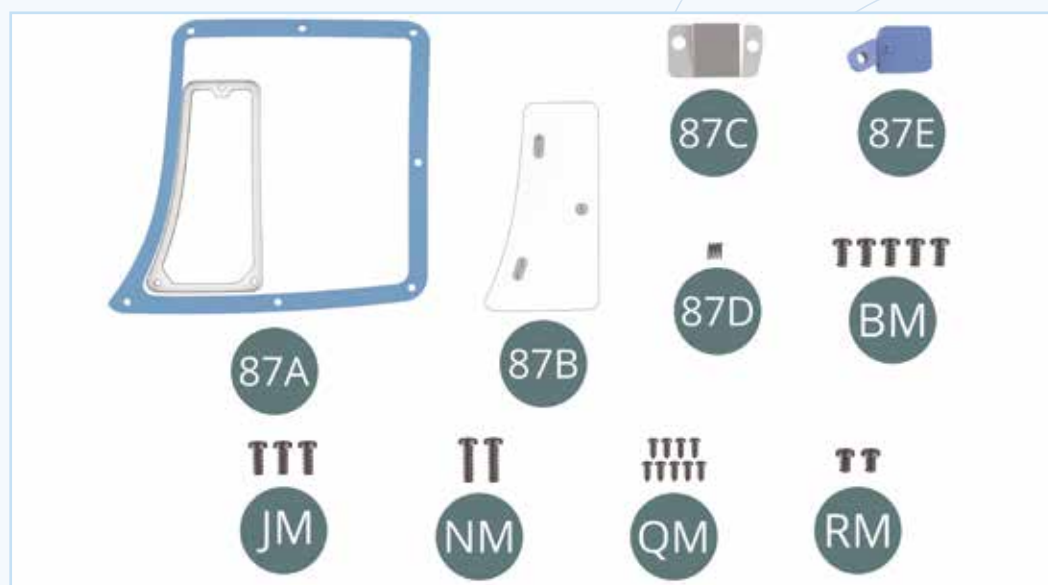
BM M2,0 x4mm (x5)

JM M2,0 x5mm (x3)

NM M2,0 x7mm (x2)

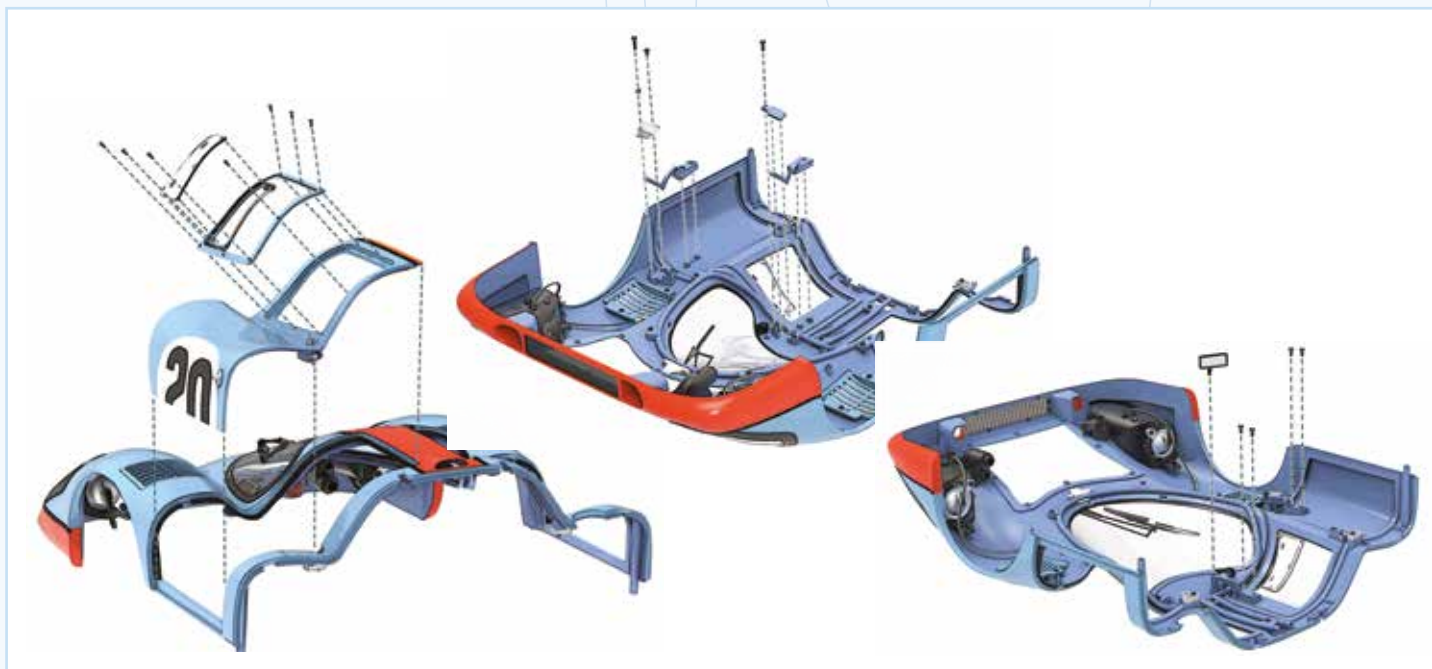
QM M1,2 x3mm (x9)

RM M2,0 x3mm (x2)



Left door assembly
and attachment.
Rear view mirror
attachment

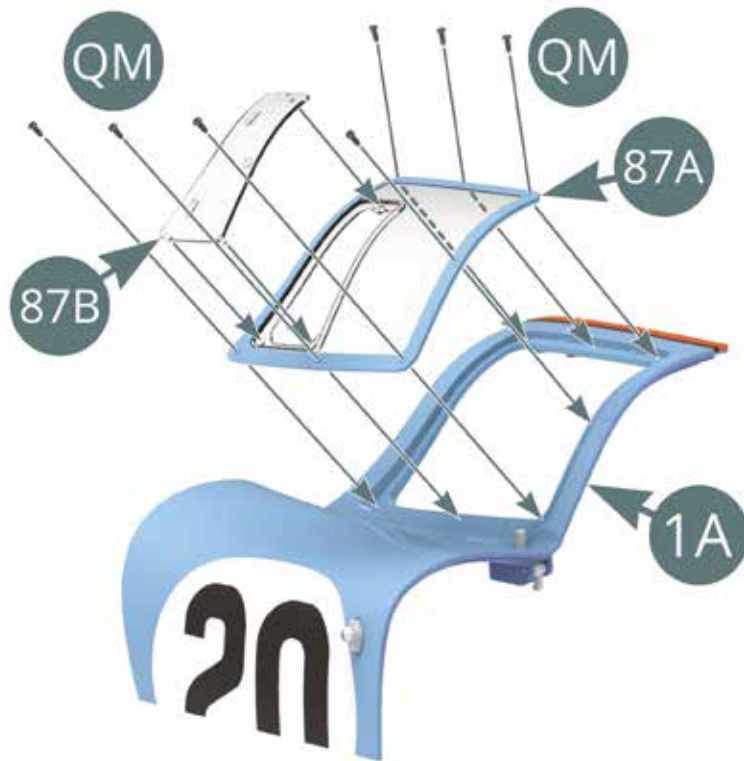
ASSEMBLY DIAGRAM





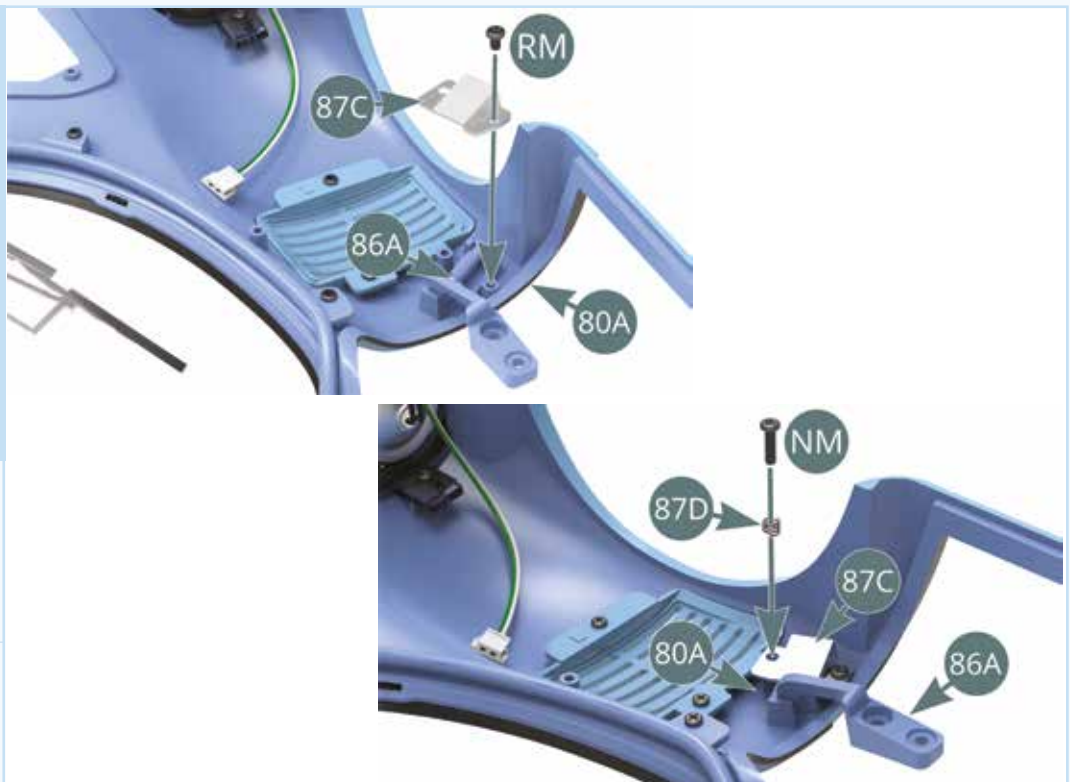
STEP 1

Attach 87B Vent window to 87A Window on its three pins.
Attach 87A Window to 1A Left door and fasten with seven QM screws.



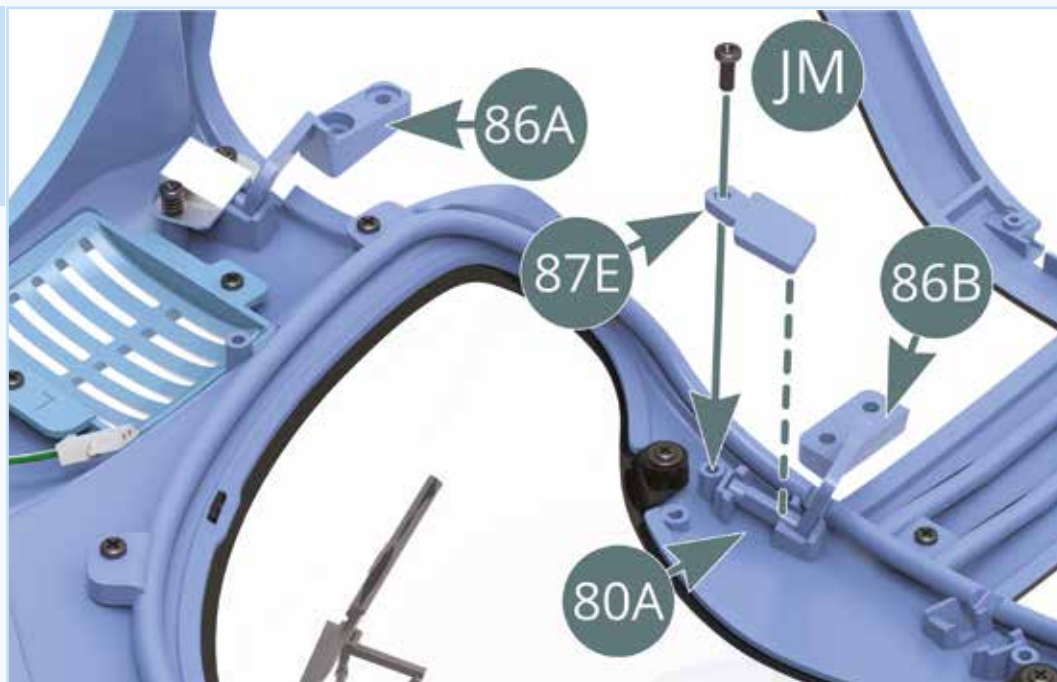
STEP 2

Place 86A Lower hinge axle into 80A Bodywork cradle and fasten with 87C Clamp and RM screw from one side. From the other side, fasten 87C Clamp to 80A Bodywork with NM screw passing it through 87D Spring. Don't tighten NM screw, leave space for 87D Spring compression.

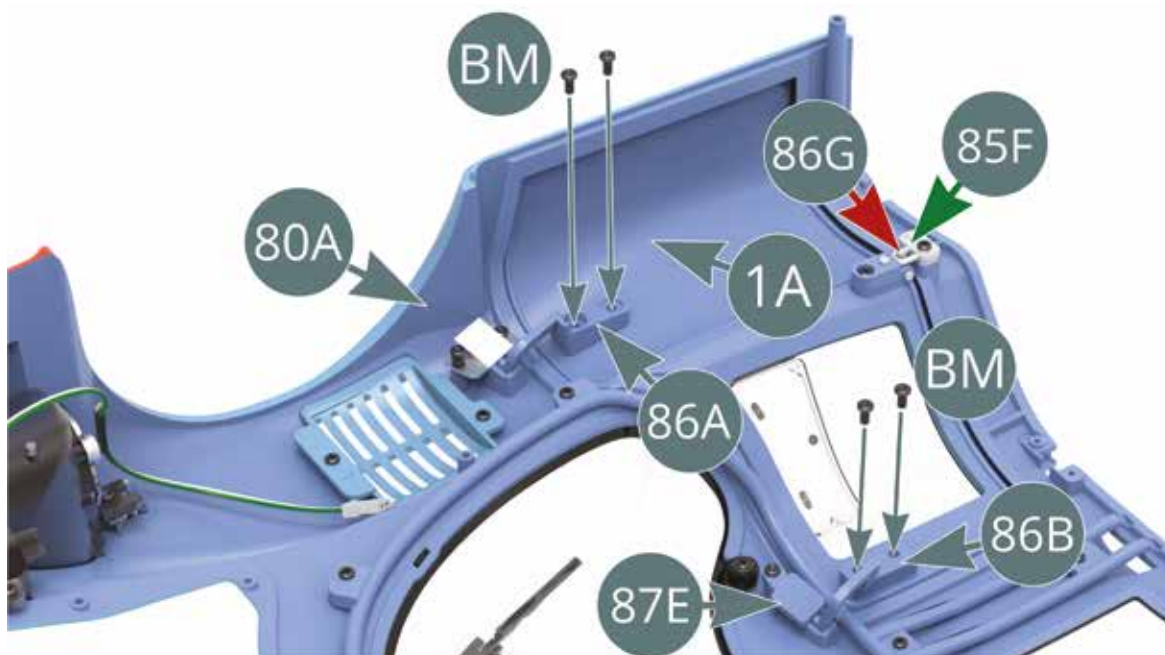


STEP 3

Place 86B Upper hinge axle into 80A Bodywork cradle and fasten with 87E Clamp and JM screw.



STEP 4



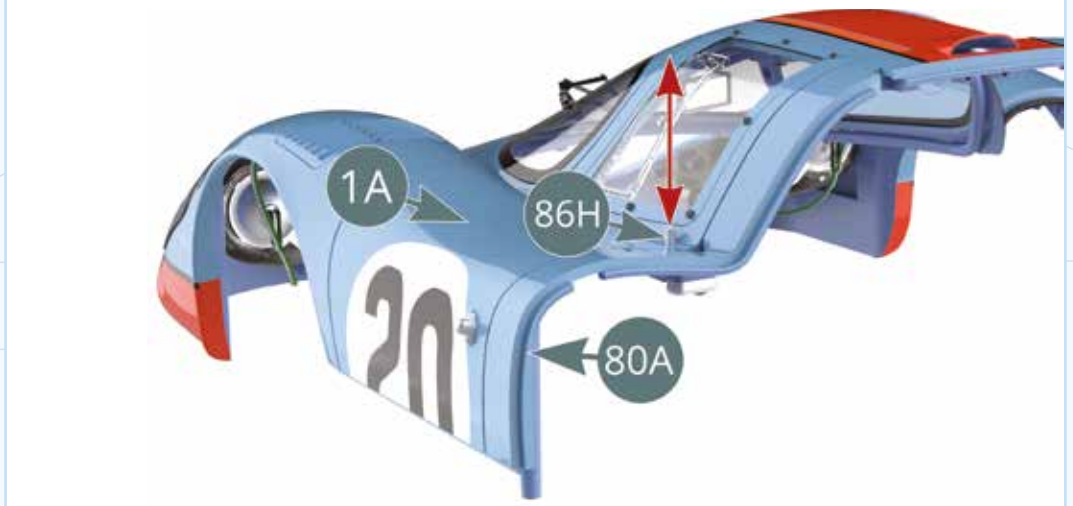
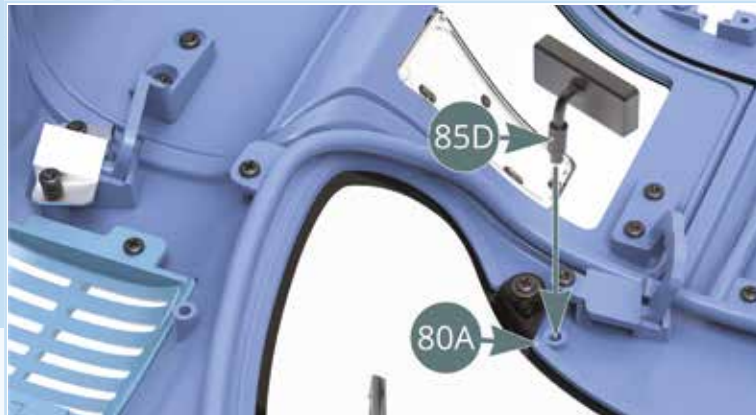
Attach 1A Left door to 80A Bodywork, engaging 86G Latch into 85F Left door lock loop. Fasten 86A Lower and 86B Upper hinges to 1A Left door with four BM screws.



STEP 5

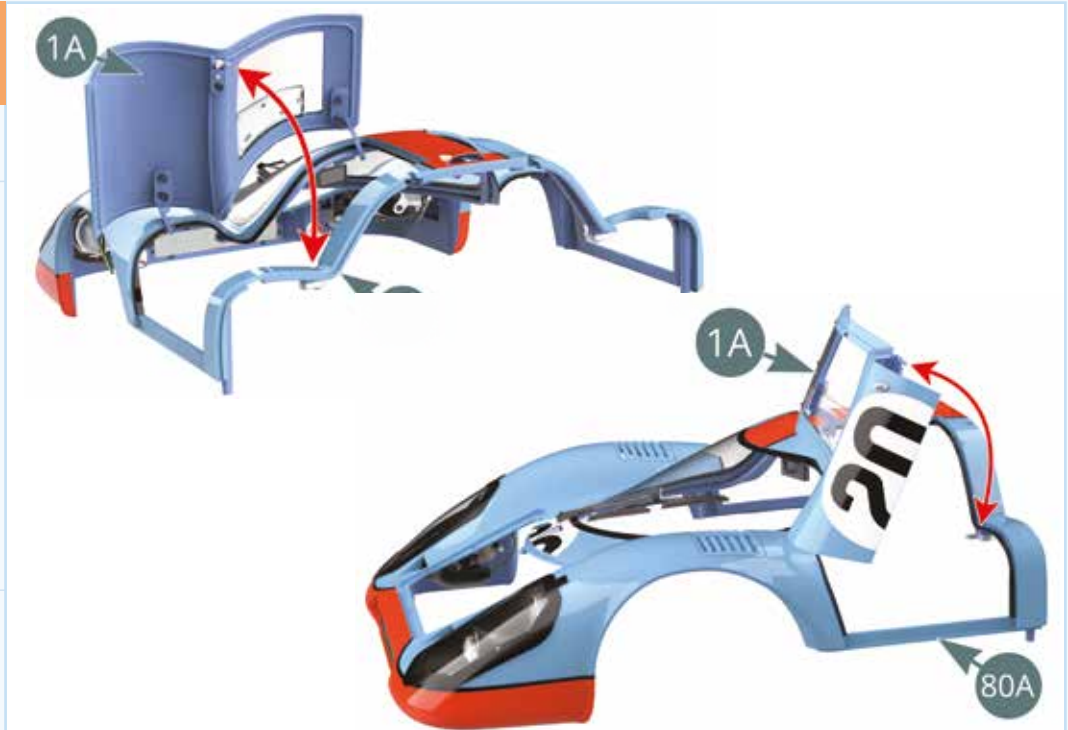
Fit Rear Mirror by its 85D Bracket to 80A Bodywork inner ceiling socket.

Push 86H Lock release to test opening of 1A Left door as shown further.



STEP 6

Check opening and closing of 1A Left door



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 88

88A Right door

88B Lower hinge

88C Top hinge

88D Decal (x 2)



88A

88B



88C

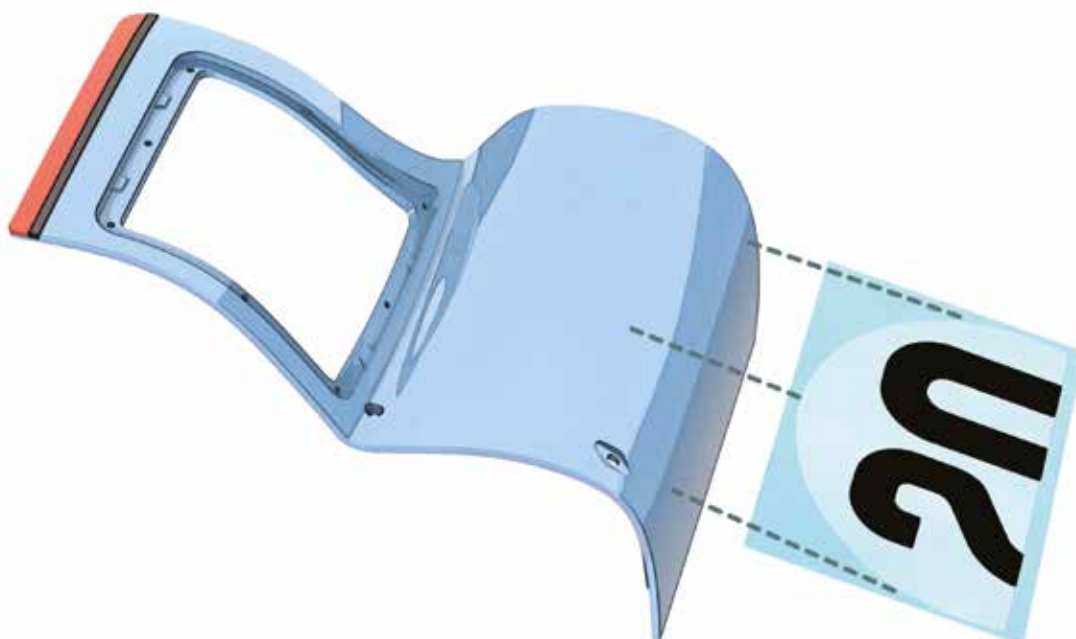


88D



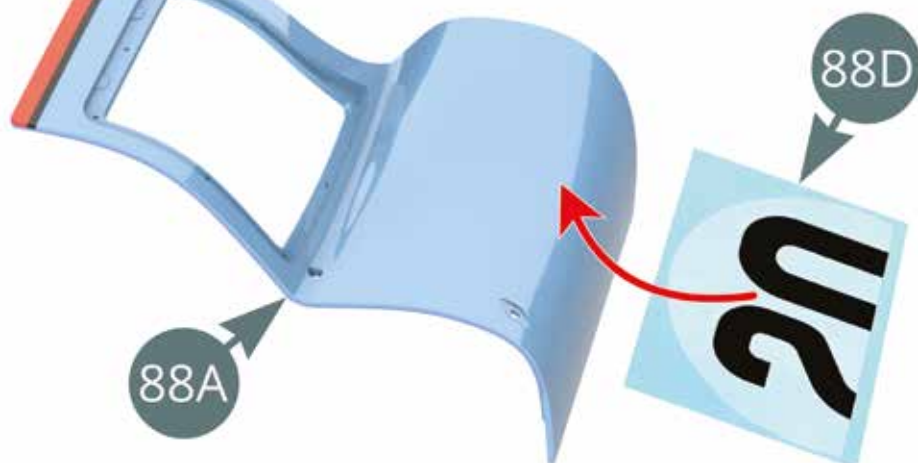
Position of the decal with the car's race number on the right door

ASSEMBLY DIAGRAM



STEP 1

Immerse the decal (88D) into water for 60 seconds, then carefully slide it onto the outside of the right door (88A).



STEP 2

Align and position the decal according to the following illustration. Wait 3 minutes for it to set, then gently smooth it with a soft cotton pad.





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 89

89A Window

89B Vent window

89C Clamp

89D Clamp

89E Door light

89F Lock

89G Latch

89H Lock release

89I Pin (longer)

89J Pin (shorter)

89K Spring (smaller)

89L Spring (larger)

BM M2,0 x4mm (x5)

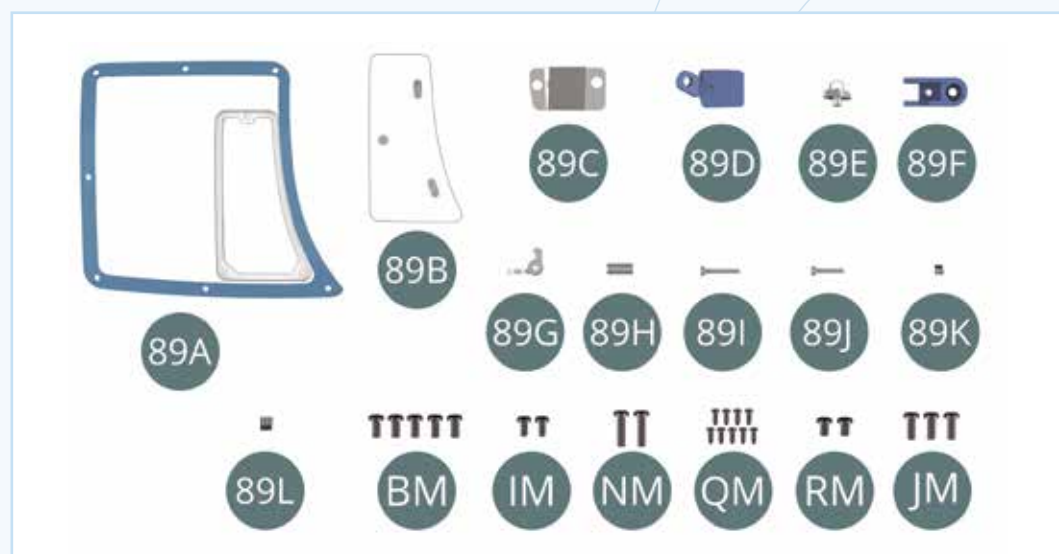
IM M1,7 x3,5mm (x2)

NM M2,0 x7mm (x2)

QM M1,2 x3mm (x9)

RM M2,0 x3mm (x2)

JM M2,0 x5mm (x3)



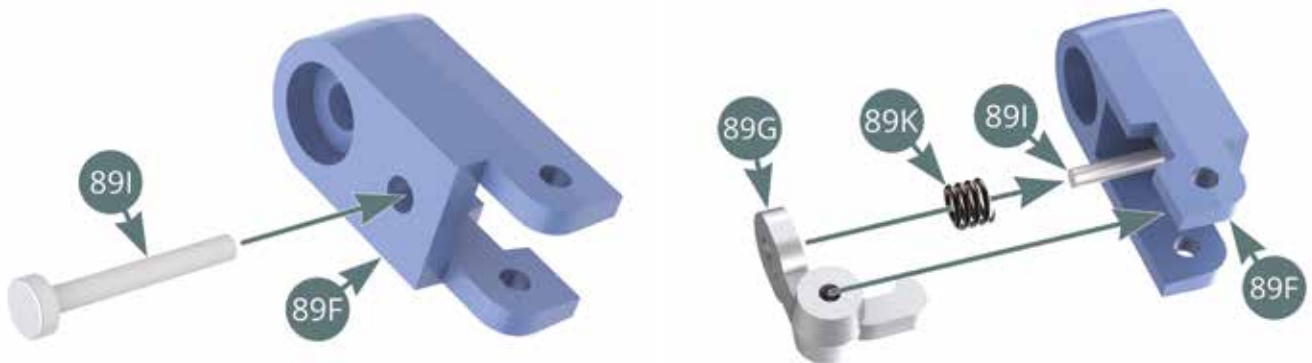
Right door assembly
and attachment

ASSEMBLY DIAGRAM





STEP 1

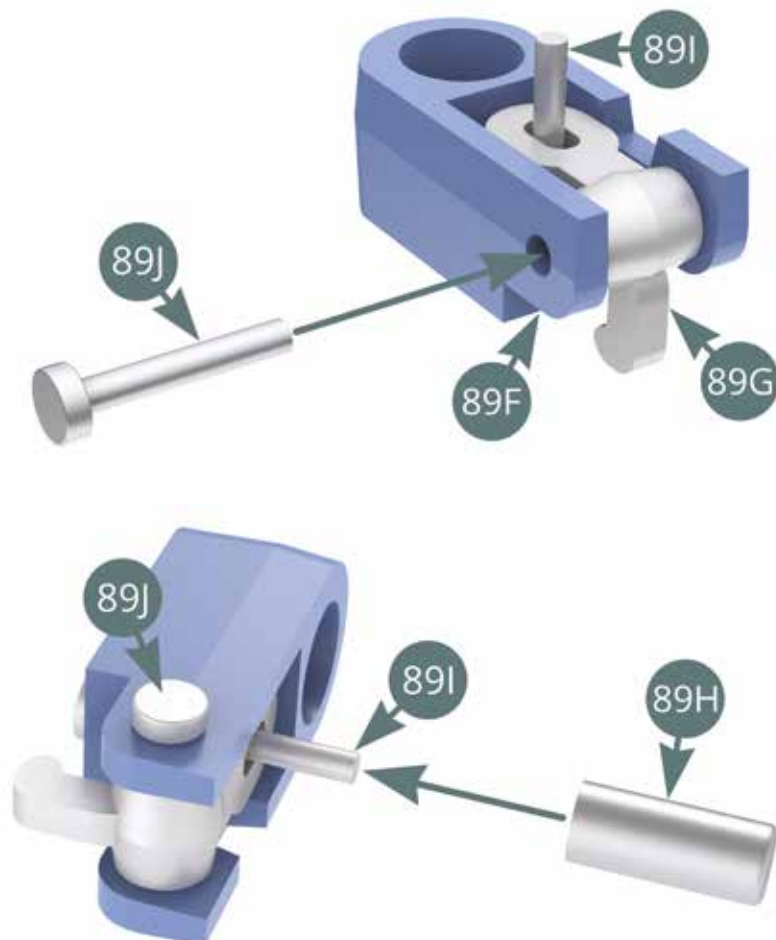


Insert longer 89I Pin into 89F Lock body. Fit 89K Spring and 89G Latch on 89I Pin.

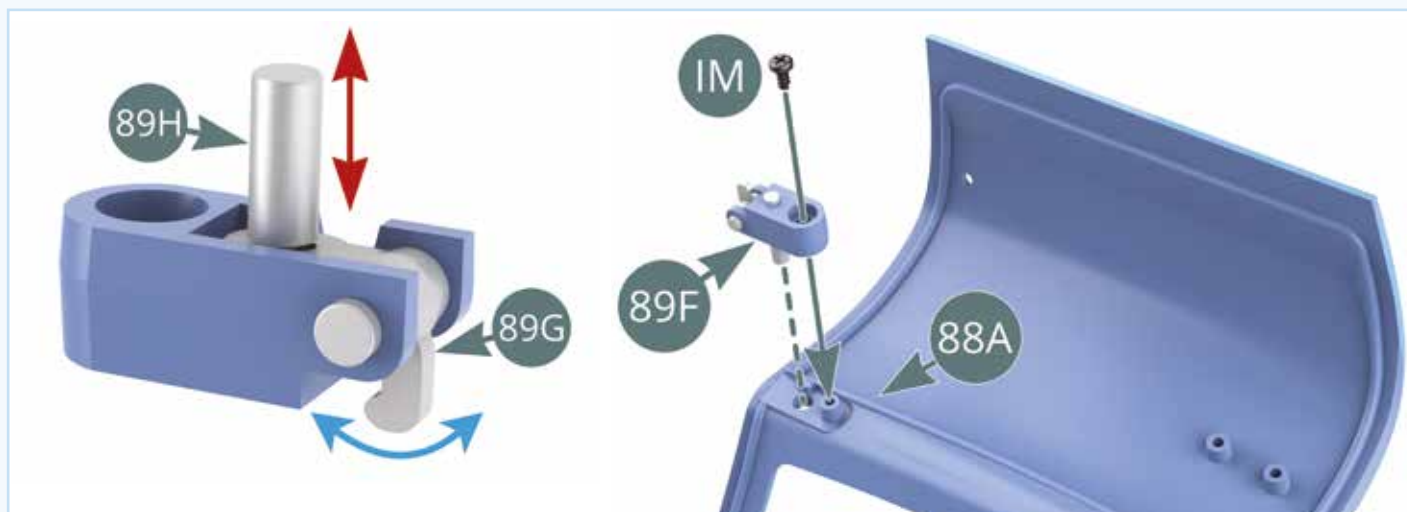
STEP 2

Align 89G Latch axis to 89F Lock and insert 89J Pin.

Fit 89H Lock release on 89I Pin.



STEP 3

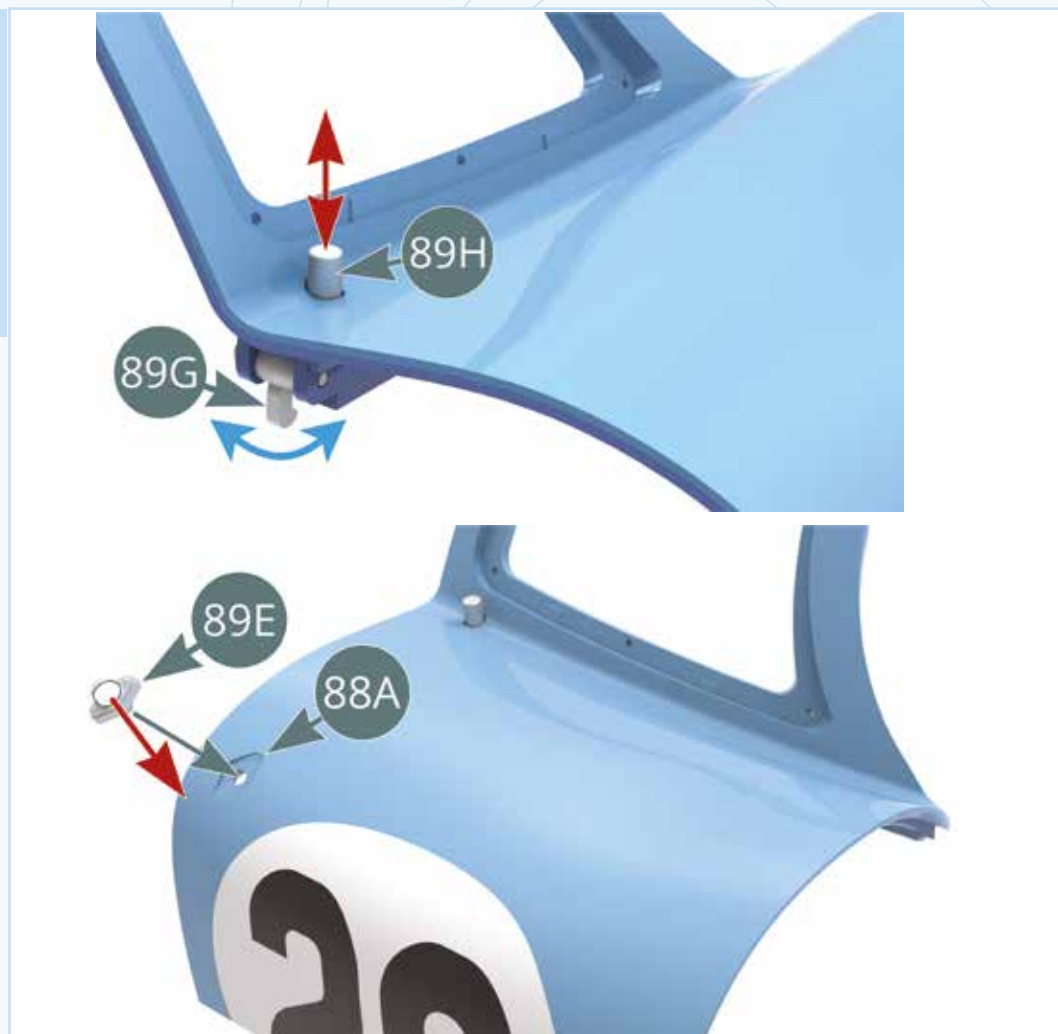


Push 89H Lock release to check 89G Latch rocking motion. Attach preassembled 89F Lock to the backside of 88A Right door and fasten with IM screw.

STEP 4

Press 89H Lock release to check once more 89G Latch rocking motion in response.

Attach 89E Door light to 88A Right door, minding its lamp forward orientation.

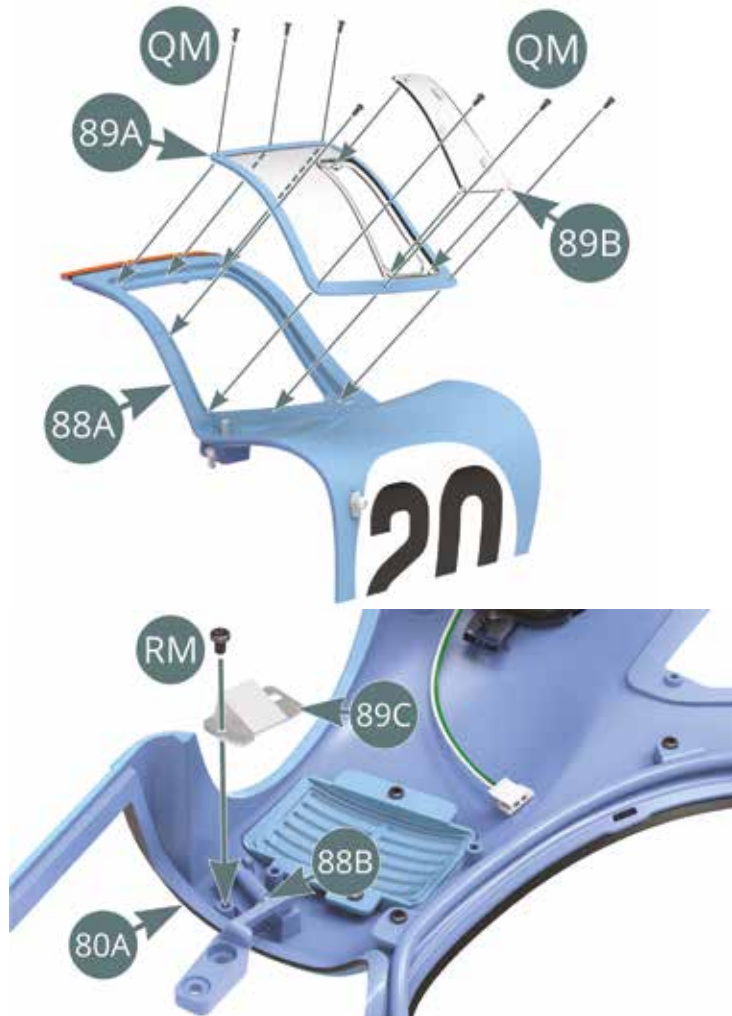




STEP 5

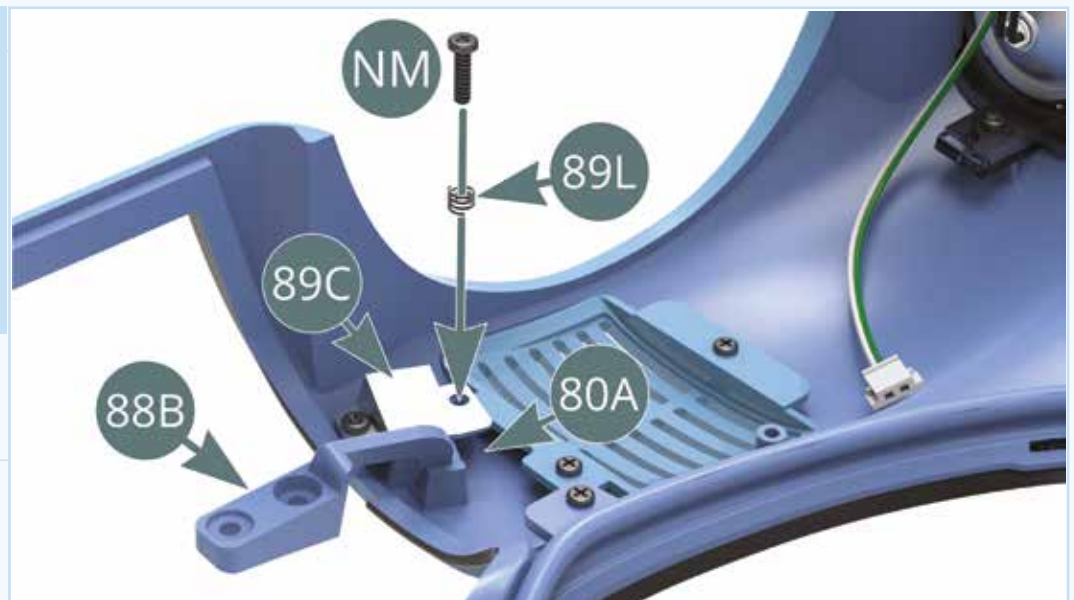
Attach 89B Vent window to 89A Window on its three pins. Attach 89A Window to 88A Right door and fasten with seven QM screws.

Place 88B Lower hinge axle into 80A Bodywork cradle and fasten with 89C Clamp and RM screw from one side.



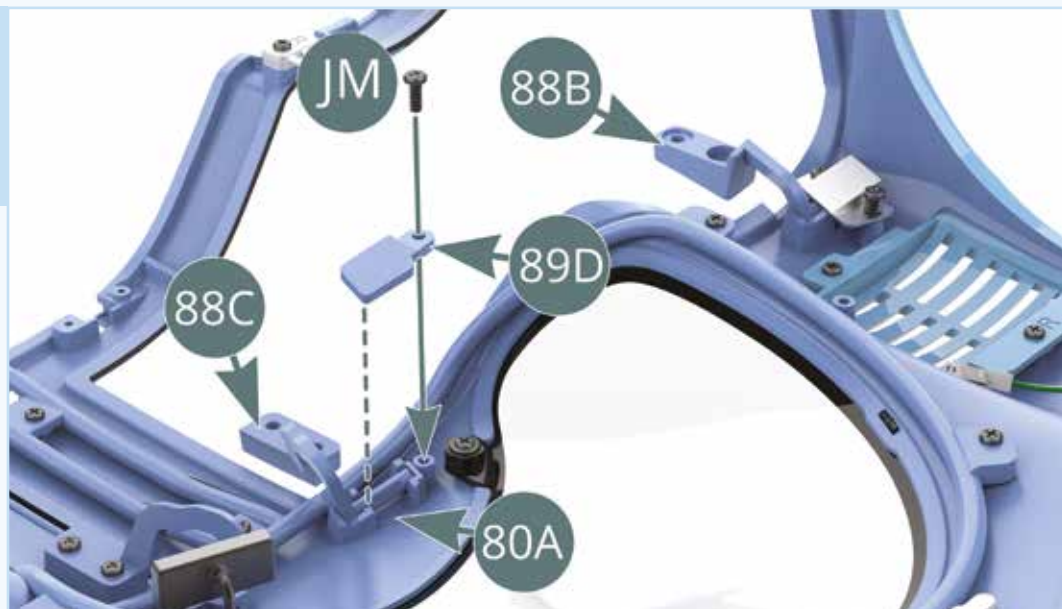
STEP 6

From the other side, fasten 89C Clamp to 80A Bodywork with NM screw passing it through 89L Spring. Don't tighten NM screw, leave space for 89L Spring compression.

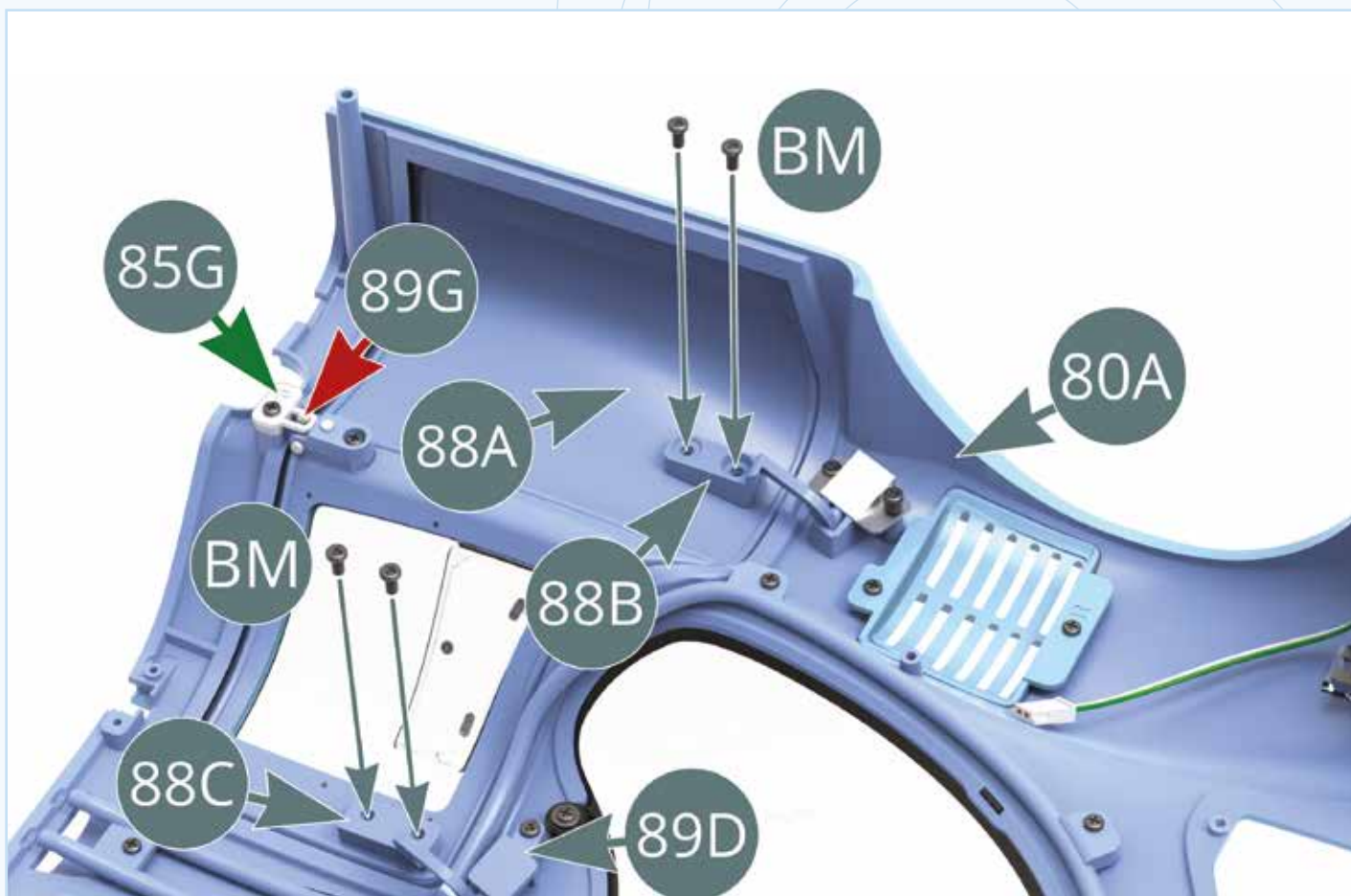


STEP 7

Place 88C Upper hinge axle into 80A Bodywork cradle and fasten with 89D Clamp and JM screw.



STEP 8



Attach 88A Right door to 80A Bodywork, engaging 89G Latch into 85G Right door lock loop. Fasten 88B Lower and 88C Upper hinges to 88A Right door with four BM screws.



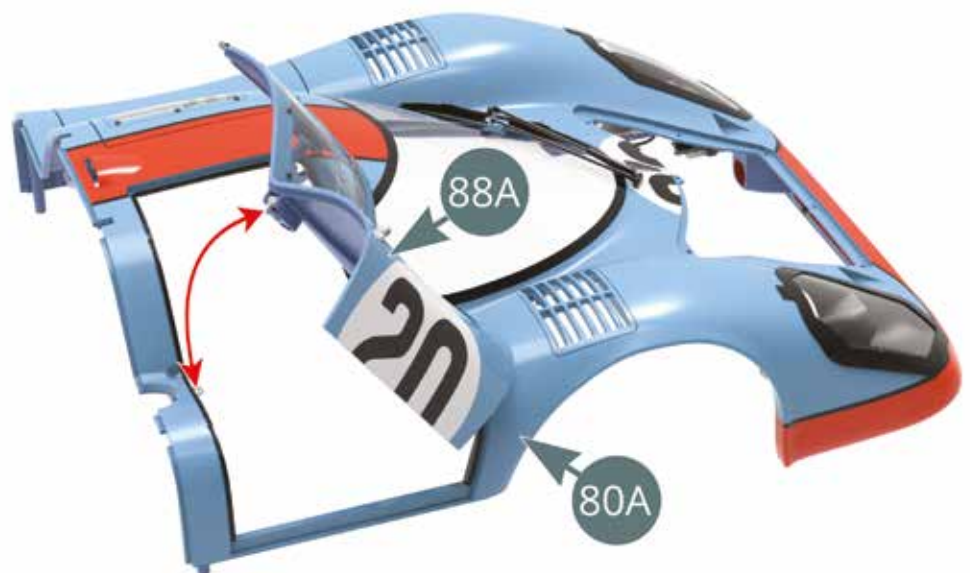
STEP 9



Push 89H Lock release to test opening of 88A Right door as shown further.

STEP 10

Check opening and closing of 88A Right door



GENERAL VIEW





Assembly guide

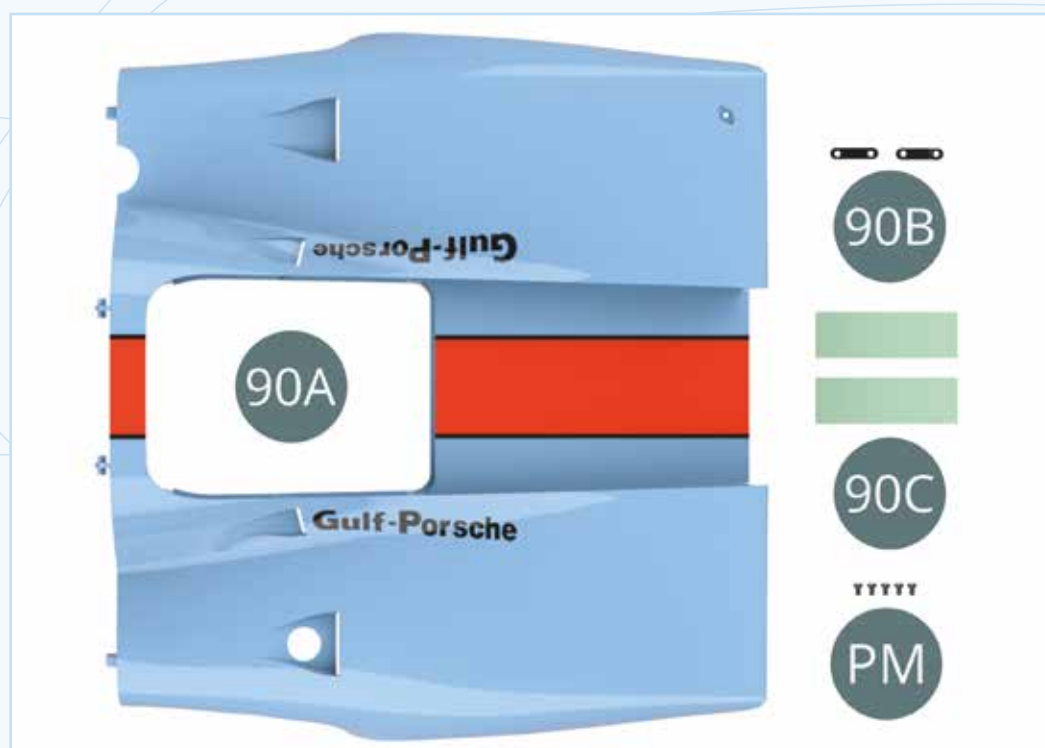
PARTS OF THE ISSUE 90

90A Rear hood

90B Hinge clamp (x2)

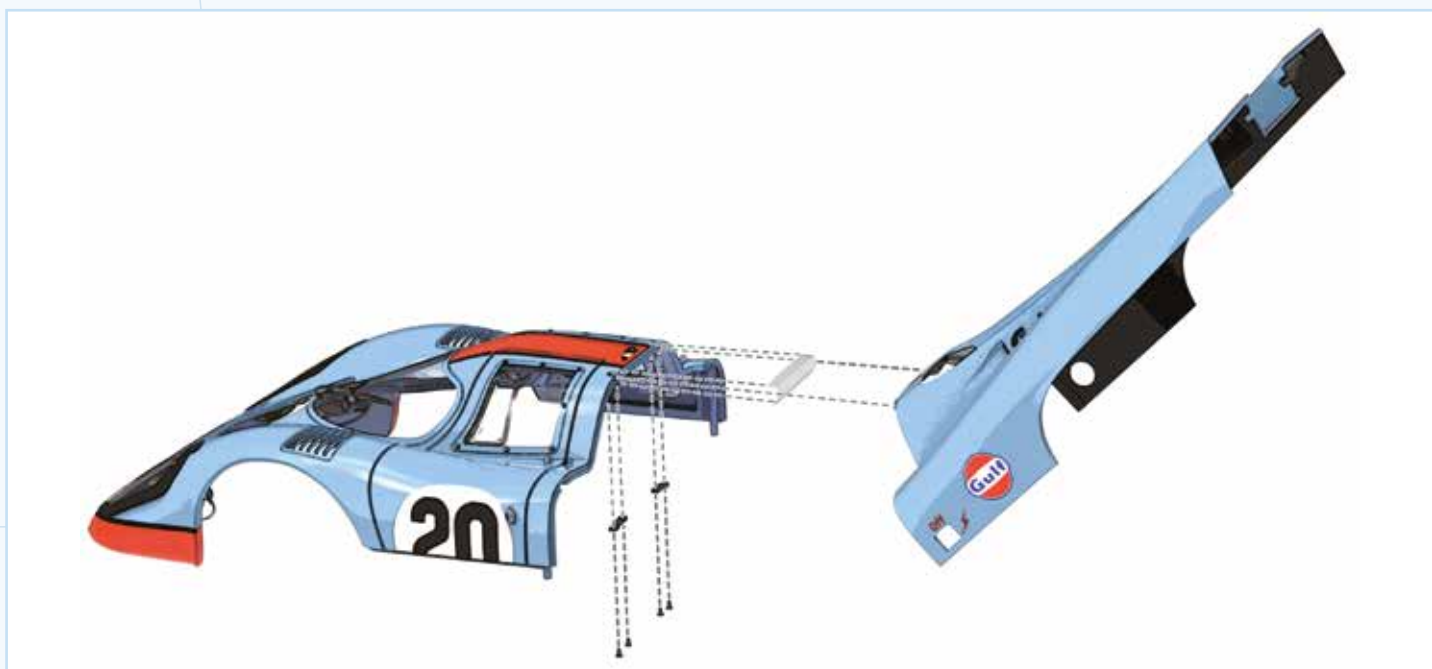
90C Transparent tape (x2)

PM M2,0 x4mm (x5)



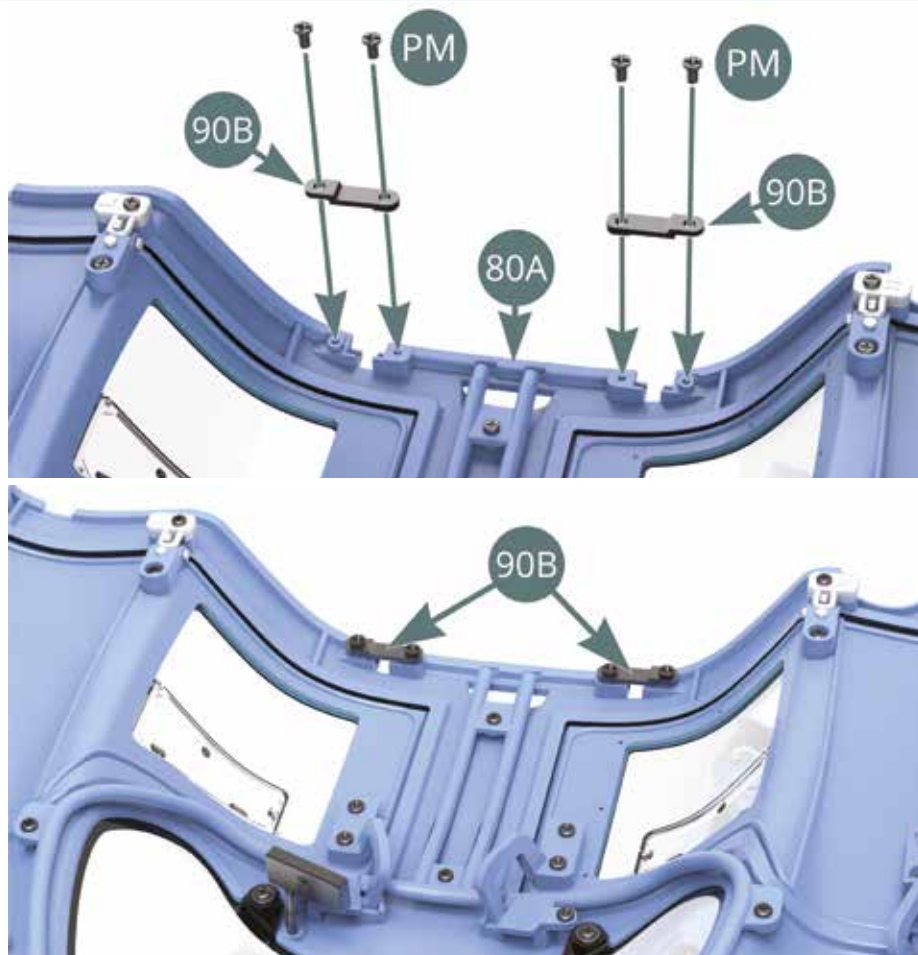
Bodywork hinge
clamps attachment,
rear hood
attachment test

ASSEMBLY DIAGRAM



STEP 1

Attach two 90B Hinge clamps to the underside edge area of 80A Bodywork and fasten with four PM screws.



STEP 2

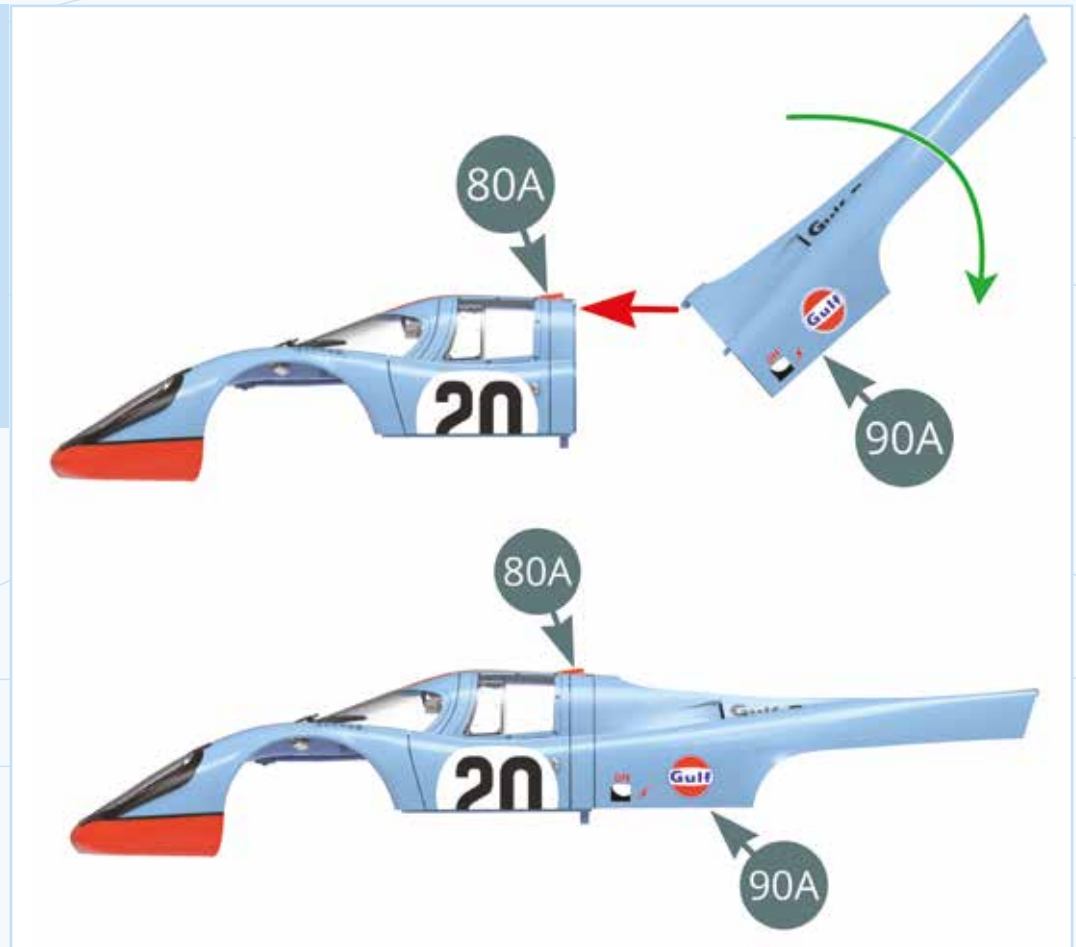


Raise 90C Transparent tape off its backing paper and wrap around 80A Bodywork edge. This 90C Transparent tape will serve to safeguard the edge painting from scratching during the following 90A Rear hood attachment test.

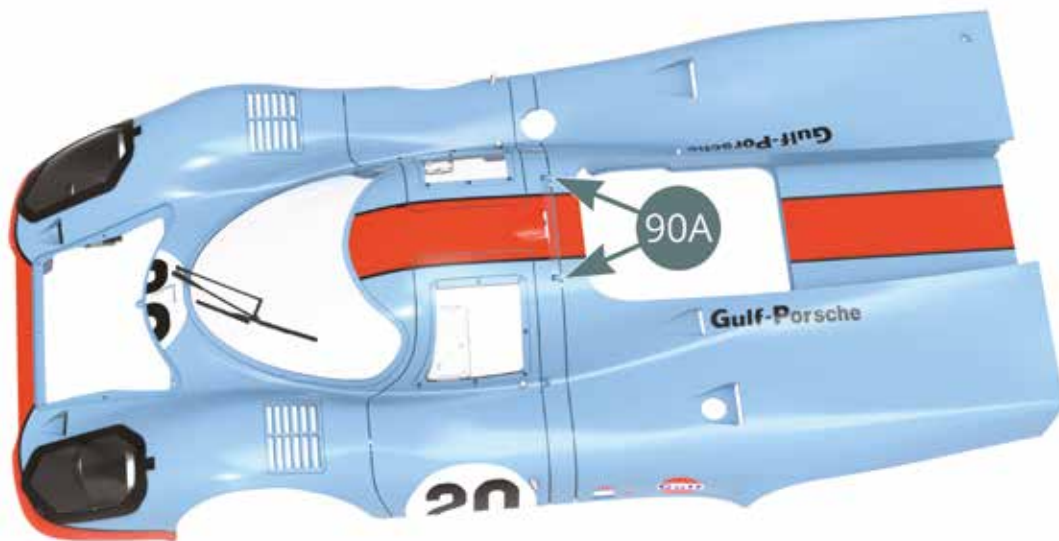


STEP 3

Raise 90A Rear hood to 45 degrees angle and keeping that way move forward (red arrow) to insert its two hinges into 80A Bodywork hinge sockets. Once inserted, turn 90A Rear hood to horizontal position (green arrow, upper and lower illustrations).



STEP 4



Having tested the joint, remove 90A Rear hood in reverse order (raise it up to 45 degrees and pull back horizontally) for its further assembly.

GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 91

91A Left air duct

91B Right air duct

91C Clear cap

91D Double-sided circular tape

IM Screw M 1.7 x 3.5 mm (x 5)



*Mounting the
air ducts and
transparent cap to
the rear bonnet*

ASSEMBLY DIAGRAM



STEP 1

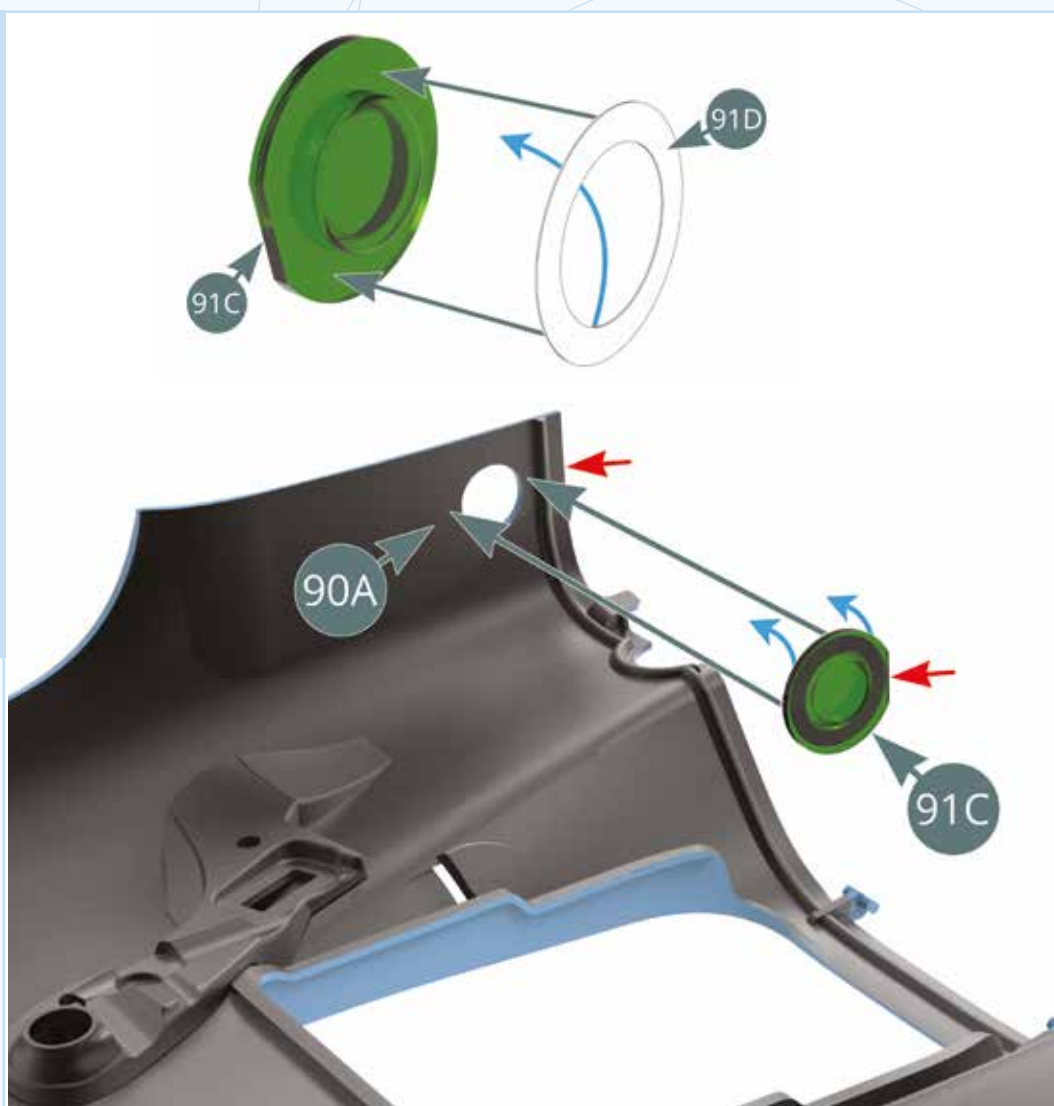


Position the left air duct (91A) on the inside of the rear bonnet (90A) and secure with two IM screws. Position the right air duct (91B) on the inside of the rear bonnet (90A) and secure with two IM screws.

STEP 2

Remove the circular double-sided tape (91D) from its paper backing and affix it around the protruding part of the clear cap (91C).

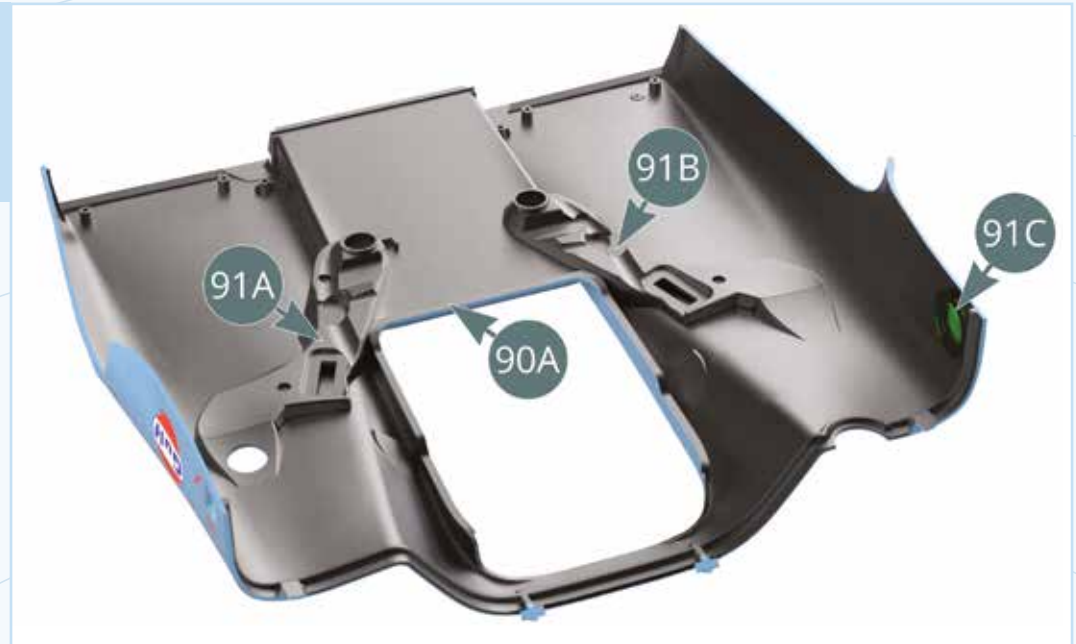
Detach the paper backing from the double-sided tape that is attached to the clear cap (91C) - blue arrows - and stick it into the opening on the inner left side of the rear bonnet (90A). Orient the right side of the clear cap (91C) as indicated by the red arrows.





STEP 3

Left (91A) and right (91B) air ducts as well as the clear cap (91C) are attached to the rear bonnet (90A).



GENERAL VIEW





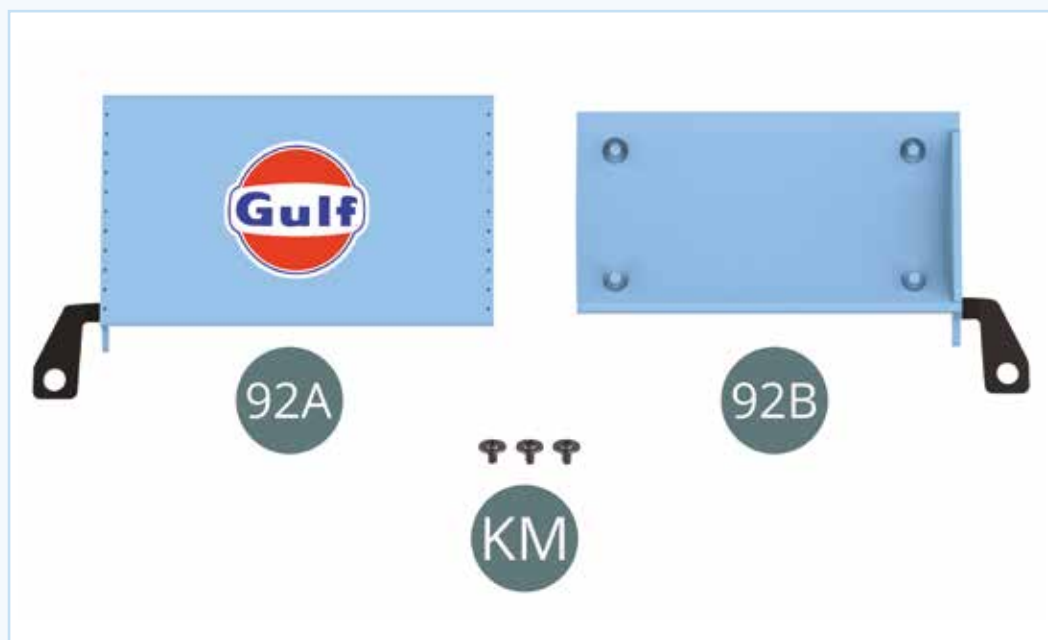
Assembly guide

PARTS OF THE ISSUE 92

92A Top centre spoiler

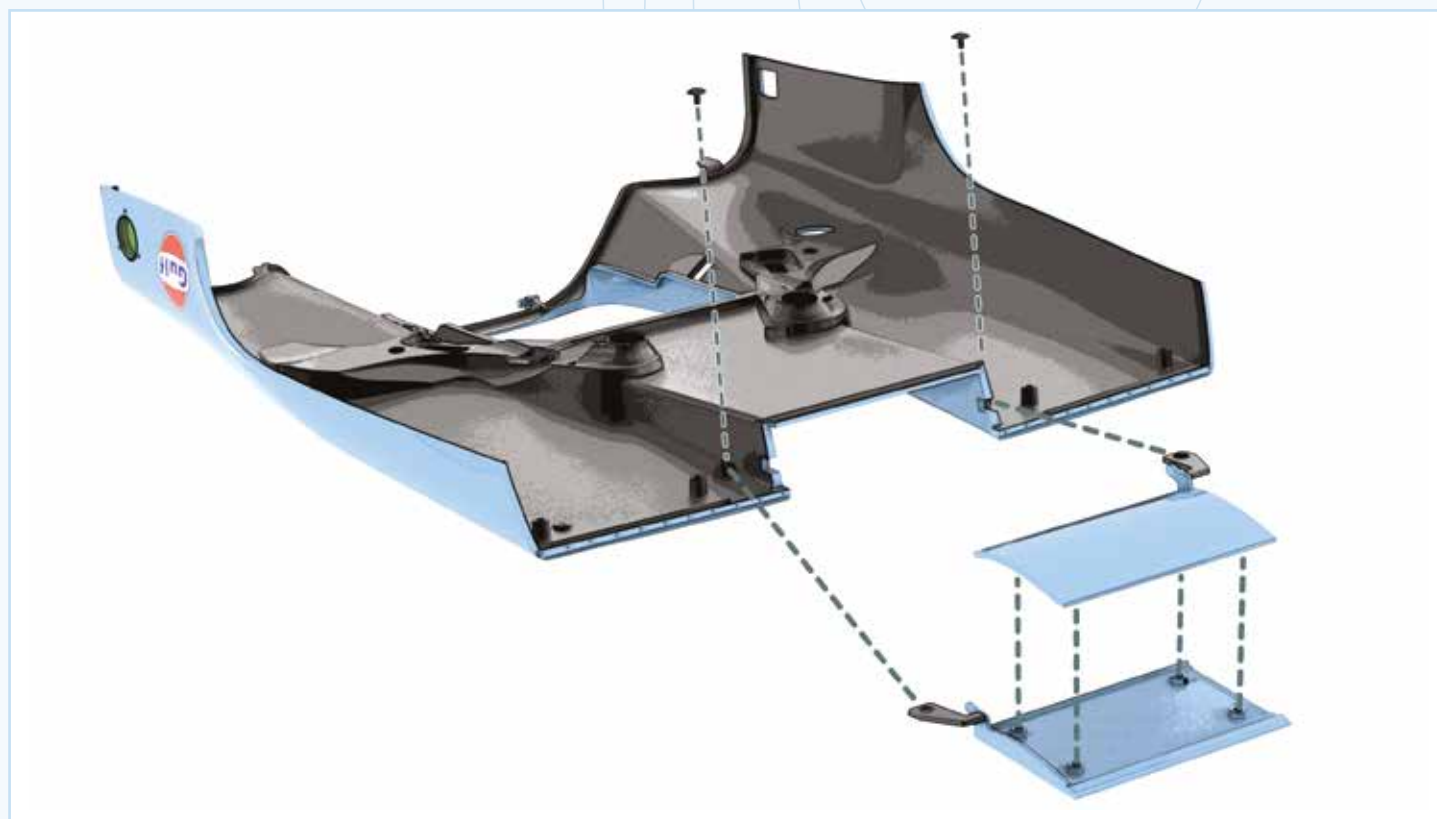
KM Screw M 1.7 x 3 x 5 mm (x 3)

92B Bottom centre spoiler



*Assembly of the rear
centre spoiler and
installation to the rear
bonnet*

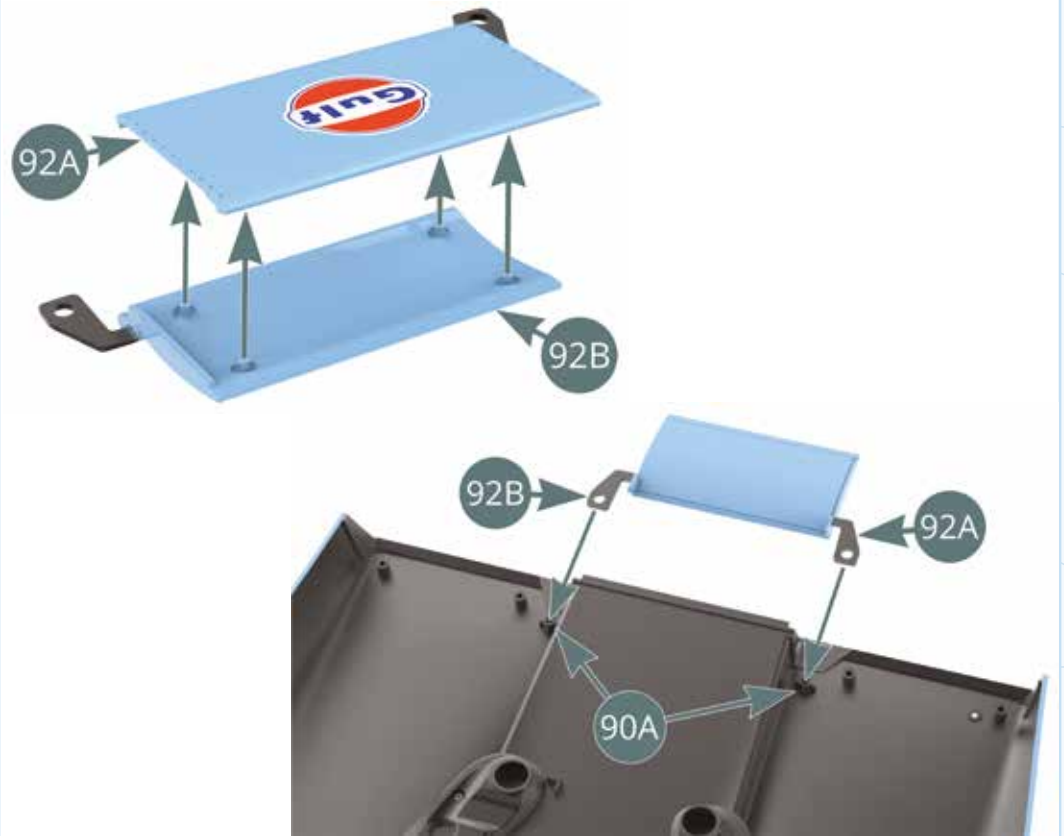
ASSEMBLY DIAGRAM





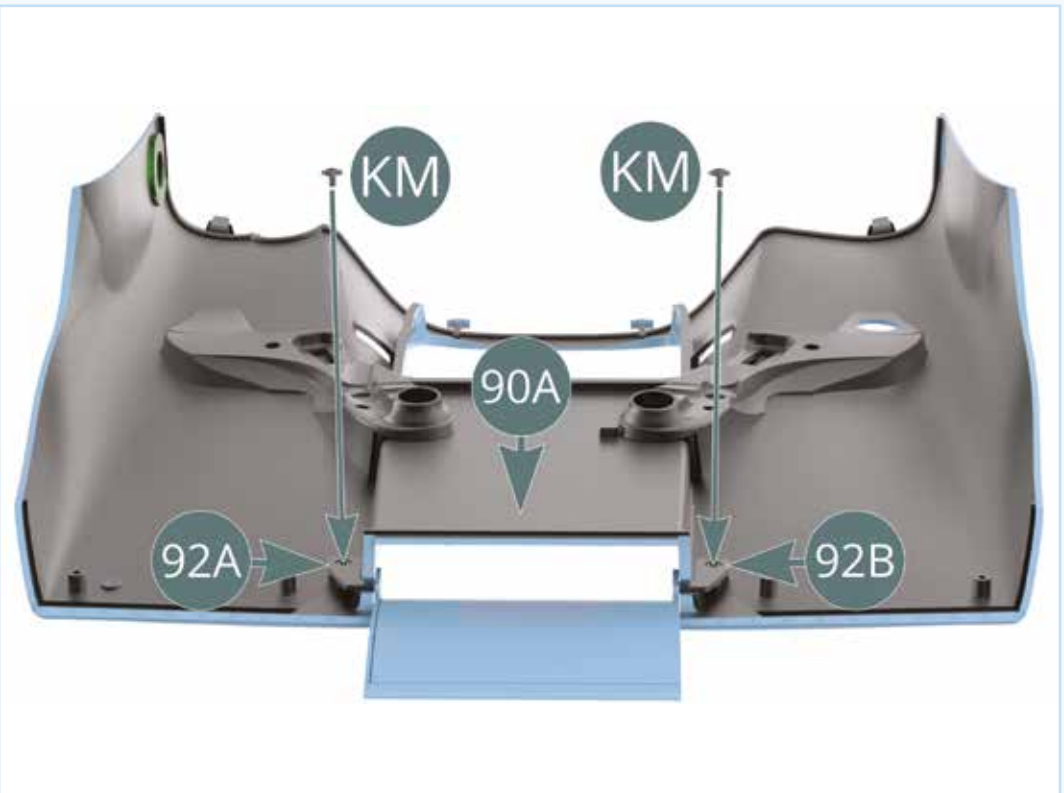
STEP 1

Assemble the top (92A) and bottom (92B) of the centre spoiler. Place the centre spoiler assembly - top (92A) and bottom (92B) - onto the rear bonnet (90A).

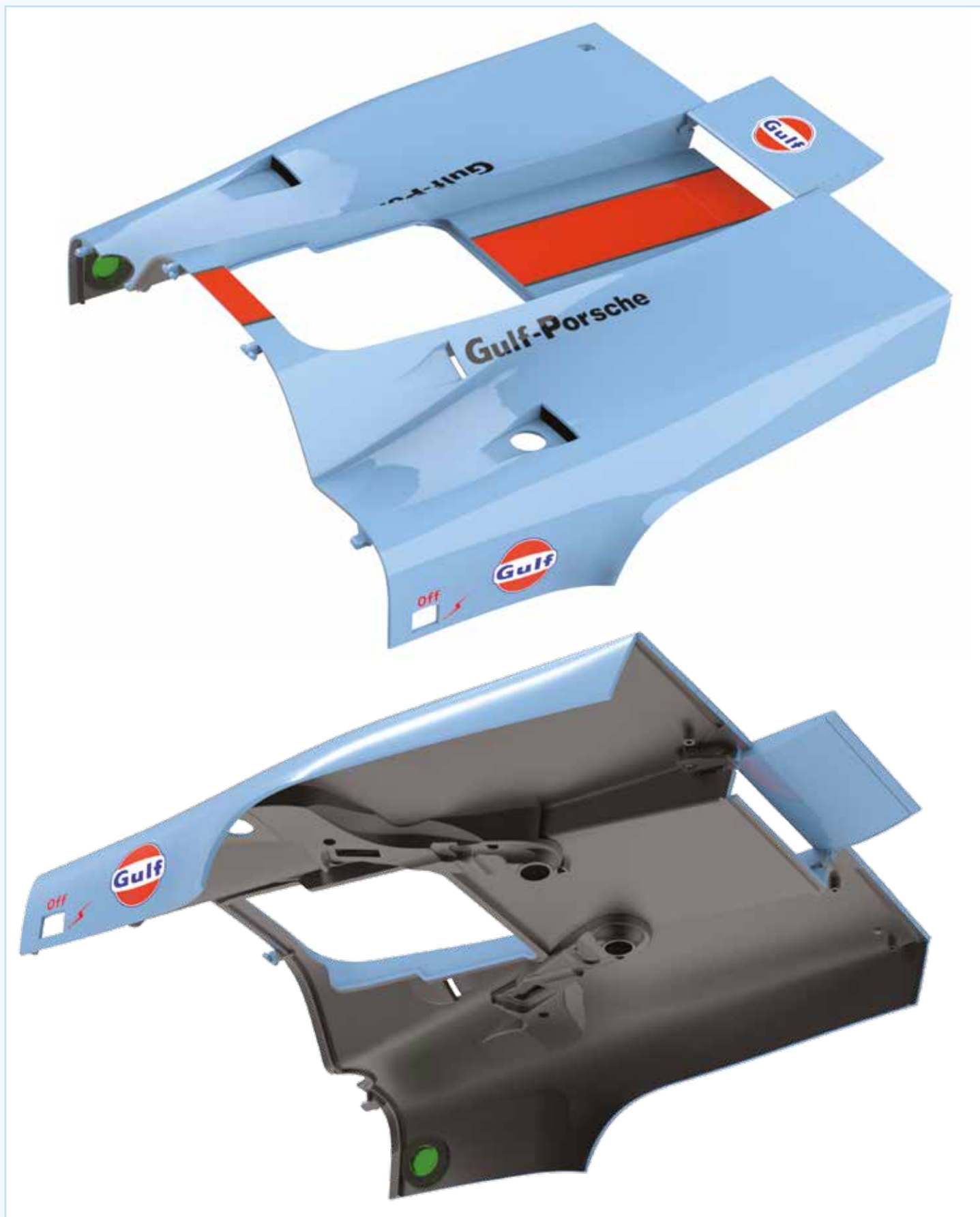


STEP 2

Attach the centre spoiler assembly - top (92A) and bottom (92B) - to the rear bonnet (90A) with two KM screws.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 93

93A Rear bonnet panel

93B Lock support (x 2)

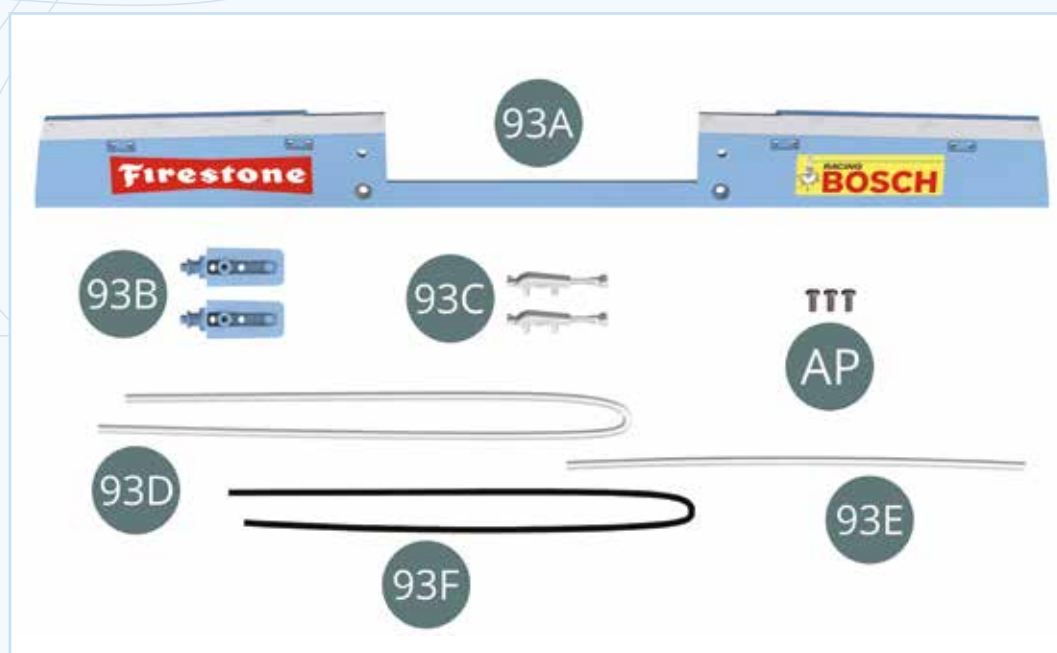
93C Lock (x 2)

93D Fuel hose (long)

93E Fuel hose (short)

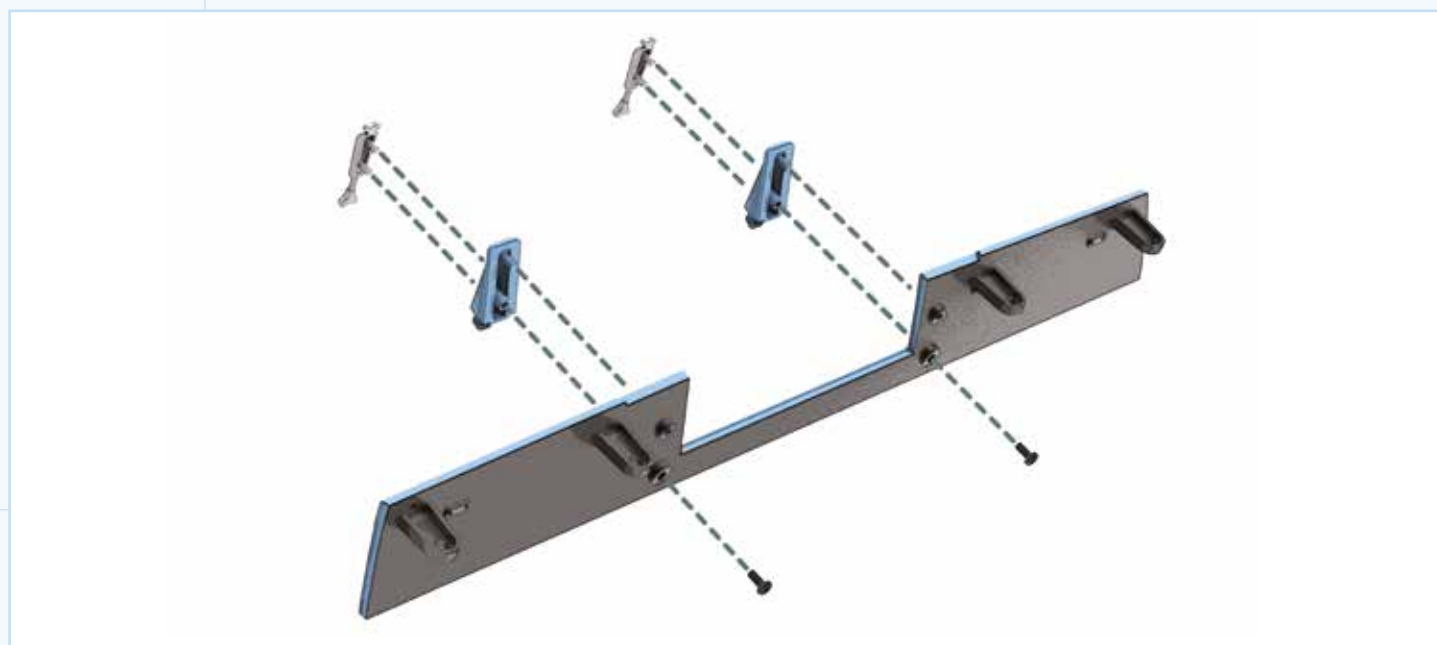
93F Fuel vent hose

Screw AP M 1.7 x 4 mm (x 3)

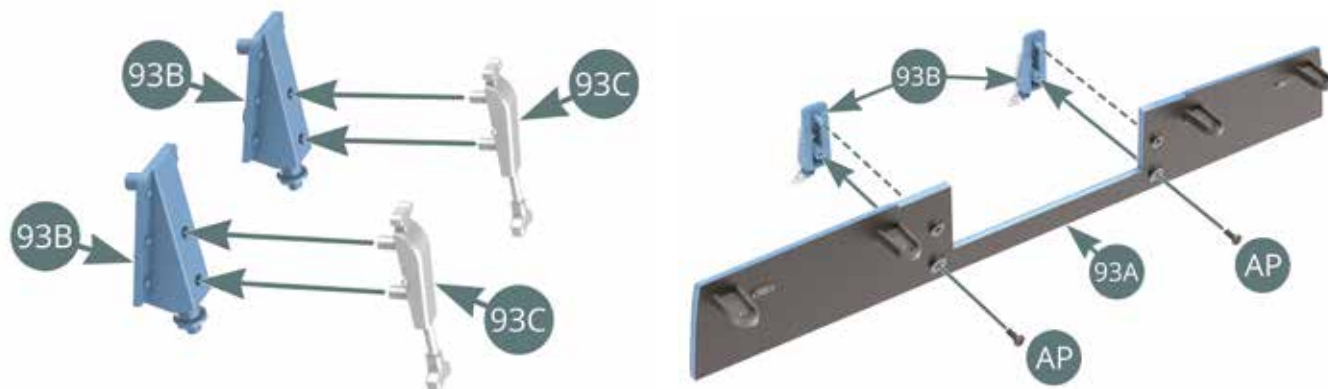


Rear bonnet panel
assembly and fuel line
adjustment

ASSEMBLY DIAGRAM



STEP 1

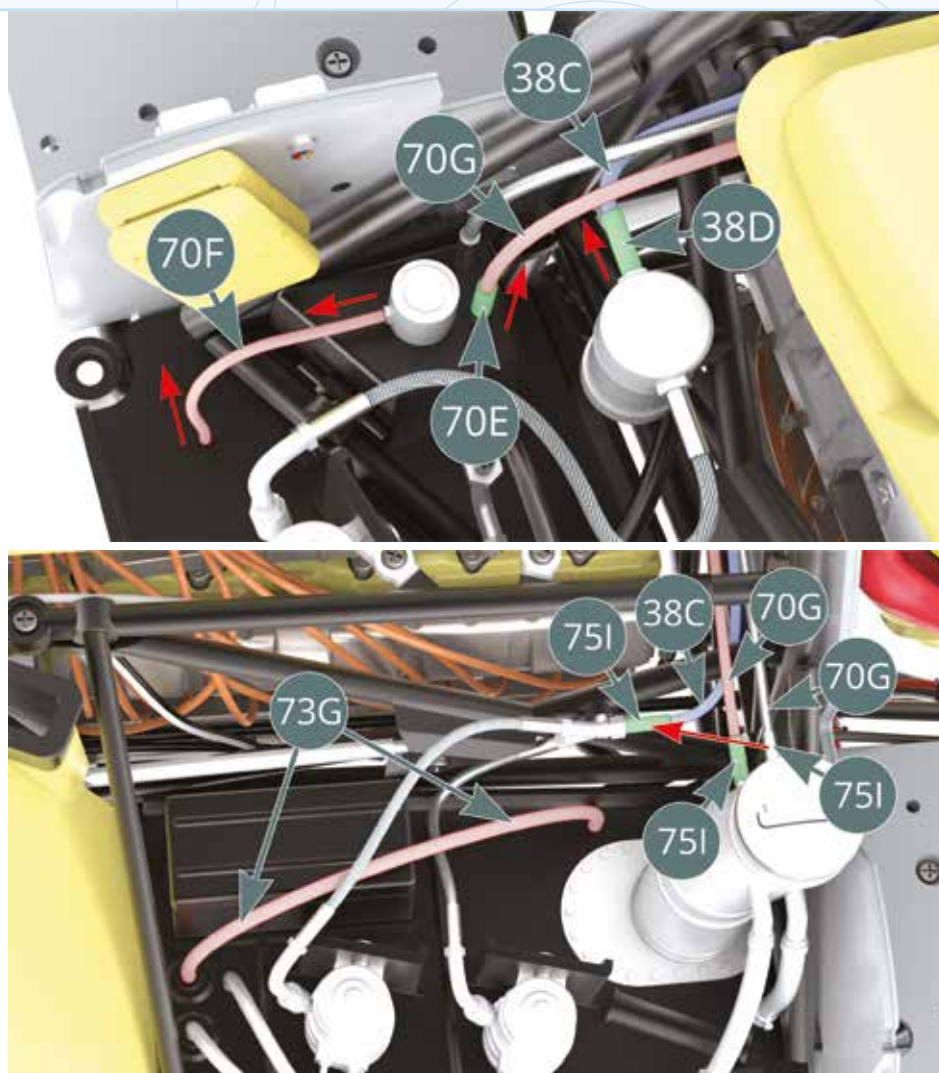


Position the two locks (93C) on the two lock supports (93B). Position the two lock supports (93B) on the rear bonnet panel (93A) and secure them with two AP screws.

STEP 2

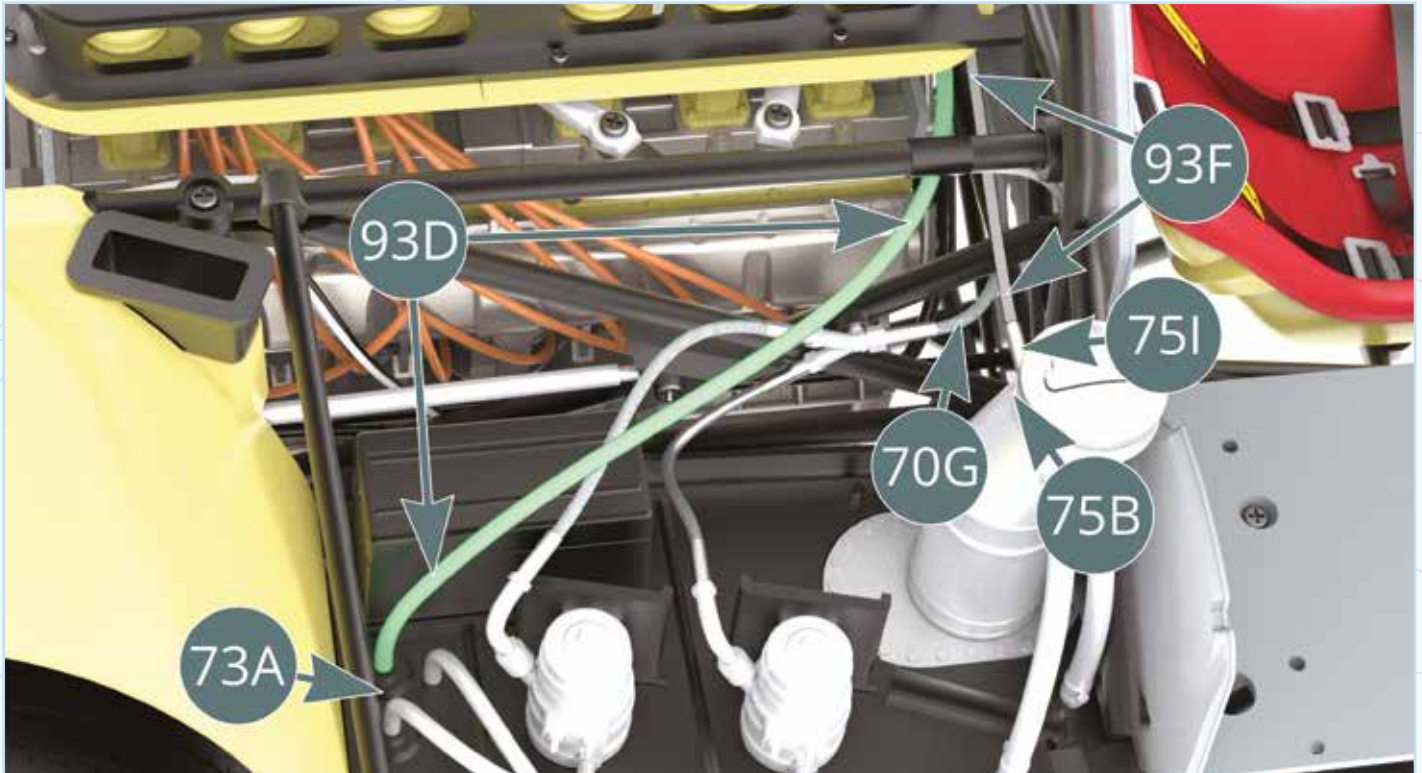
On the left side of the chassis, detach the fuel hose (70F) - highlighted in red. Remove the shielded fuel line (70G) - highlighted in red - by carefully pulling it upwards with its fitting (70E). Remove the fuel hose (38C) and its connector (38D).

On the right side of the chassis, detach the fuel hose (73G) - highlighted in red. Remove the shielded fuel line (70G) - highlighted in red - with its connector (75I). Remove the fuel hose (38C) - highlighted in blue - and its connector (75I) and replace it with the shielded fuel line (70G) with its connector (75I) that have just been removed.





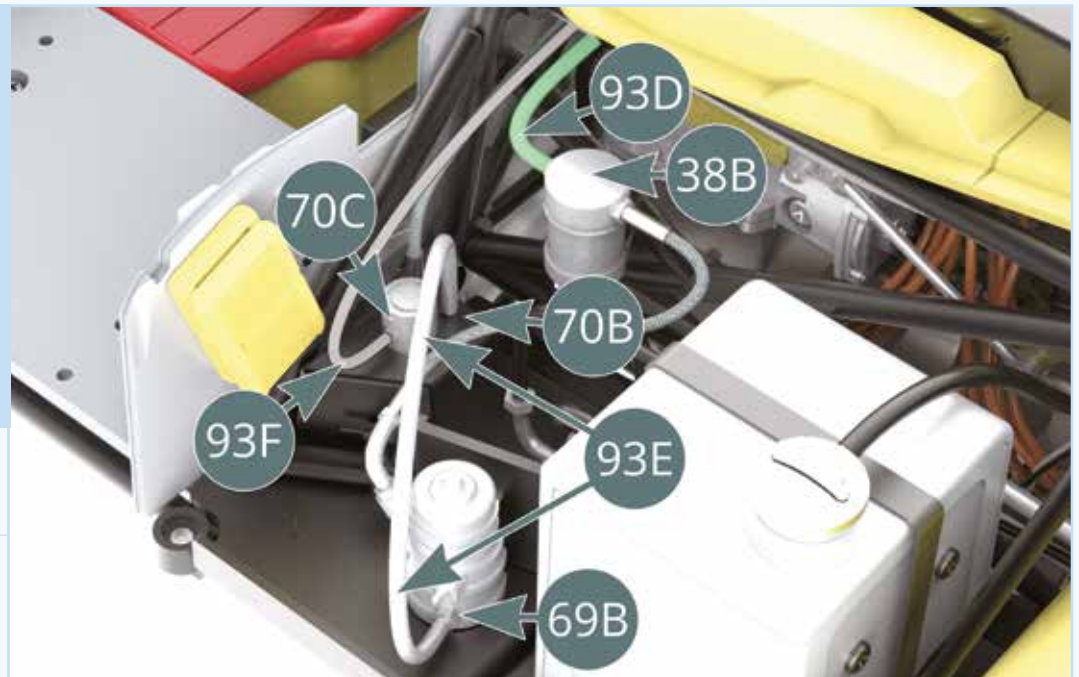
STEP 3



After reconnecting the shielded fuel line (70G) as described in the previous step, fit the fuel hose - long (93D) to the nozzle located on the right side platform (73A), then point the free end towards the other side of the chassis, sliding it along the front of the engine. Attach the fuel breather pipe (93F) with connector (75I) to one of the two nozzles on the fuel filler neck (75B), then point the free end towards the other side of the chassis, sliding it along the front of the engine.

STEP 4

Return to the left side of the chassis and fit the fuel hose - long (93D) to the fuel filter (38B), then fit the fuel vent tube (93F) to the nozzle on the fuel cap (70C). Attach the fuel hose - short (93E) to the fuel manifold (70B) and nozzle of the fuel pump (69B).

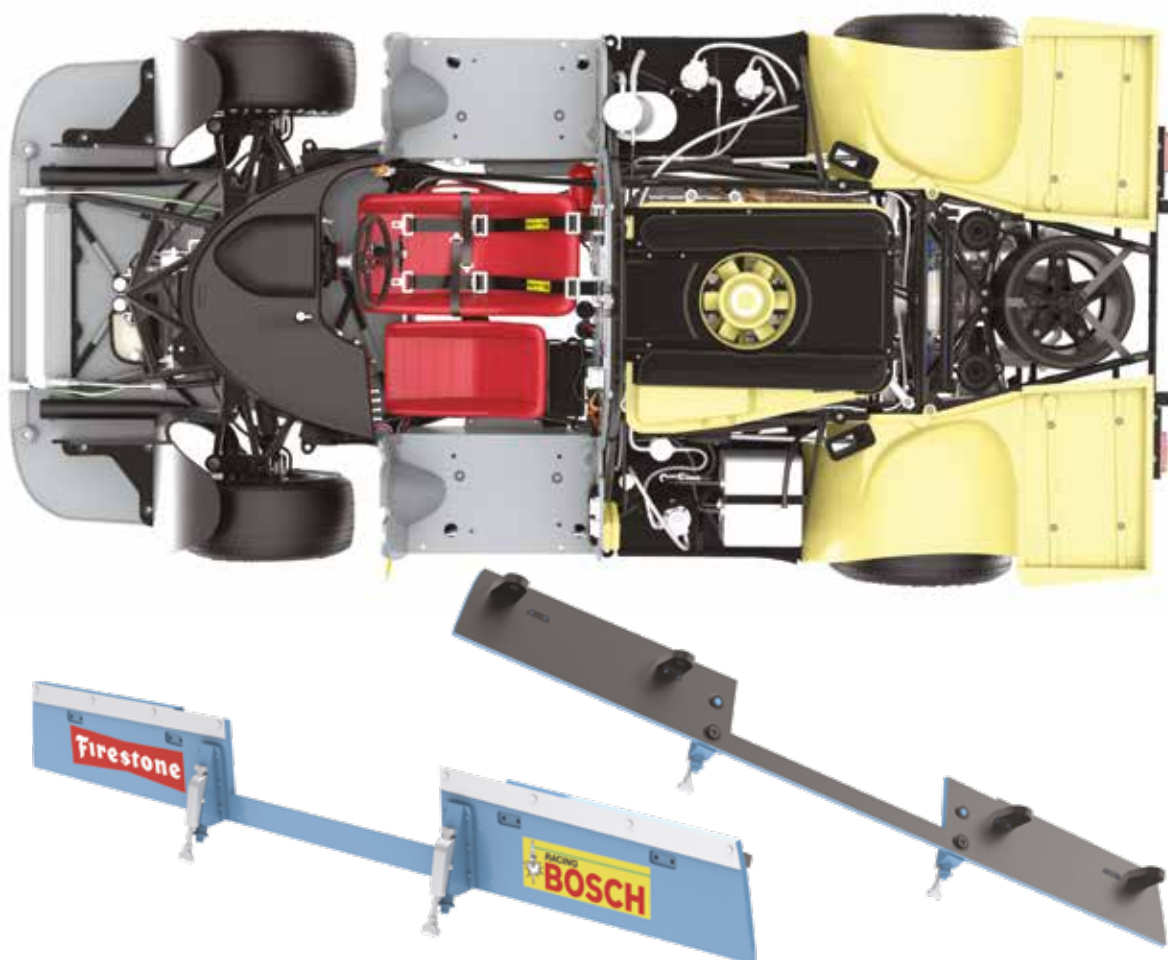


STEP 5

General layout of fuel hoses



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 94

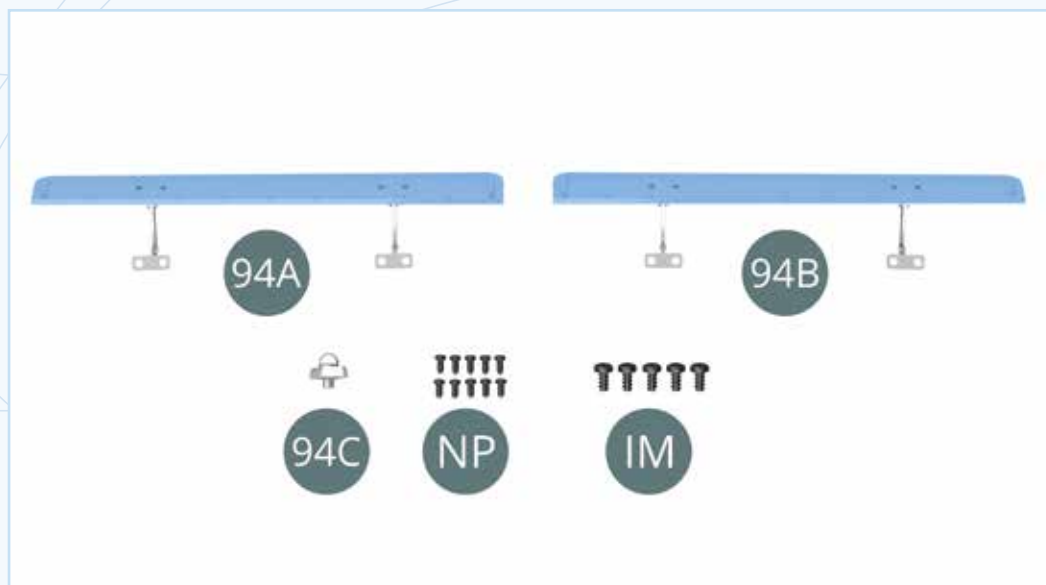
94A Left side spoiler (L)

94B Right side spoiler (R)

94C Rear bonnet light

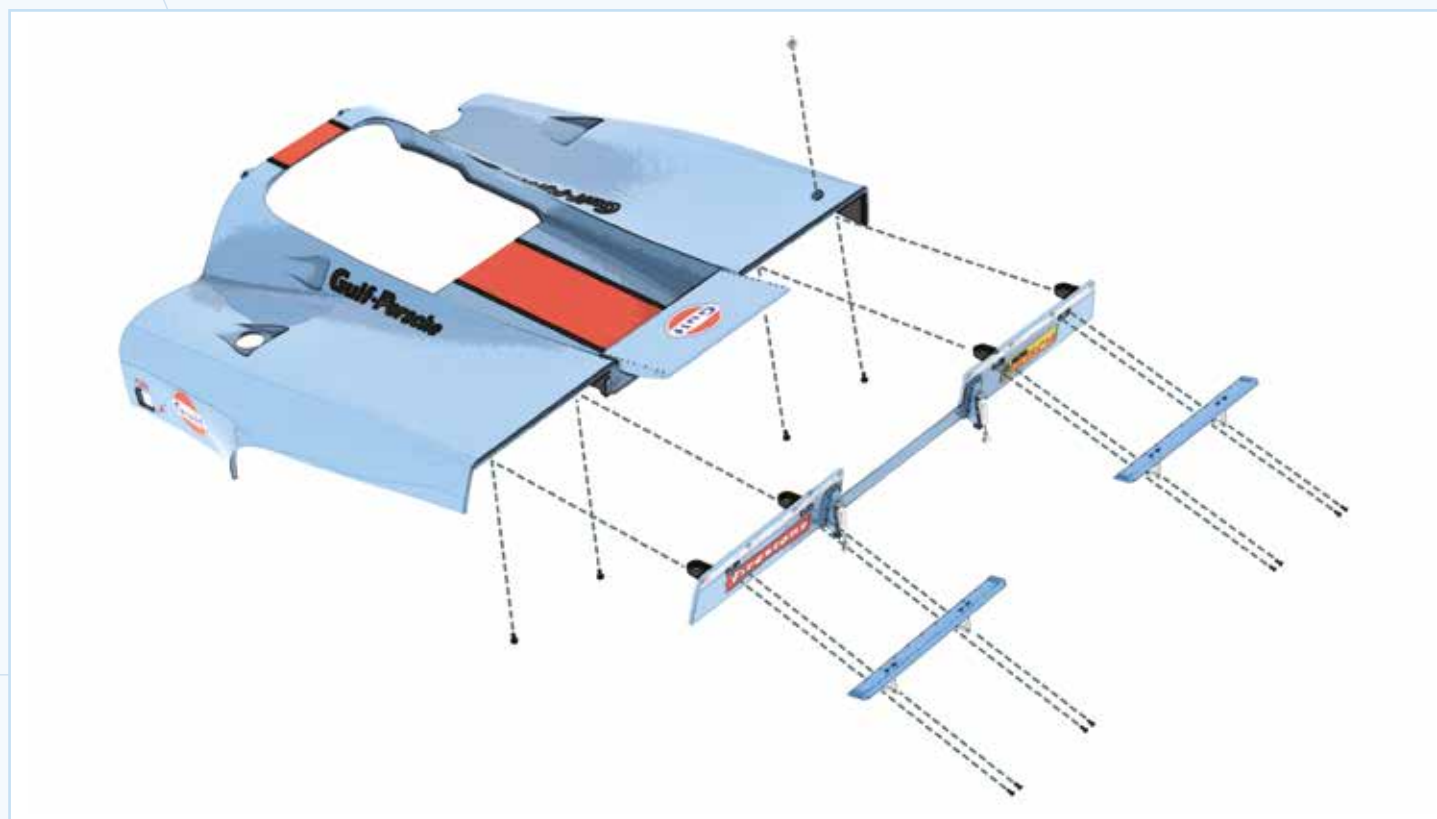
Screw NP M 1.2 x 2.5 mm (x 10)

Screw IM M 1.7 x 3.5 mm (x 5)

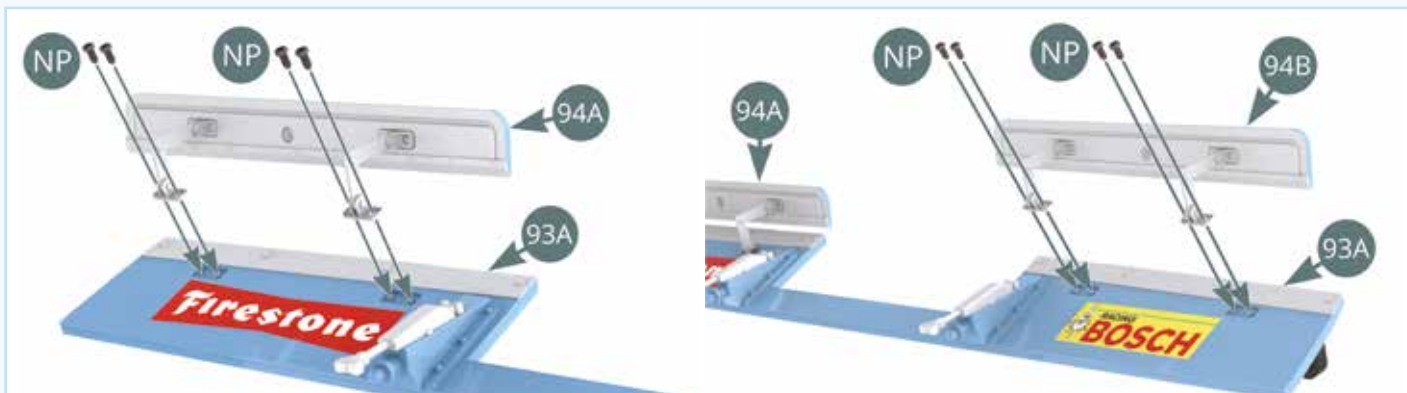


*Assembly of spoilers and
installation of rear bonnet
panel*

ASSEMBLY DIAGRAM



STEP 1

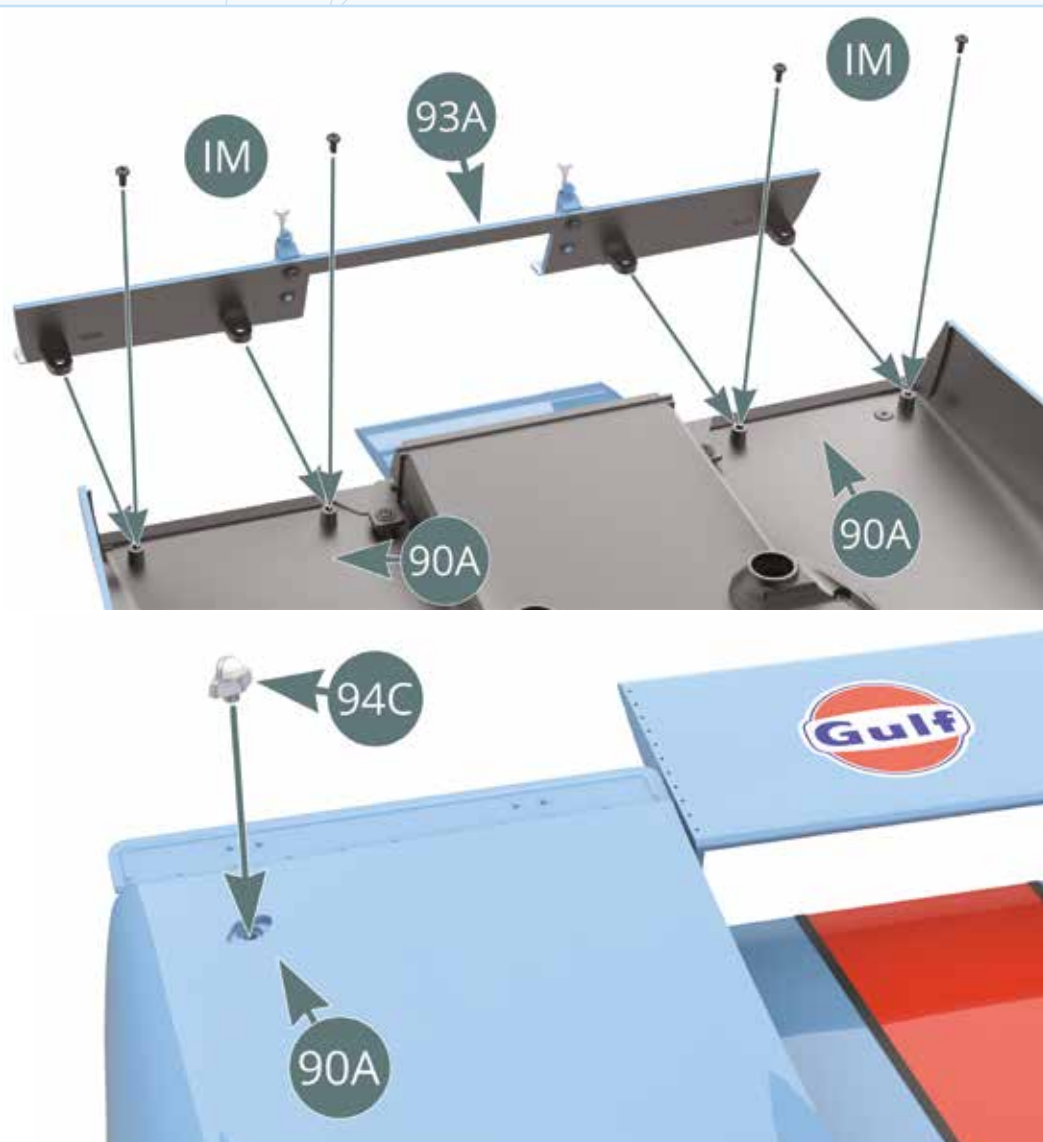


Position the left spoiler (94A) on the rear bonnet panel (93A) and secure with four NP screws.
Position the right spoiler (94B) on the rear bonnet panel (93A) and secure with four NP screws.

STEP 2

Position the rear bonnet panel (93A) on the rear bonnet (90A) and secure with four IM screws.

Position the light (94C) above the right side of the rear bonnet. Position the white glass of the rear bonnet light towards the front of the car.





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 95

95A Left half ventilation duct

95B Left half ventilation duct

95C Right half ventilation duct

95D Right half ventilation duct

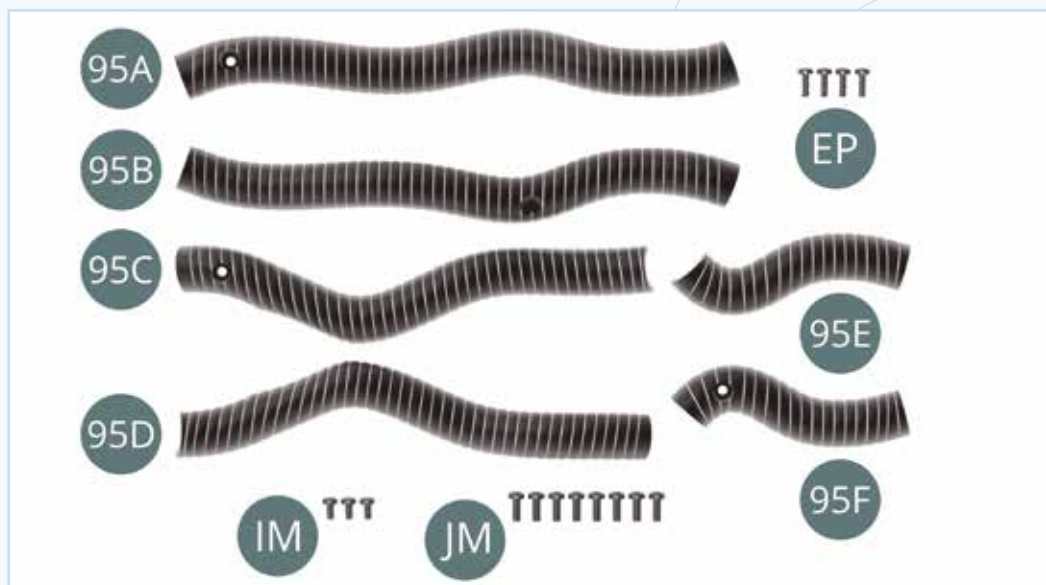
95E Right half ventilation duct

95F Right half ventilation duct

Screw EP M 1.7 x 5 mm (x 4)

Screw IM M 1.7 x 3.5 mm (x 3)

Screw JM M 2.0 x 5 mm (x 8)



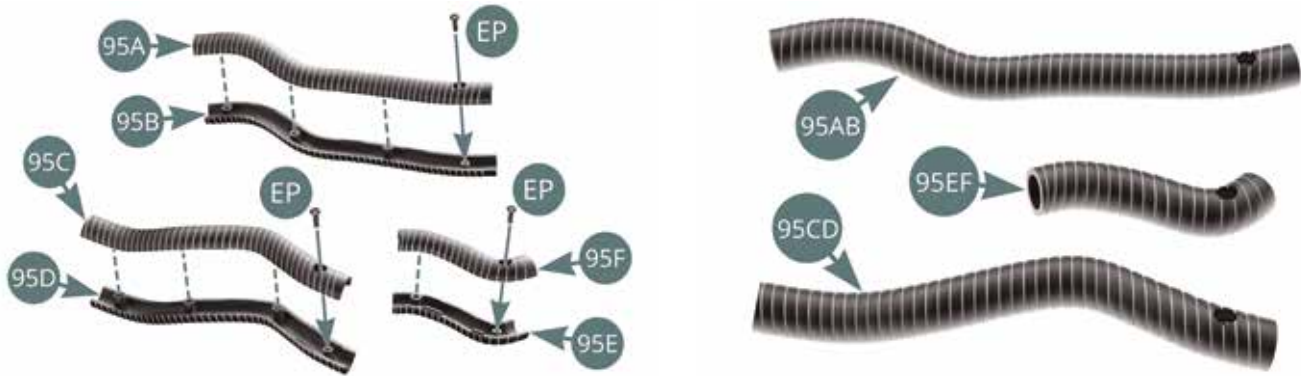
*Assembling of the
cabin ventilation
ducts and mounting
of the body to the
chassis*

ASSEMBLY DIAGRAM





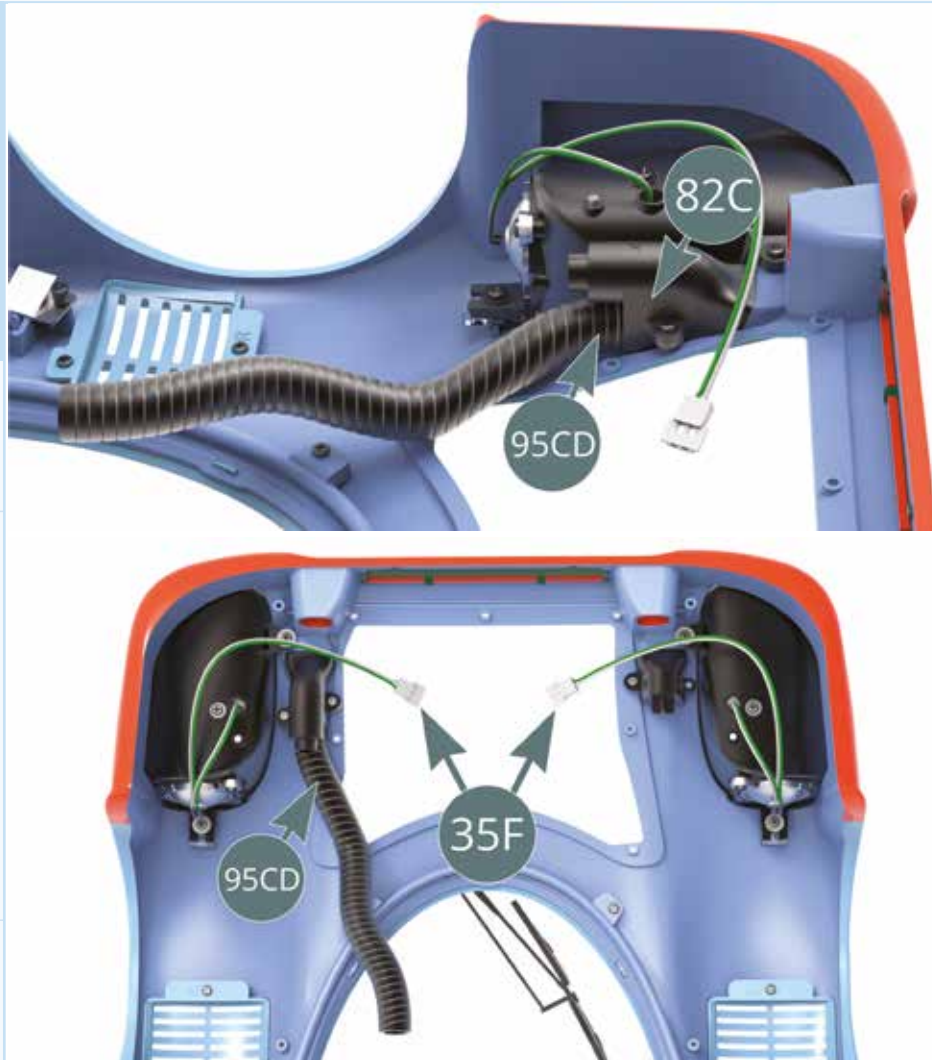
STEP 1



Assemble the half-duct units (95A&95B) and secure them together with an EP screw to form the left ventilation duct (95AB) - top illustration. Assemble the half-duct units (95C&95D) and secure them together with an EP screw to form the right ventilation duct (95CD) - illustration above left. Assemble the half-duct units (95E&95F) and secure them together with an EP screw to form the right vent duct (95EF) - illustration above right.

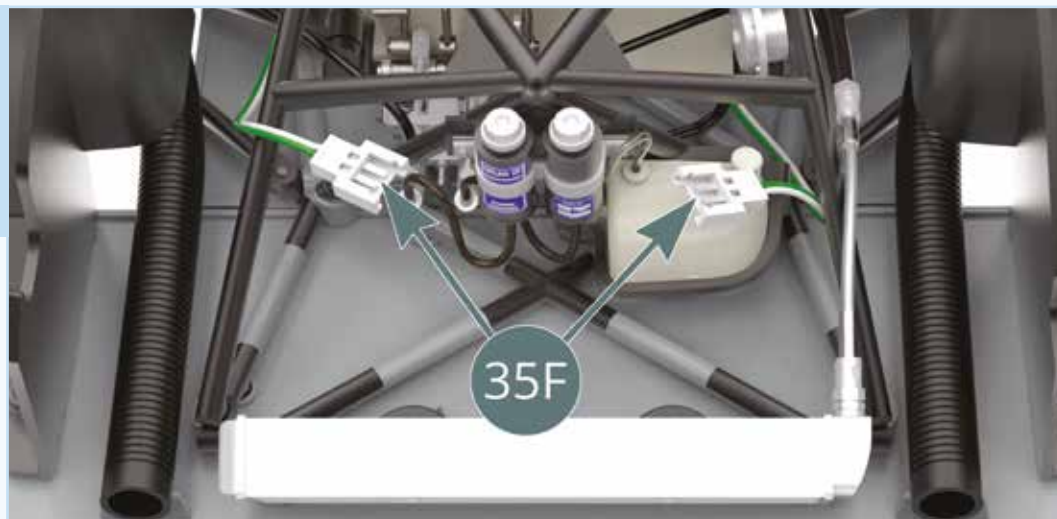
STEP 2

Fit the screw threaded end of the right duct (95CD) to the nozzle of the right air intake (82C) - closest to the bodywork. Place the connectors for the headlight LED cables (35F) into the position indicated opposite.



STEP 3

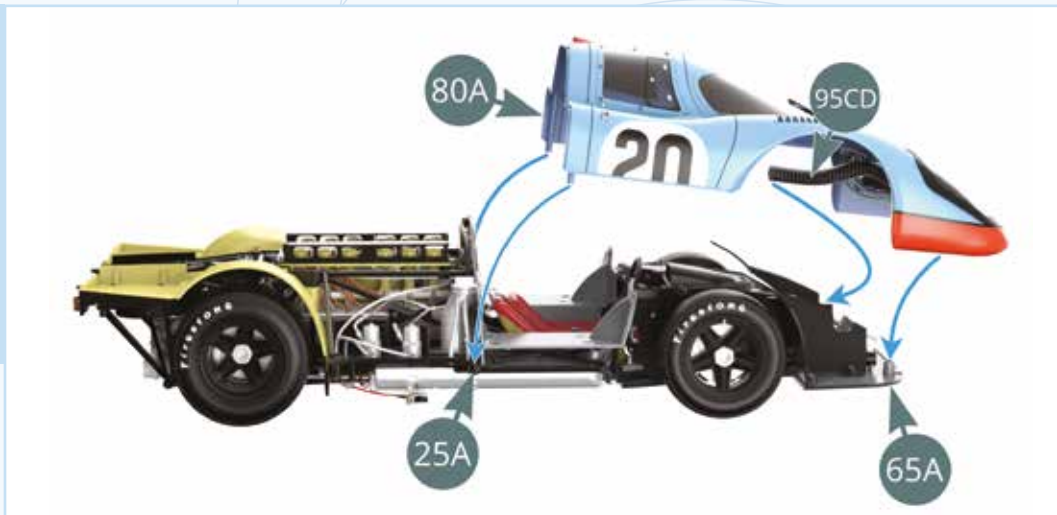
At the front end of the chassis, place the connectors for the headlight LED cables (35F) into the position indicated opposite.



STEP 4

Position the body (80A) on the lower frame (25A) and on the flat front floor (65A).

At the same time, guide the right duct (95CD) through the tubular trellis as illustrated in the next step.



STEP 5

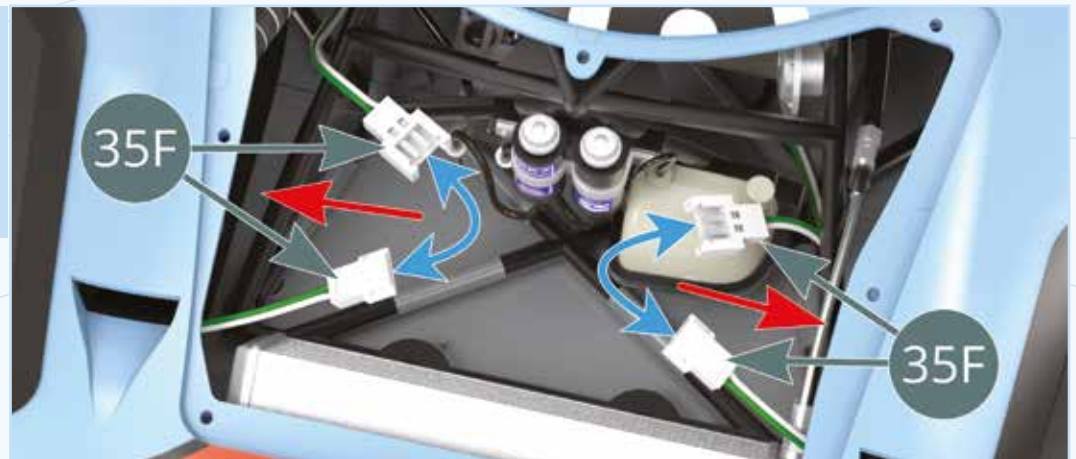
Pass the right duct (95CD) through the tubular trellis below the dashboard.





STEP 6

Join the connectors for the headlight LED cables (35F), then move them sideways to conceal them (red arrows).



STEP 7

Attach the screw threaded end of the right duct (95EF) to the nozzle of the right air intake (82C). Pass the left duct (95AB) through the tubular trellis, which can be made easier by gently pulling it from the left open door.

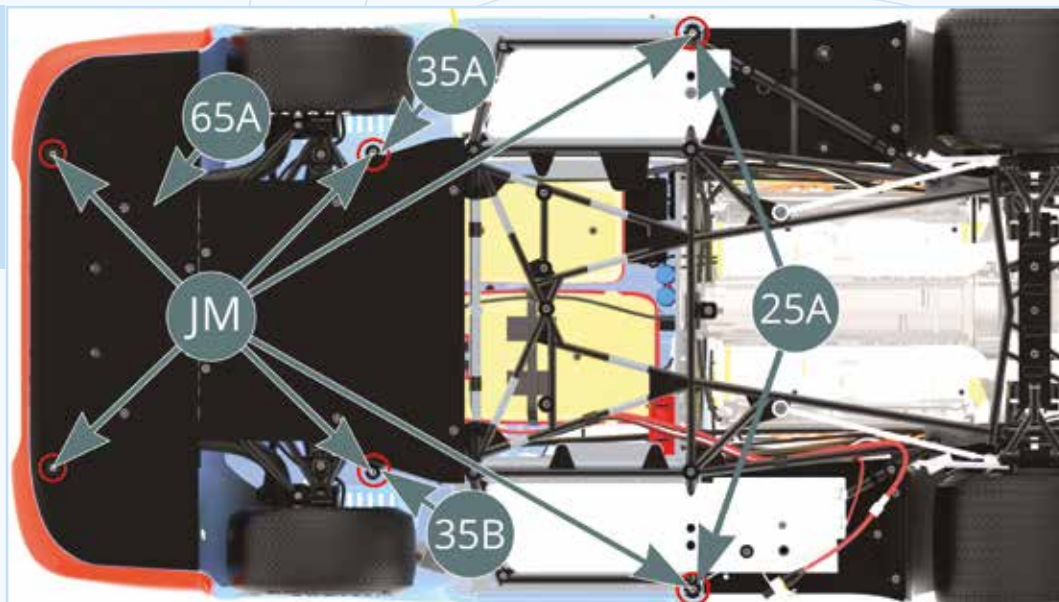


STEP 8

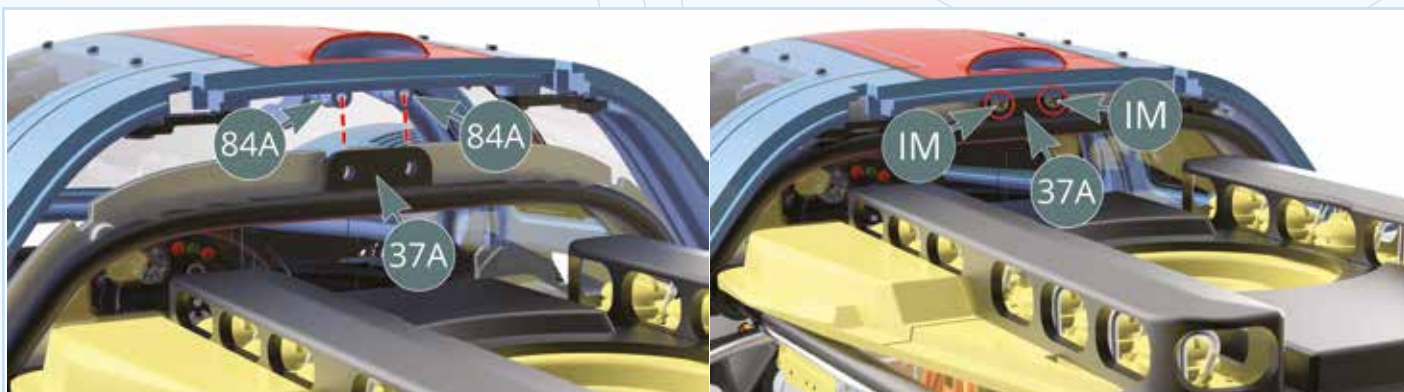
Attach the screw-threaded end of the left duct (95AB) to the nozzle of the left air intake (82B) with the help of a tweezer.



Secure the body from below, to the front flat floor (65A), the lower frame (25A) and the left (35A) and right (35B) mudguards, using six JM screws.



STEP 9



Attach the tab of the cockpit bulkhead (37A) and the two ends of the upper roll bar (84A) together using two IM screws - illustrations above.

GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 96

96A Left rocker panel

96B Upper bracket

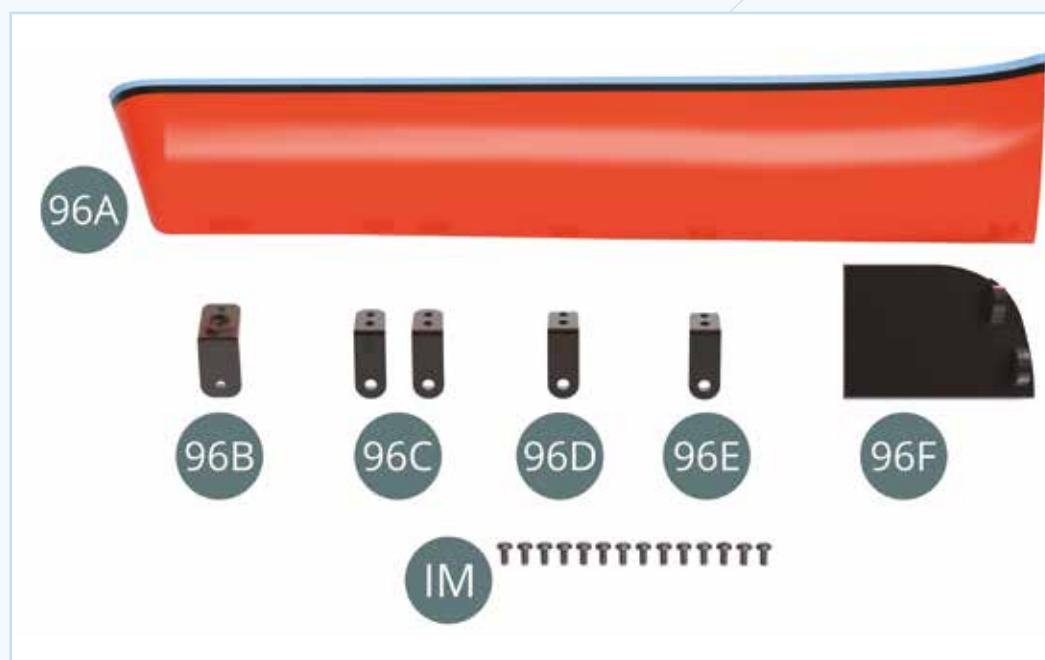
96C Bracket #1 (x 2)

96D Bracket #2

96E Bracket #3

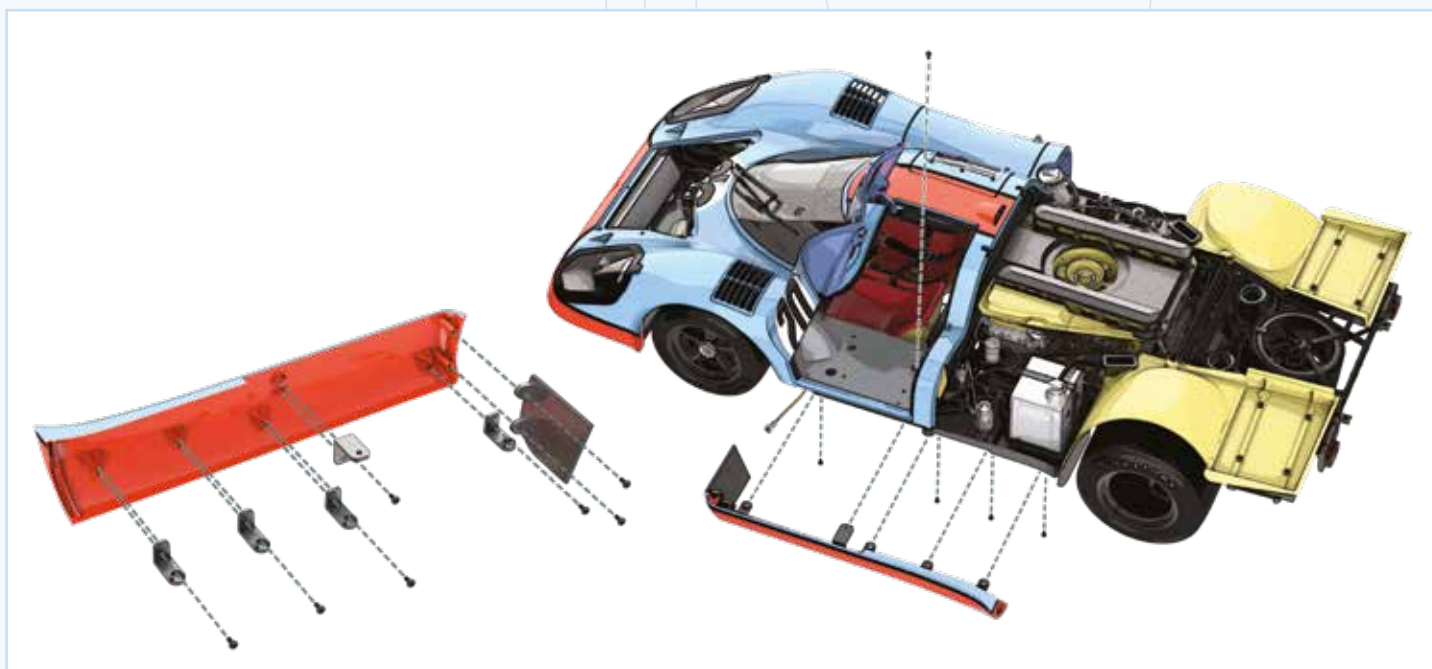
96F Front panel

Screw IM M 1.7 x 3.5 mm (x 14)



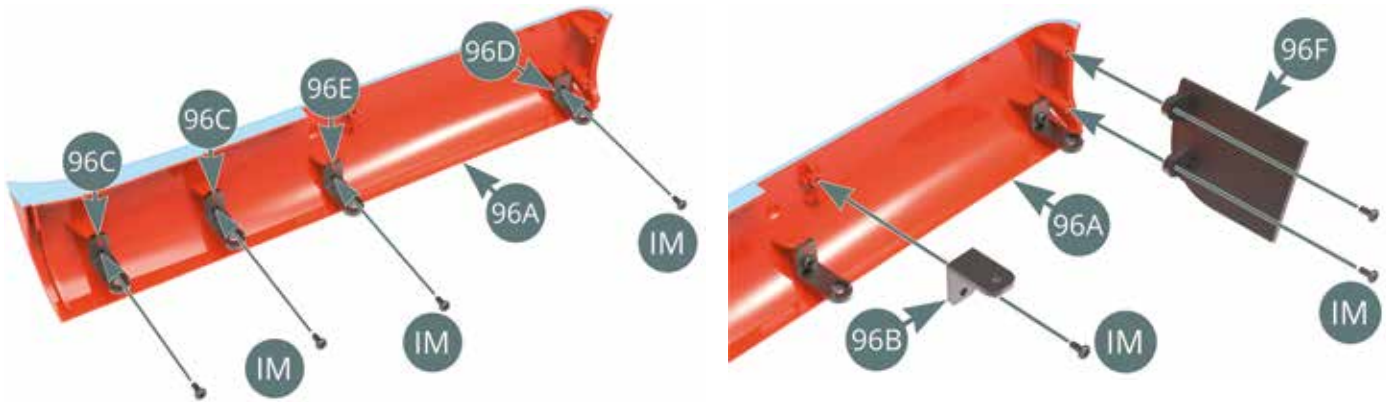
Assembly and
installation of the
left rocker panel

ASSEMBLY DIAGRAM





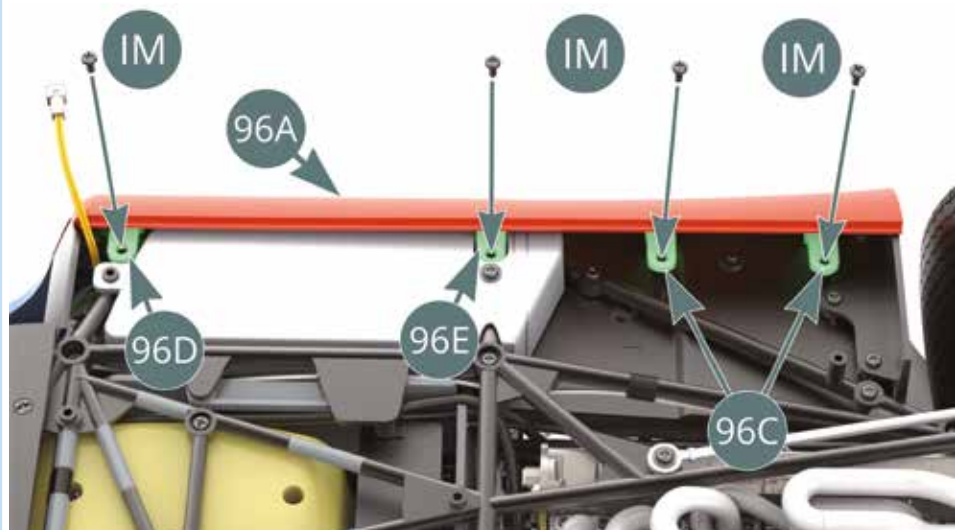
STEP 1



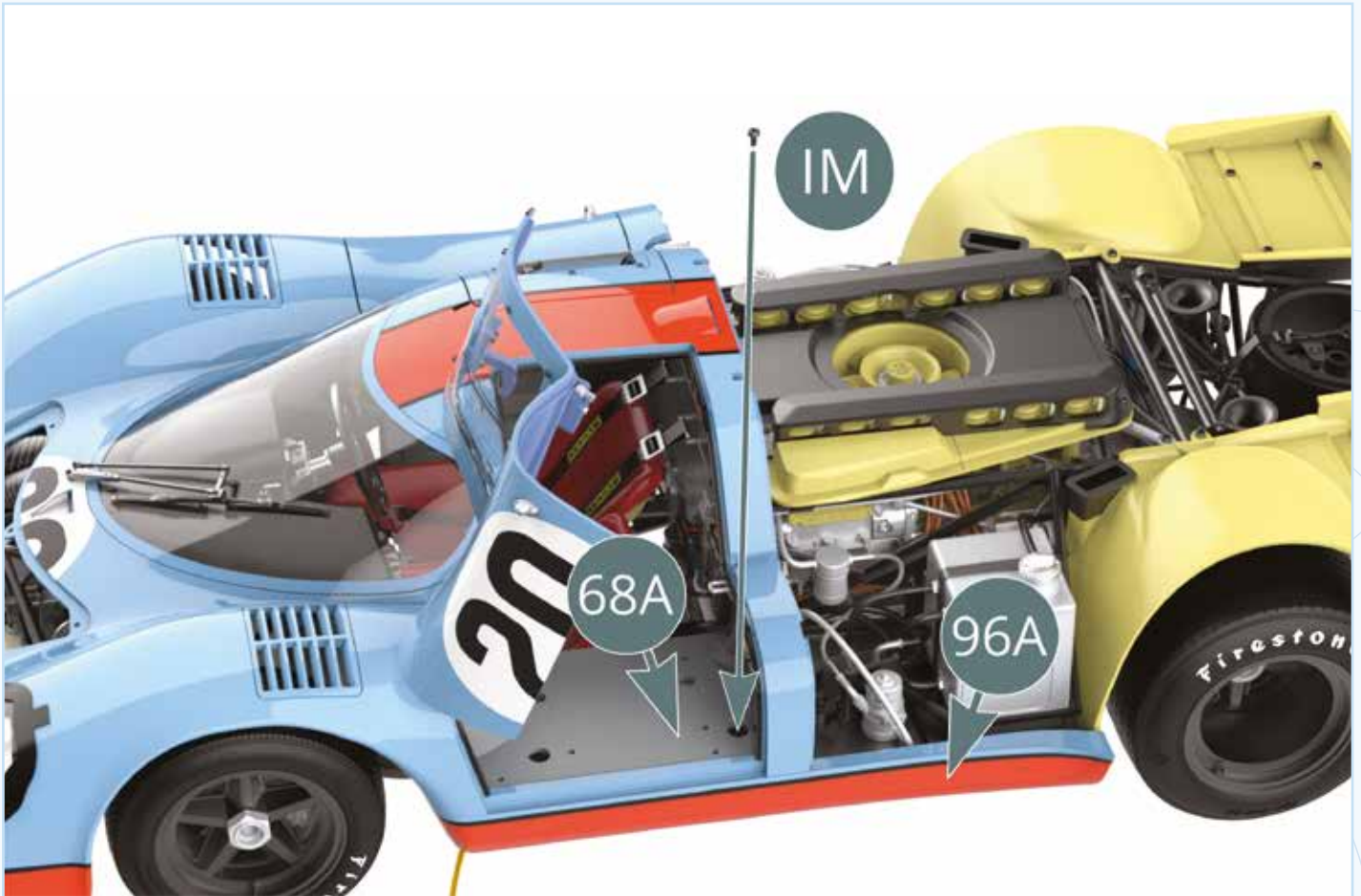
Position the brackets (96D #2, 96E #3) and the two brackets (96C #1) on the left rocker panel (96A), then secure them with four IM screws. Position the upper bracket (96B) and the front panel (96F) on the left rocker panel (96A), then secure them with three IM screws.

STEP 2

Position the left rocker panel (96A) on the mounting points of the lower frame (25A) and of the left side platform (69A), then secure with four IM screws - illustrations opposite and below. Be sure to conceal the connection cables behind the front panel (96F) - red arrow - and the yellow cable should remain extended.



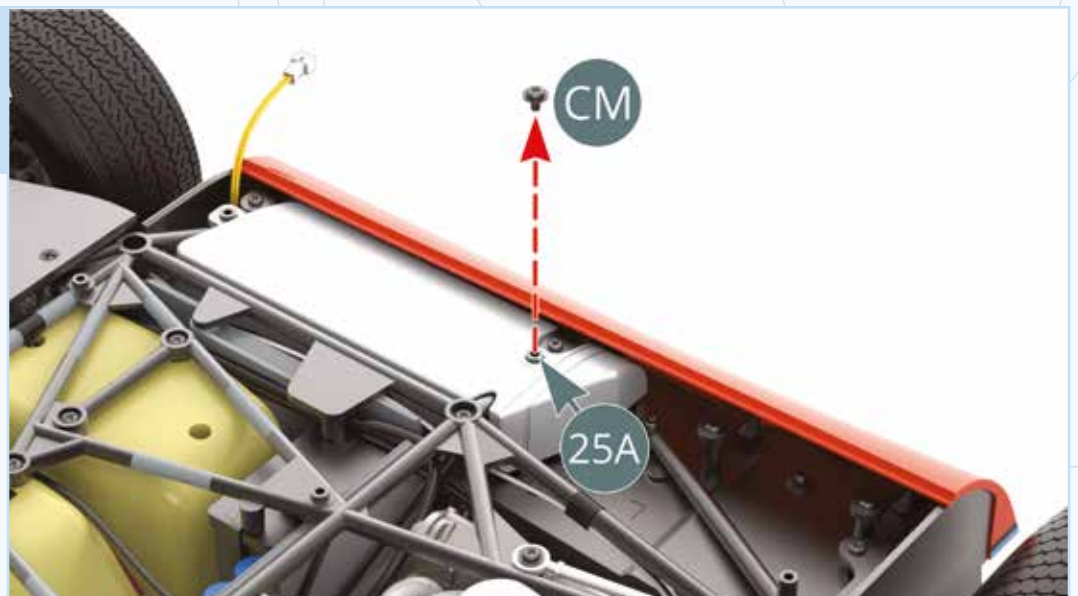
STEP 3



Open the left door and secure the left rocker panel (96A) - via the upper bracket 96B - to the chassis (31B) using an IM screw, through an opening in the rear of the left cockpit housing (68A).

STEP 4

Remove the CM screw from under the lower frame (25A), as it is no longer required.





GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 97

97A Rocker panel, right

97B Upper support

97C Bracket #1 (x 2)

97D Bracket #2

97E Bracket #3

97F Front panel

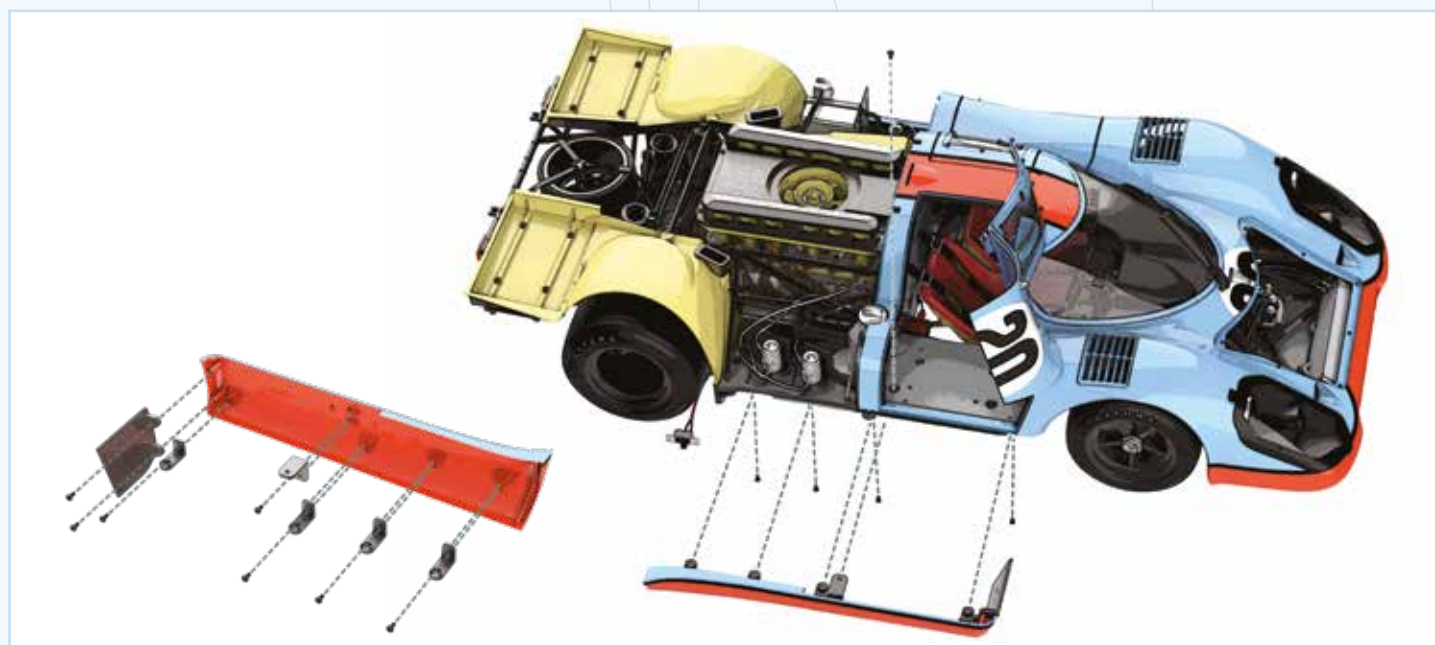
Screw IM M 1.7 x 3.5 mm (x 14)

Screw SM M 1.7 x 3.5 mm (x 3)



*Assembly and fitting of
the right side rocker panel*

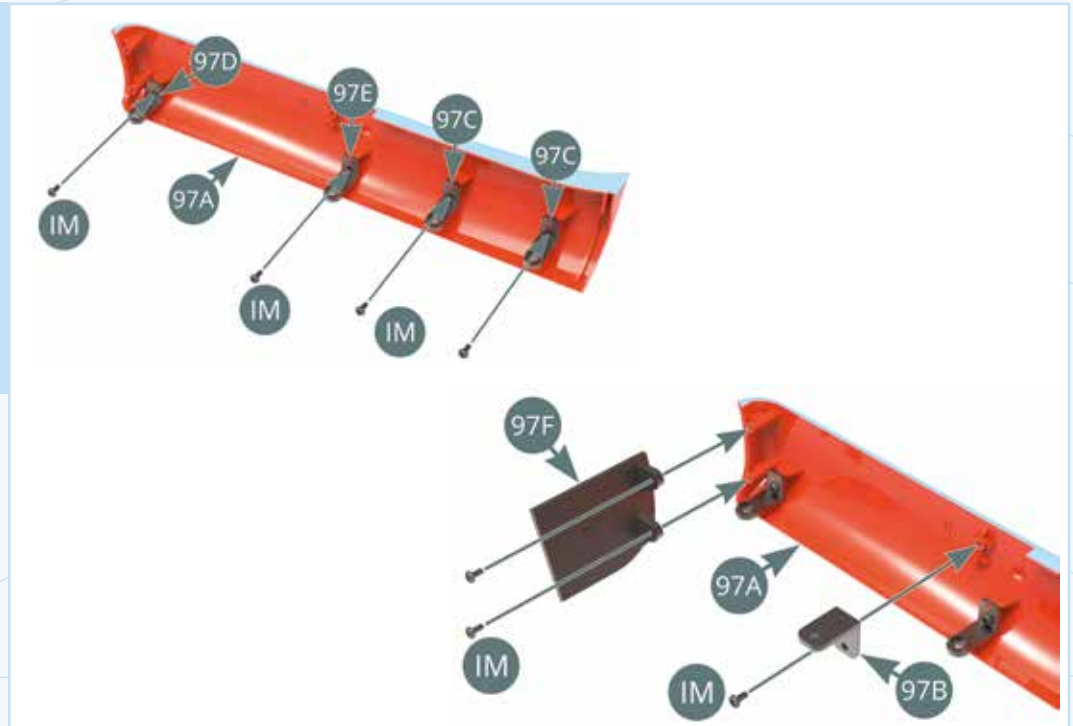
ASSEMBLY DIAGRAM





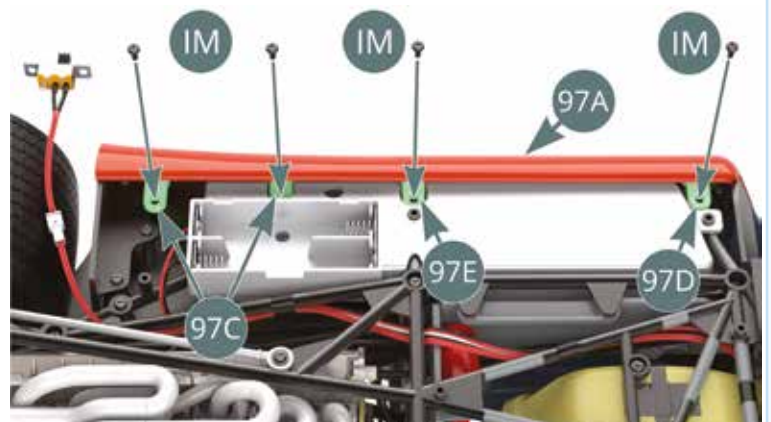
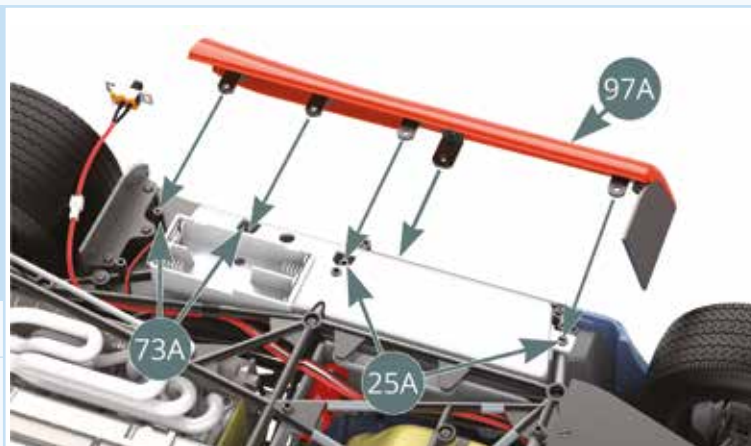
STEP 1

Place the brackets (97D#2 & 96E#3) and brackets (97C#1) on the right rocker panel (97A) and secure these with four IM screws. Place the upper support (97B) and the front panel (97F) onto the right rocker panel (97A) and secure these with 3 IM screws.



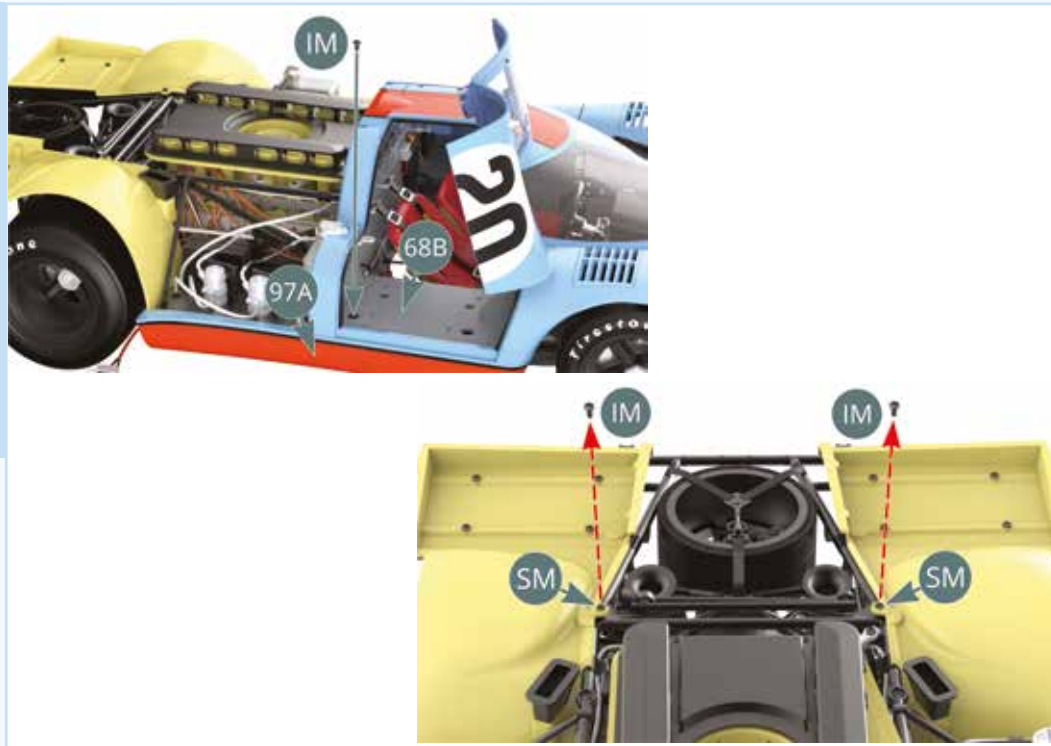
STEP 2

Position the right rocker panel (97A) onto the attachment points of the lower frame (25A) and right side platform (73A) and secure with four IM screws (see opposite and below).



STEP 3

Open the right door and attach the right rocker panel (97A) – with the help of the upper support (97B) – onto the chassis (34B) with an IM screw, through the opening in the back of the right cockpit housing (68B). Replace the two IM screws with the new provided SM screws.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 98

98A Left trim panel

98B Right trim panel

98C Left trim strip

98D Right trim strip



98A



98B



98C



98D

Attaching trim panels and trim strips to the cockpit

ASSEMBLY DIAGRAM



STEP 1



Open the right door and secure the right trim panel (98B) with its four lugs to the right cockpit housing (68B). Attach the right trim strip (98D) along the edge of the right trim panel (98B) to the right cockpit housing (68B).

STEP 2

With the right trim strip (98D) and right trim panel (98B) fitted, now close the right door.

Open the left door and fit the left trim panel (98A) by sliding it under the ignition box (56L) - green arrow - then over the left cockpit housing (68A) - blue arrow.



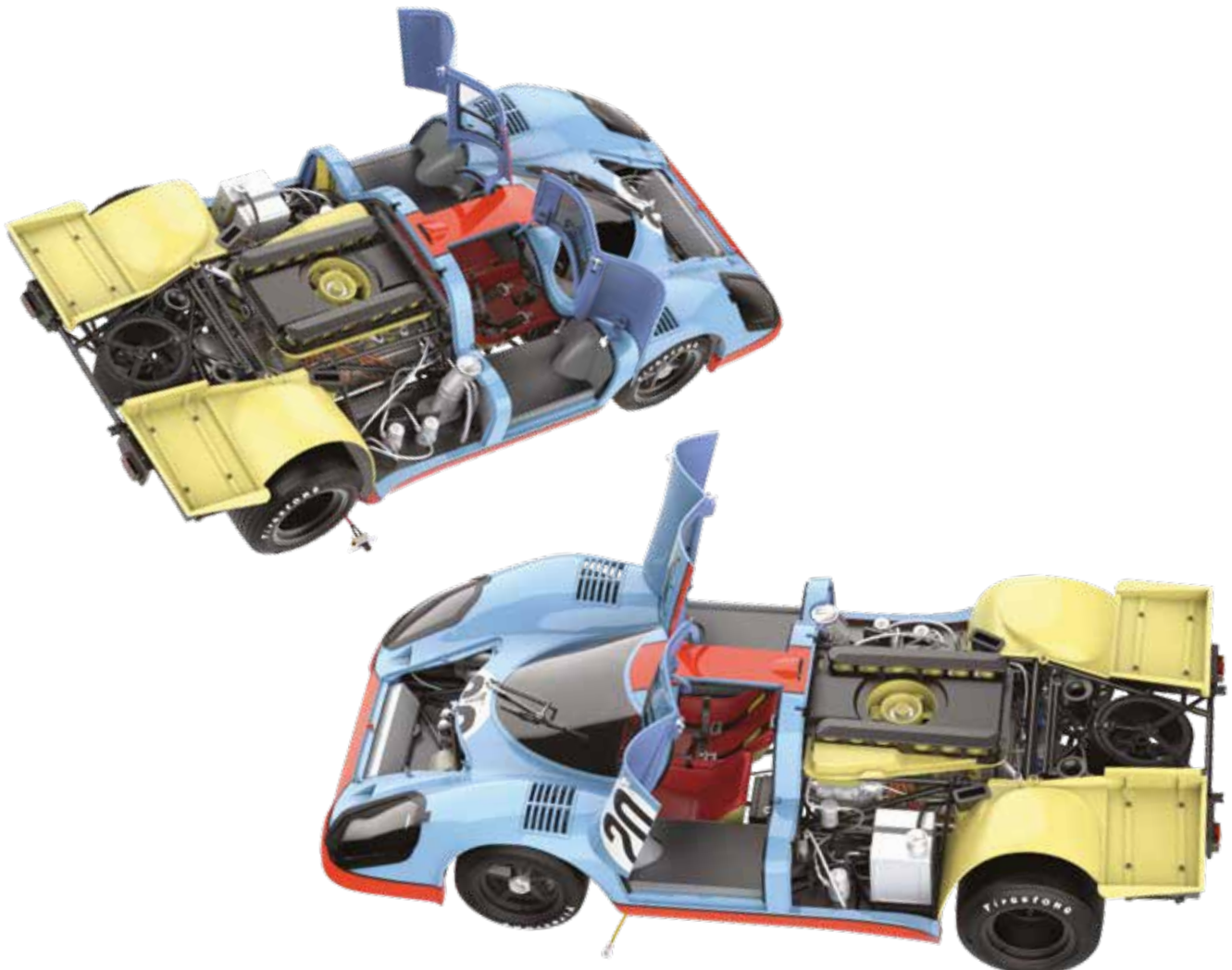


STEP 3



Fit the left trim strip (98C) along the edge of the left trim panel (98A) to the left cockpit housing (68A). With the left trim strip (98C) and left trim panel (98A) attached, proceed to close the left door.

GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 99

99A Flat floor panel

99B Fixing bracket

99C Decal (x 2)

Screw BM M 2.0 x 4 mm (x 8)

Screw PM M 2.0 x 4 mm (x 6)

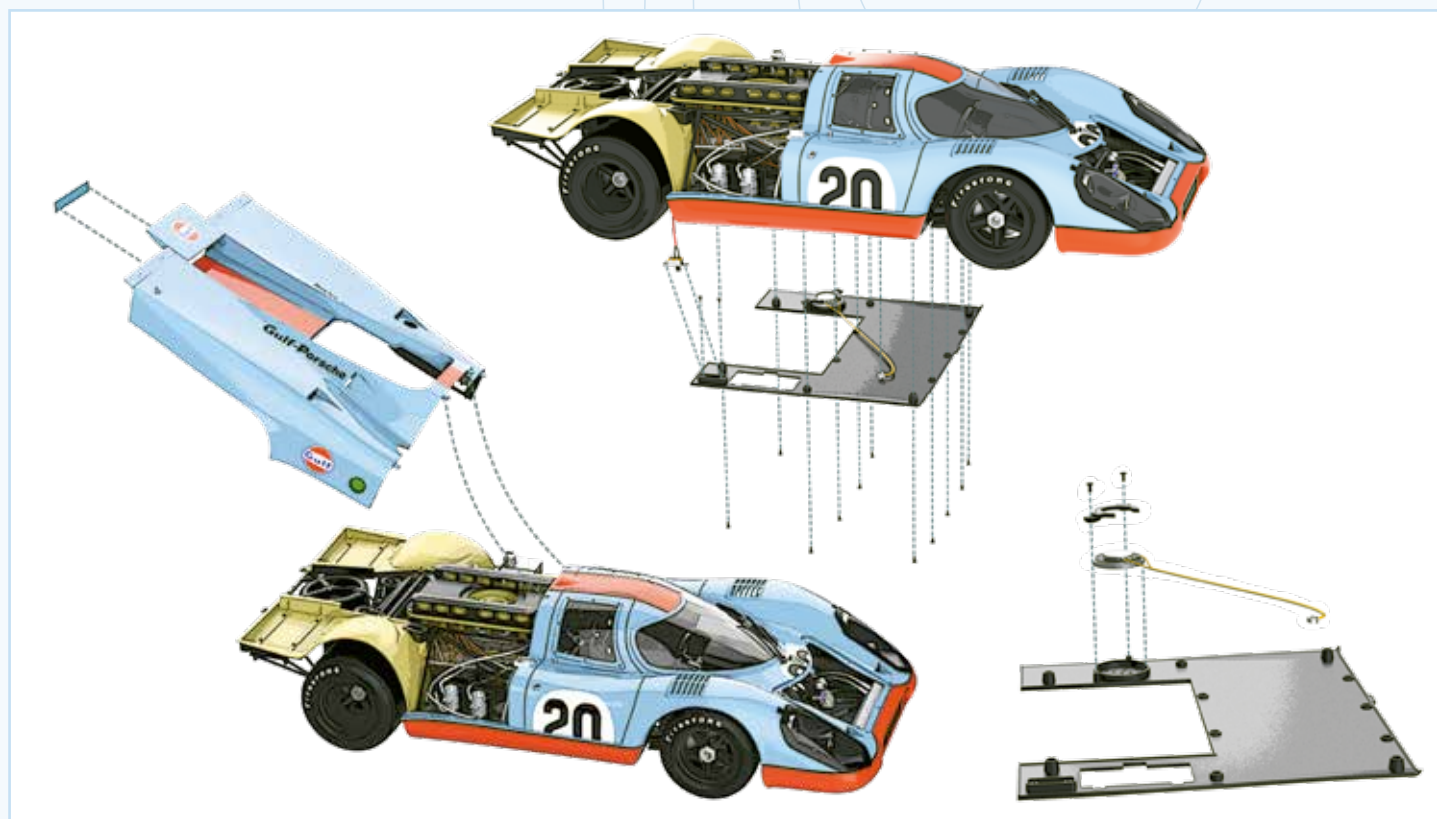
Screw MP M 2.0 x 4 mm (x 3)

Screw OP M 1.7 x 3 mm (x 3)



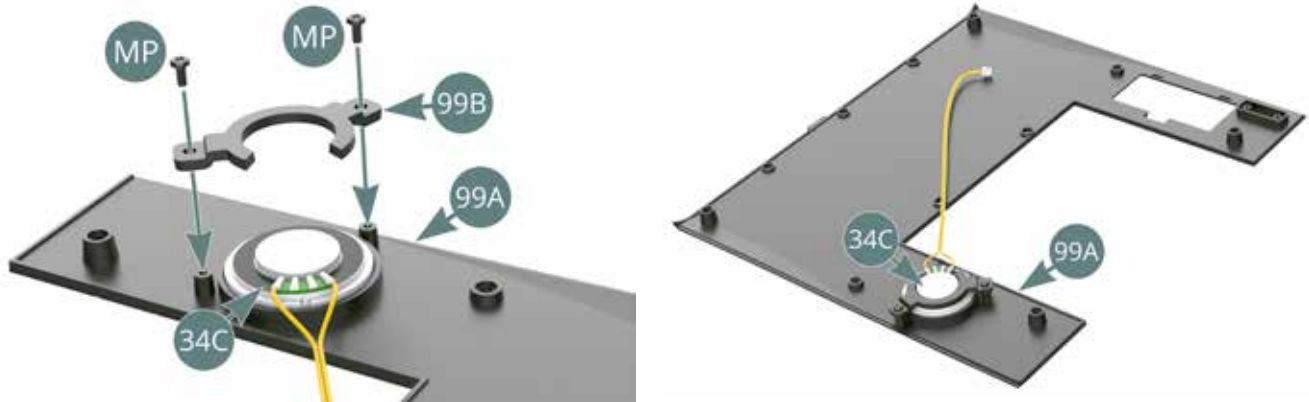
Assembly of switch,
loudspeaker and flat floor
panel

ASSEMBLY DIAGRAM





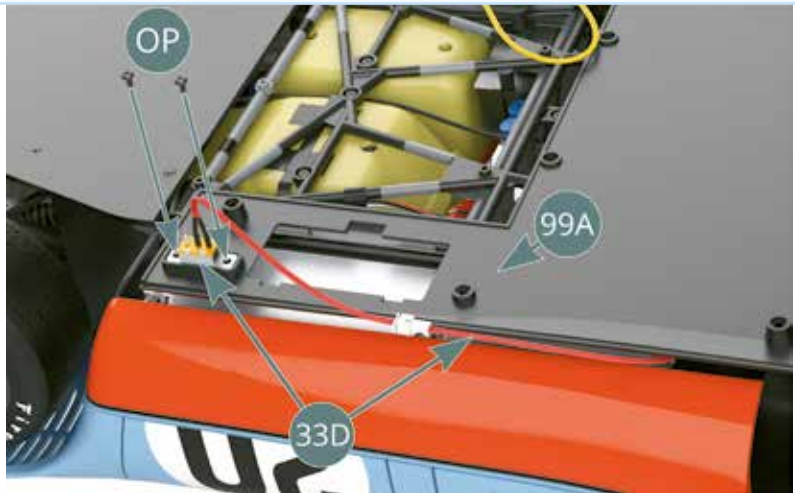
STEP 1



Position the loudspeaker (34C) in the round recess provided in the flat floor panel (99A), and secure it with the mounting bracket (99B) and two MP screws - see illustrations above.

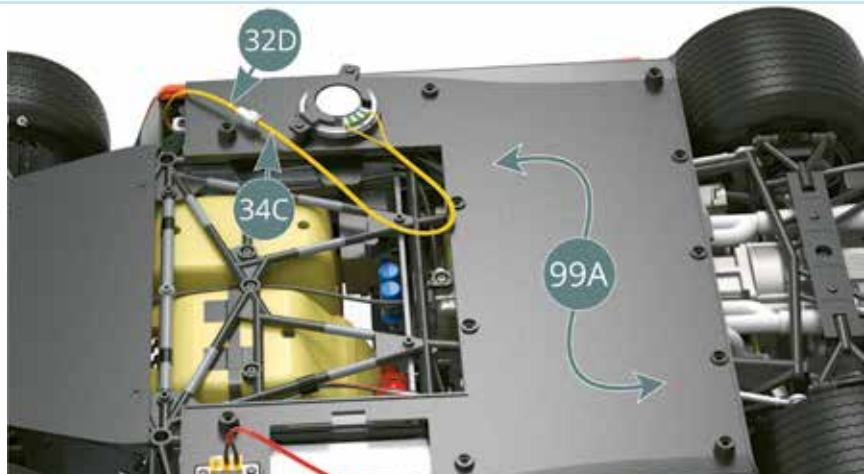
STEP 2

Position the flat floor panel (99A) against the bottom of the upside-down car and secure the switch (33D) with two OP screws.



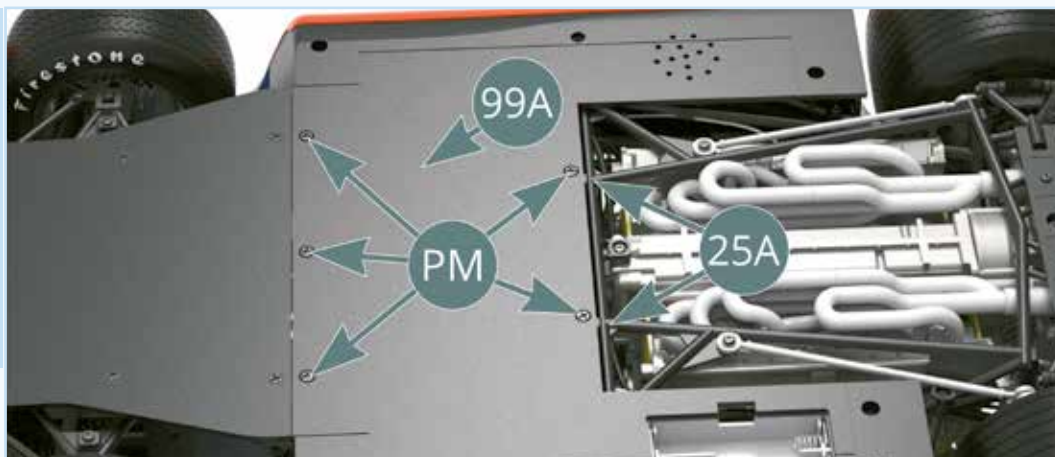
STEP 3

Connect the yellow speaker cable (34C) to the yellow cable of the PCB (32D). Turn the flat floor panel (99A) upside down.



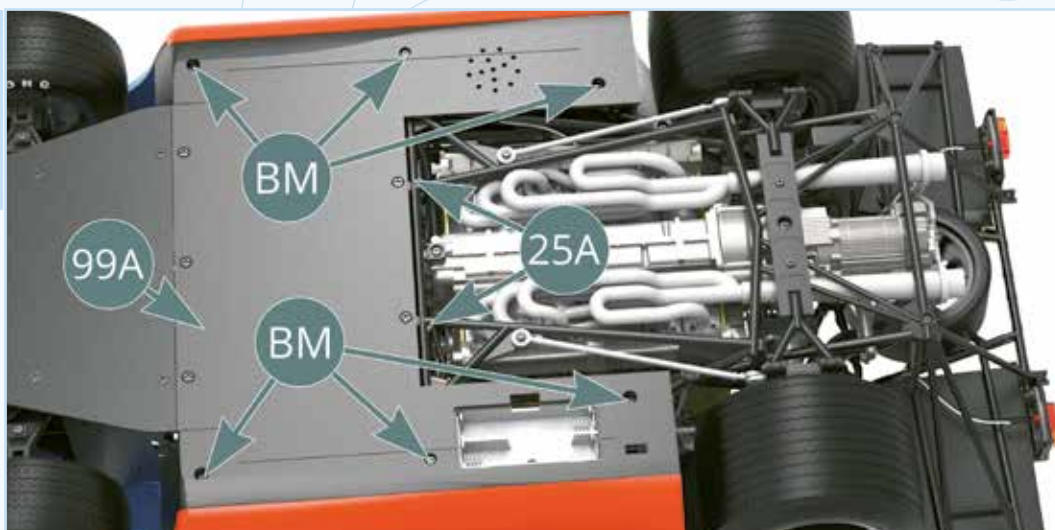
STEP 4

The previously connected cables are now hidden underneath the flat floor panel (99A). Align the flat floor panel (99A) with the bottom of the car and secure it to the lower frame (25A) using five PM screws.



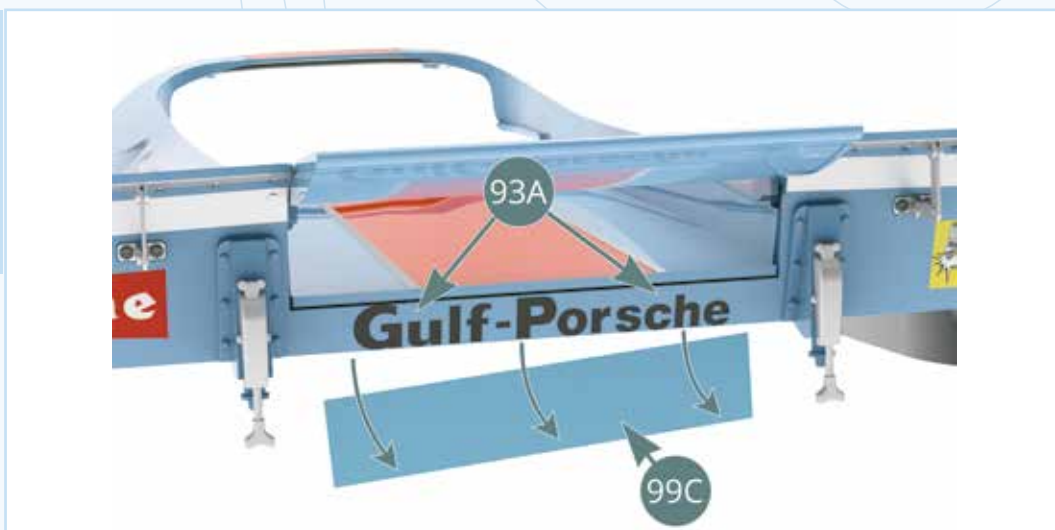
STEP 5

Secure the left and right sides of the flat floor panel (99A) to the undercarriage (25A) using six BM screws.



STEP 6

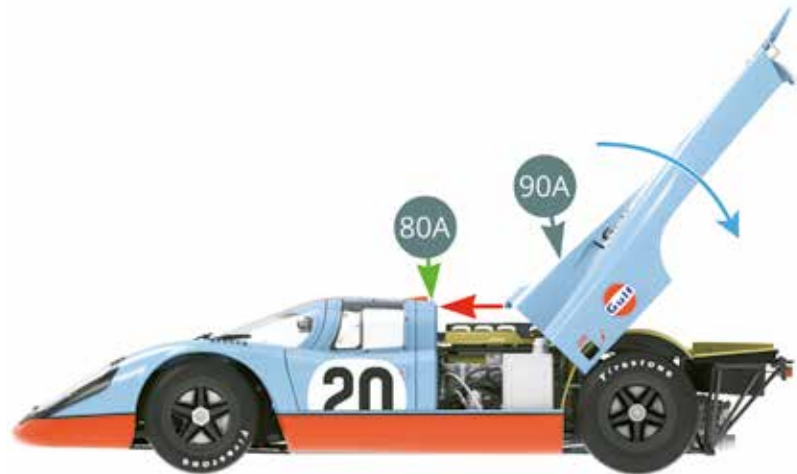
Immerse the decal (99C) in water for 30 seconds, then slide it from its paper backing and position it in the middle of the rear bonnet panel (93A).





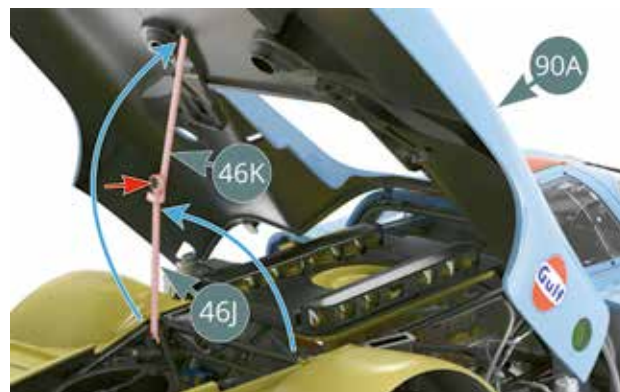
STEP 7

Position the rear bonnet (90A) onto the body (80A) at a 45 degree angle (red arrow), then close the bonnet (blue arrow). Take care not to scratch the edge of the bodywork when closing the bonnet (green arrow).



STEP 8

Raise the rear bonnet (90A), then extend the support arm (46J-46K) and check that it is supporting the bonnet correctly. If necessary, slightly loosen the two hinge screws (red arrows) until the arm is aligned with the support point on the bonnet.



GENERAL VIEW





Assembly guide

PARTS OF THE ISSUE 100

100A Battery compartment cover

100B Decal emblem (x 2)

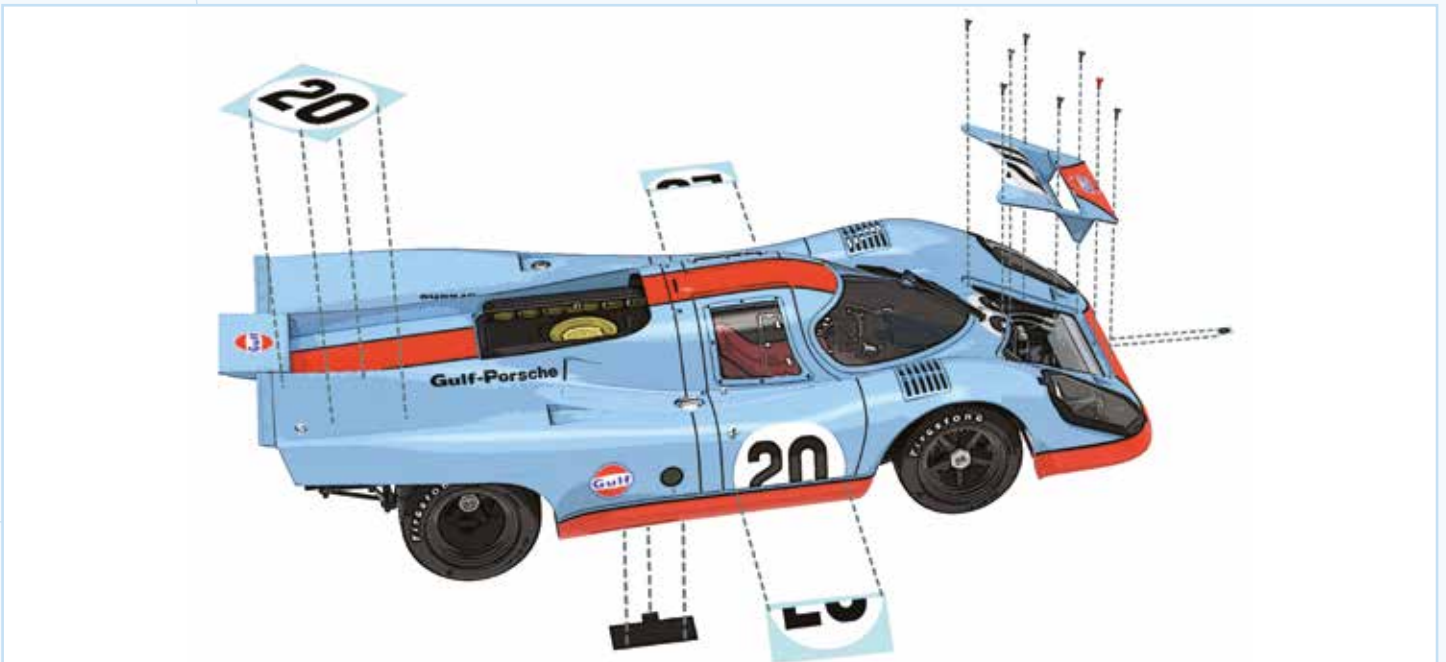
100C Decal door number (x 4)

100D Decal rear bonnet number (x 2)

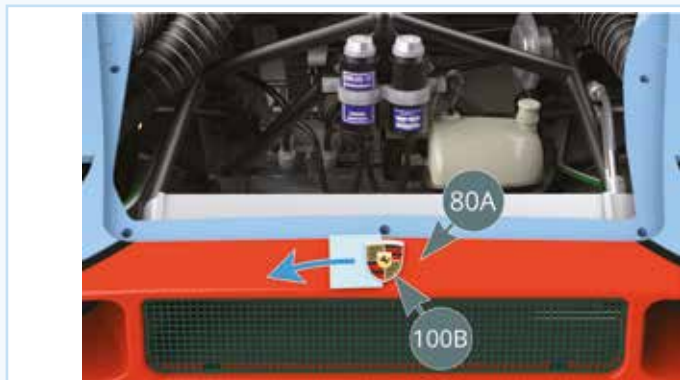


Position of Porsche emblem and race number decals on the sides and top of the rear bonnet

ASSEMBLY DIAGRAM



STEP 1



Immerse the emblem decal (100B) in water for 30 seconds to soften it. Position the decal (100B) on the bumper at the front of the body (80A), then carefully slide it off its paper backing. While it is still wet, you are able to adjust the decal (100B), if necessary.

STEP 2



Immerse the door number decal (100C) in water for 30 seconds to soften it. Position the decal (100C) so that it is in line with the racing number on the left-hand lower door, then carefully slide it from its paper backing. Adjust the decal (100C) while it is still slightly wet and remove any excess water with a soft cotton pad.

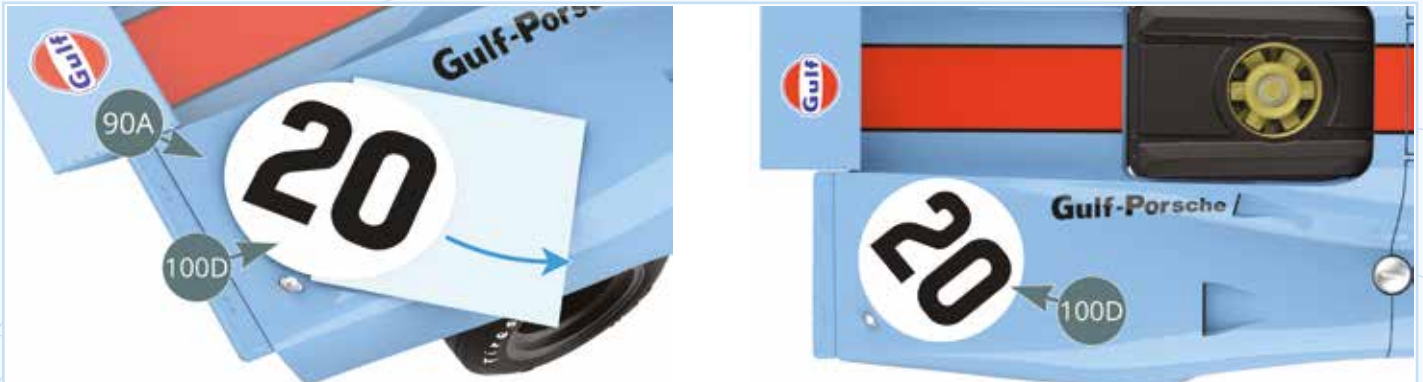
STEP 3



Immerse the door number decal (100C) in water for 30 seconds to soften it. Position the decal (100C) so that it is in line with the racing number on the left-hand lower door, then carefully slide it from its paper backing. Adjust the decal (100C) while it is still slightly wet and remove any excess water with a soft cotton pad.



STEP 4

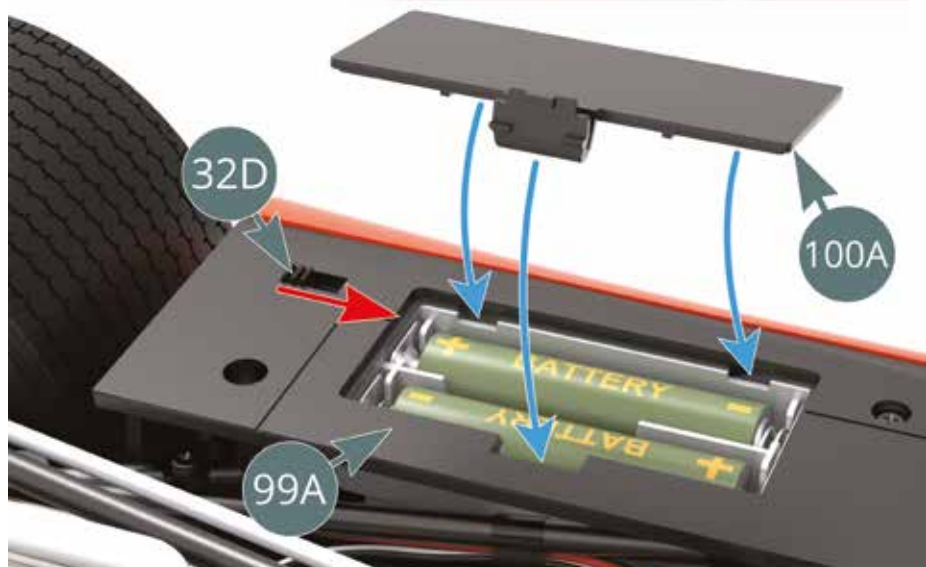


Immerse the number decal for the rear bonnet (100D) in water for 30 seconds to soften it. Position the decal (100D) above and to the rear right of the rear bonnet (90A), then carefully slide it from its backing paper. Adjust the decal (100D) while it is still wet and remove any excess water with a soft cotton pad.

STEP 5

Position the bonnet (1B) onto the front body compartment (80A) and secure it using six blue bonnet clips (82F), one white bonnet clip (82H) and one orange bonnet clip (82G).

Place two type AAA batteries (these are not supplied) in the battery compartment and position the cover (100A) in the flat floor panel (99A). Operate the switch (32D) by moving it forwards.



STEP 6



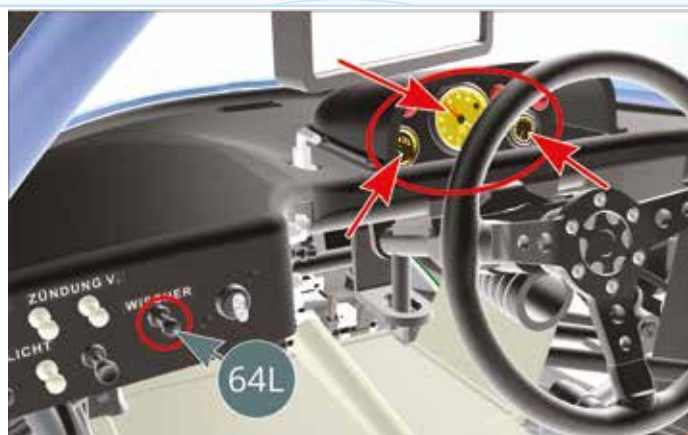
Rear lights
48D et 49D

Open the left door and press the switch (64L) to check that the lights are working as shown in the following three illustrations.

STEP 7



The four front lights



Dashboard backlights

STEP 8



Press the brake pedal (26F) - the one in the middle - by using the tip of a pencil to check that the brake lights (48D & 49D) at the rear are working properly - illustrations above.



STEP 9

Press the switch (64M) to activate the horn.
Press the switch (64L) to activate the engine running sound.



STEP 10

Place two supports (78C) underneath the left and right side of the car to keep the wheels raised and check that the steering wheel rotates correctly.



GENERAL VIEW





