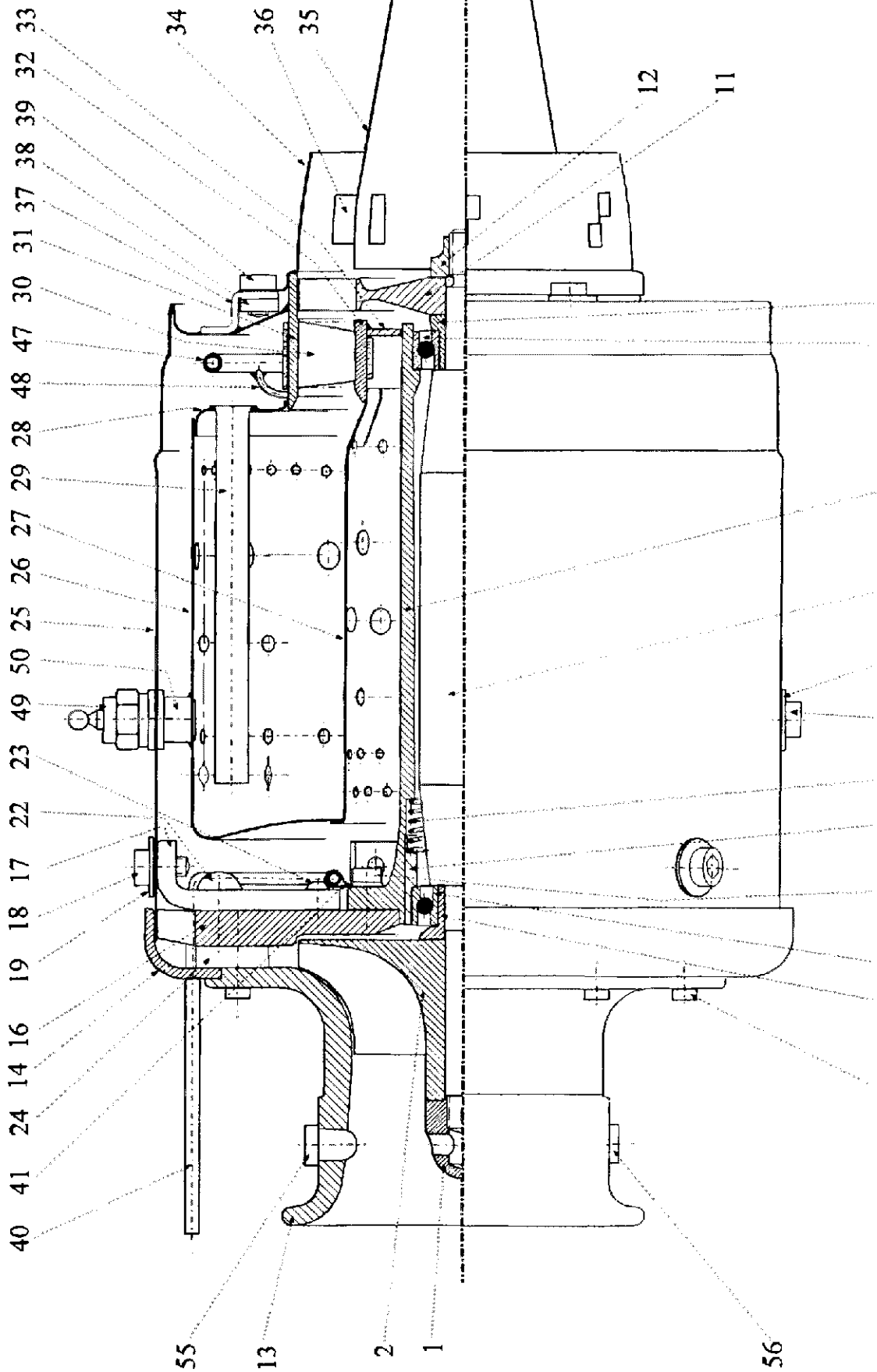


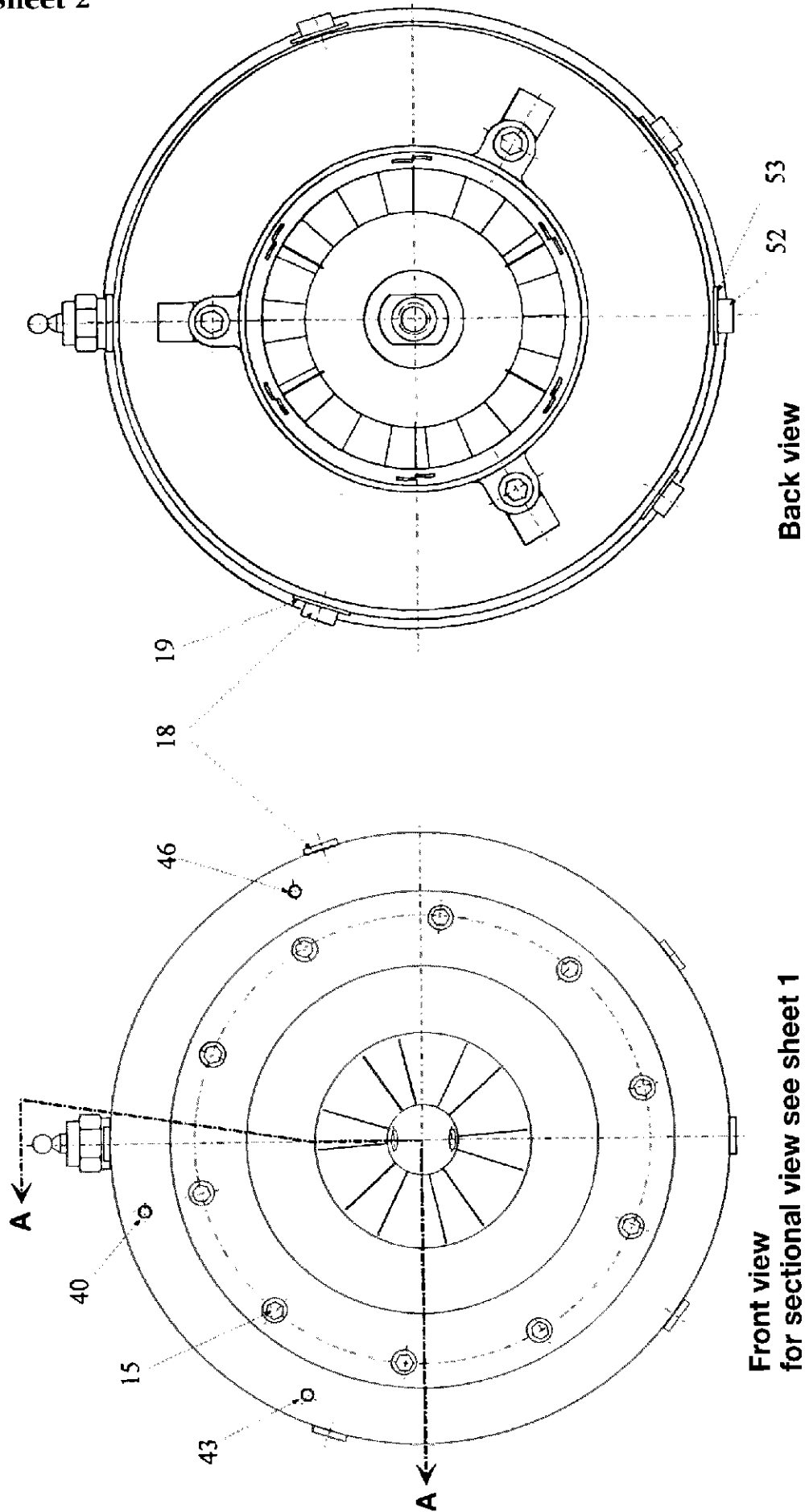
Parts list and drawings

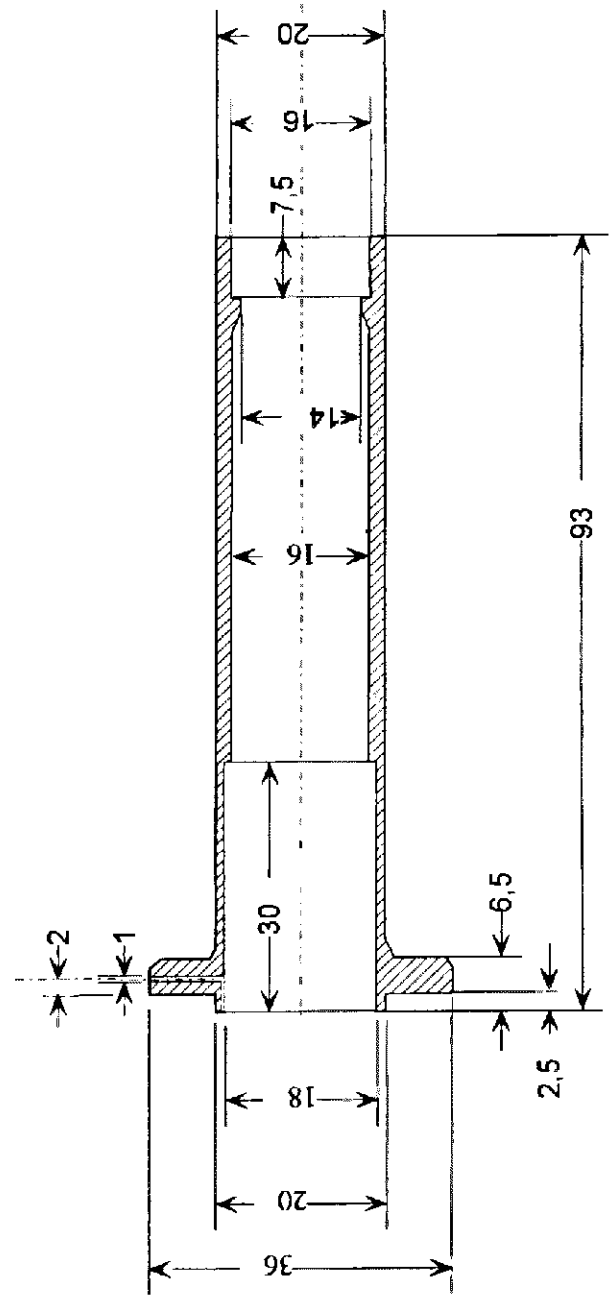
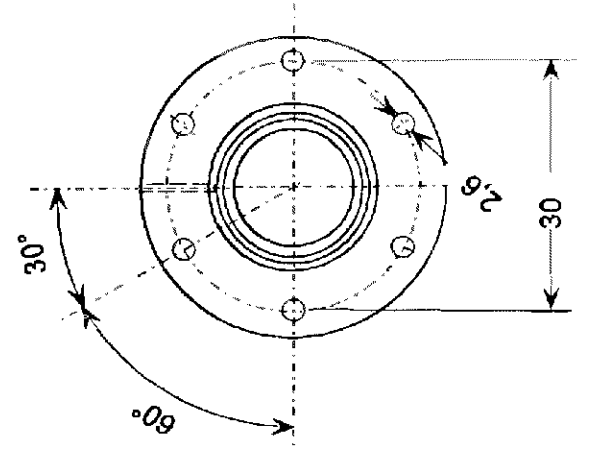
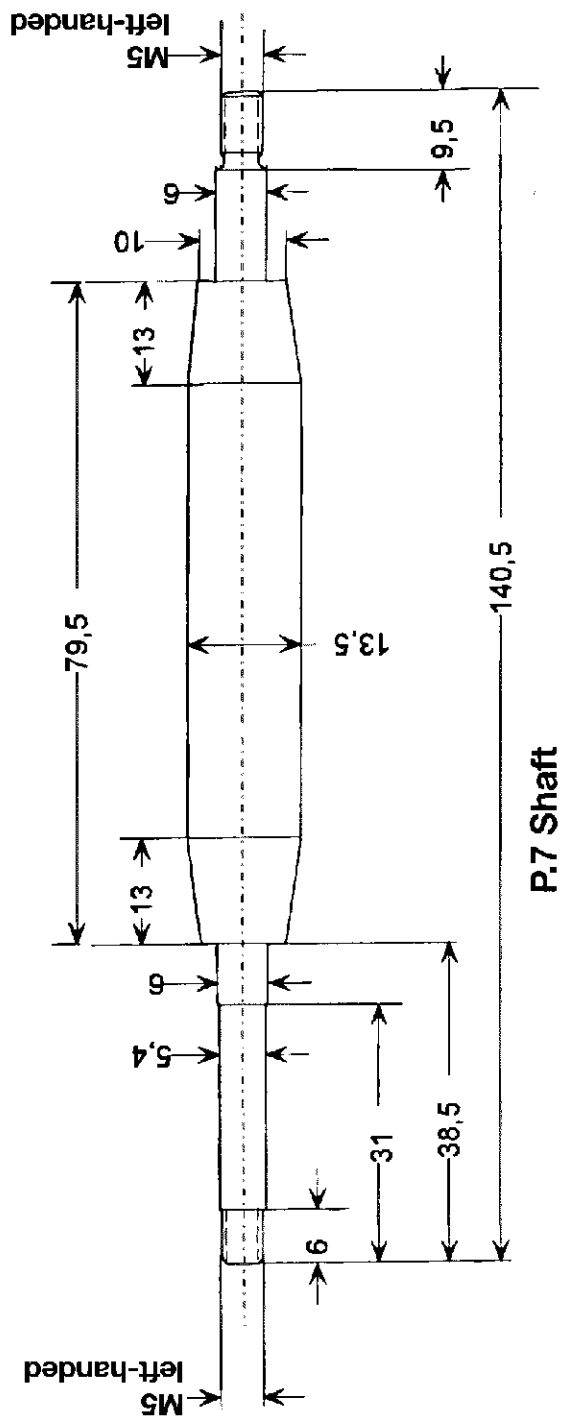
Parts list: TK-50

Item	Description	No.	Material	Semi-finished (dimensions mm)	Notes	Drawing Sheet No.
1	Compressor nut	1	Al-alloy Dural or similar	Round, 12 Ø		6
2	Compressor wheel	1	Al-alloy		Type 14/03, KKK	16
3	Spacer bush	1	St C45 or better	Round, 15 Ø		6
4	Compressor bearing	1			Type D688/602 976, GRW	
5	Slide bush	1	St C45 or better	Round, 18 Ø		6
6	Pre-load spring	1	Spring steel	Wire, 1 Ø		6
7	Shaft	1	St C45 or better	Round, 15 Ø		3
8	Shaft tunnel	1	Al-alloy Dural or similar	Round, 40 Ø		
9	Turbine bearing	1			Type D688/602 976, GRW	
10	Space bush	1	St C45 or better	Round, 15 Ø		6
11	Turbine wheel	1	Ni-basis		Finished part—see suppliers	16
12	Turbine nut	1	CrNi	12 Ø		6
13	Intake nozzle	1	Al-alloy	80 Ø		5
14	Lid	1	Al, soft	Sheet, 1.5 thick		5
15	Front screw	10	St		Hexagon socket M2 × 12 G 8.8	
16	Guide vane holder	1	Al-alloy Dural or similar	Sheet, 8 thick		4
17	Connector	5	Al-alloy Dural or similar	Sheet, 3 thick		7
18	Screw	5	St		Hexagon socket M3 × 5 G 8.8	
19	Tooth wheel	5	St			
20	Screw	6	St		Hexagon socket M2.5 × 8 G 8.8	
21	Sooth wheel	6	St			
22	Rivet	3	Al		SK 4 Ø	
23	Rivet	3	Al		SK 2 Ø	
24	Compressor guide vane	10	Al-alloy Dural or similar	Sheet, 3 thick		6
25	Housing	1	CrNi 18/10 or similar		External part of thermos flask	15
26	Comb. chamber ext. wall	1	CrNi 18/10 or similar		Internal part of thermos flask	12,13
27	Comb. chamber int. wall	1	CrNi 18/10 or similar	Sheet, 0.5 thick		11
28	Comb. chamber back wall	1	CrNi 18/10 or similar	Sheet, 0.5 thick		14
29	Stick	6	CrNi 18/10 or similar	Tube 5 × 0.4		12
30	Turbine guide vane	9	Thermos or similar	Sheet, 0.6 thick		8
31	Turbine ring	1	CrNi 18/10 or similar	Round, 40 Ø	Ready-made, see suppliers list	8
32	Central body	1	CrNi 18/10 or similar	Round, 50 Ø	Ready-made, see suppliers list	8
33	Disk	1	CrNi 18/10 or similar	Sheet, 3 thick		8
34	Nozzle sheath	1	CrNi 18/10 or similar	Sheet, 0.5 thick	Alternative bank – egg cup	10
35	Nozzle core	1	CrNi 18/10 or similar	Sheet, 0.5 thick	Alternative bank – egg cup	9
36	Radius arm	6	CrNi 18/10 or similar	Sheet, 0.5 thick		7
37	Z-connector	3	CrNi 18/10 or similar	Sheet, 1 thick		7
38	Nut	3	CrNi 18/10 or similar		M3	7
39	Screw	1	St		Hexagon socket M3 × 5	
40	Lubricant supply line	1	Brass	Tube 2 × 0.4		13
41	Tab	1	Brass	Sheet, 0.5 thick		13
42	Capillary	1	Brass	Tube 1 × 0.2	Not visible in sectional view	13
43	Auxiliary gas line	1	Brass	Tube 2 × 0.4	Not visible in sectional view	13
44	Connecting piece	1	Brass	Tube 3 × 0.5	Not visible in sectional view	13
45	Gas capillary	2	Brass	Tube 1 × 0.2	Not visible in sectional view	13
46	Fuel supply line	1	Brass	Tube 2 × 0.4	Not visible in sectional view	14
47	Distributor ring	1	Brass	Tube 3 × 0.5		14
48	Fuel capillary	6	Brass	Tube 1 × 0.2		14
49	Glow plug	1			Finished part	7
50	Threaded bush	1	St	Round, 10 Ø		7
51	Tab	1	CrNi 18/10 or similar	Sheet, 0.5 thick	Not visible in sectional view	12
52	Nut	1	CrNi 18/10 or similar		M3, hidden in sectional view	12
53	Screw	1	CrNi 18/10 or similar		Hexagon socket M3 × 5	
54	Tooth wheel	1	St			
55	IR-transmitter	1			Electronic control component	
56	IR-receiver	1			Electronic control component	
57	Clamping jaw	3	St	Sheet, 1 thick		7
58	Restrictor line	1	Brass	Tube 1 × 0.2	approx. 200 mm long	
59	Connecting piece	2	Brass	Tube 2 × 0.4	approx. 10 mm long	
60	Wire	1	St	0.5 Ø	approx. 200 mm long	

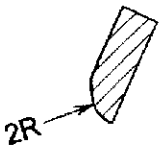
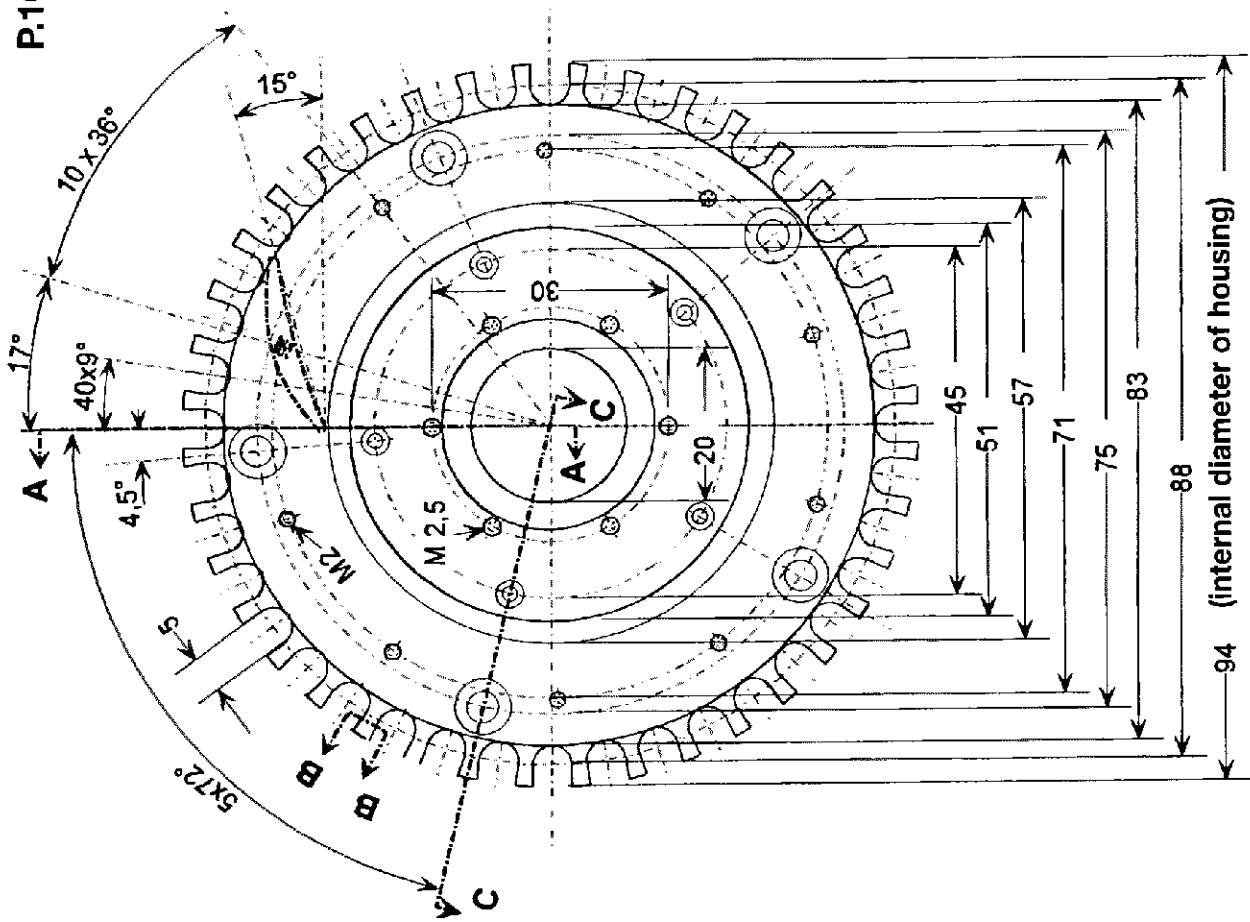
TK-50: Sheet 1



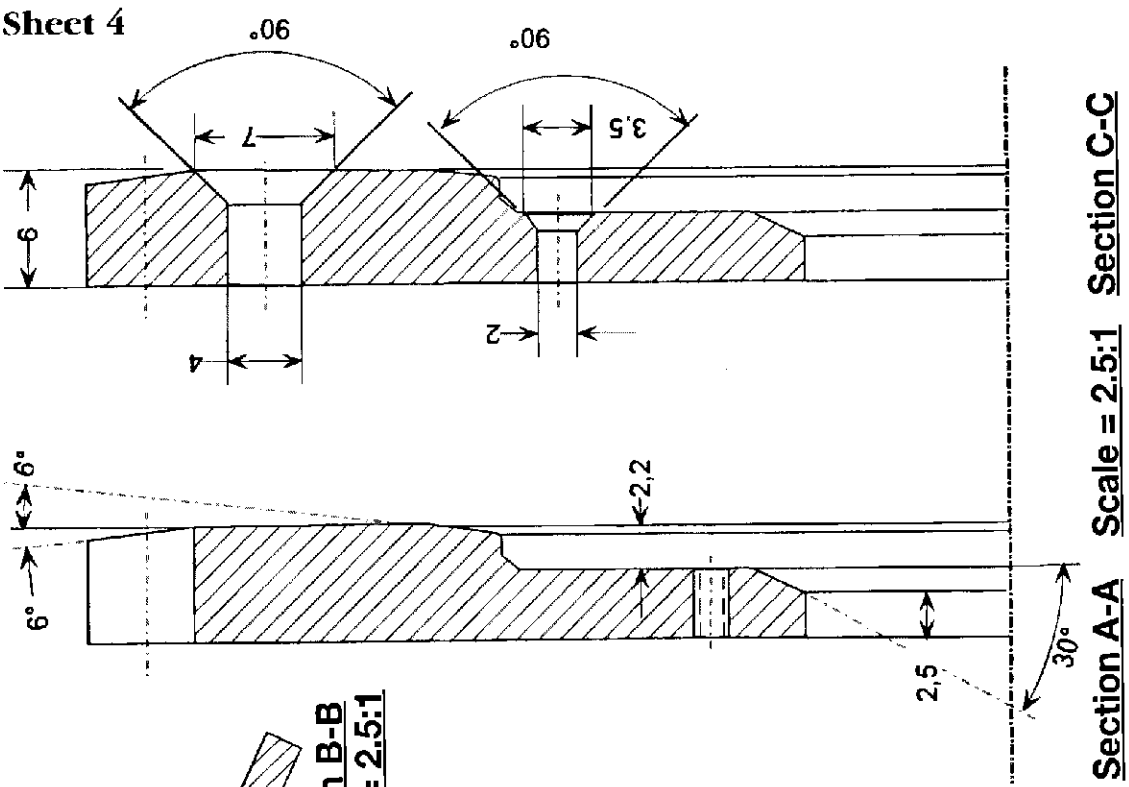




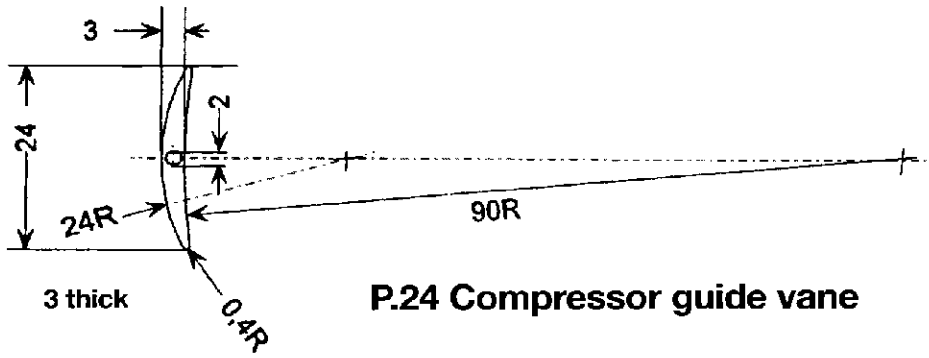
P:16 Guide vane holder



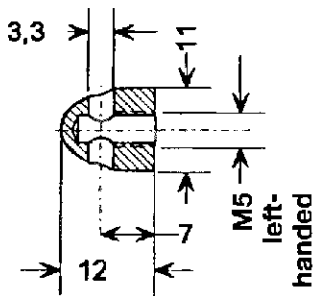
Section B-B
Scale = 2.5:1



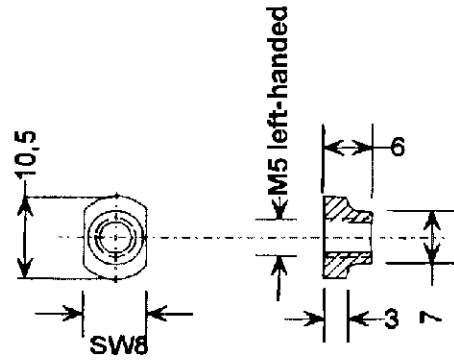
Section A-A Scale = 2.5:1 Section C-C



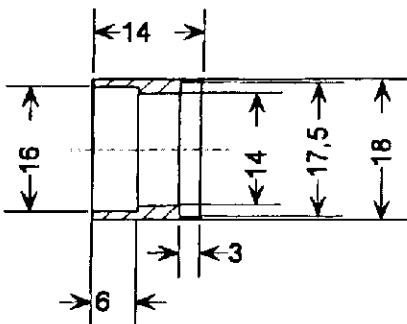
P.24 Compressor guide vane



P.1 Compressor nut

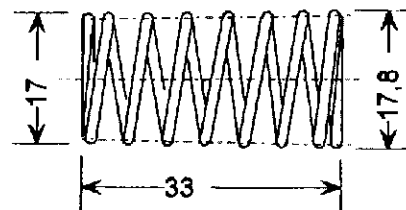


P.12 Turbine nut

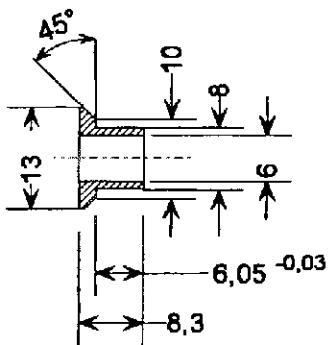


P.5 Slide bush

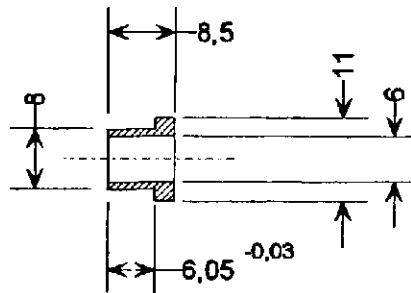
7.5 Wdg. 1.4 Ø wire



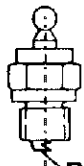
P.6 Pre-load spring



P.3 Spacer bush



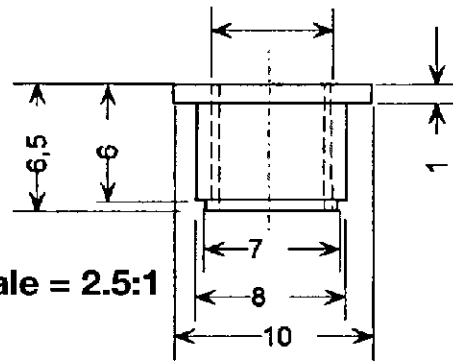
P.10 Spacer bush



Pull-out filament approx. 1 mm

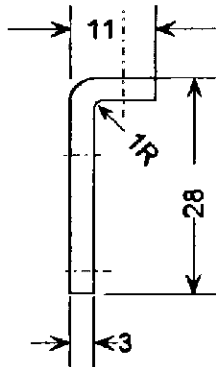
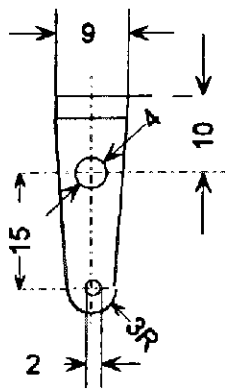
P.49 Glow plug

1/4" Thread glow plug

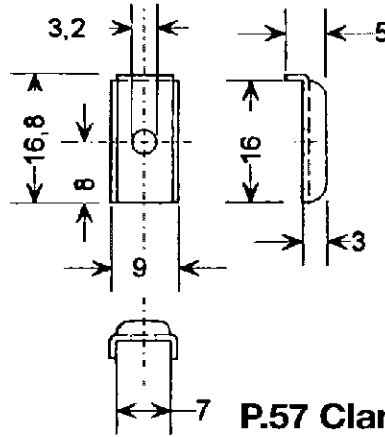


Scale = 2.5:1

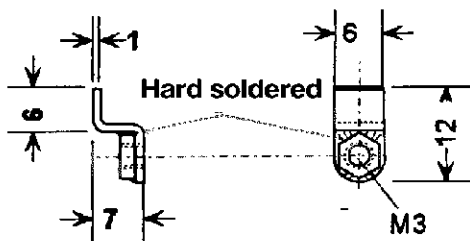
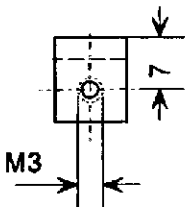
P.50 Threaded bushing



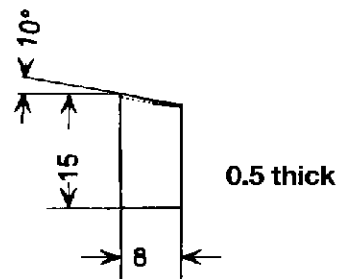
P.17 Connector



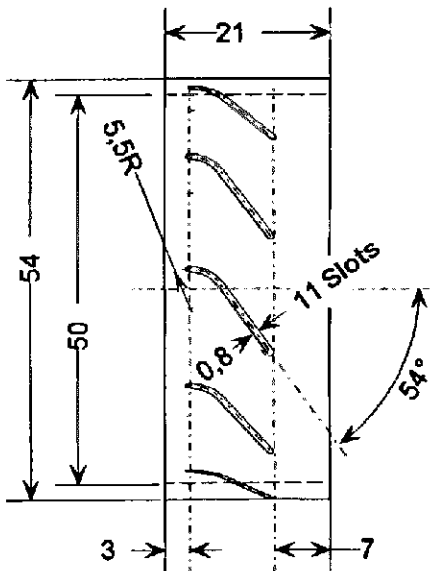
P.57 Clamping jaw



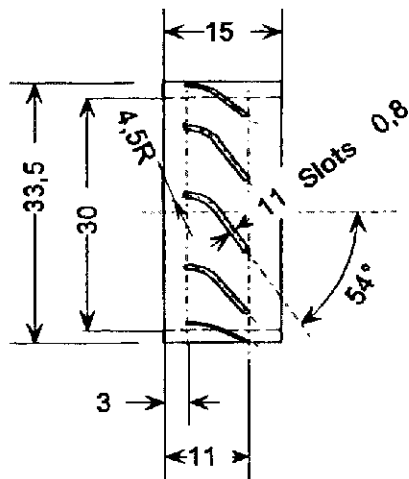
P.37 Z-Connector
P.38 Nut



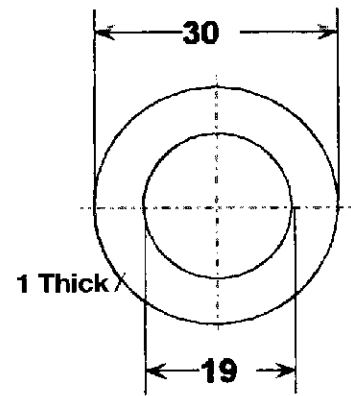
P.36 Radius arm



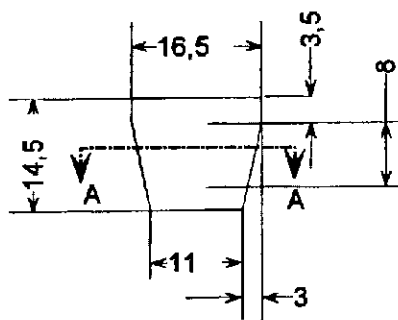
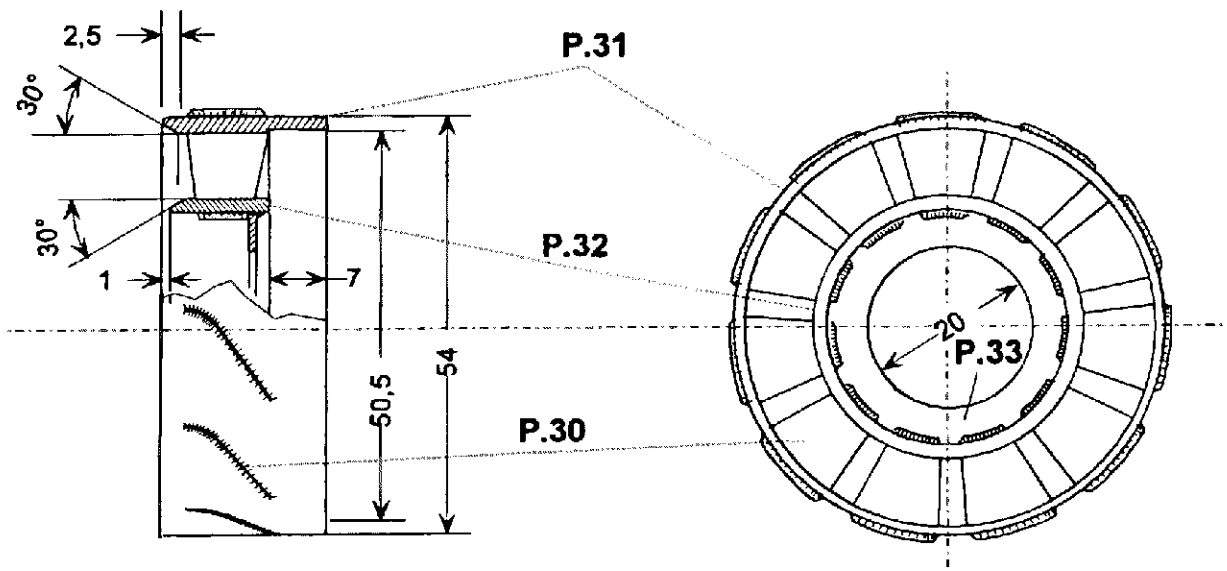
P.31 Turbine ring



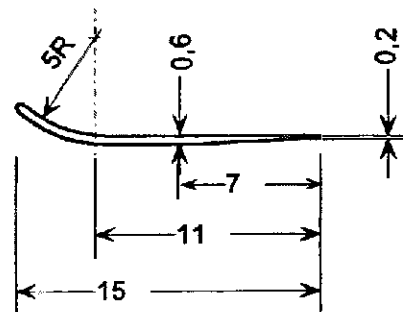
P.32 Central body



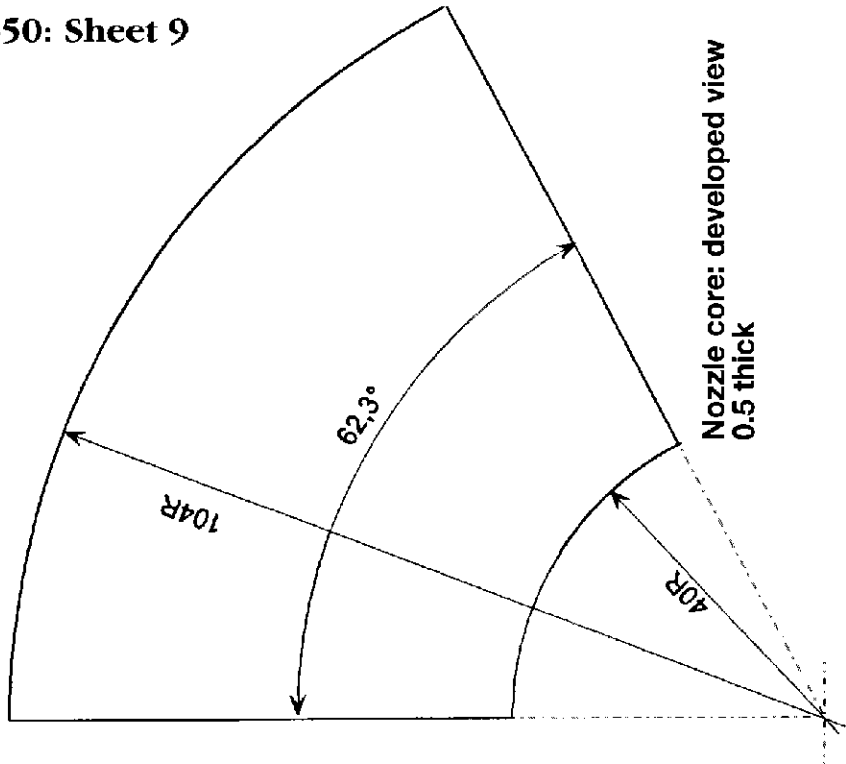
P.33 Radius arm



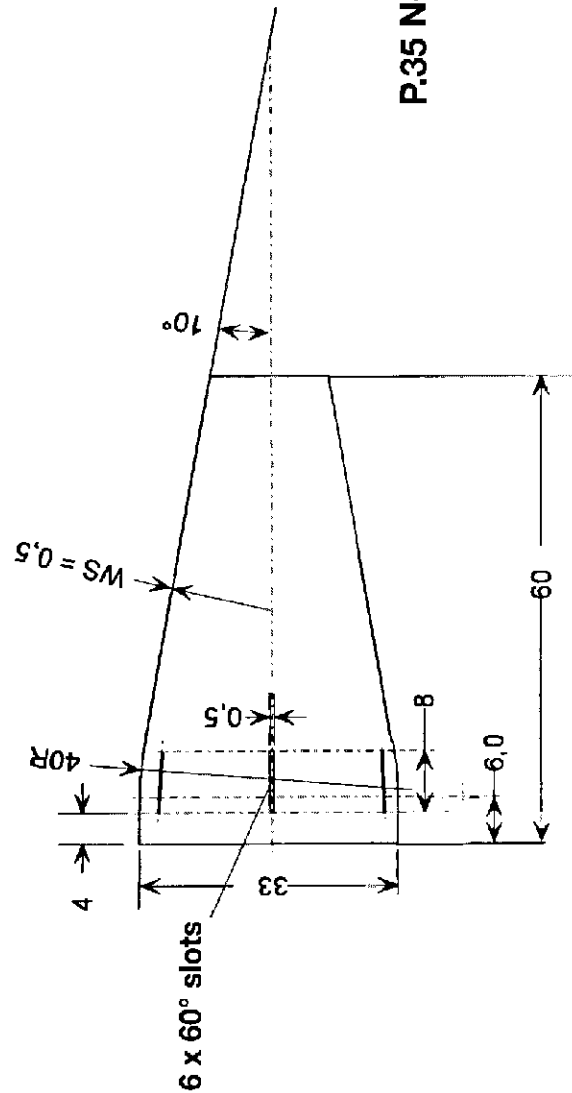
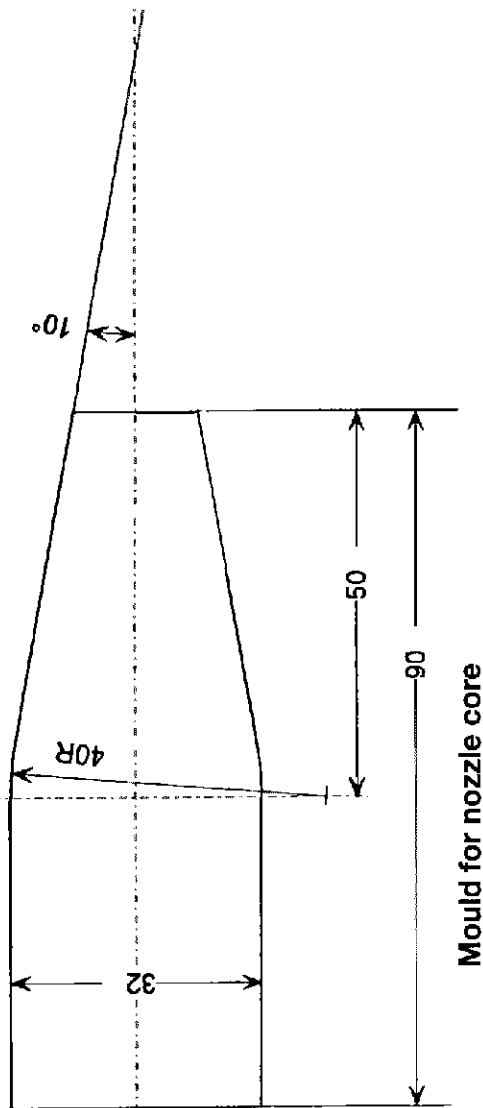
P.30 Turbine guide vane

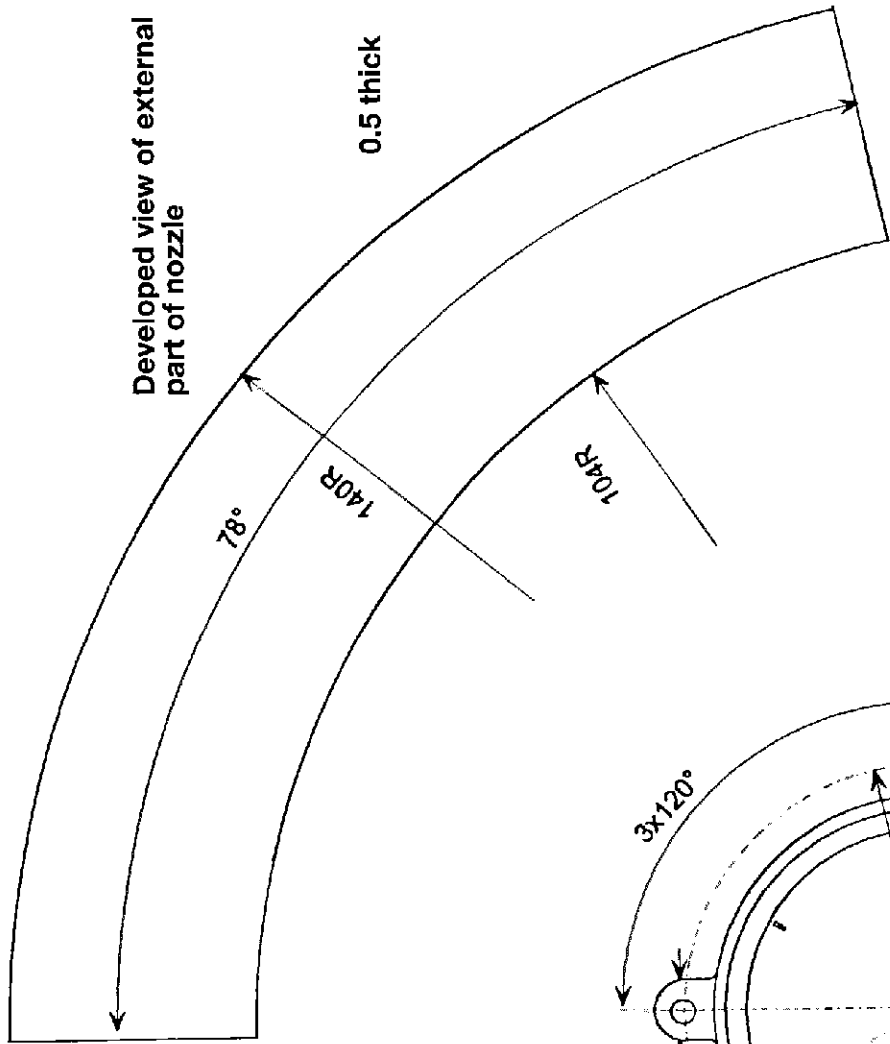


Section A-A
Scale = 2.5:1

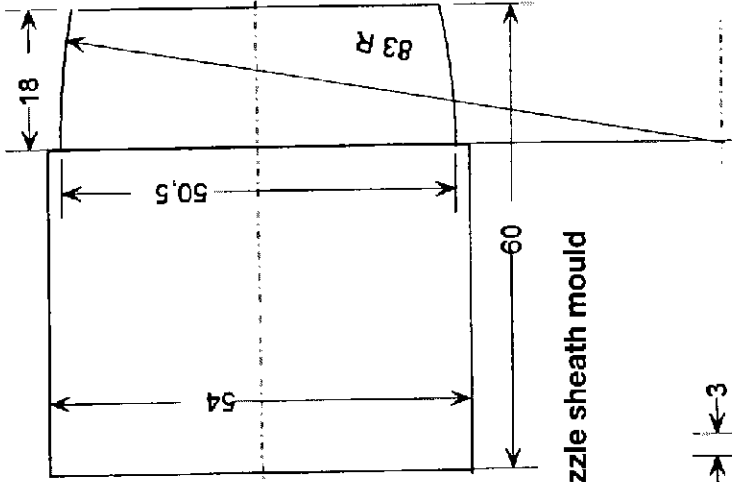
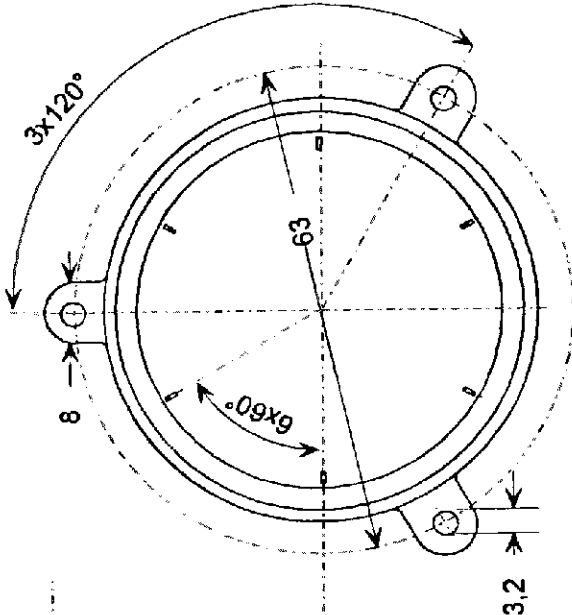


P.35 Nozzle core

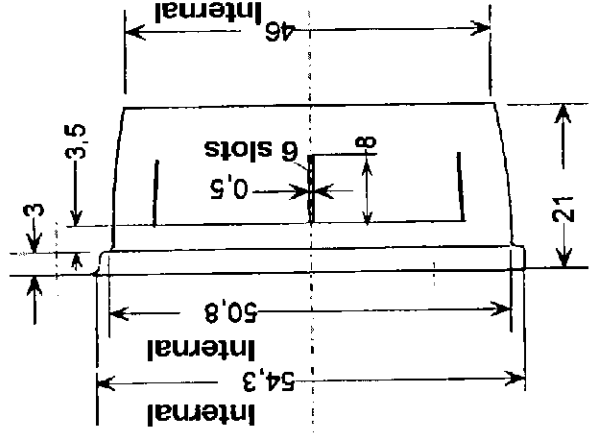


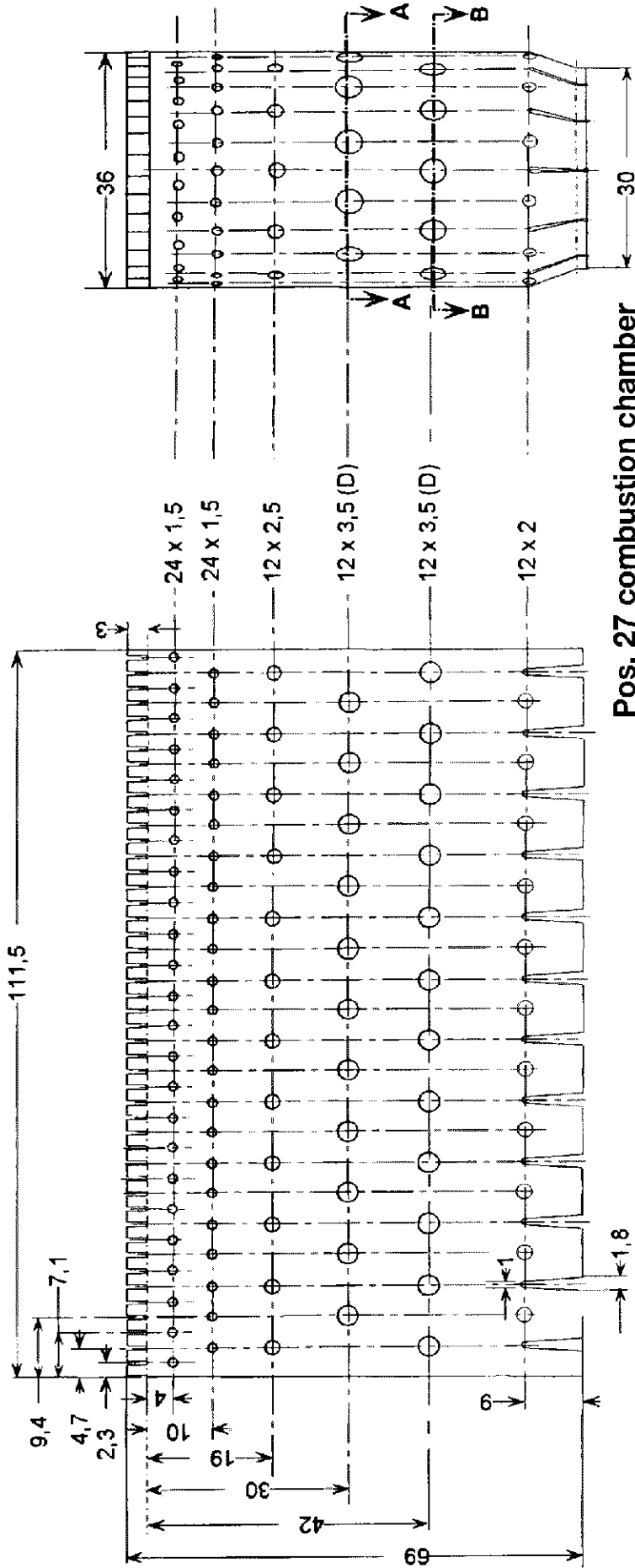


P.30 Nozzle sheath

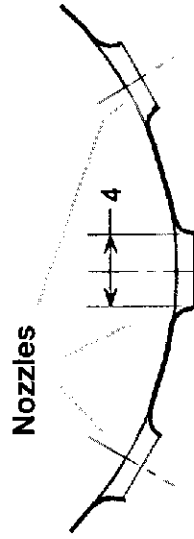


Nozzle sheath mould

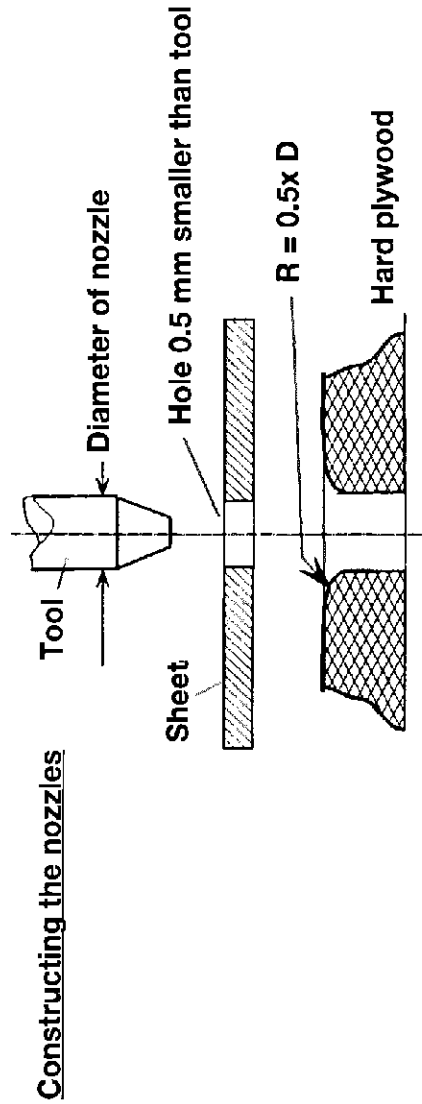


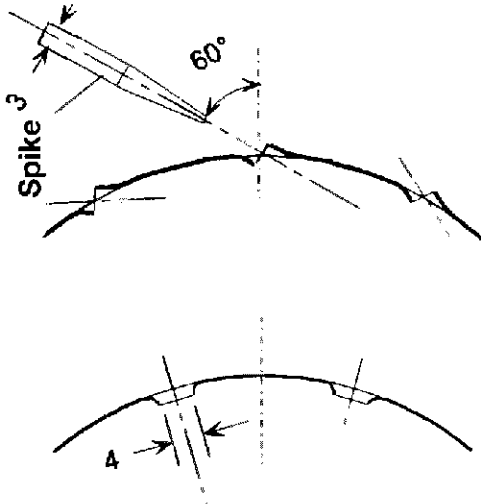
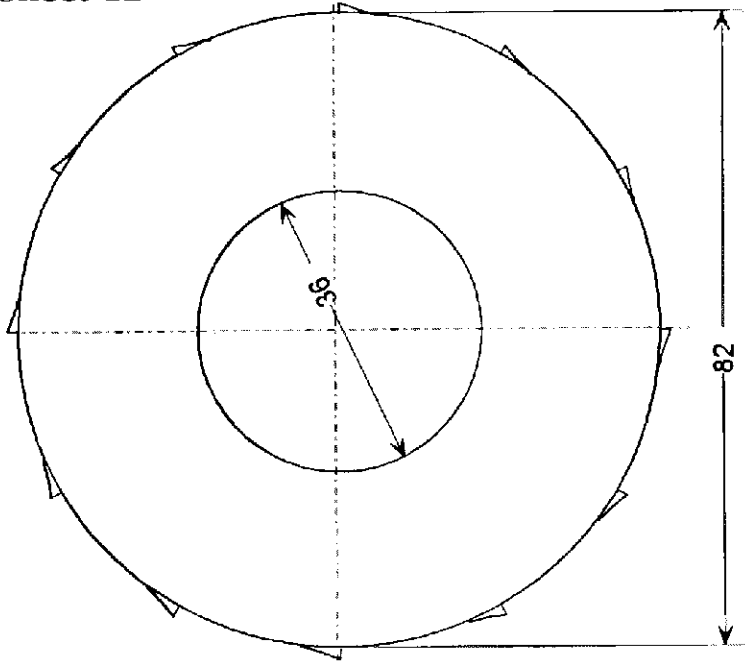
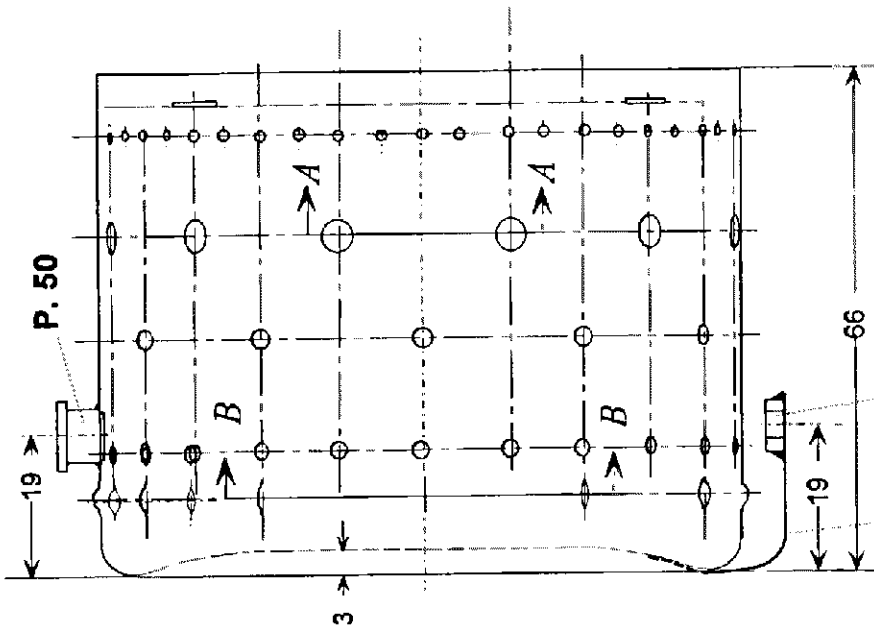


Pos. 27 combustion chamber
Internal wall



Section A-A and B-B
Scale = 2.5:1

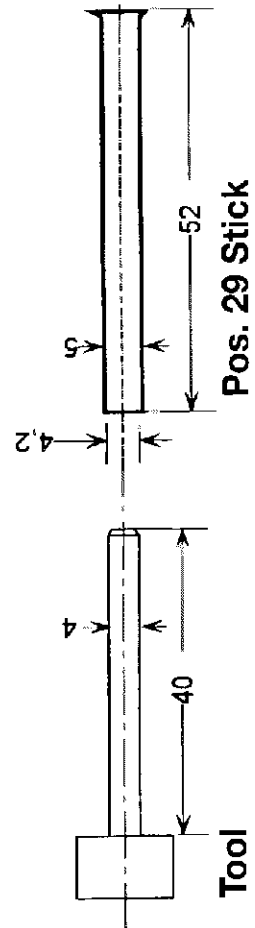




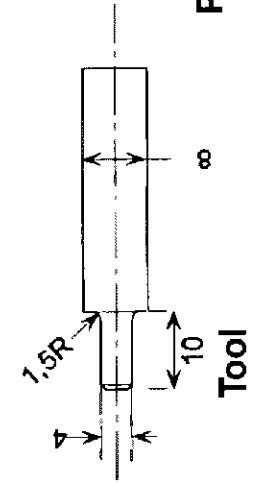
Section A-A Section B-B

Pos. 26 External wall of combustion chamber

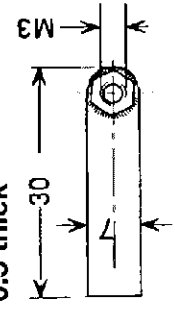
P. 58 P. 59



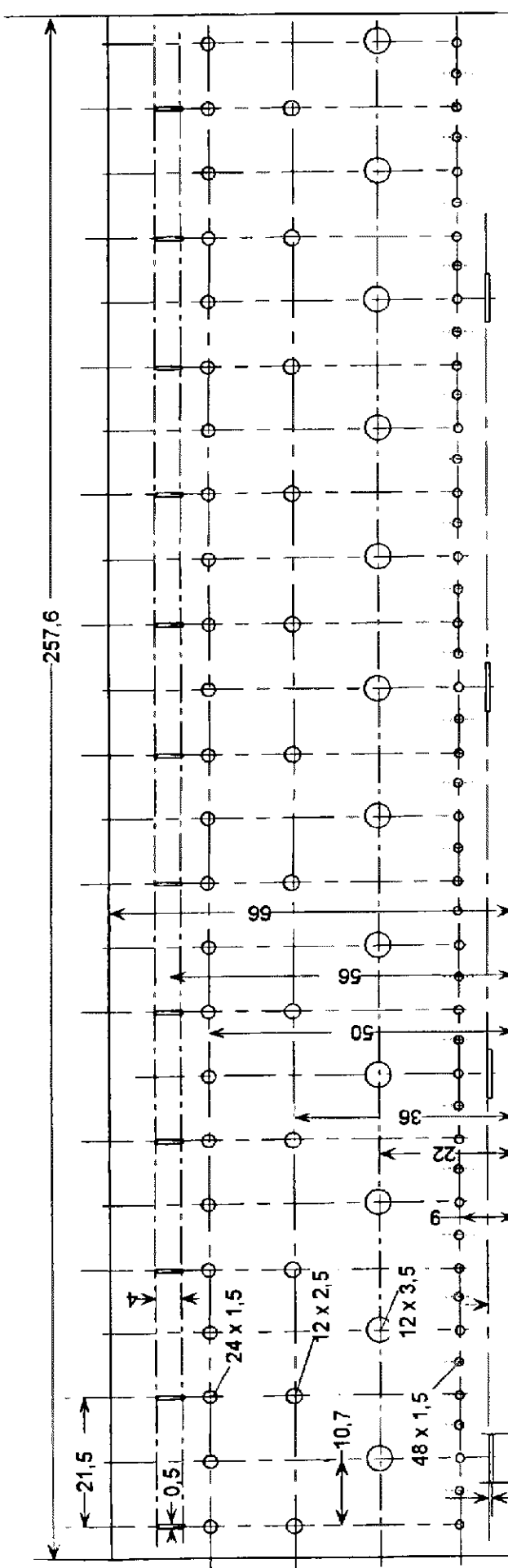
Pos. 29 Stick



0.5 thick



P.51 Tab (mounting link) P.52 Nut



Developed view of hole plan for the external wall of the combustion chamber

Brass - cap 1 x 0.2
75 lg.

Brass - cap 3 x 0.4
25 lg.

Brass - cap 2 x 0.4
100 lg.

P.43 Auxiliary gas supply line

P.45 Gas Capillary

Hard soldered

P.44 Connecting piece

Hard soldered

Brass - cap 2 x 0.4 140 long

Brass - cap 1 x 0.2 75 long

2.6

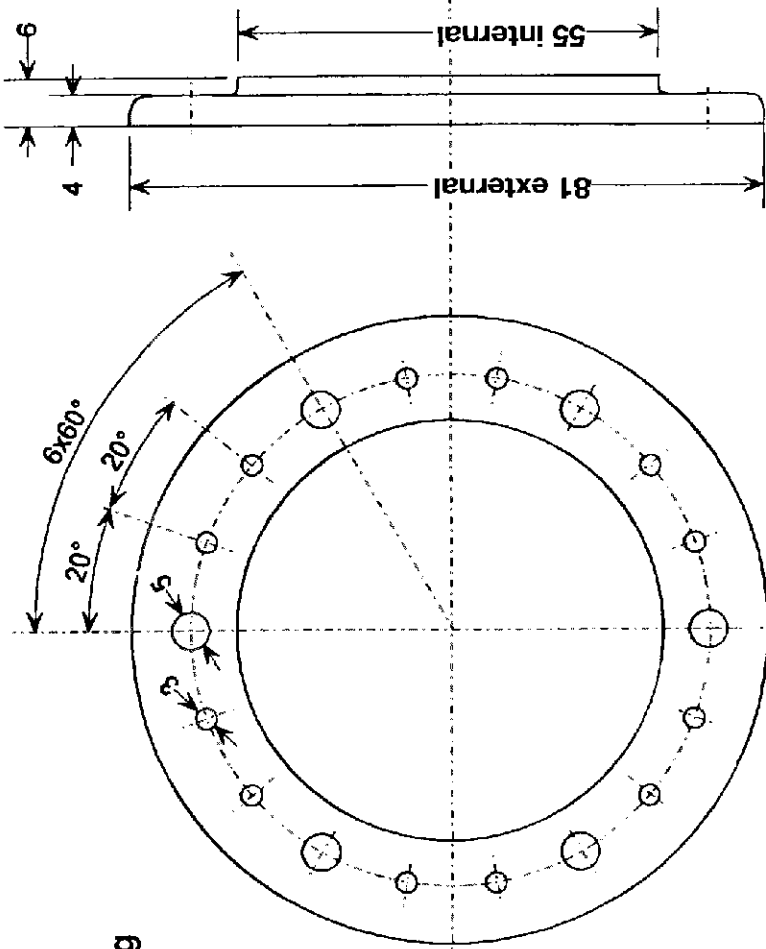
7

55

P.41 Tab

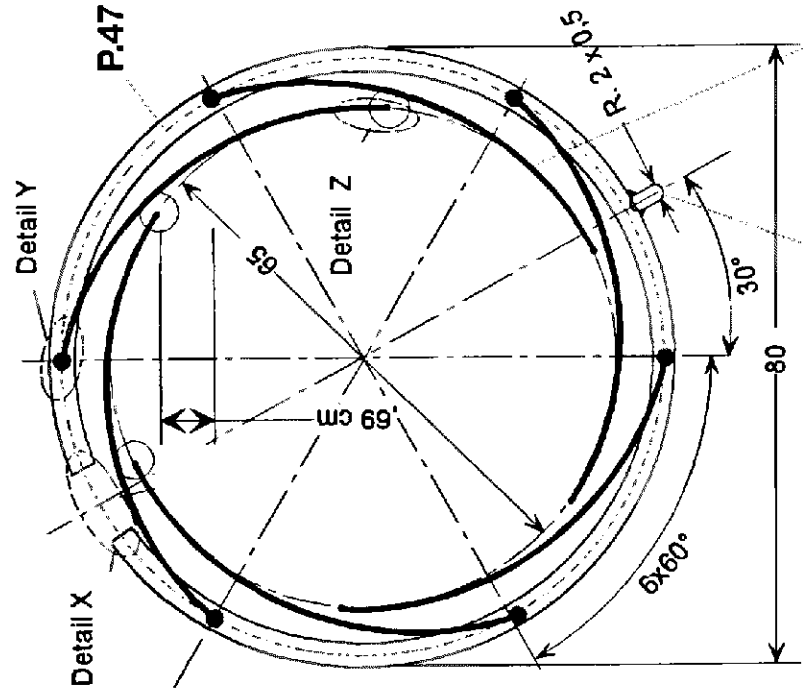
P.40 Lubricant supply line

P.42 Capillary

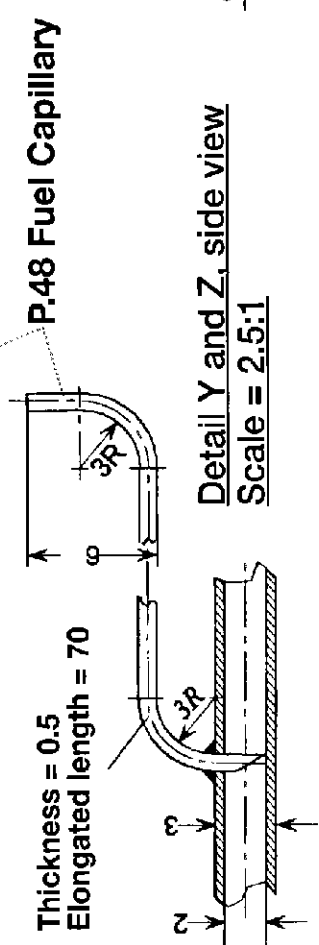


P.47 Distributor ring

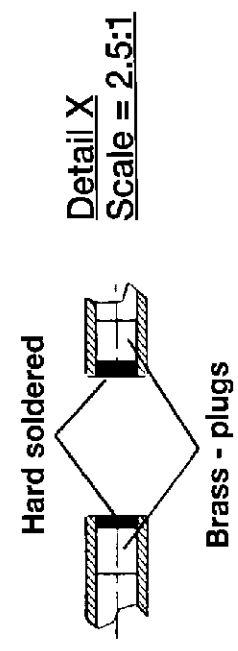
P.28 Combustion chamber wall



P.46 Fuel supply line

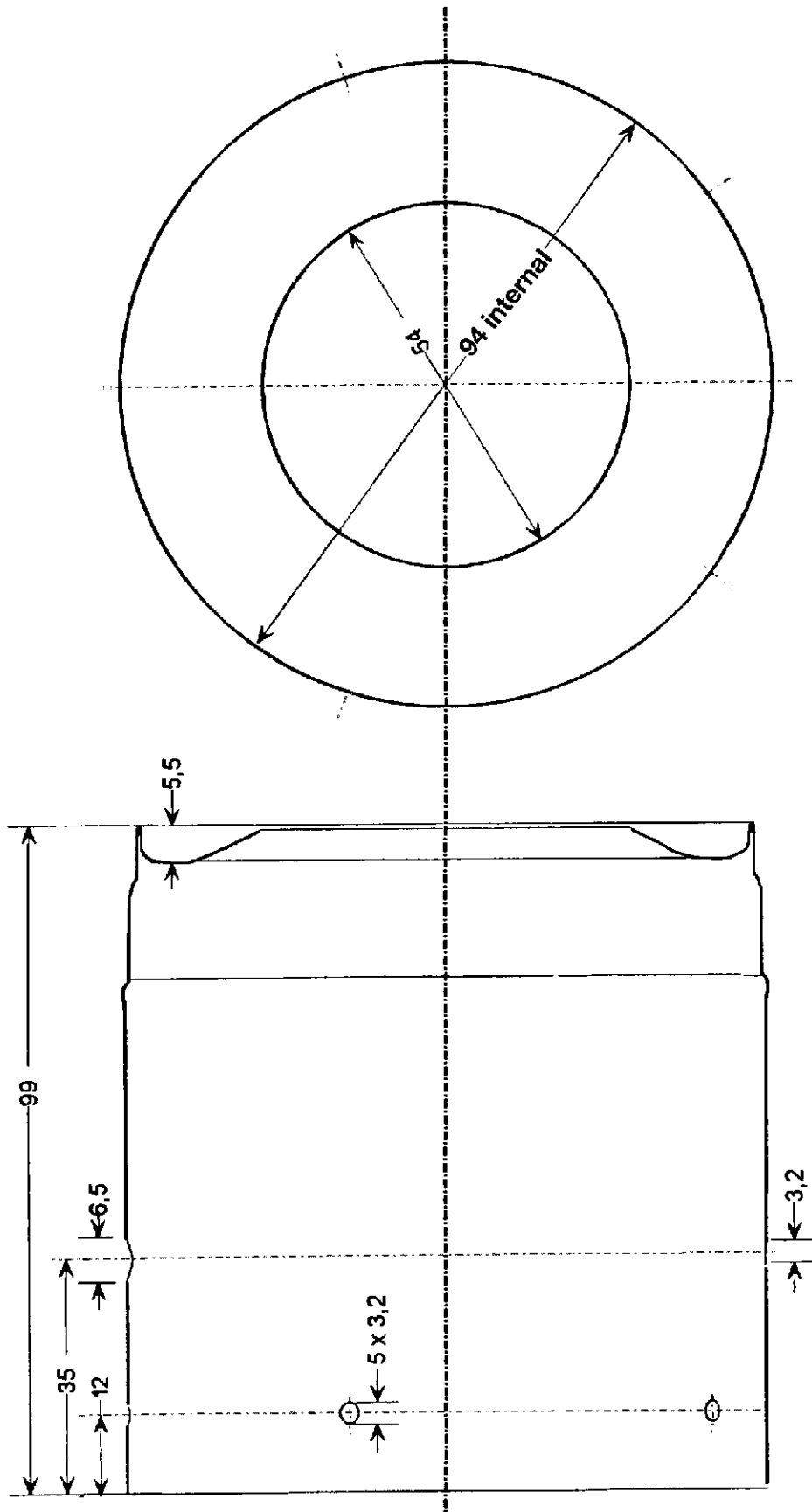


P.48 Fuel Capillary



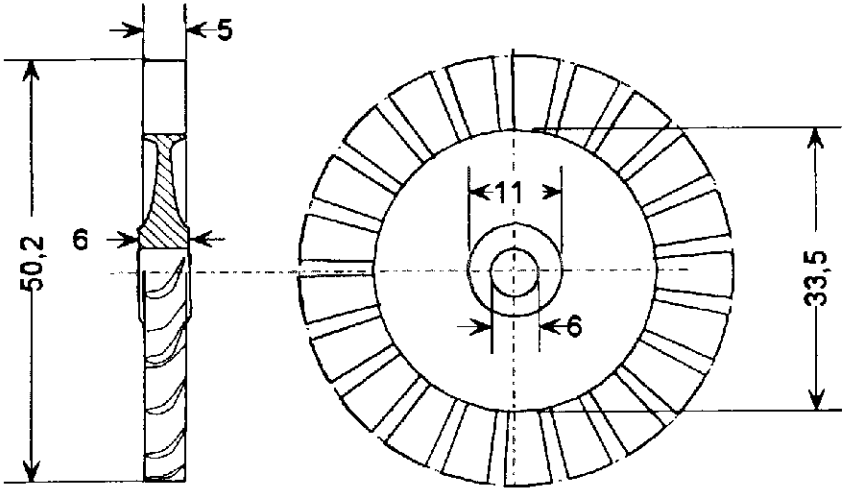
Detail Y and Z, side view
Scale = 2.5:1

Detail X
Scale = 2.5:1

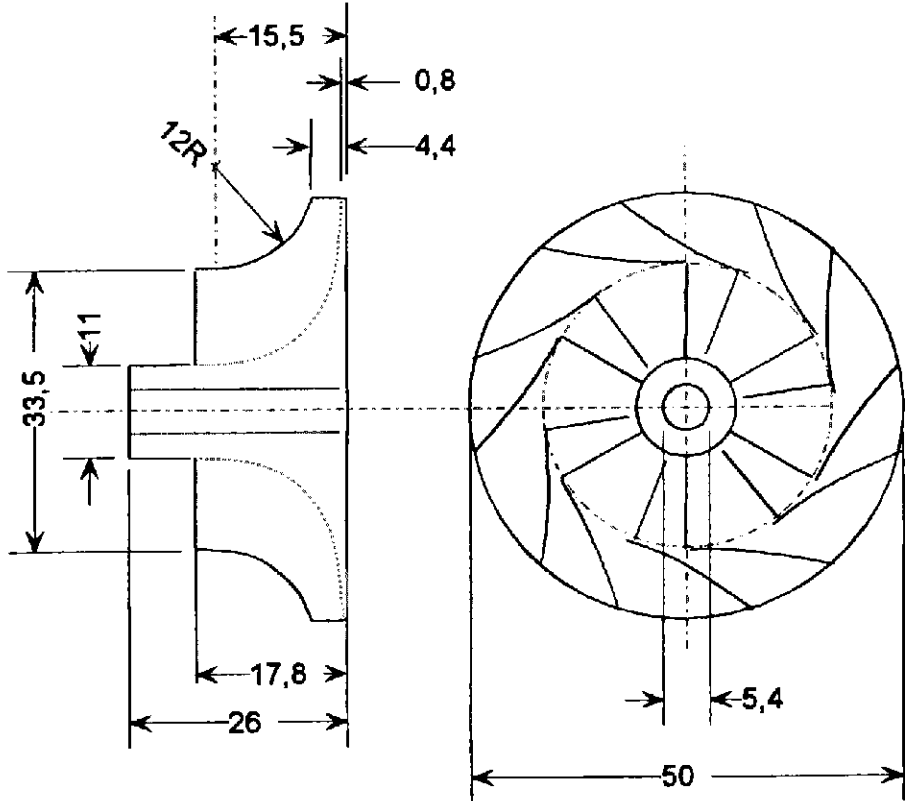


Pos. 25 Housing

Section View



P.11 Turbine wheel



Pos. 2 Compressor wheel