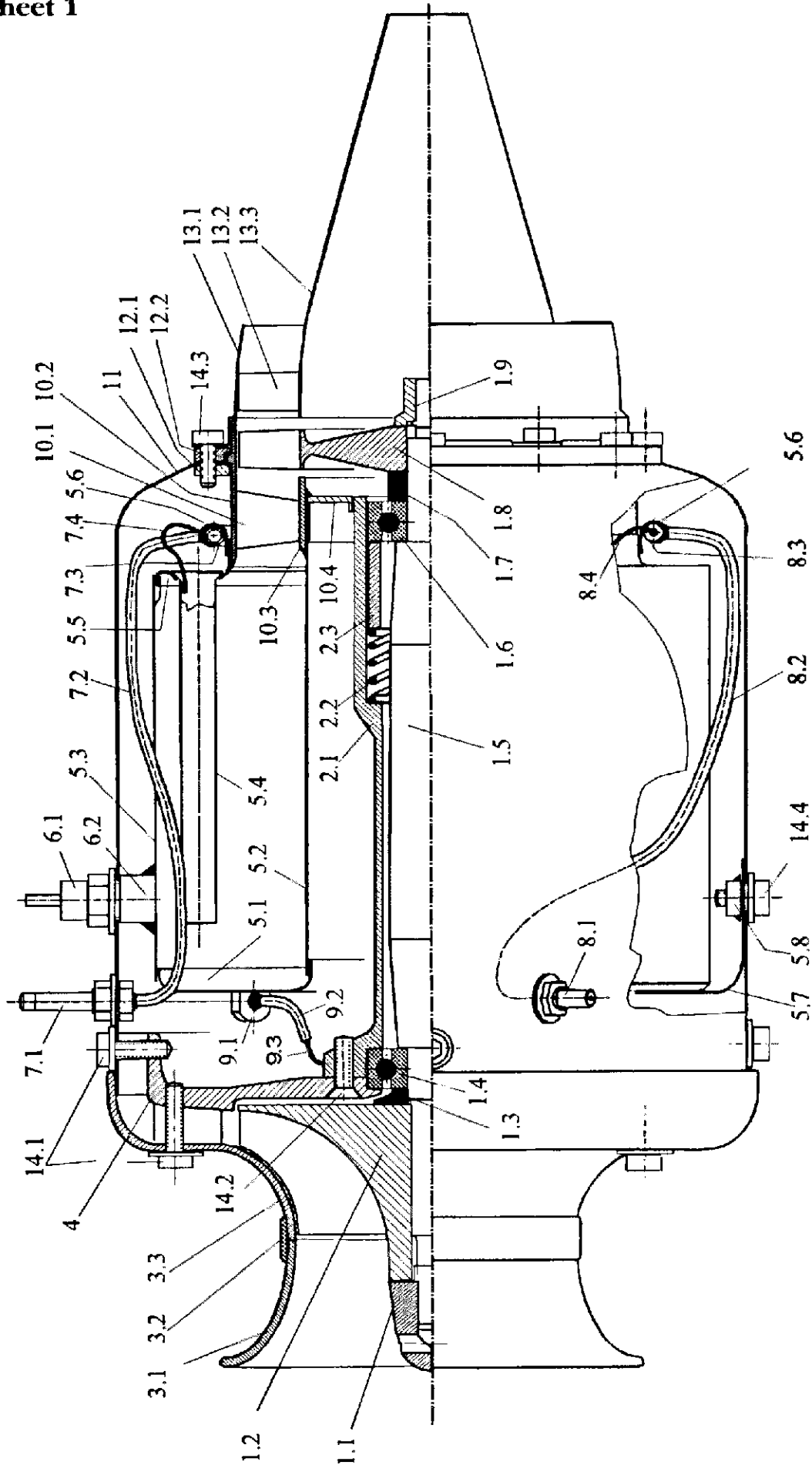


Parts list and drawings

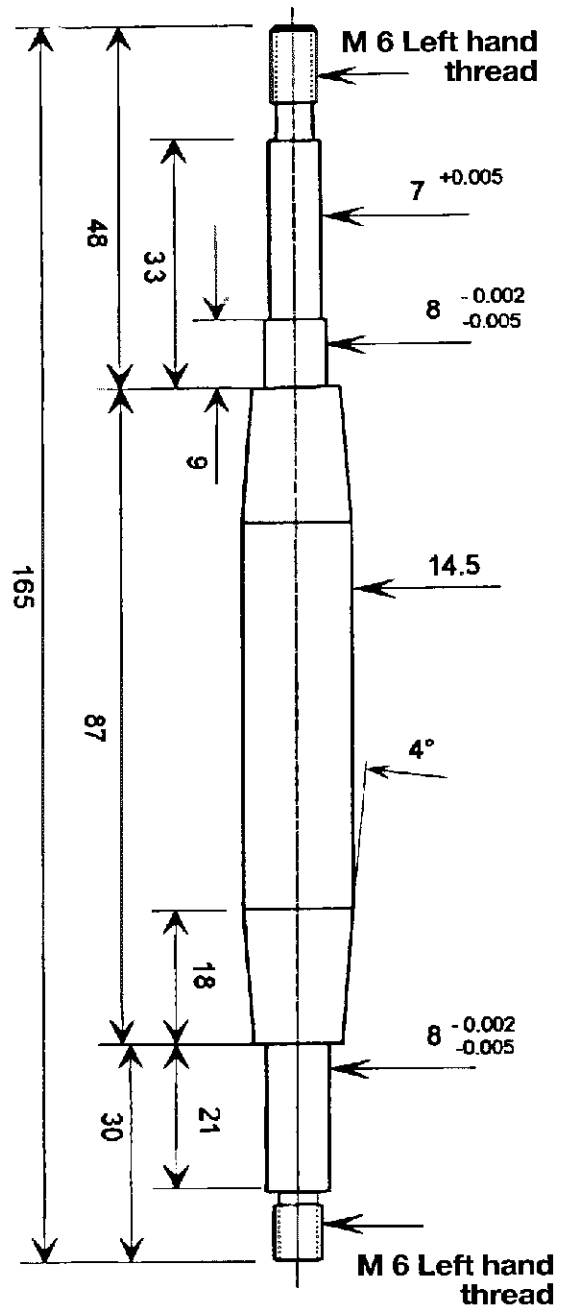
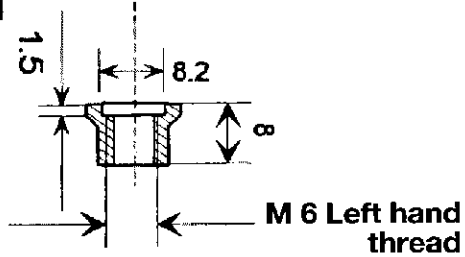
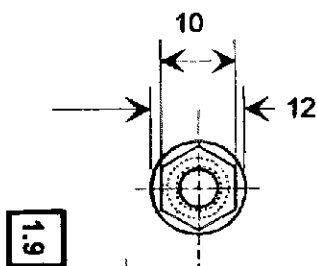
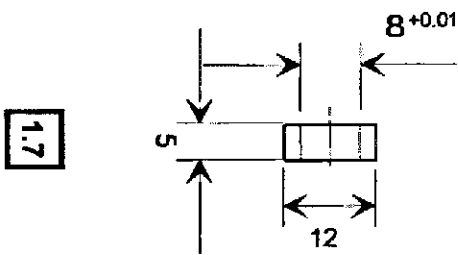
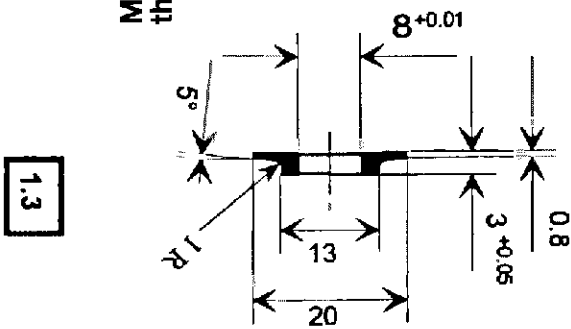
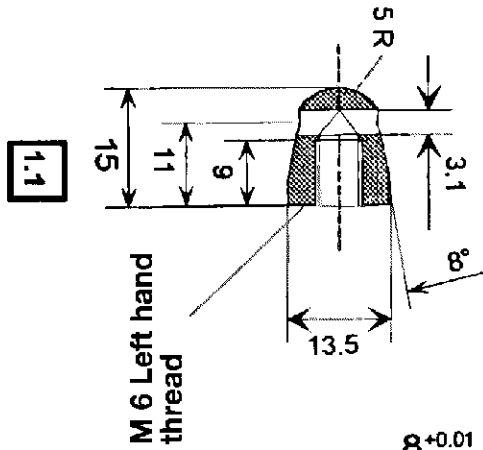
Parts list KJ-66

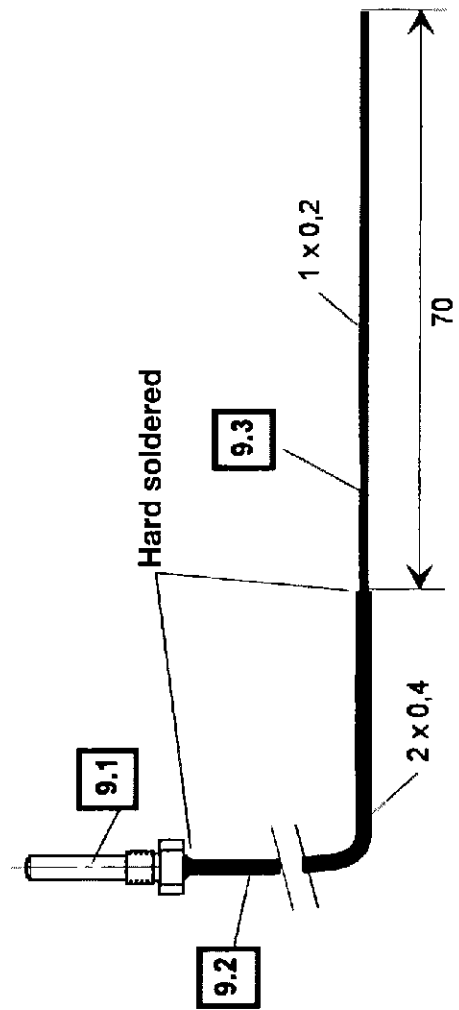
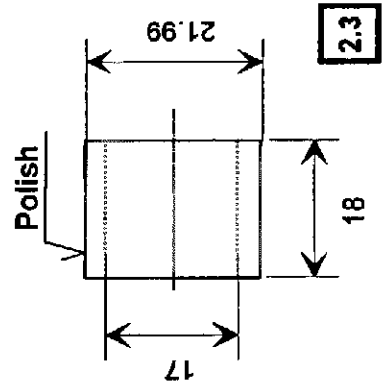
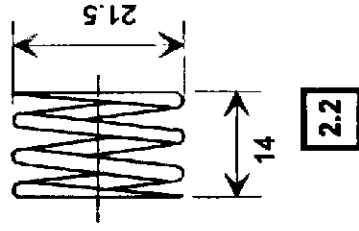
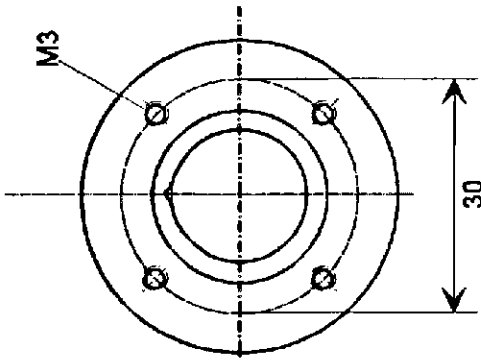
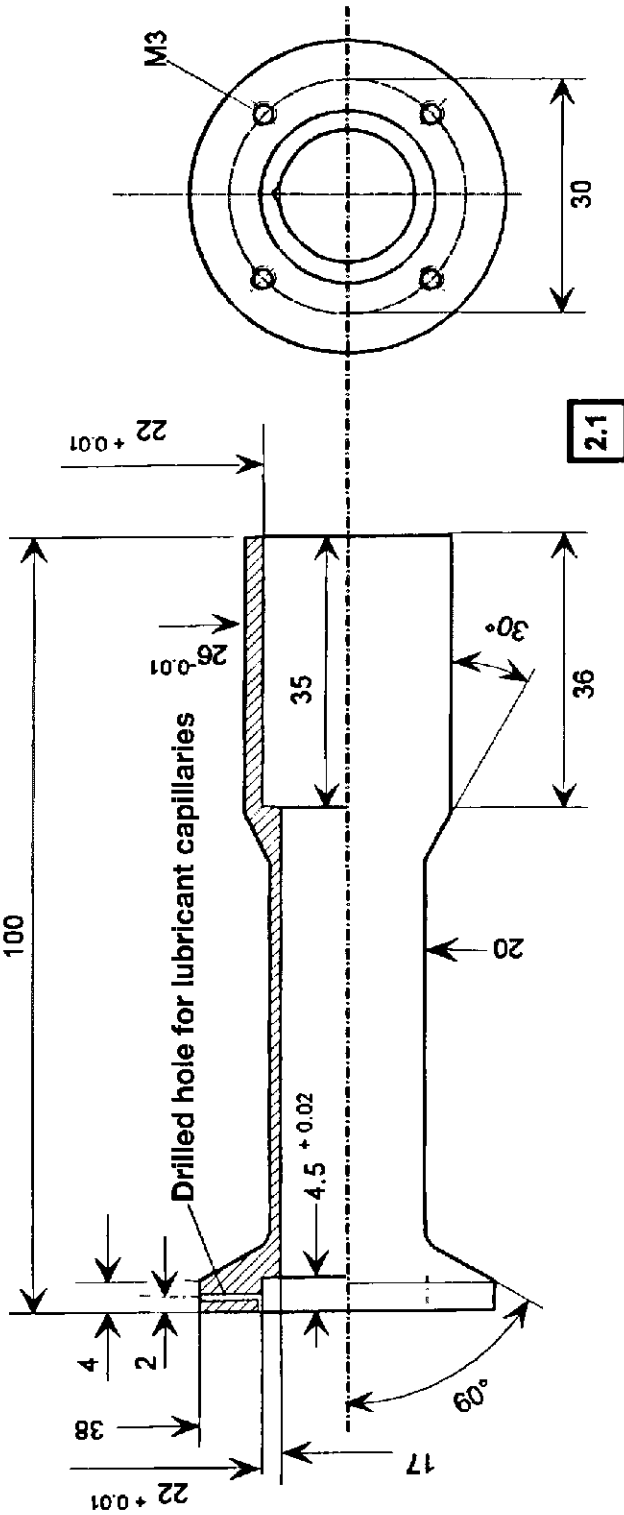
Item	Description	No.	Material	Semi-finished (dimensions mm)	Notes	Drawing Sheet No.
1.1	Compressor nut	1	AlZnMgCu	Round, 15 Ø		2
1.2	Compressor wheel	1	Special Al		Finished part No. 2038 KKK	18
1.3	Spacer ring C	1	Tool steel	Round, 20 Ø		2
1.4	Ball bearing C	1			Type D608/602 839. GRW	2
1.5	Shaft	1	Tool steel	Round, 20		2
1.6	Ball bearing T	1			Type D608/602 839. GRW	
1.7	Spacer ring T	1	Tool steel	Round, 15 Ø		
1.8	Turbine wheel	1	Inconel 713		Ready-made, see suppliers list	18
1.9	Turbine nut	1	High-temp steel	Round, 15 Ø		2
2.1	Shaft tunnel	1	AlZnMgCu	Round, 40 Ø		3
2.2	Spring	1	Spring steel			3
2.3	Bush	1	Tool steel	Round, 25 Ø		3
3.1	Intake nozzle	1	Al 99.9	Sheet 1.5 thick		15
3.2	Ring	1	AlMg	Round, 60 Ø		15
3.3	Lid	1	Al 99.9	Sheet 1.5 thick		15
3.4	Intake nozzle with lid	1	AlMg	Round, 115 Ø	Alternative to 3.1-3.3	16
4	Compressor guide system	1	AlZnMgCu	Round, 120 Ø	Ready-made, see suppliers list	4
5.1	Front part of comb. chamber	1	CrNi 18/10	Sheet 0.4 thick	Ready-made, see suppliers list	7
5.2	Internal part of comb. chamber	1	CrNi 18/10	Sheet 0.3 thick	Ready-made, see suppliers list	5
5.3	External part of comb. chamber	1	CrNi 18/10	Sheet 0.3 thick	Ready-made, see suppliers list	6
5.4	Stick	6	CrNi 18/10	Tube 6 × 0.5	Ready-made, see suppliers list	7
5.5	Back part of comb. chamber	1	CrNi 18/10	Sheet 0.4 thick	Ready-made, see suppliers list	7
5.6	Tab	5	CrNi 18/10	Sheet 0.4 thick		9
5.7	Fixing bracket	1	CrNi 18/10	Sheet 0.4 thick		9
5.8	Nut	1	CrNi 18/10	Round, 15 Ø		9
5.9	Wire loop	6	CrNi 18/10	Wire 0.6 Ø		
6.1	Glow plug	1			Finished part, standard quality	
6.2	Glow plug fitting	1	Steel	Round, 10 Ø		9
7.1	Fuel connection	1	Brass	Round, 10 Ø		13
7.2	Fuel supply line	1	Brass	Tube 2 × 0.4		13
7.3	Fuel distributor	1	Brass	Tube 3 × 0.4		13
7.4	Fuel pipe	6	Brass	Tube 1 × 0.2		13
8.1	Auxiliary gas connection	1	Brass	Round, 10 Ø		13
8.2	Auxiliary gas line	1	Brass	Tube 2 × 0.4		13
8.3	Auxiliary gas distributor	1	Brass	Tube 3 × 0.4		13
8.4	Gas dosing tube	2	Brass	Tube 1 × 0.2		13
9.1	Oil connection	1	Brass	Round, 10 Ø		13
9.2	Oil line	1	Brass	Tube 2 × 0.4		3
9.3	Oil dosing tube	2	Brass	Tube 1 × 0.2		3
10.1	Turbine guide vane	15	Inconel 600	Sheet 0.7 thick	Ready-made, see suppliers list	11
10.2	Turbine ring	1	CrNi 18/10	Sheet 2 thick	Ready-made, see suppliers list	10
10.3	Central body	1	CrNi 18/10	Sheet 1 thick	Ready-made, see suppliers list	10
10.4	Centring ring	1	CrNi 18/10	Sheet 1 thick	Ready-made, see suppliers list	10
11	Housing	1	Steel		Camping gas CV 470	17
12.1	Flange A	1	CrNi 18/10	Sheet 2 thick		12
12.2	Flange B	1	CrNi 18/10	Sheet 3 thick		12
13.1	Nozzle sheath	1	CrNi 18/10	Sheet 0.4 thick		8
13.2	Radius arm	1	CrNi 18/10	Sheet 0.6 thick		14
13.3	Cone	1	CrNi 18/10	Sheet 0.4 thick		14
14.1	Screw	9	St. 8.8	Hexagon socket M3×10		
14.2	Screw	4	St. 8.8			
14.3	Screw	12	CrNi 18/10	Hexagon socket M3×10		
14.4	Screw	1	St 8.8	Hexagon socket M3×5		

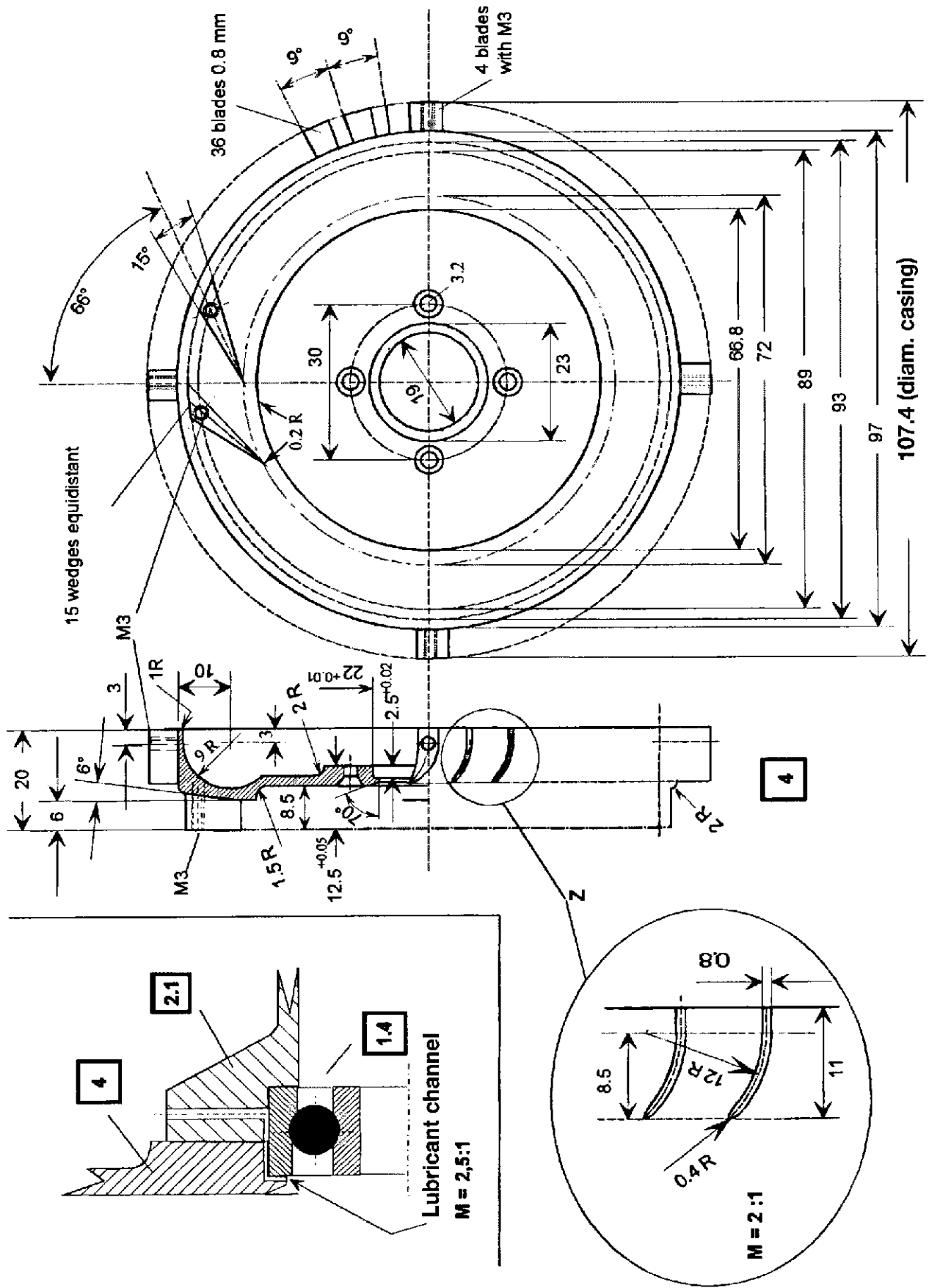
KJ-66: Sheet 1



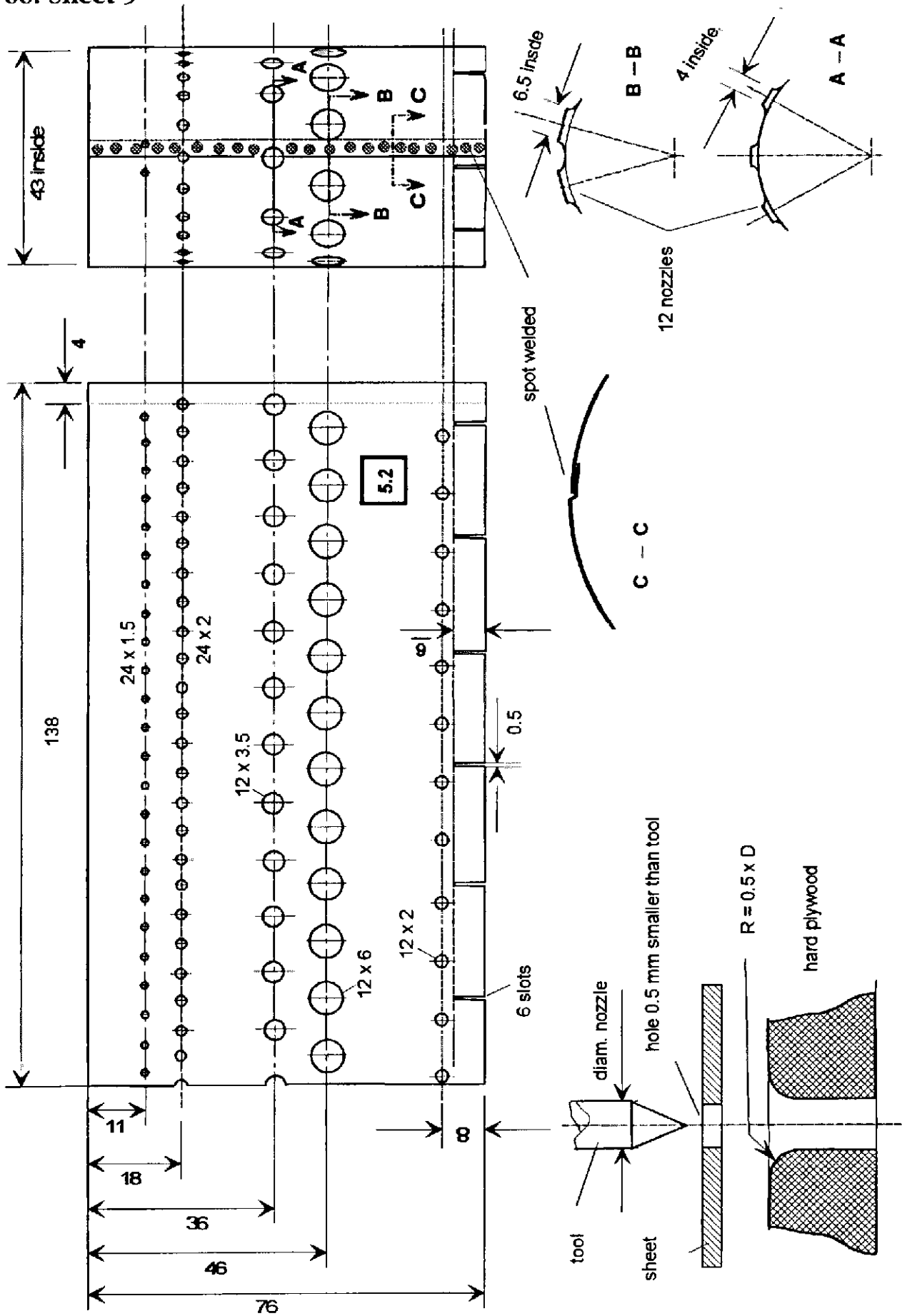
KJ-66: Sheet 2

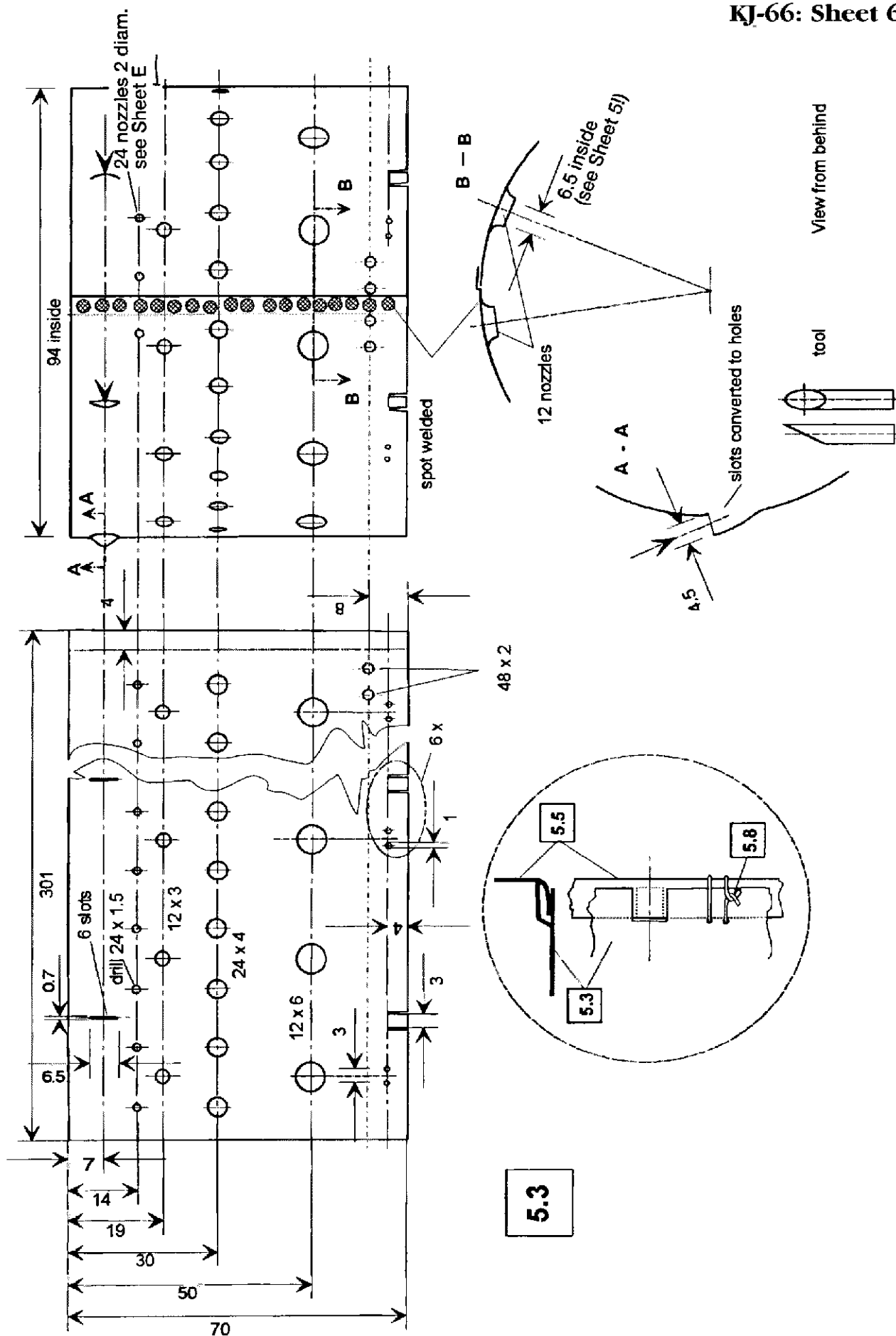


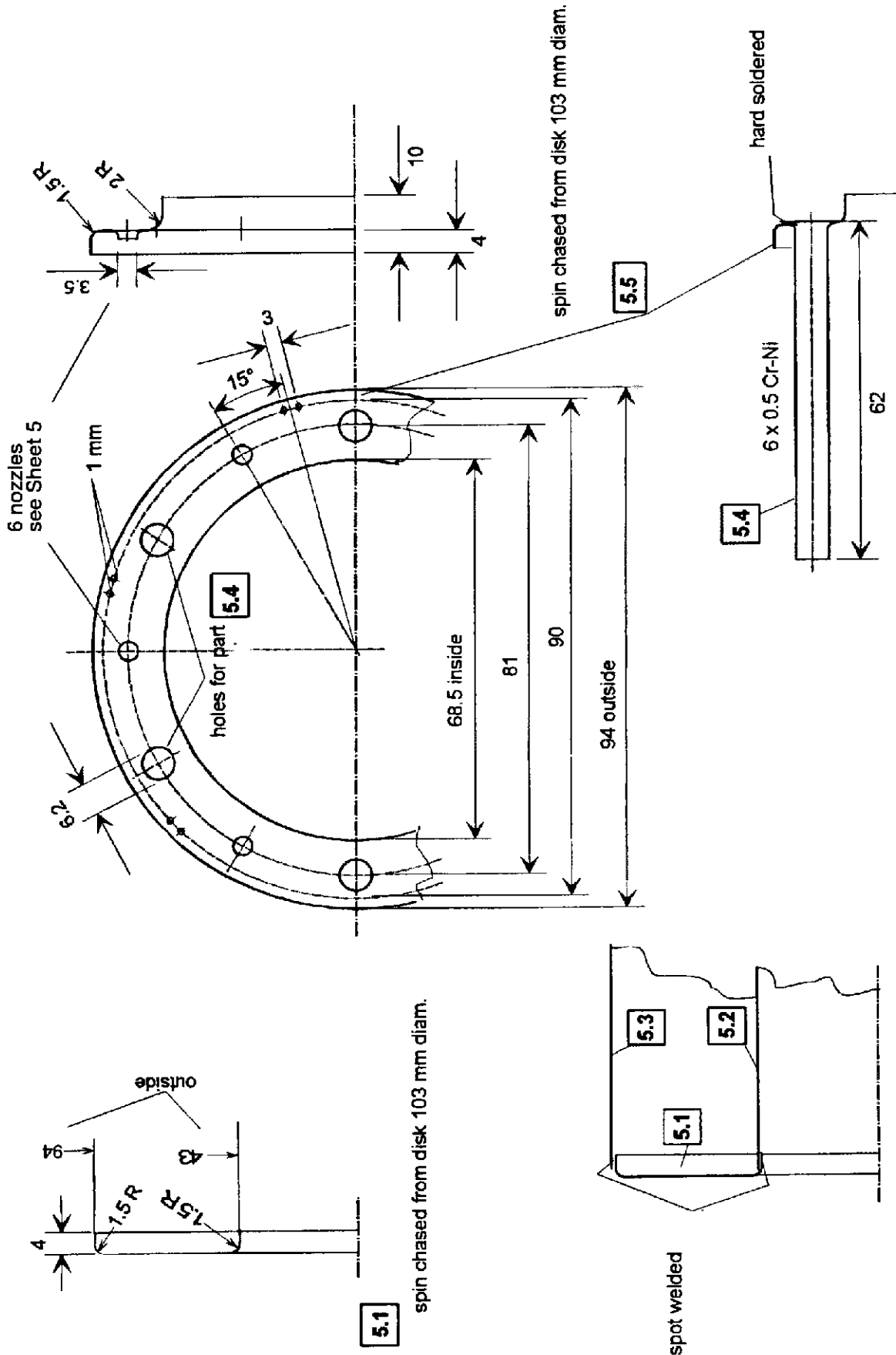


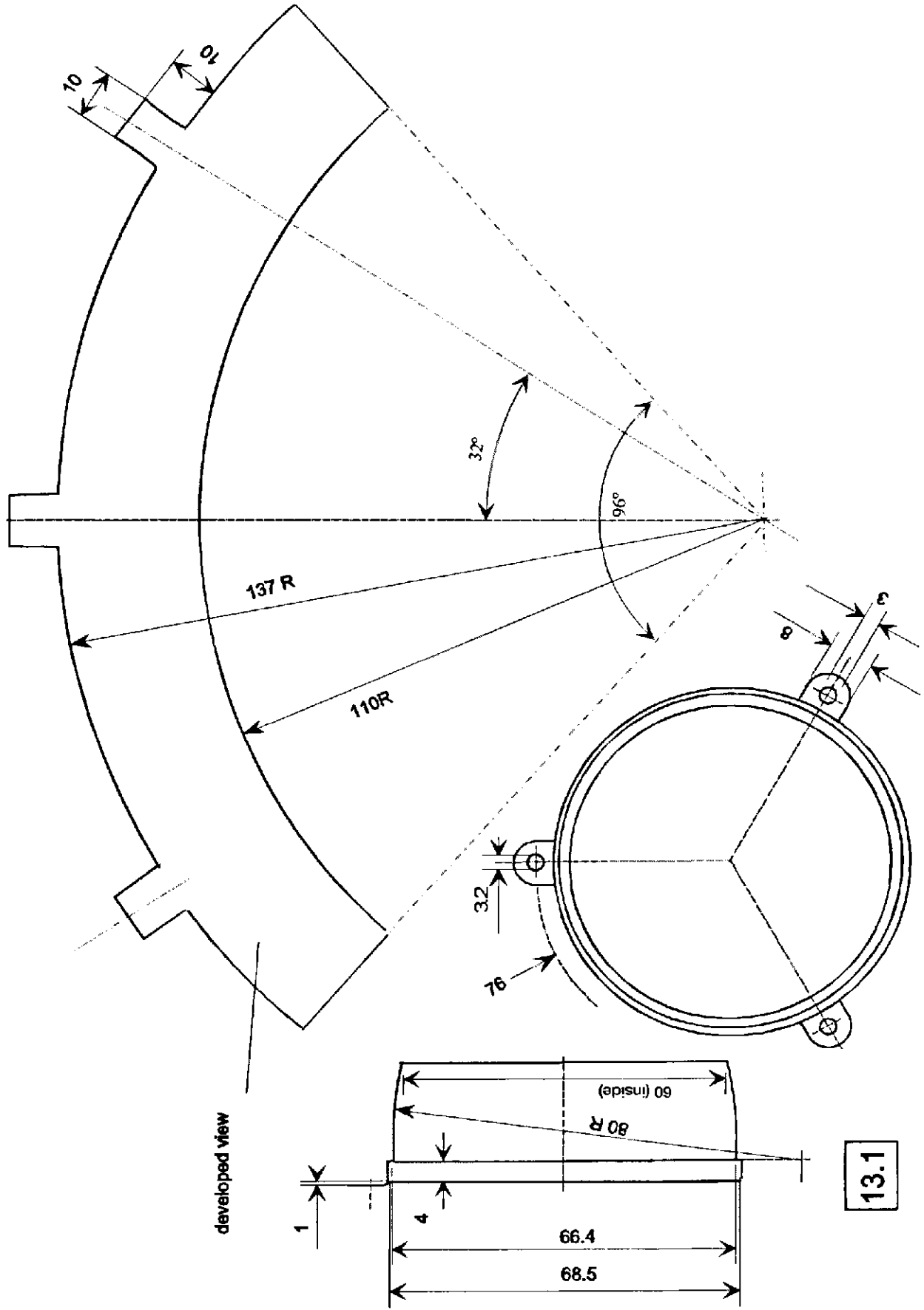


KJ-66: Sheet 5

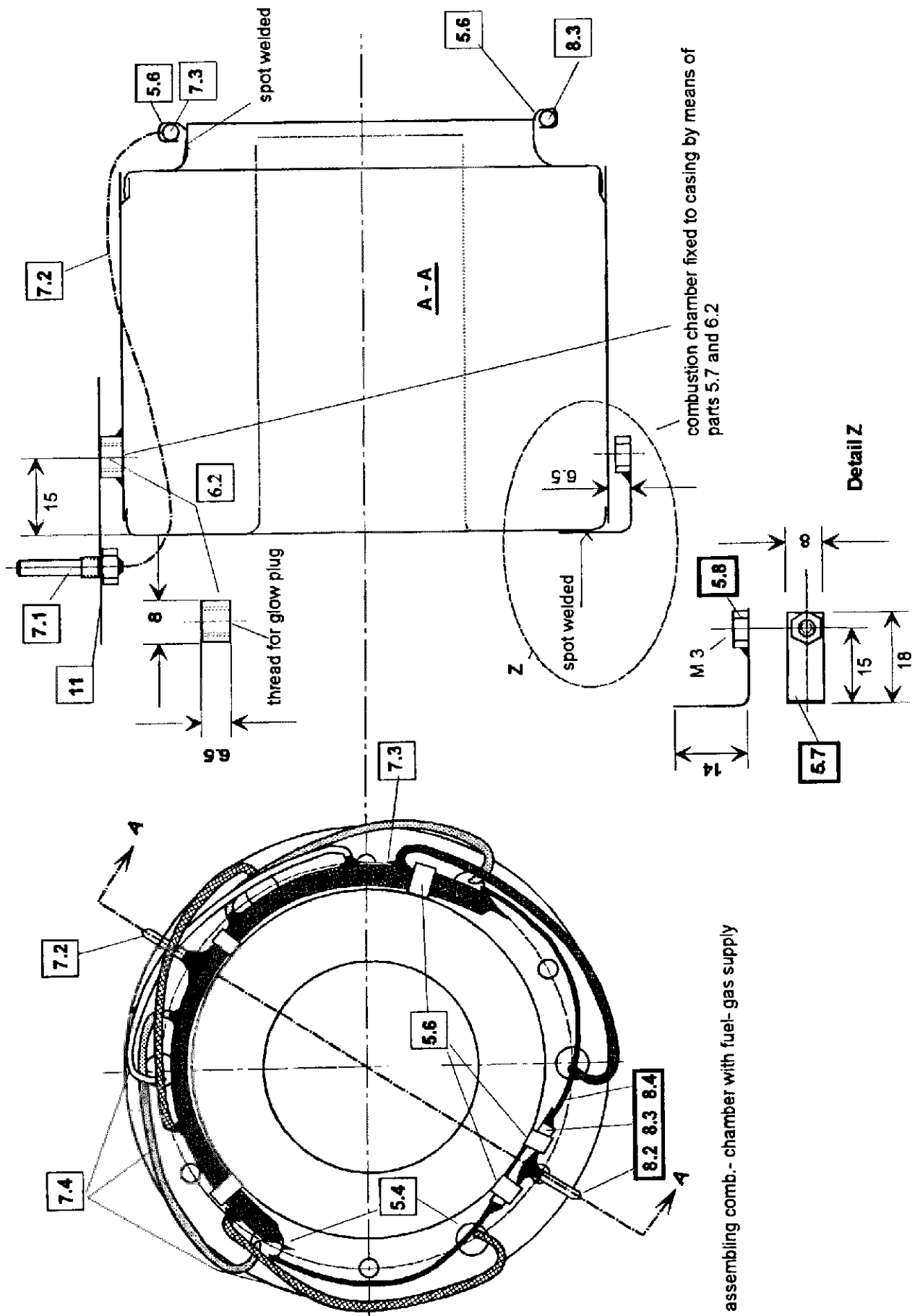


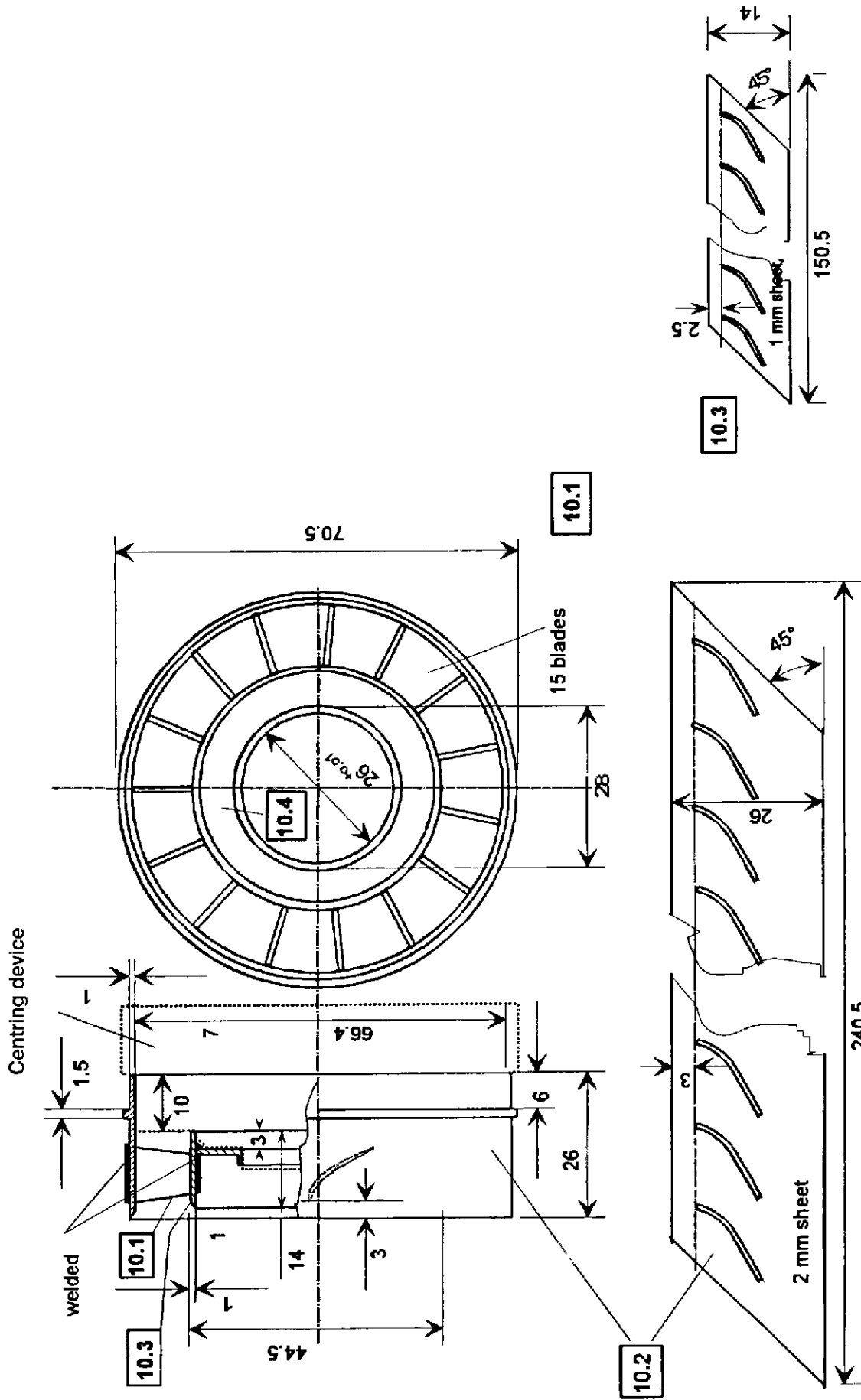






13.1





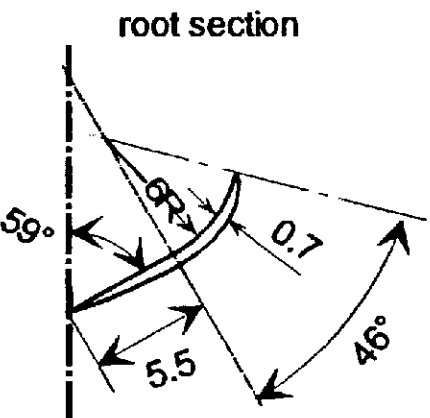
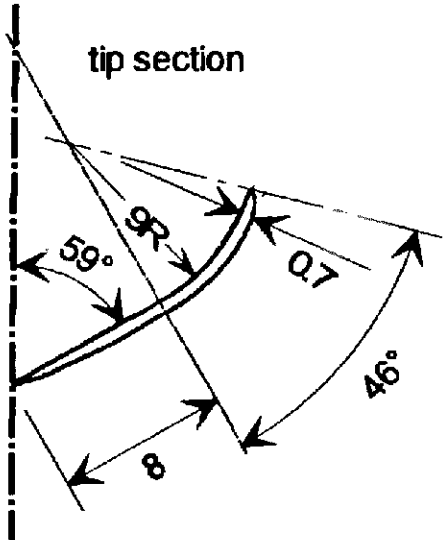
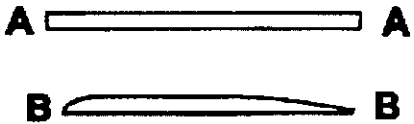
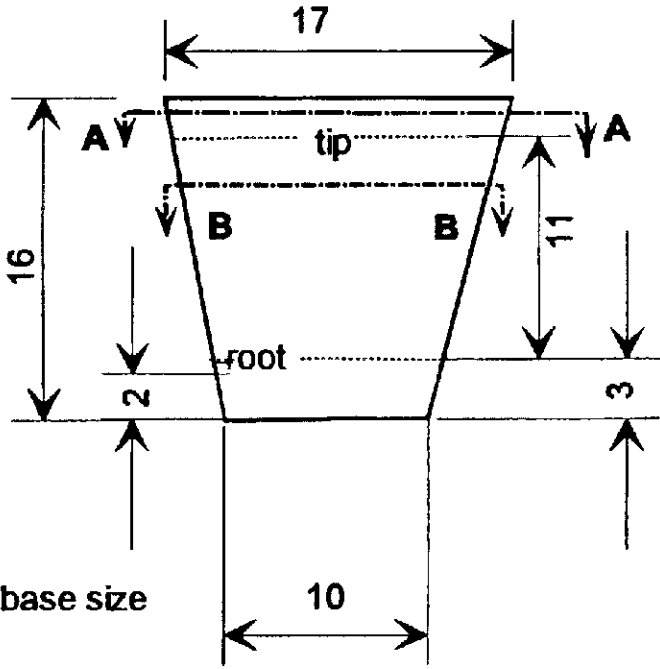
Making the rings from sheet material: Cut the slots for the blades first. Bend strip to a ring. Weld diagonal edges. Retouch slots to the right dimension.

Developed view 10.1

tip root

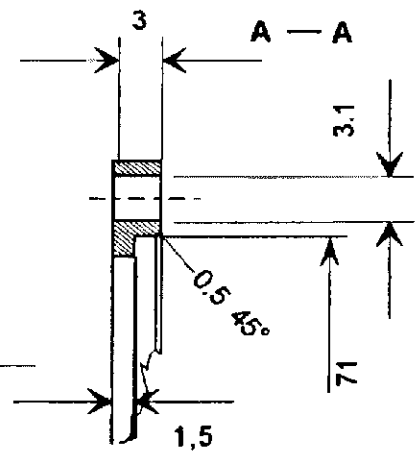
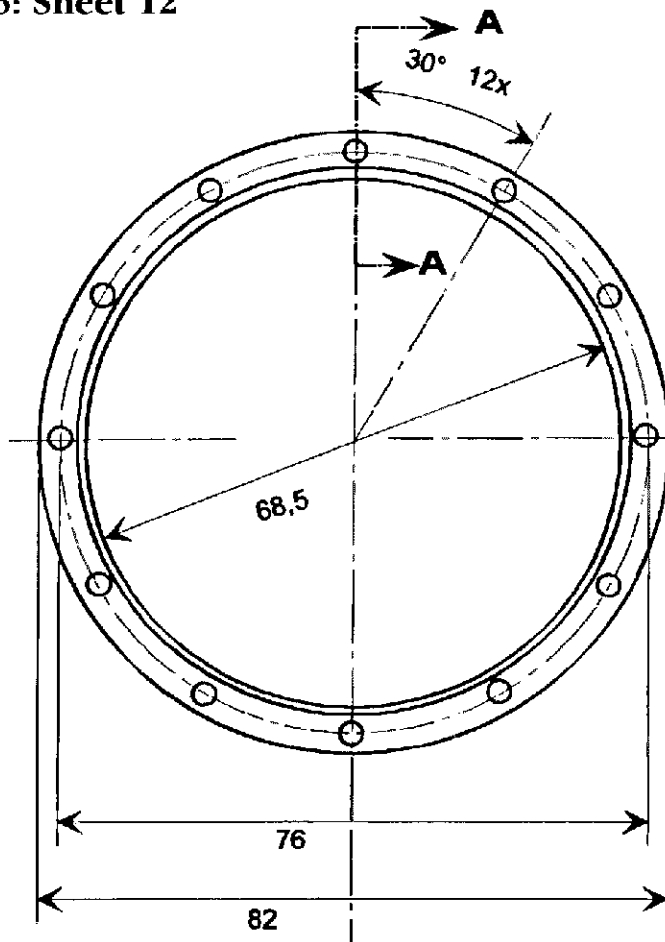


Full scale
1 : 1

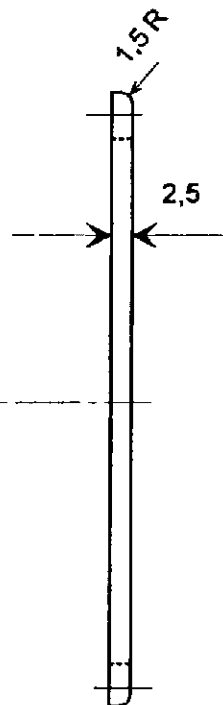
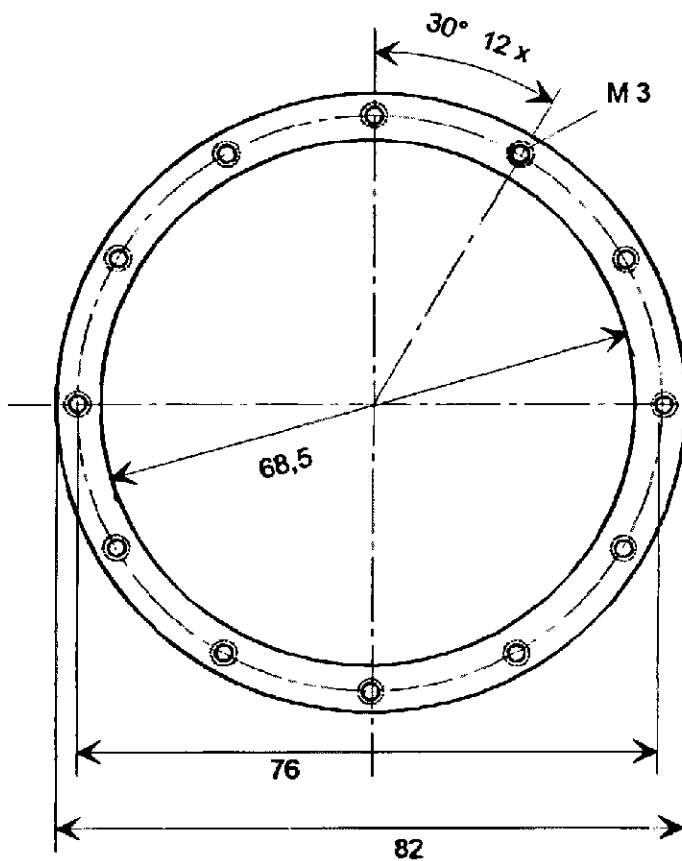


10.1 scale = 2 : 1

KJ-66: Sheet 12

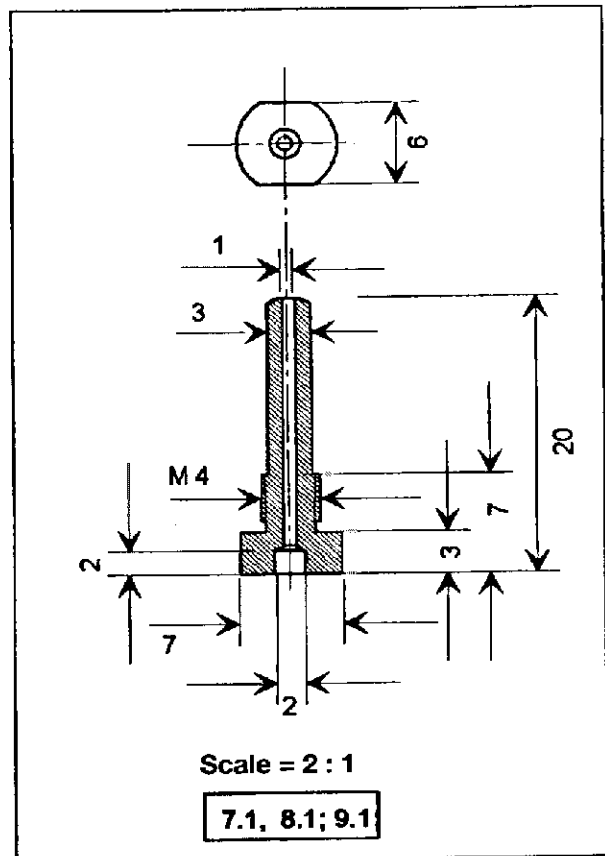
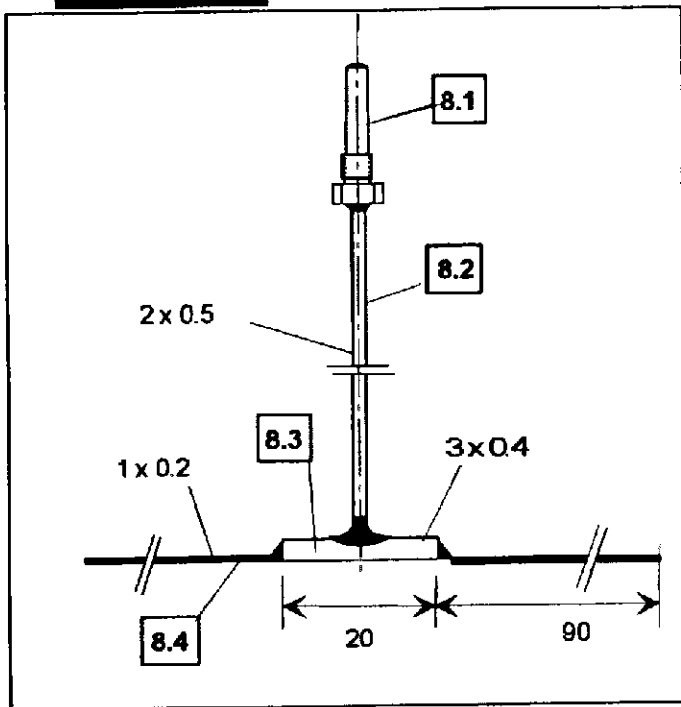
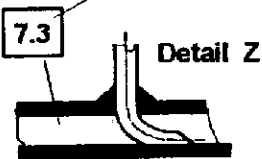
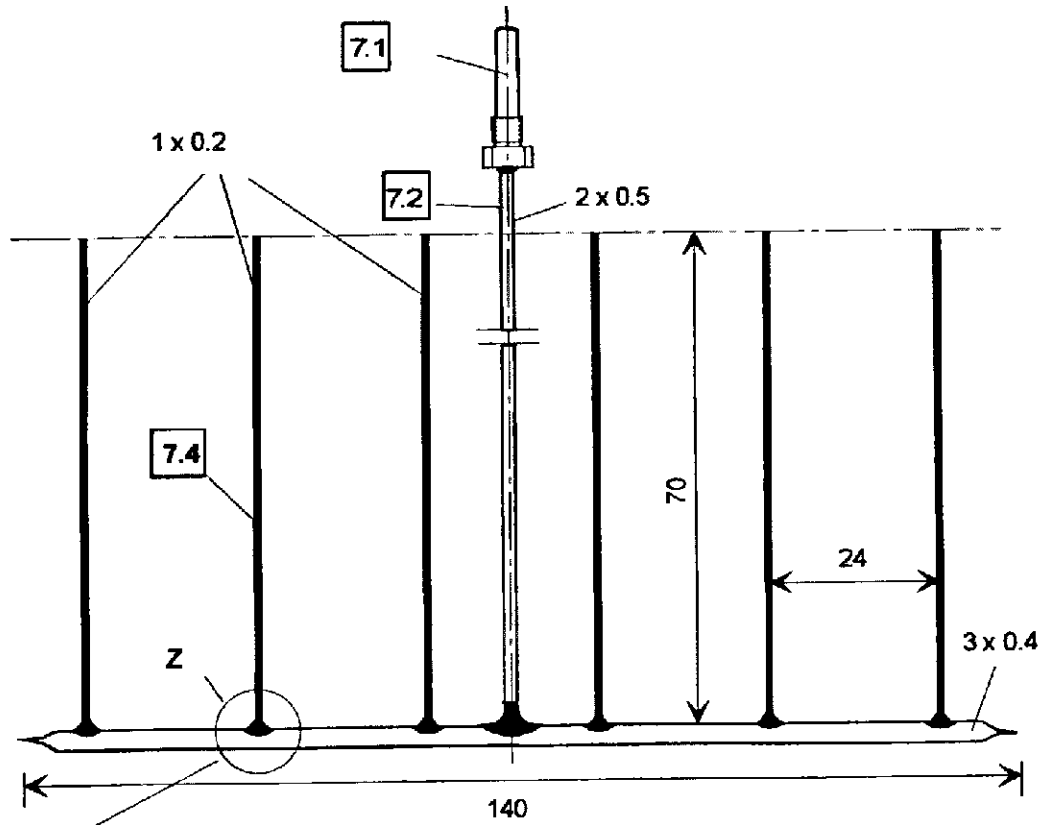


12.2



12.1

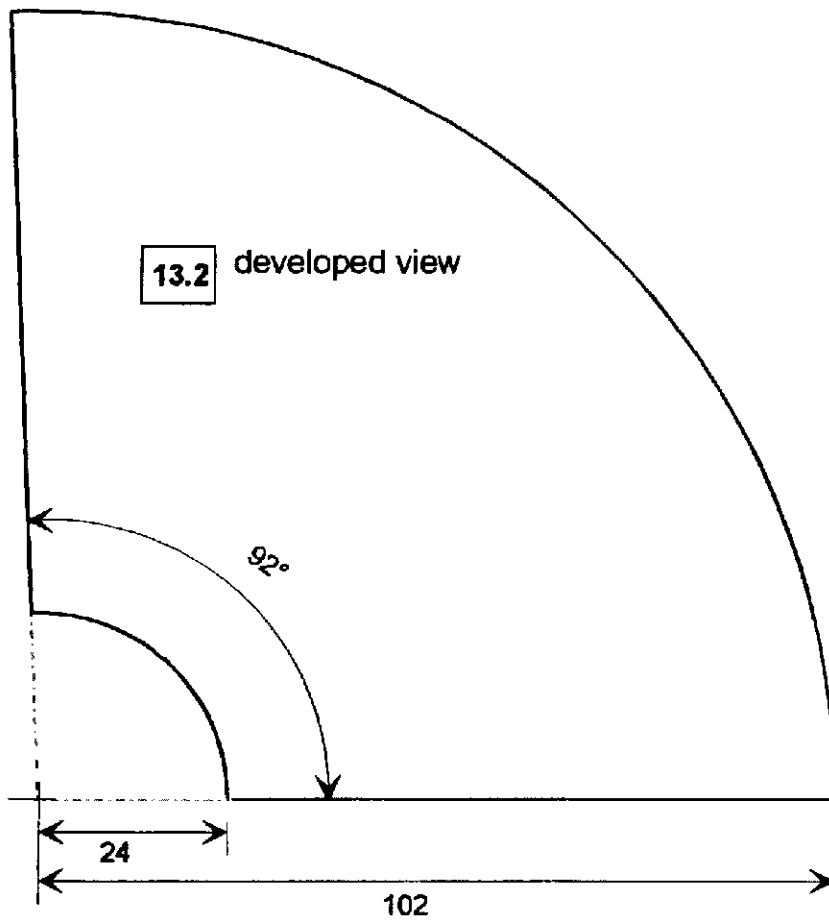
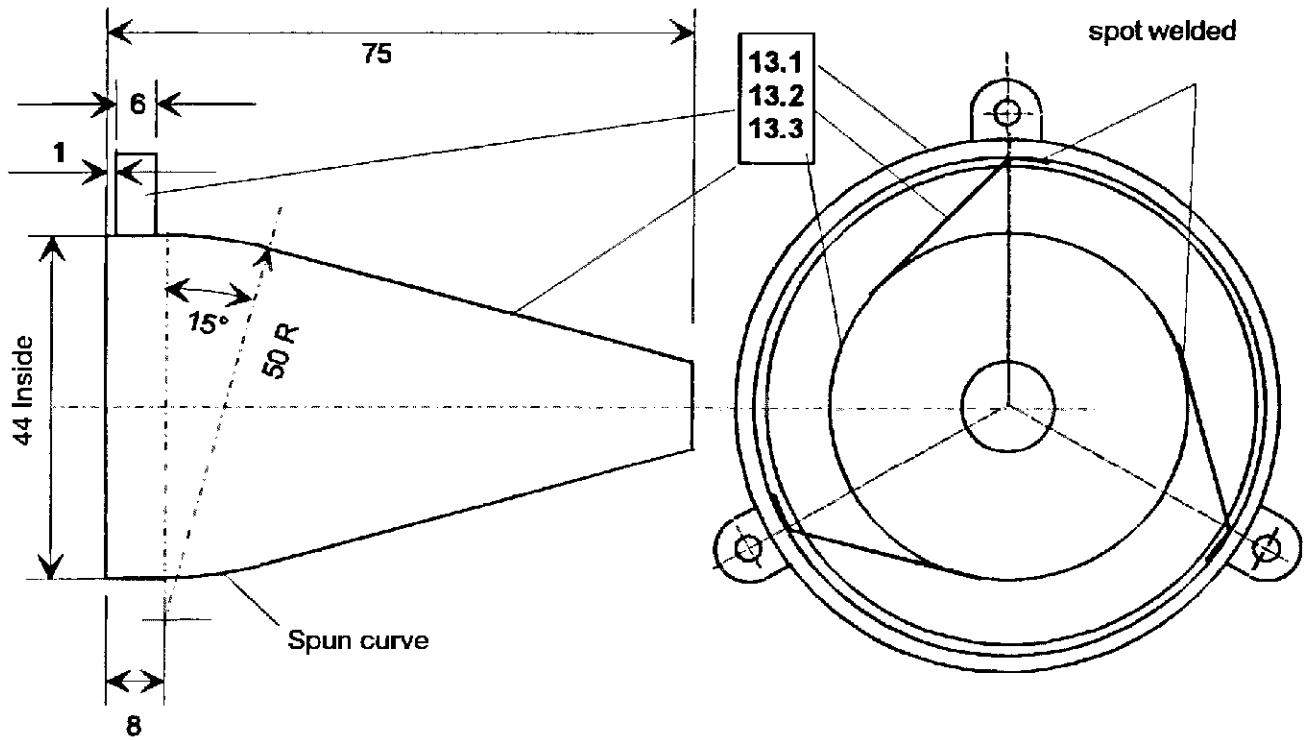
KJ-66: Sheet 13



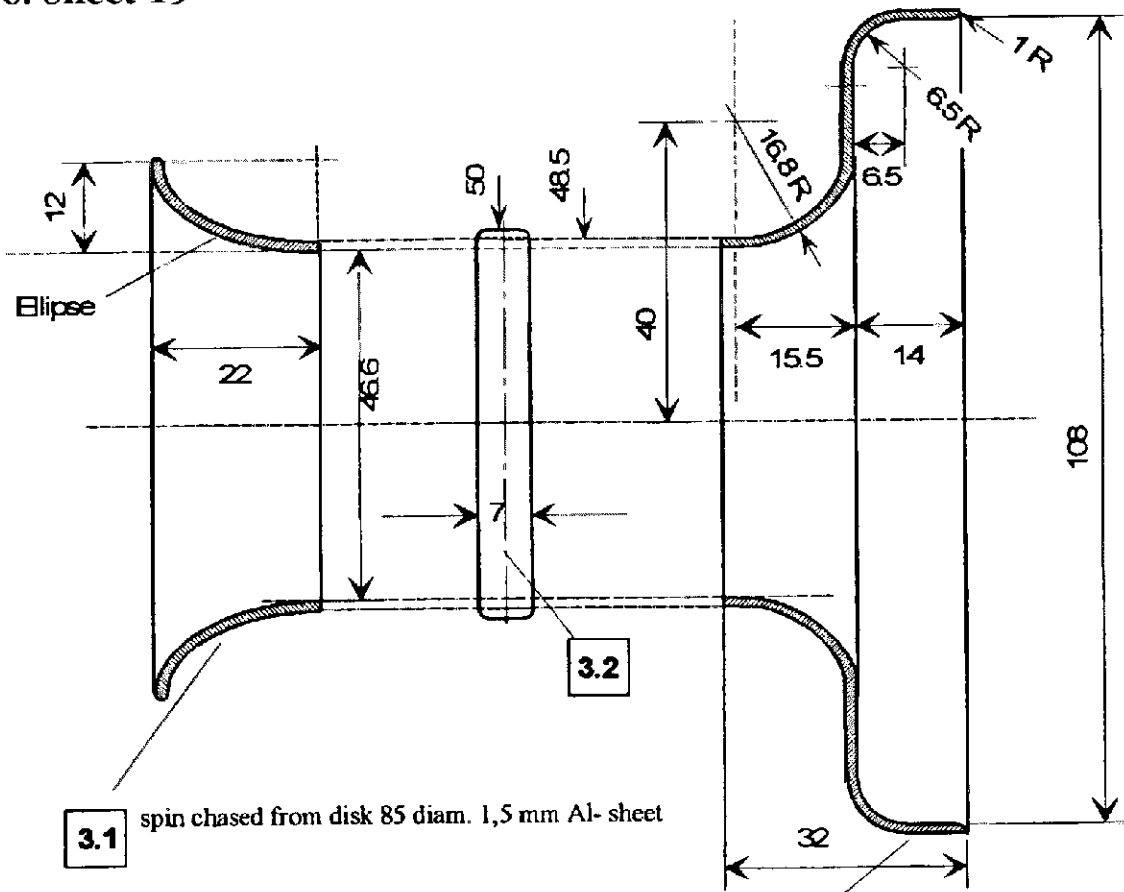
Scale = 2 : 1
7.1, 8.1; 9.1

▲ hard soldered, all tubes brass

KJ-66: Sheet 14

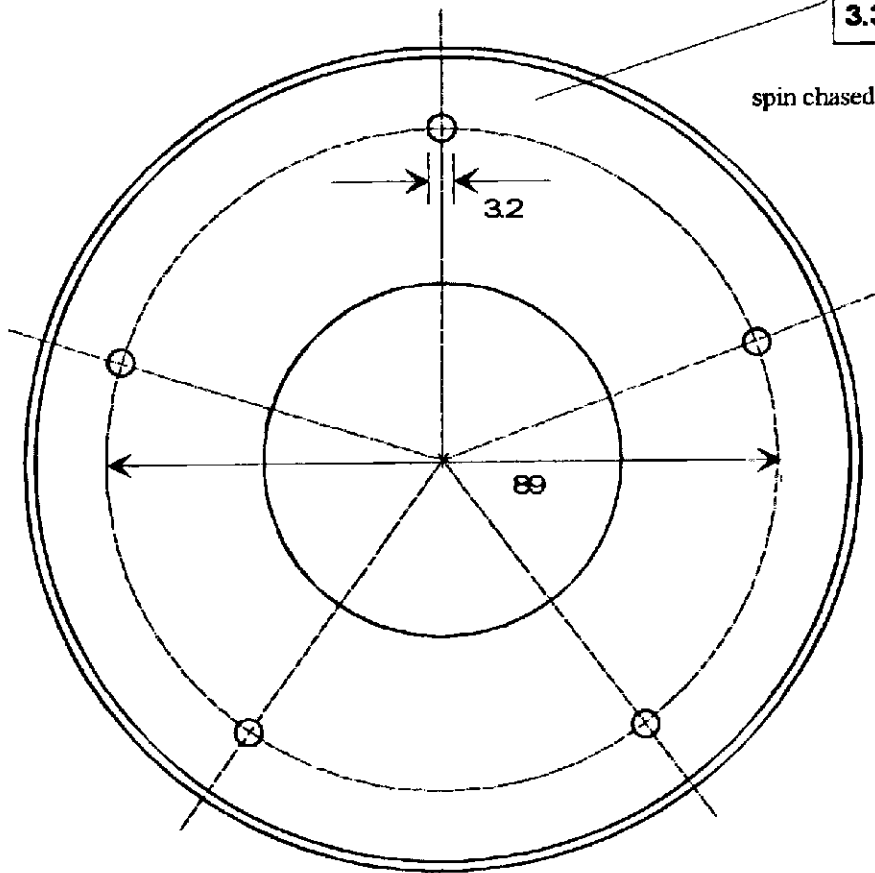


KJ-66: Sheet 15

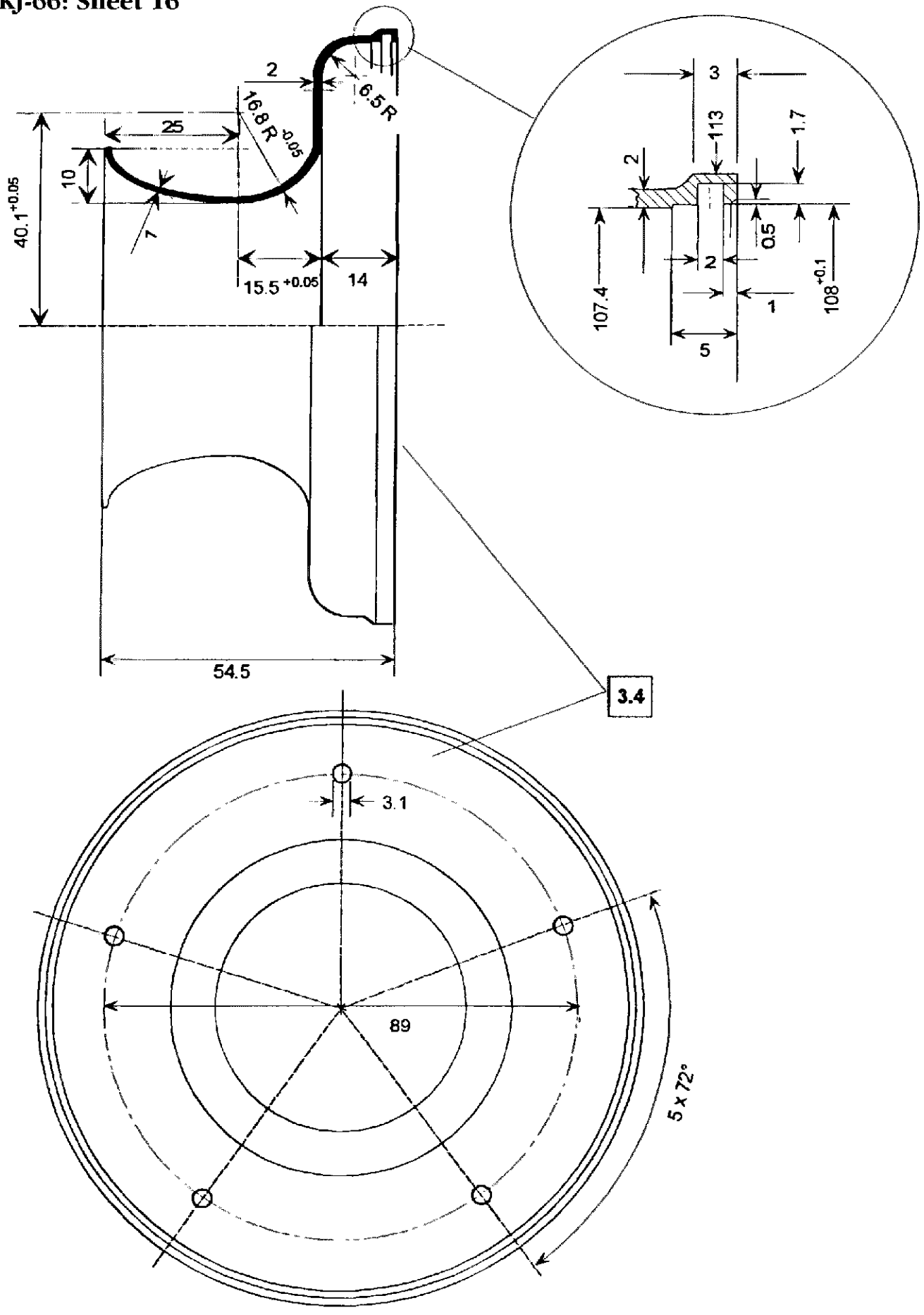


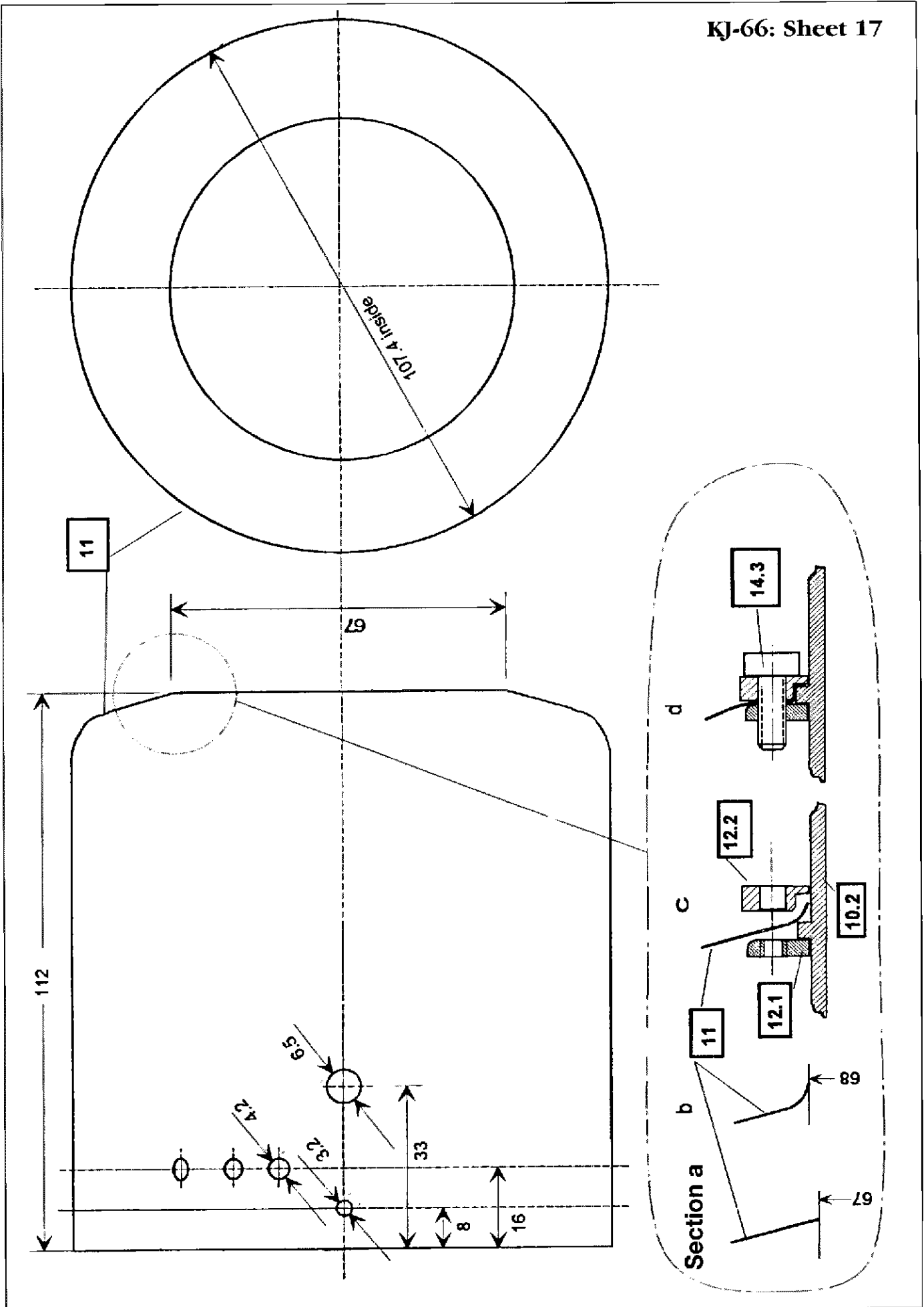
3.1 spin chased from disk 85 diam. 1,5 mm Al- sheet

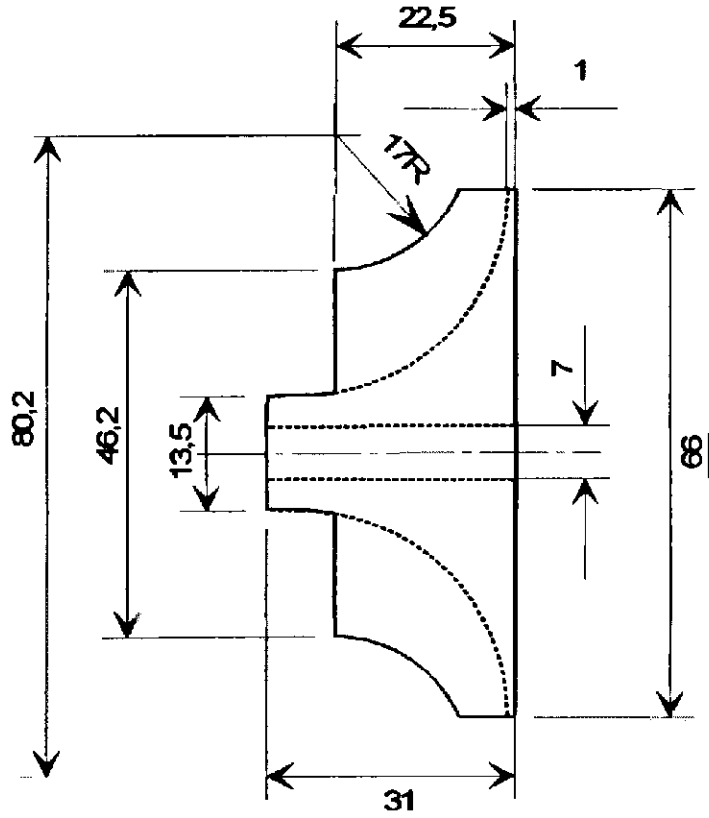
3.3 spin chased from disk 133 diam. 1,5 mm Al- sheet



KJ-66: Sheet 16







main dimensions

