

THE SPY WHO LOVED ME™

LOTUS
esprit



Pack 03

BUILD INSTRUCTIONS

STAGE 017: PREPARING THE
ENGINE BLOCK

STAGE 018: FITTING THE ENGINE BLOCK
AND EXHAUST MANIFOLD

STAGE 019: ATTACHING THE PULLEYS

STAGE 020: FITTING THE OIL PUMP,
DISTRIBUTOR AND SPARK PLUG CABLES

STAGE 021: FITTING THE ALTERNATOR
AND BELTS

STAGE 022: ATTACHING THE AIR BOX

STAGE 023: FITTING THE BACKPLATE
AND GEARBOX

STAGE 024: ATTACHING THE OIL SUMP

STAGE 025: MOUNTING THE ENGINE
BLOCK ONTO THE CHASSIS

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Advice from the experts

Spare screws are included with each part. Occasionally, you may be instructed to keep spare or unused screws for a later stage. Keep these spares in a safe place and label them correctly.

Please make sure you don't mix up the screws. They look quite similar, but the threads do vary slightly. Using the wrong screws may damage the parts.

When securing parts together using multiple screws, fit each screw loosely to ensure all the parts are correctly aligned before gently tightening them firmly, but not overtight, in the order in which you placed them.

The screwdriver can be magnetized by stroking it with a magnet (fridge magnet, etc.) enabling it to hold the screws and make assembly easier.

If a screw is tight going into a metal part, do not force it as you may shear the head off. Remove it and put a tiny smear of Vaseline, soap or light oil on the thread. That will lubricate it and make it easier to drive home.

During the course of this build, you will receive many pieces that you will assemble immediately – following the instructions in the corresponding stage – and other pieces that you should store safely to one side, for use in future assembly stages.

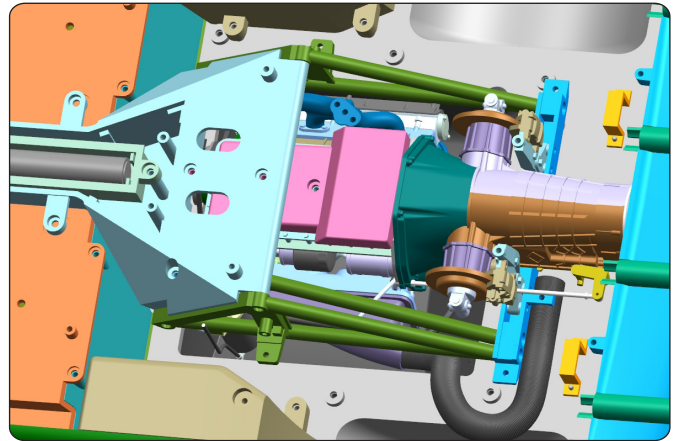
Left and Right! When building your *The Spy Who Loved Me* Lotus Esprit, the left- or right-hand side refers to that side as if you are sitting in the car.



WARNING: Some parts are assembled using magnets. These magnets can cause serious injury if they are swallowed. Keep away from children. If you suspect a magnet has been swallowed, seek medical help straight away.

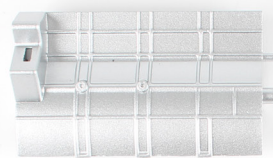
Stage 017: Preparing the Engine Block

In this stage you'll prepare the engine block by fitting a mounting bracket and breather pipe.



STAGE 017 PARTS LIST

Name
17-A Engine block
17-B Bracket
17-C Breather pipe
DS05 screws x5



17-A



17-B

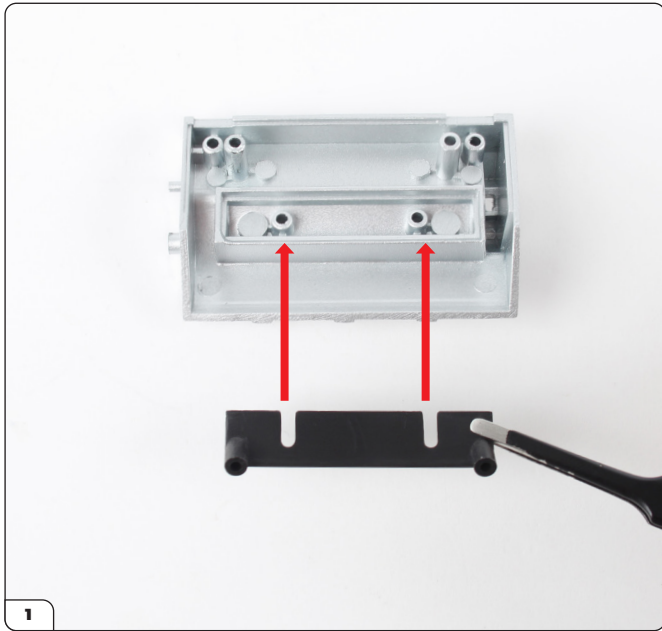


17-C

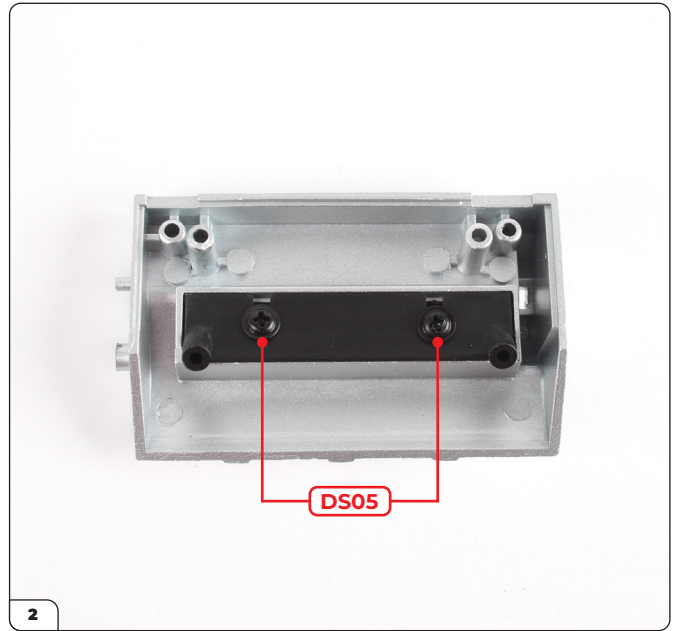


DS05 x3

Stage 017: Preparing the Engine Block



Take the bracket (17-B) and fit it onto the engine block (17-A).



Secure in place with 2xDS05 screws.



Fit the breather pipe (17-C) into the opening in the orientation shown.



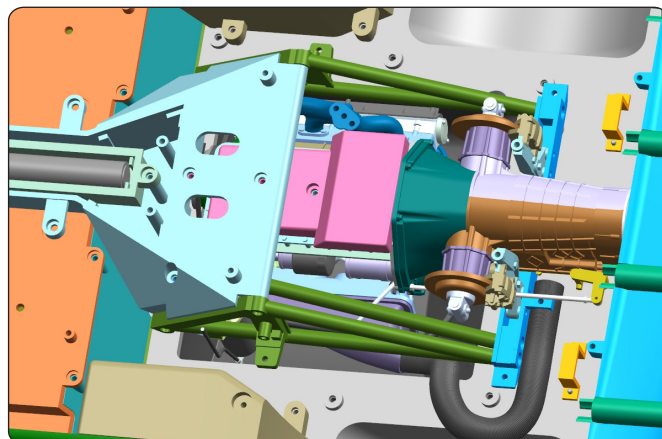
Stage 017: Preparing the Engine Block

STAGE COMPLETE



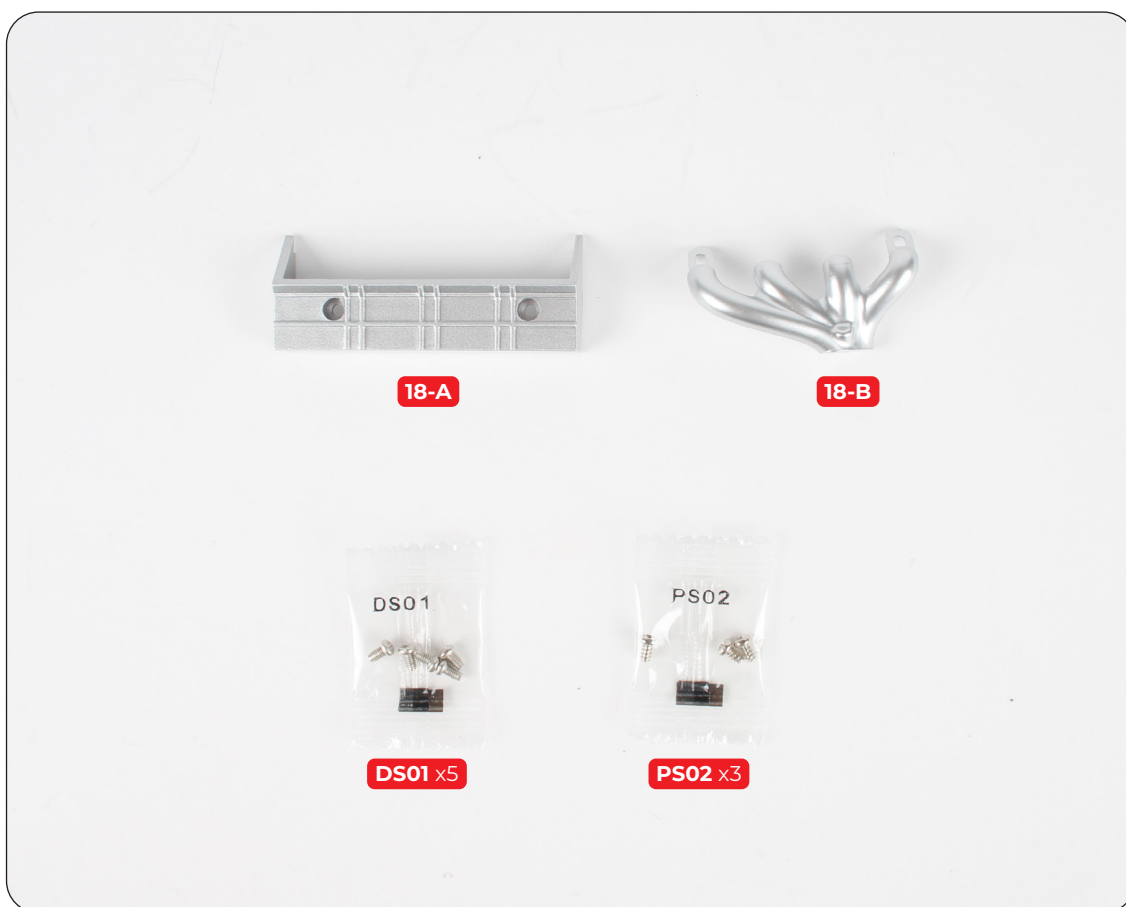
Stage 018: Fitting the Engine Block and Exhaust Manifold

You'll continue working on the engine block by attaching the exhaust manifold then fitting the engine block together.

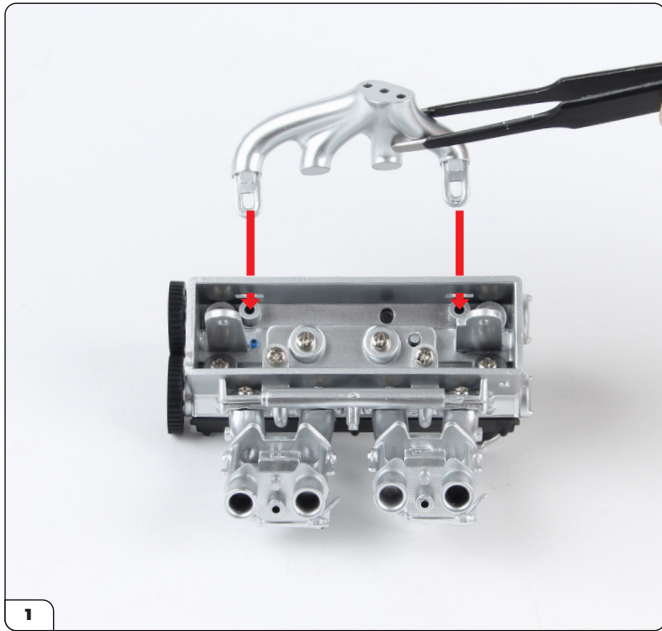


STAGE 018 PARTS LIST

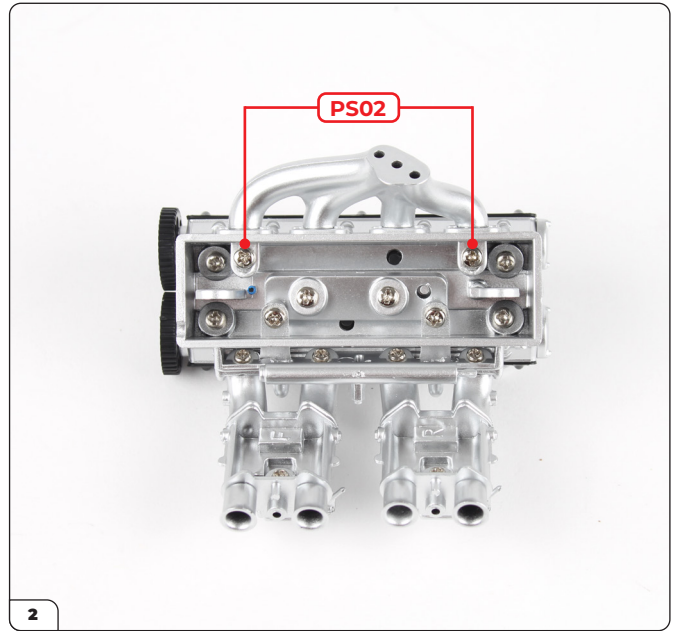
Name
18-A Engine block
18-B Exhaust manifold
DS01 screws x5
PS02 screws x3



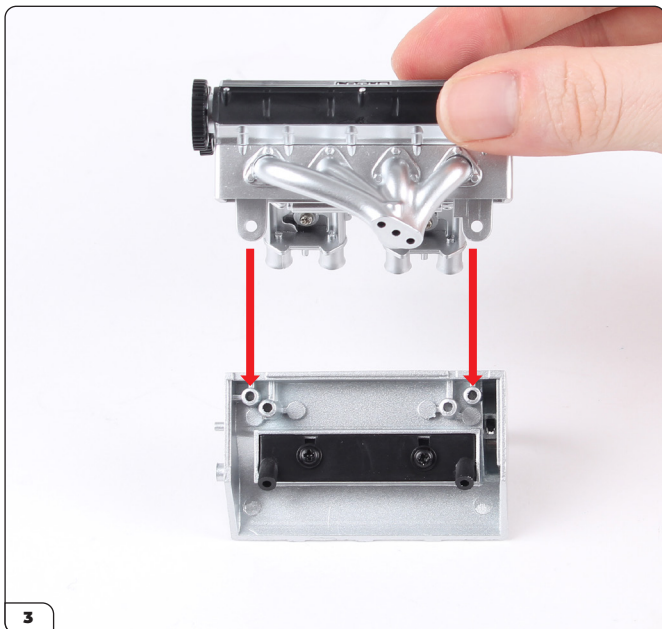
Stage 018: Fitting the Engine Block and Exhaust Manifold



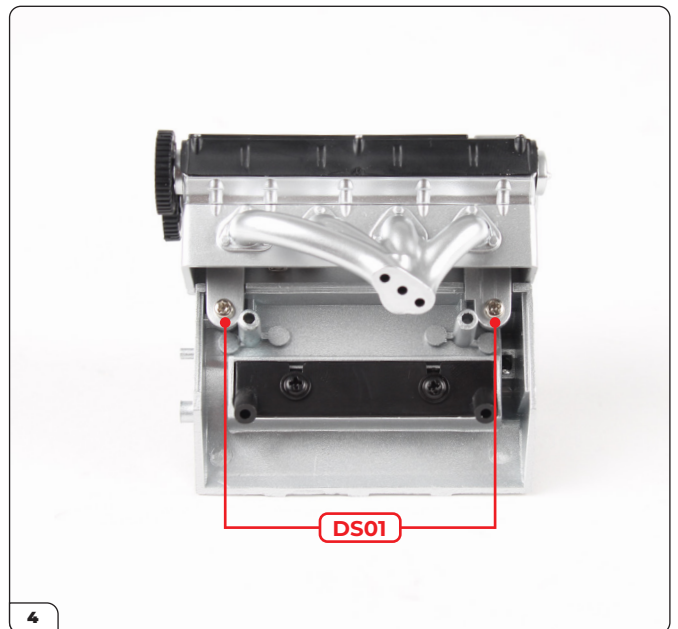
Take the cylinder head assembly (stage 011) and align the exhaust manifold (18-B) as shown.



Fit the exhaust manifold through the openings and onto the screw posts. Secure in place with 2x PS02 screws.

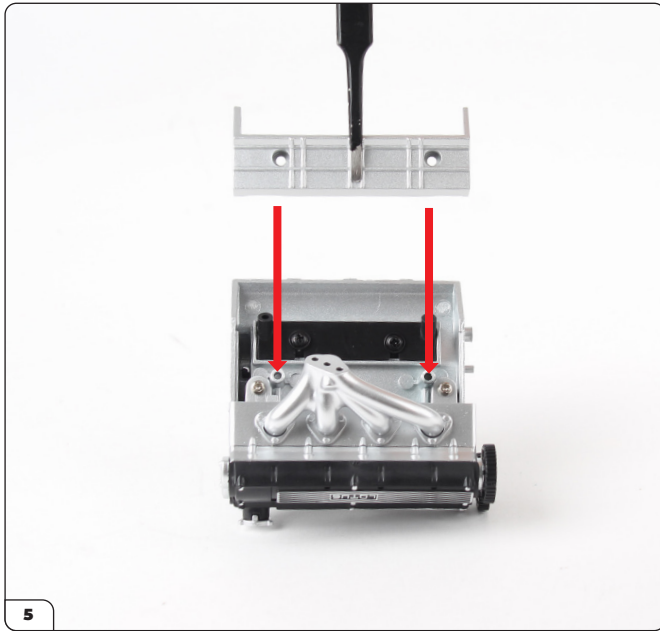


Align the assembly with the engine block (stage 017).

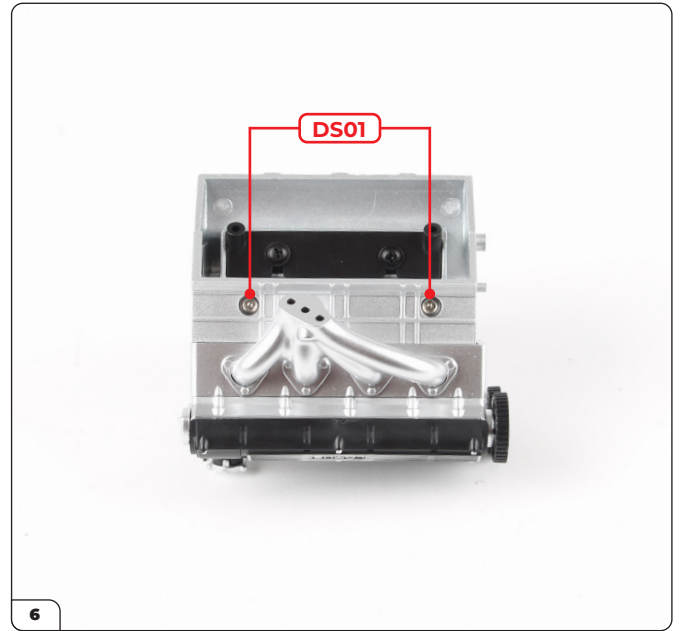


Fit the parts together and secure with 2x DS01 screws.

Stage 018: Fitting the Engine Block and Exhaust Manifold

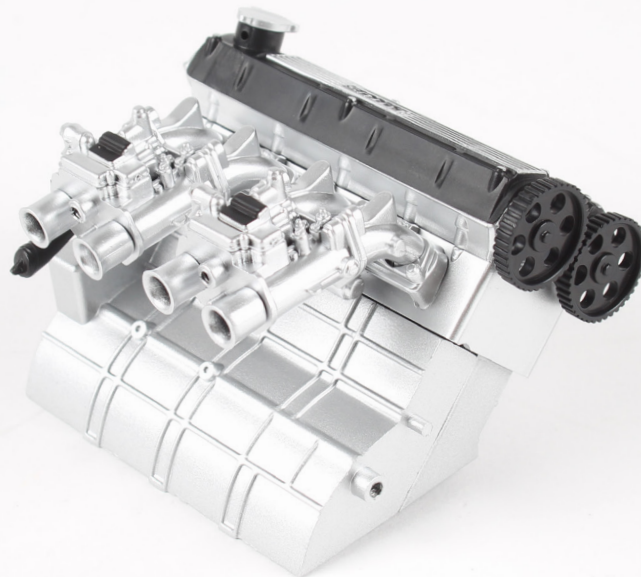


Fit the engine block (18-A) onto the assembly.



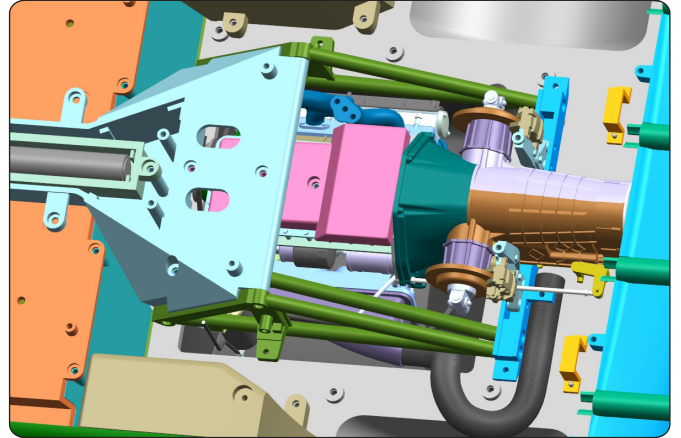
Secure in place with 2x DS01 screws.

STAGE COMPLETE



Stage 019: Attaching the Pulleys

In this stage you'll fit the pulleys to their support bracket then fix them to the engine block.



STAGE 019 PARTS LIST

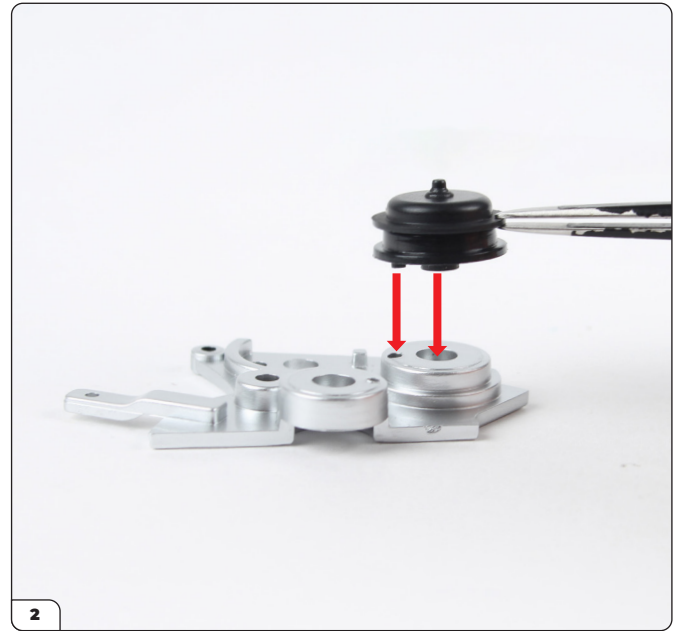
Name
19-A Support bracket
19-B Large pulley (A)
19-C Large pulley (B)
19-D Small pulley
DS01 screws x2
PS02 screws x3



Stage 019: Attaching the Pulleys



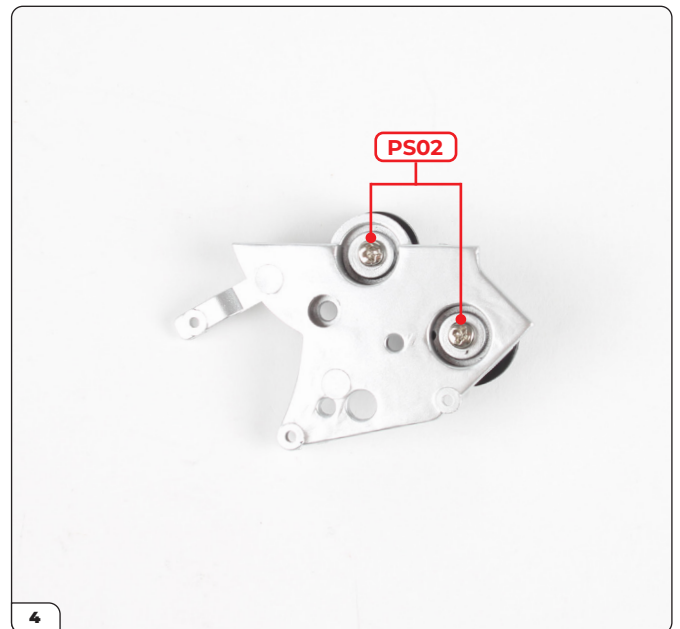
Take part A and B of the large pulley. Fit the pin and screw post through the holes (inset).



Fit the large pulley onto the support bracket (19-A) using the pin and screw post as a guide.

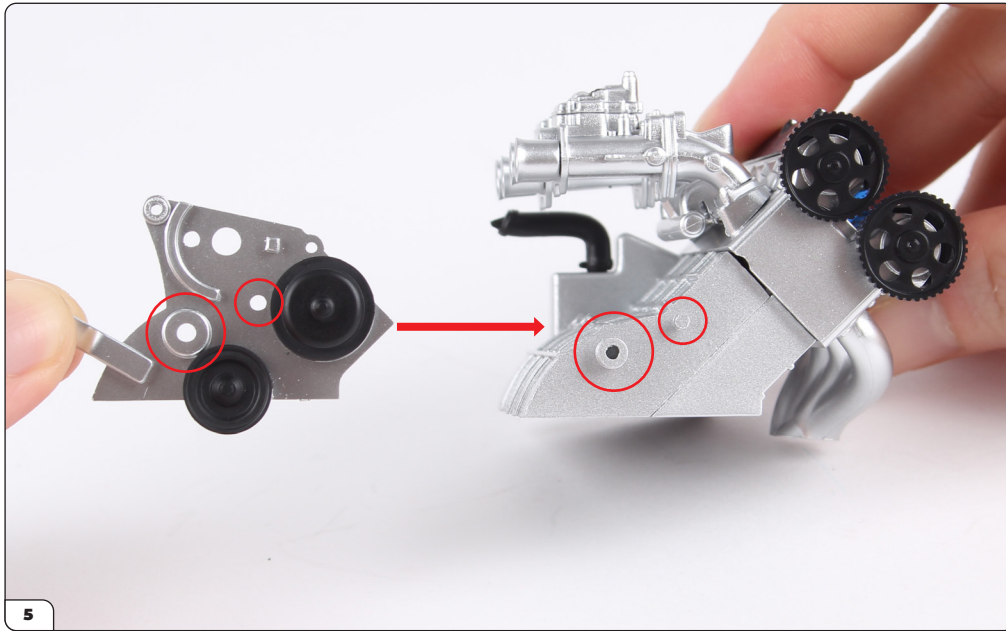


Fit the small pulley (19-D) onto the other mount using the pin and screw post.

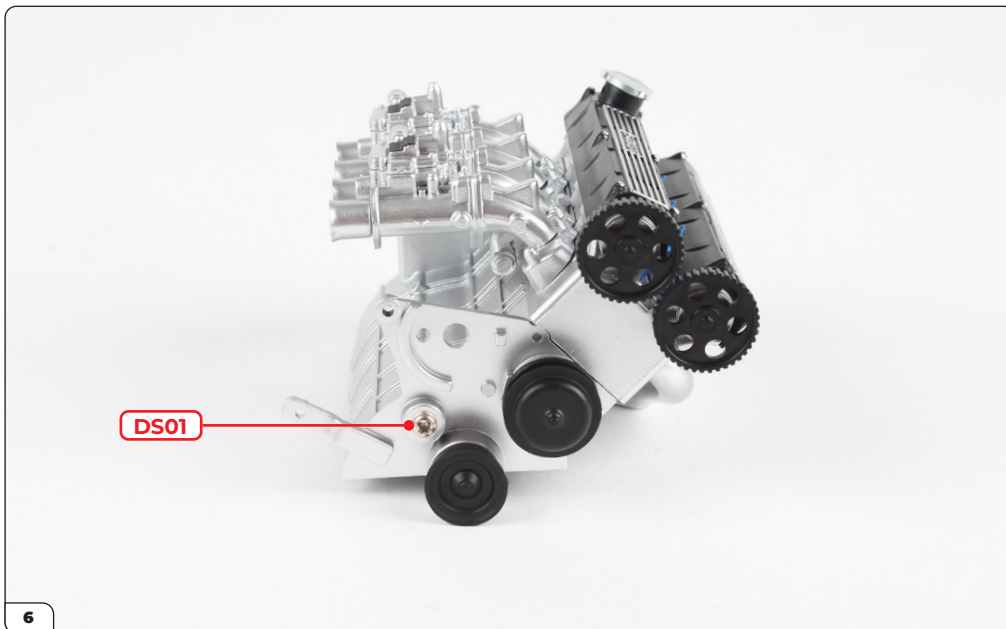


Secure the pulleys from underneath with 2x PS02 screws.

Stage 019: Attaching the Pulleys



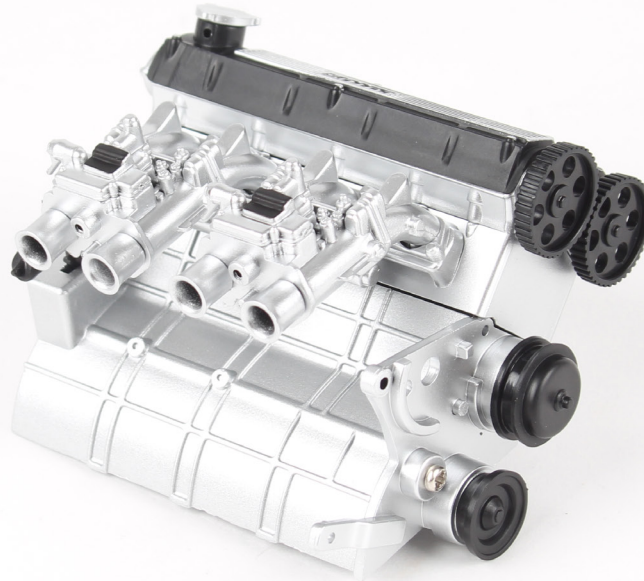
Align the support bracket with the engine block assembly (stage 018). The red circles show the fittings for the two parts.



Secure in place with a DS01 screw.

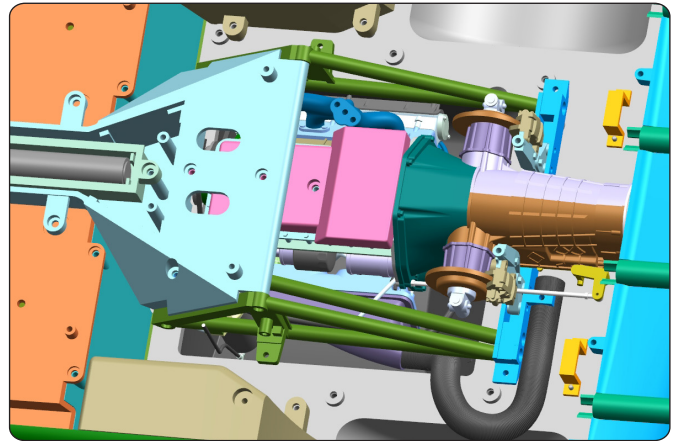
Stage 019: Attaching the Pulleys

STAGE COMPLETE



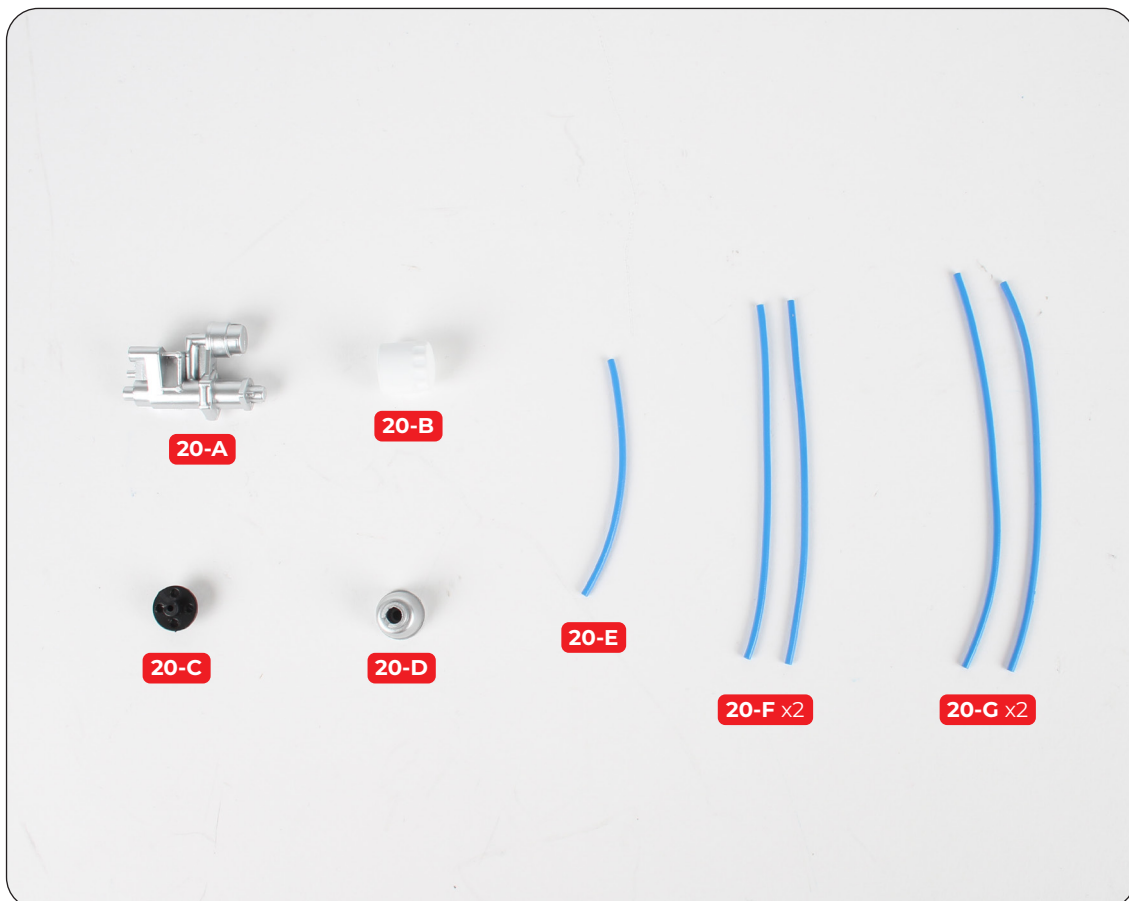
Stage 020: Fitting the Oil Pump, Distributor and Spark Plug Cables

For this stage you'll connect the spark plug cables and distributor then assemble and fit the oil pump to the engine block.

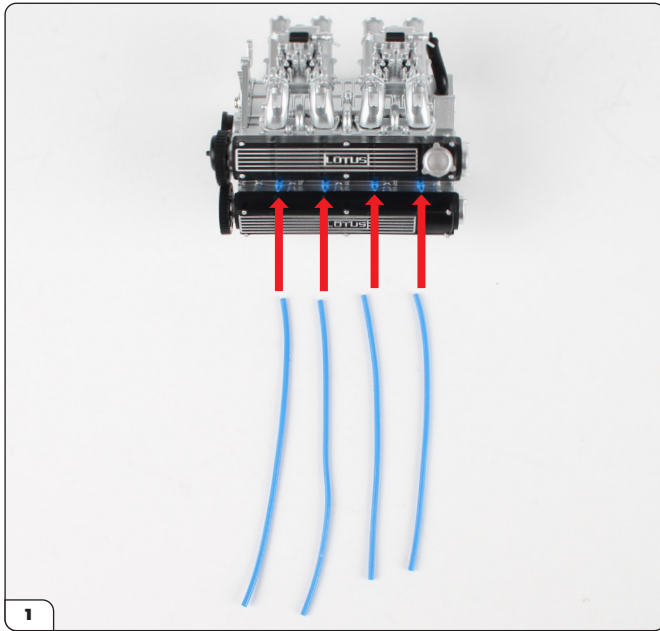


STAGE 020 PARTS LIST

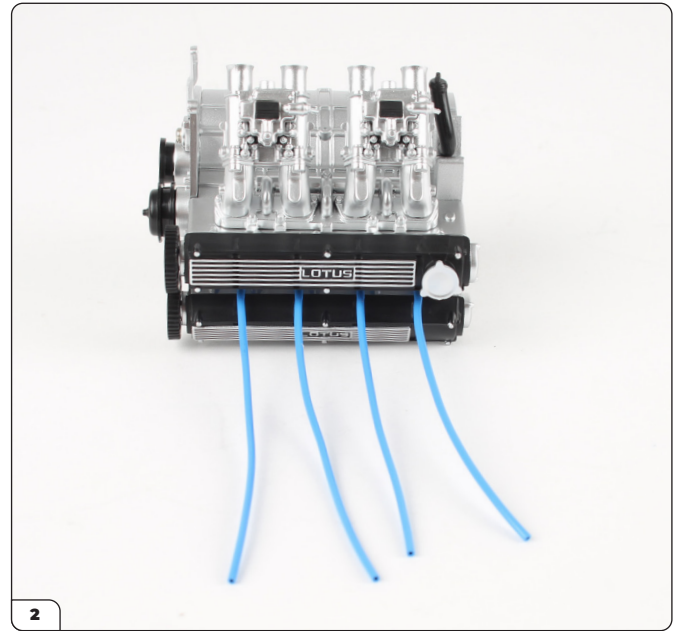
Name
20-A Oil pump
20-B Oil filter
20-C Distributor cap
20-D Distributor
20-E Spark plug cable (short)
20-F Spark plug cable (medium) x2
20-G Spark plug cable (long) x2



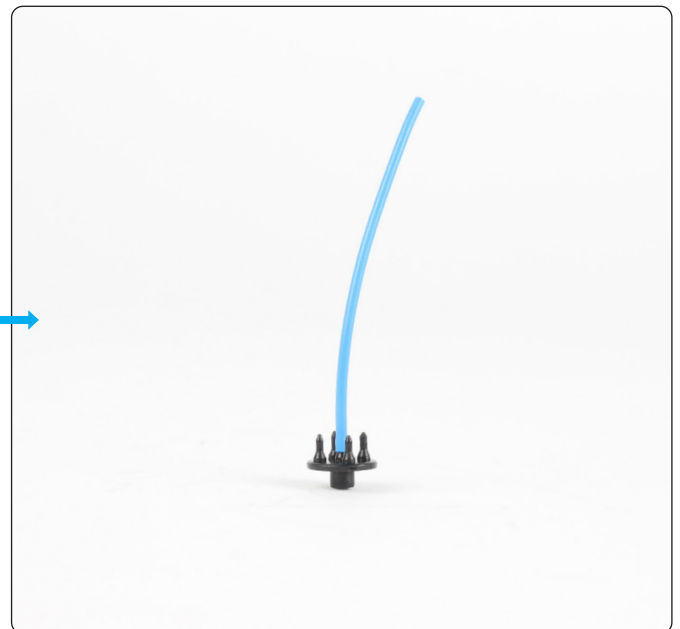
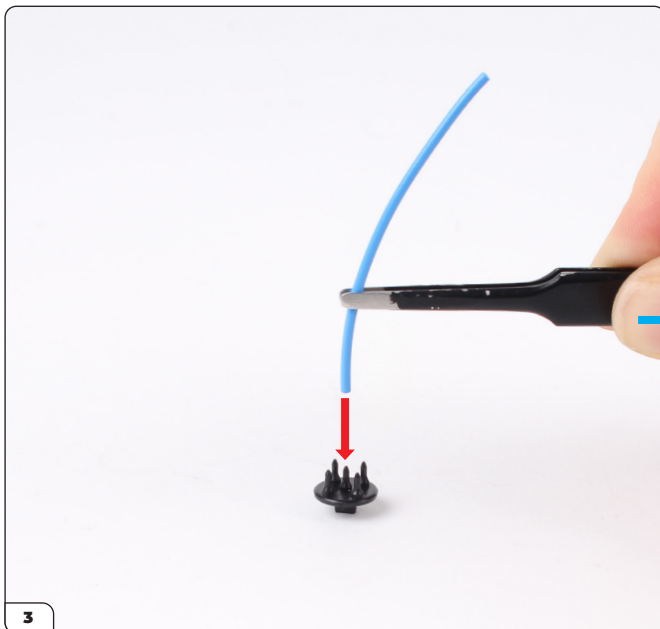
Stage 020: Fitting the Oil Pump, Distributor and Spark Plug Cables



Take the engine block assembly (stage 019) and align the two long (20-G) and two medium (20-F) spark plug cables with it as shown.

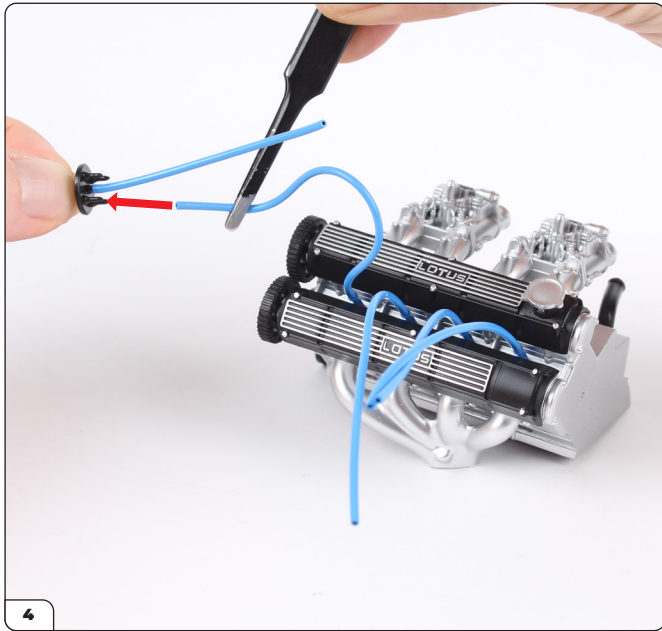


Fit the cables onto the blue spark plugs.

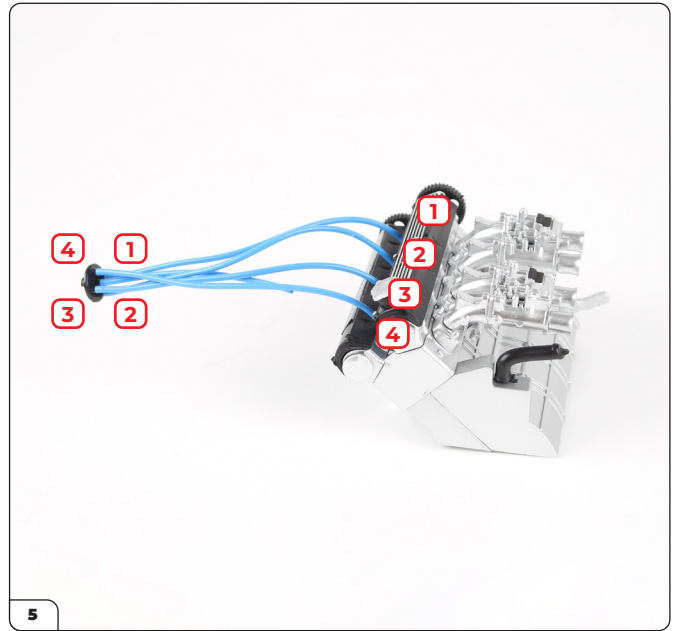


Take the short spark plug cable (20-E) and fit it onto the middle pin on the distributor cap (20-C).

Stage 020: Fitting the Oil Pump, Distributor and Spark Plug Cables



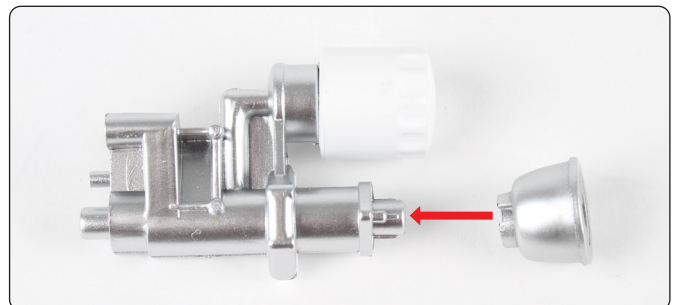
Fit the first long spark plug cable onto one of the outer pins on the distributor cap.



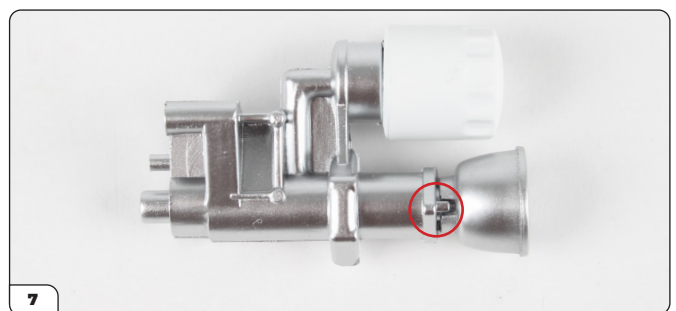
Fit the other spark plug cables in sequence, plugging them onto the pins clockwise.



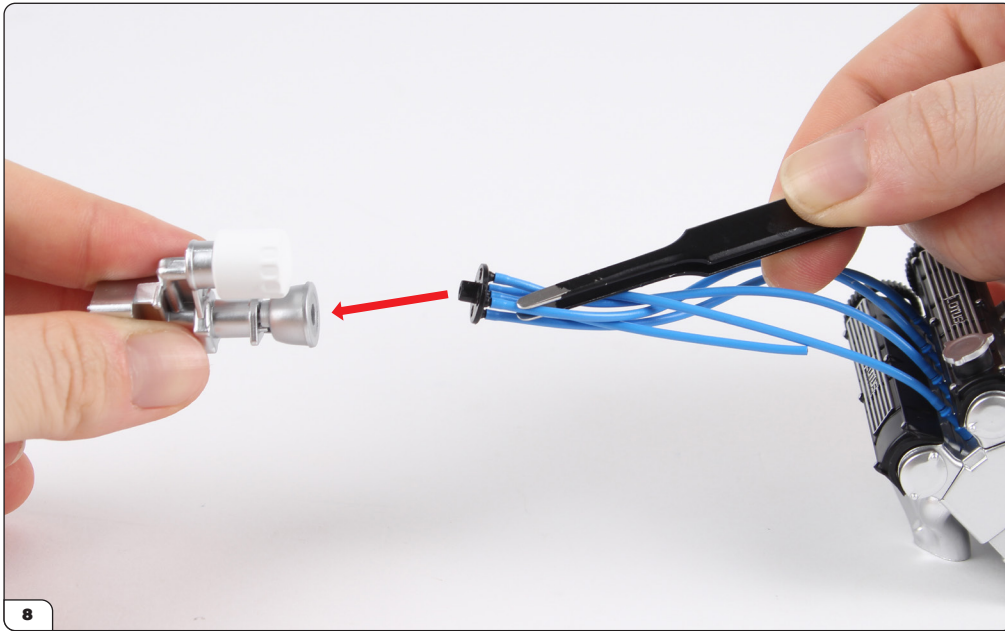
Take oil pump (20-A) and oil filter (20-B) then fit them together as shown.



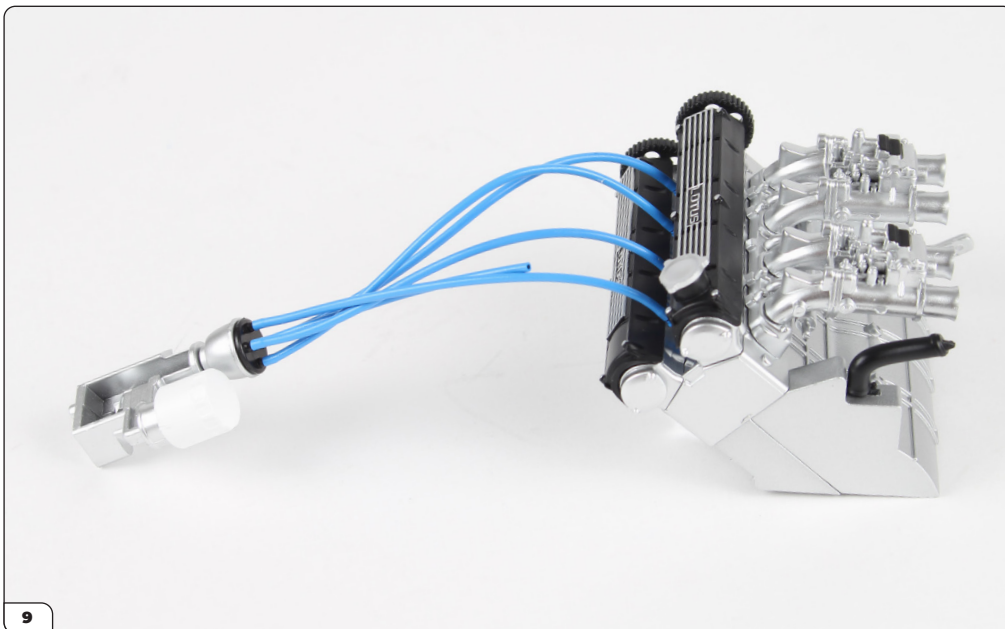
Fit the distributor (20-D) onto the oil pump, using the shaped fitting (circled) as a guide.



Stage 020: Fitting the Oil Pump, Distributor and Spark Plug Cables

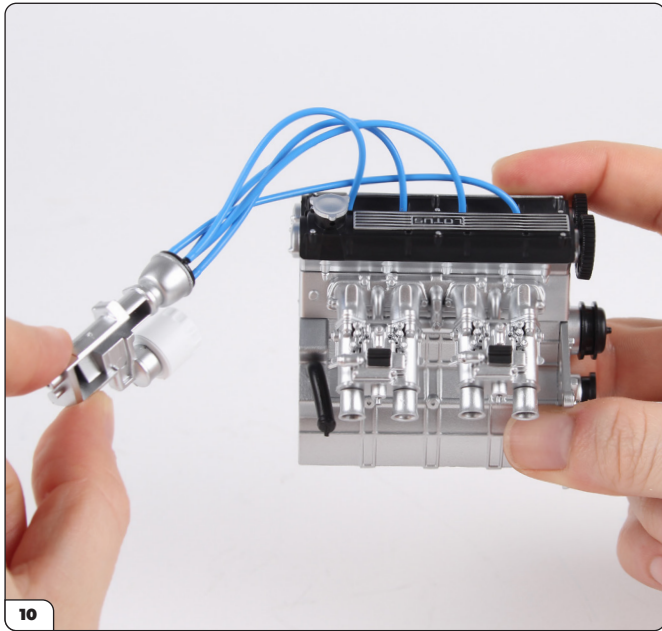


Press the distributor cap into the distributor. The fitting is shaped to make a secure connection.

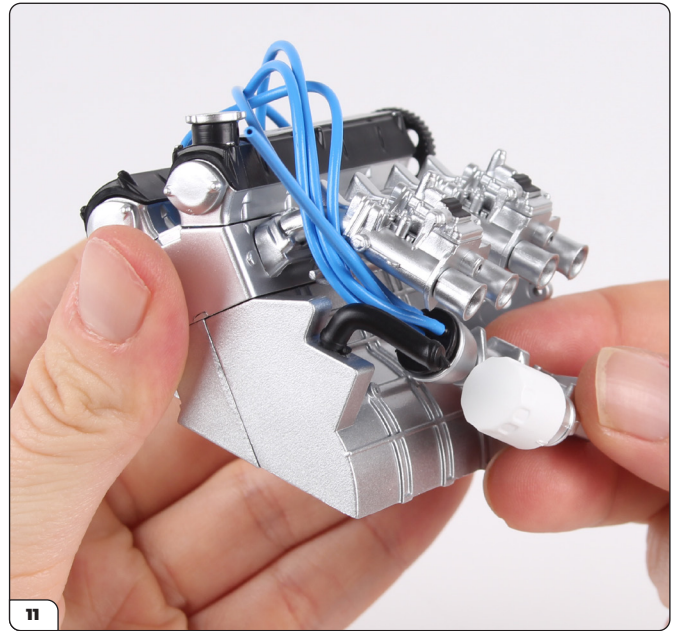


The parts should look like this once fitted together.

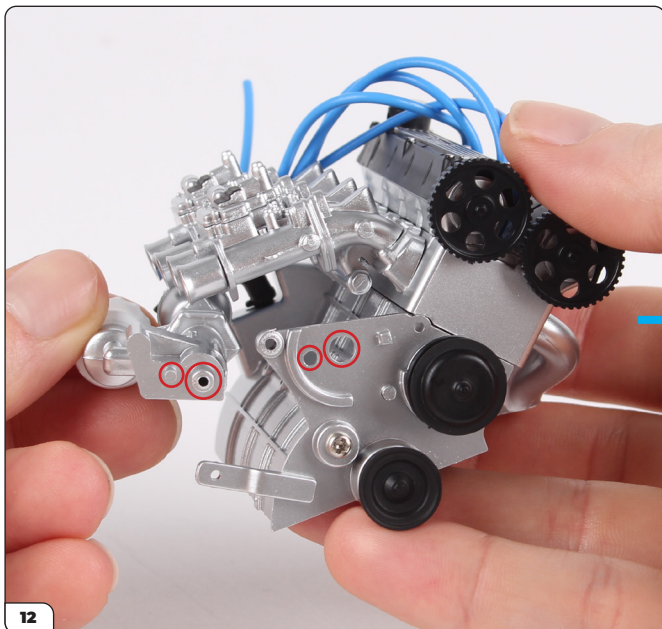
Stage 020: Fitting the Oil Pump, Distributor and Spark Plug Cables



To fit the oil pump in place, start by holding the engine block assembly as shown.



Fit the spark plug wires through the gap between the oil pipe and carburetors.

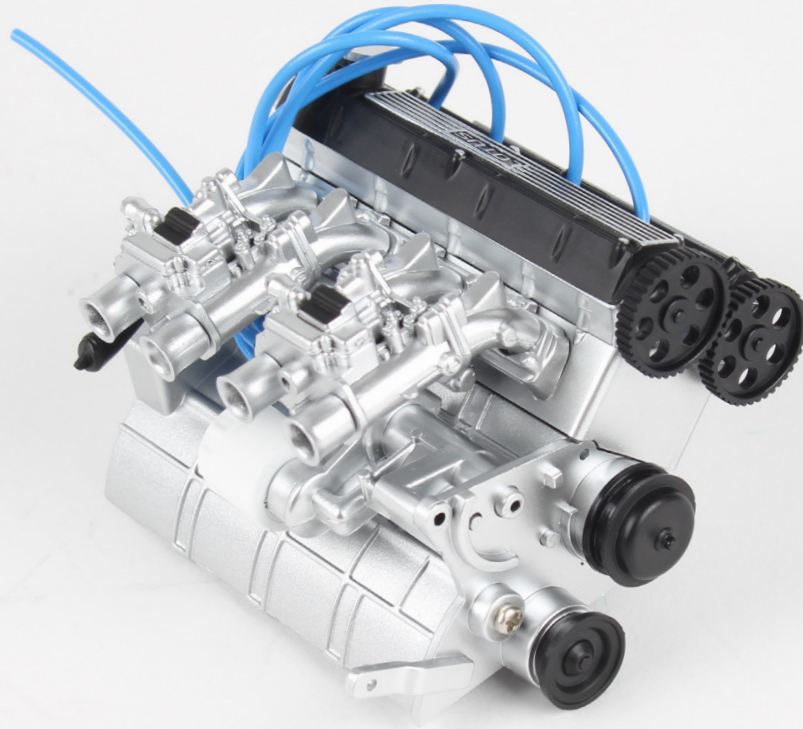


Fit the pin and screw post on the oil pump into the corresponding holes in the support bracket. This will be secured in the next stage.



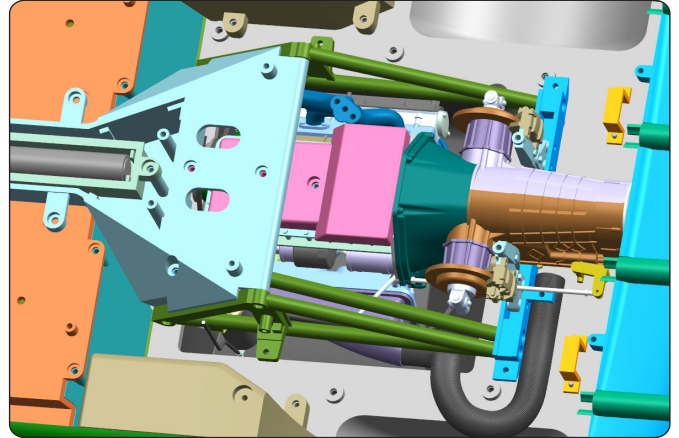
Stage 020: Fitting the Oil Pump, Distributor and Spark Plug Cables

STAGE COMPLETE



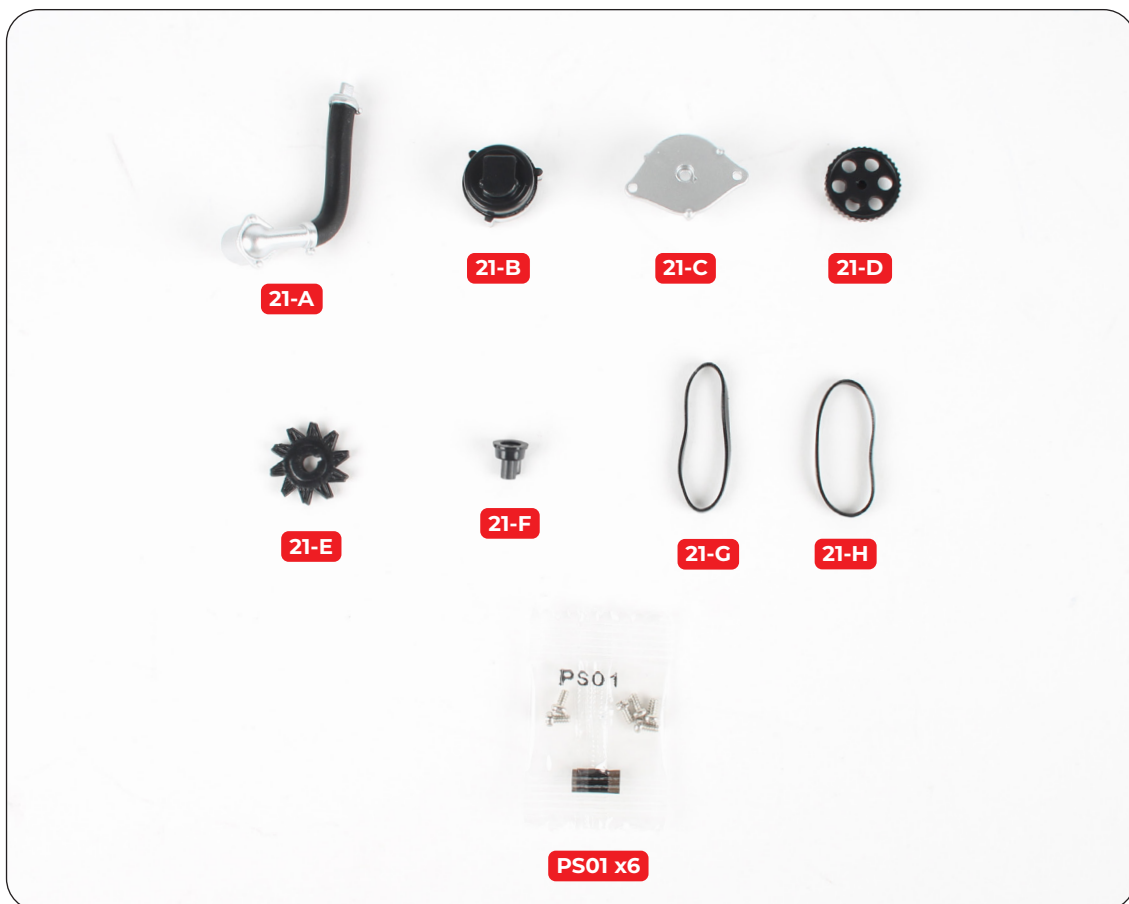
Stage 021: Fitting the Alternator and Belts

After assembling the alternator, you'll fit it to the engine block and wrap the belts around the pulleys.

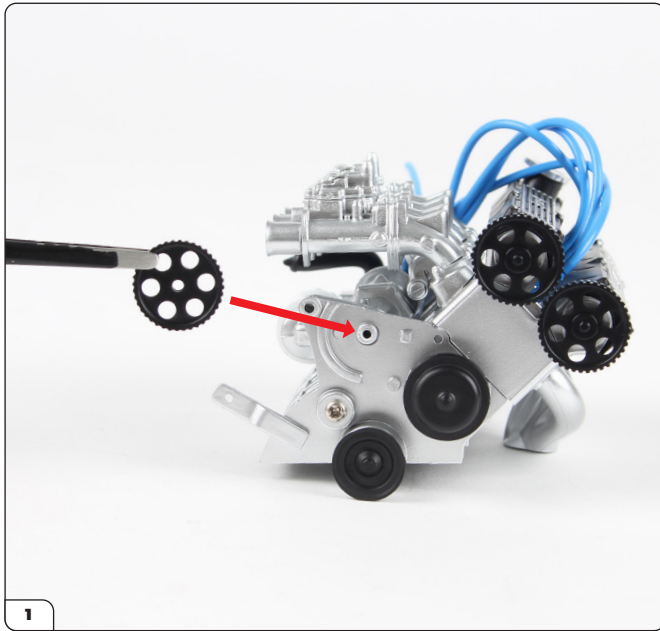


STAGE 021 PARTS LIST

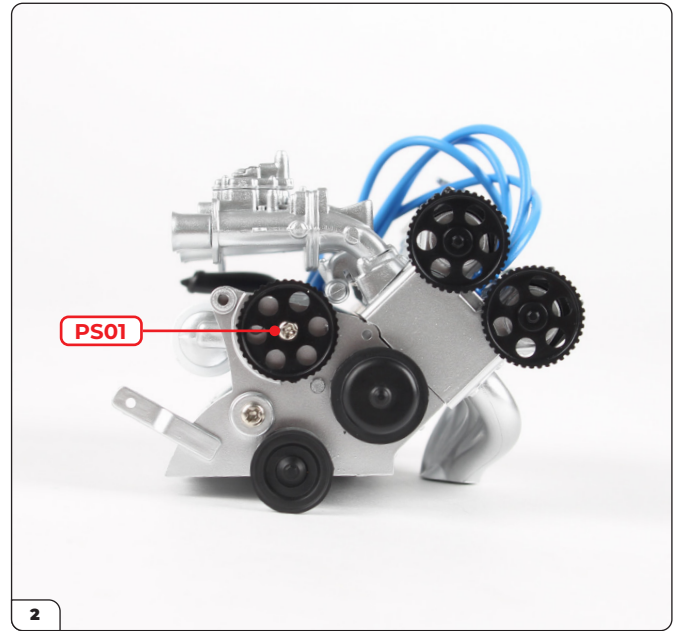
Name	Name
21-A Oil pipe	21-F Alternator pulley
21-B Alternator (A)	21-G Belt (thin)
21-C Alternator (B)	21-H Belt (thick)
21-D Toothed pulley	PS01 screws x6
21-E Alternator rotor	



Stage 021: Fitting the Alternator and Belts



Fit the toothed pulley (21-D) onto the screw post of the oil pump.



Secure with a PS01 screw.



Fit the alternator pulley (21-F) into the shaped hole in the alternator rotor (21-E). Ensure the rotor teeth are oriented as shown.

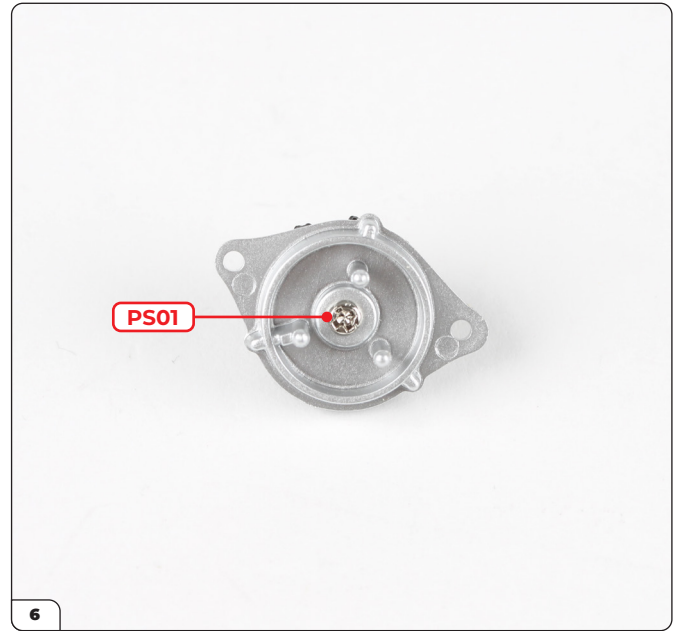


Take part B (21-C) of the alternator. Fit the rotor and pulley into the shaped hole.

Stage 021: Fitting the Alternator and Belts



The alternator assembly should look like this.



Secure the parts from underneath with a PS01 screw.

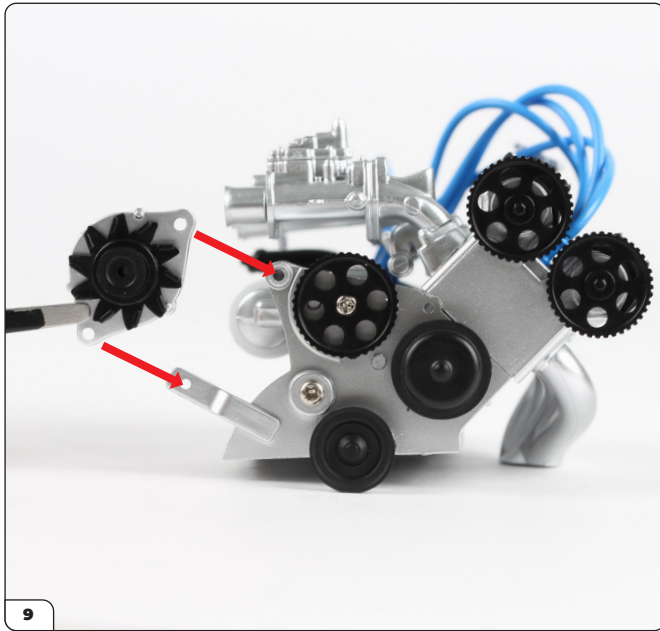


Take part A (21-B) of the alternator. Locate the shaped hole and pin on the parts.

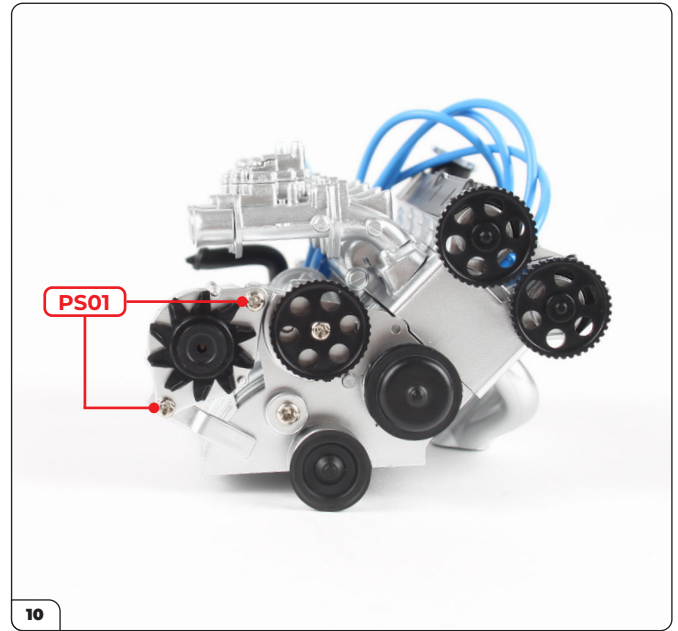


Align the shaped hole and pin on the parts then press them together (inset).

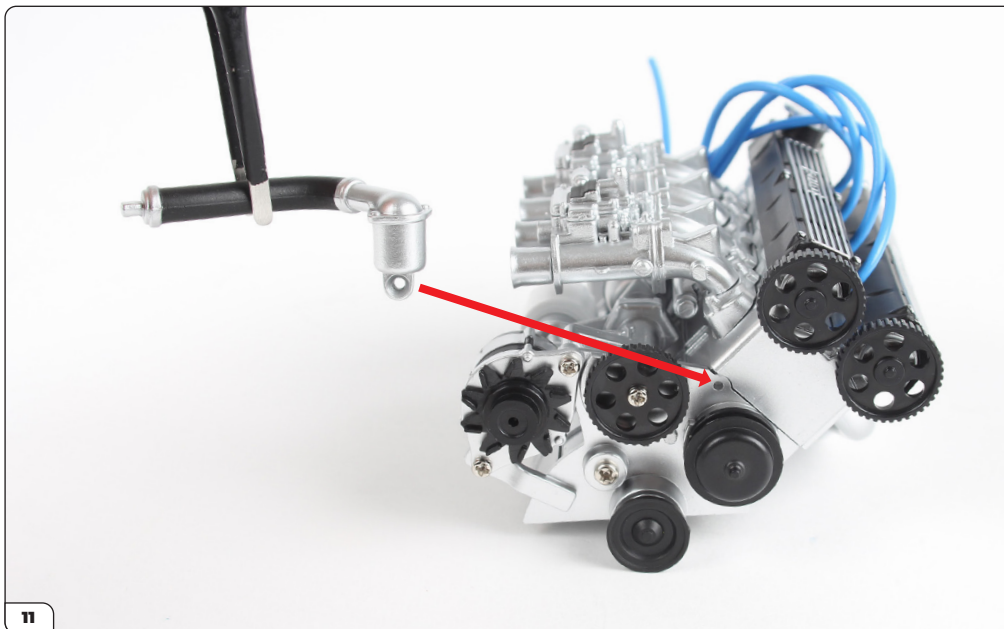
Stage 021: Fitting the Alternator and Belts



Align the alternator with the engine block assembly as shown.

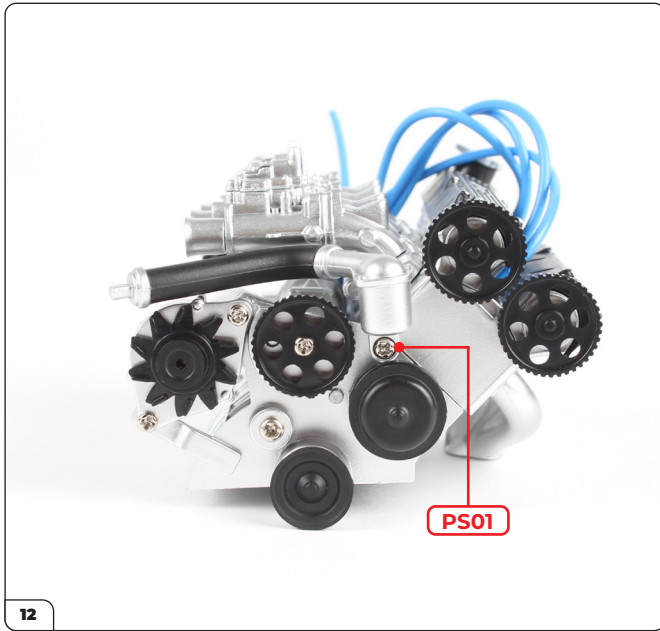


Fit the alternator then secure with 2x PS01 screws.

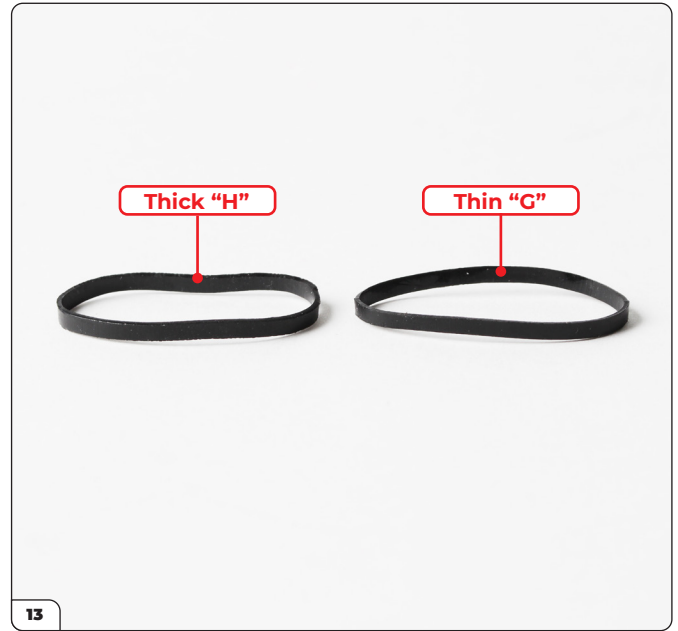


Align the oil pipe (21-A) with the engine block.

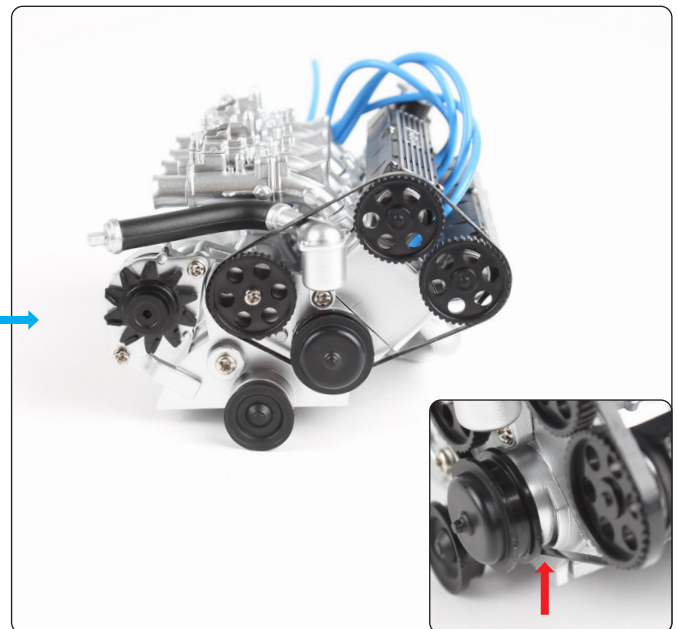
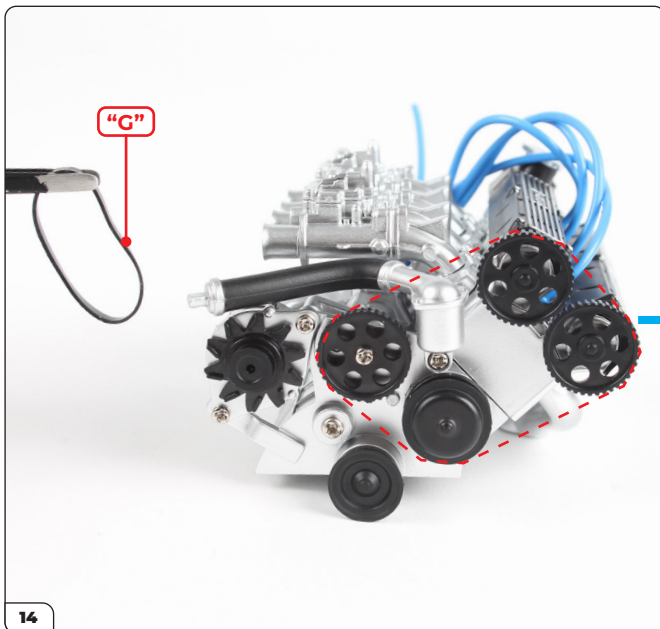
Stage 021: Fitting the Alternator and Belts



Fit the oil pipe and secure with a PS01 screw.

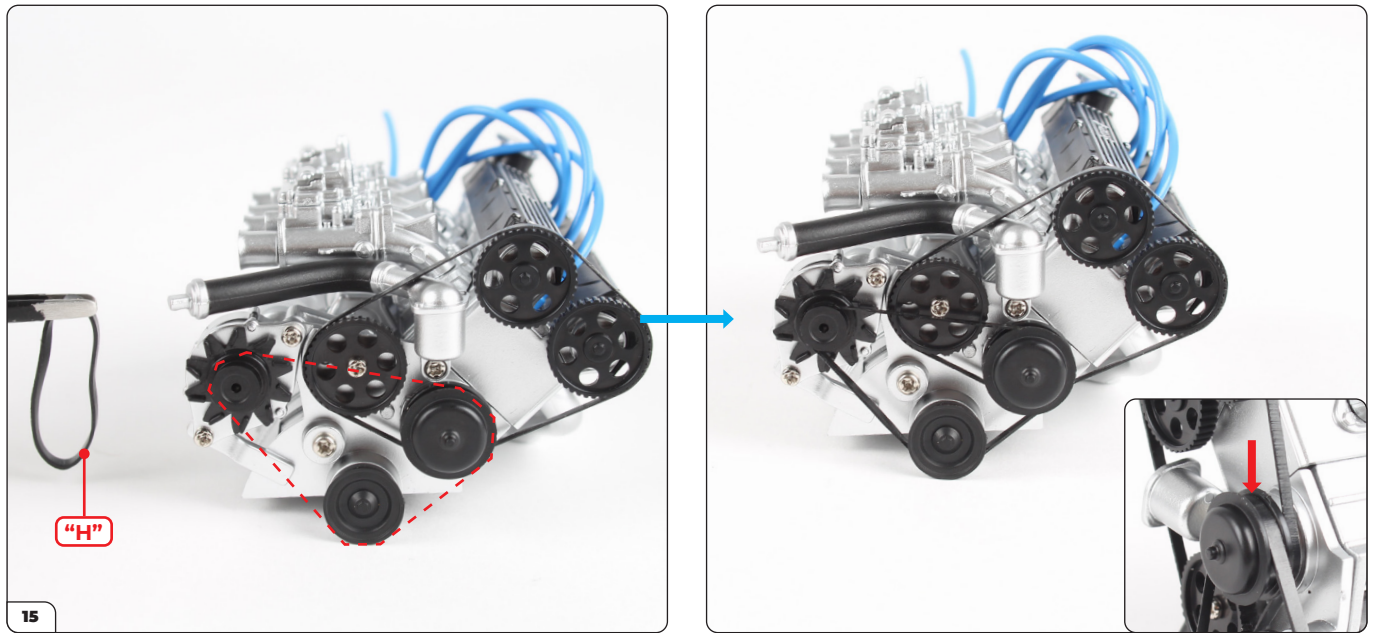


Take the two belts and compare them. One of the belts is slightly thicker than the other.

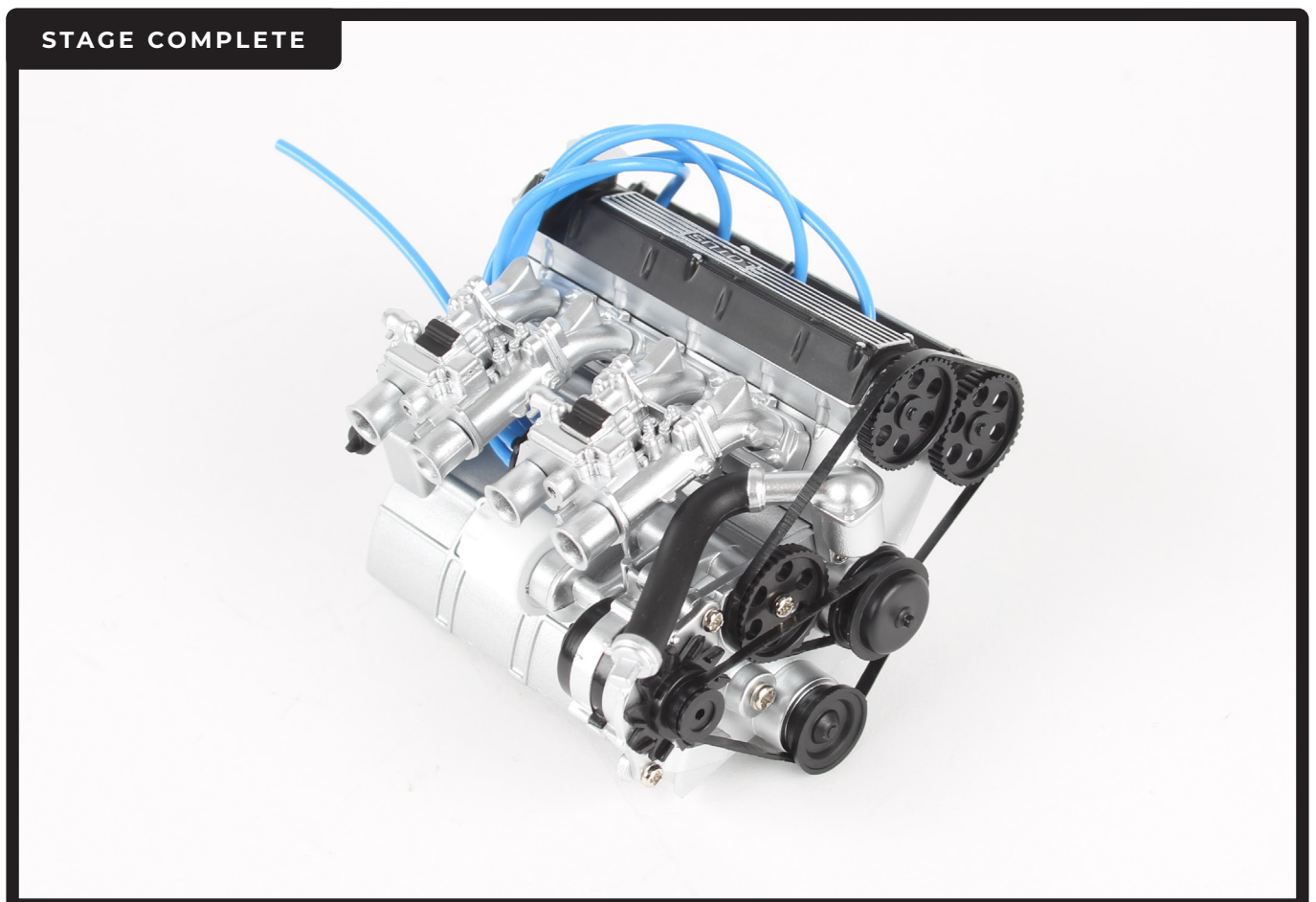


Take the thinner belt (21-G). Wrap it around the toothed pulleys and the larger pulley as indicated by the dashed line. The thin belt should feed around the silver part of the larger pulley (inset).

Stage 021: Fitting the Alternator and Belts

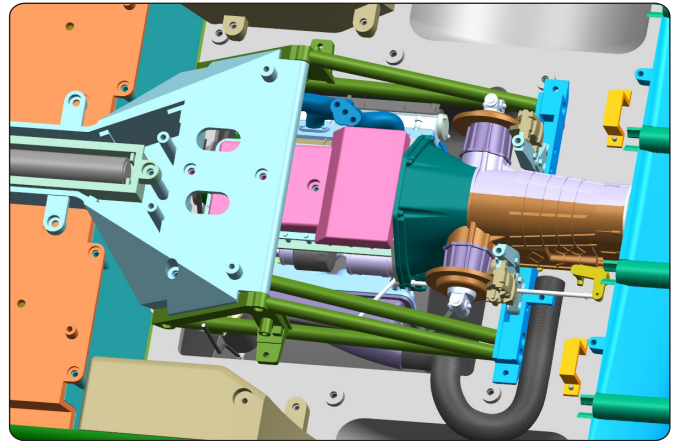


Wrap the thicker belt (21-H) around the pulleys as shown by the dashed line. The thick belt should feed around the black part of the larger pulley (inset).



Stage 022: Attaching the Air Box

In this stage you'll fit the air box in place on the engine block and connect the breather pipe to it.



STAGE 022 PARTS LIST

Name
22-A Air box cover
22-B Air box
PS05 screws x2
PS14 screws x3



22-A



22-B

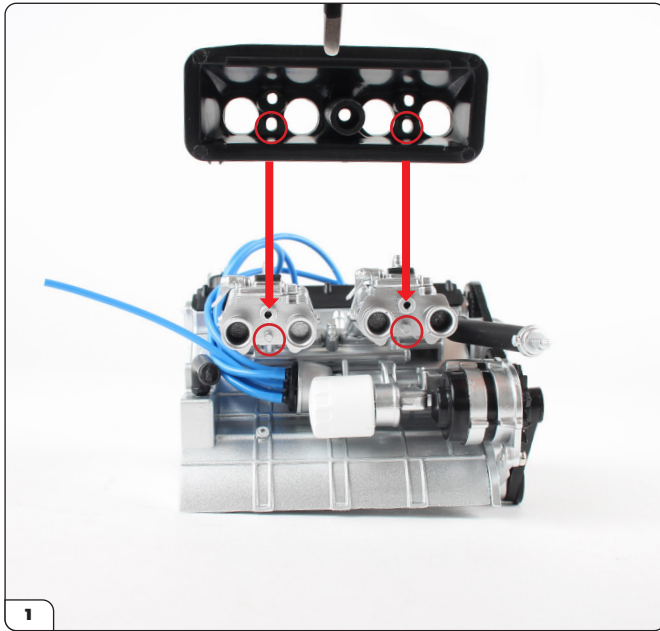


PS05 x2

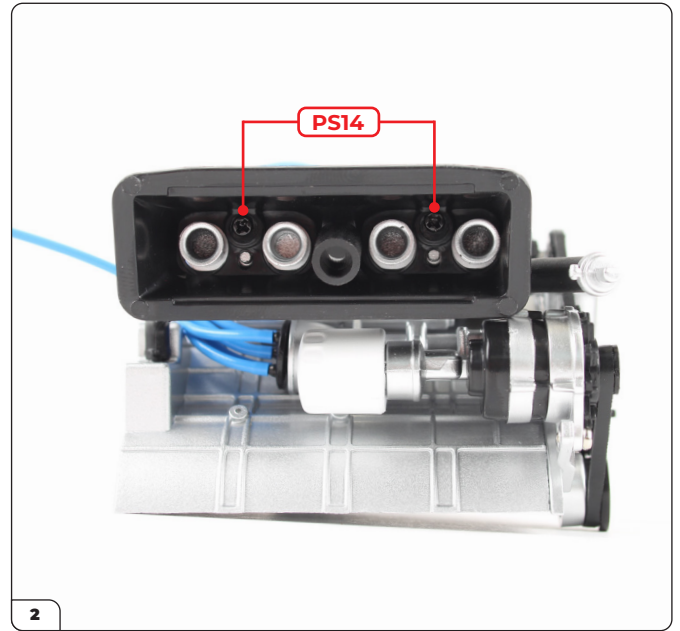


PS14 x3

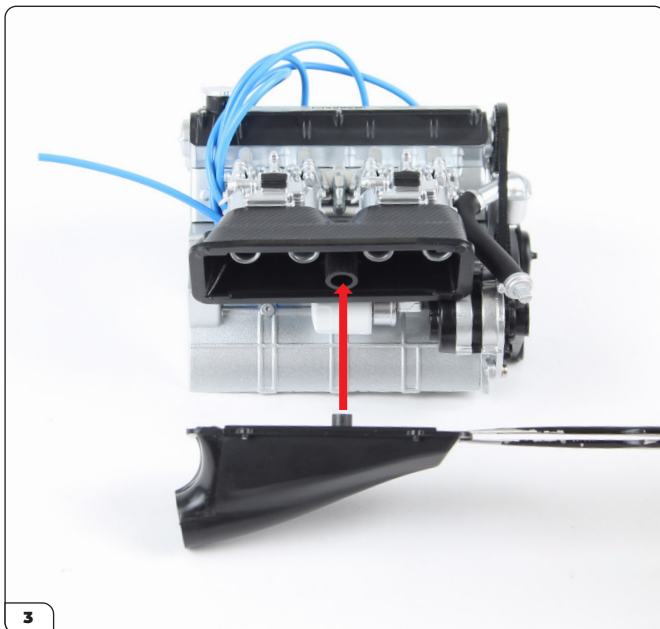
Stage 022: Attaching the Air Box



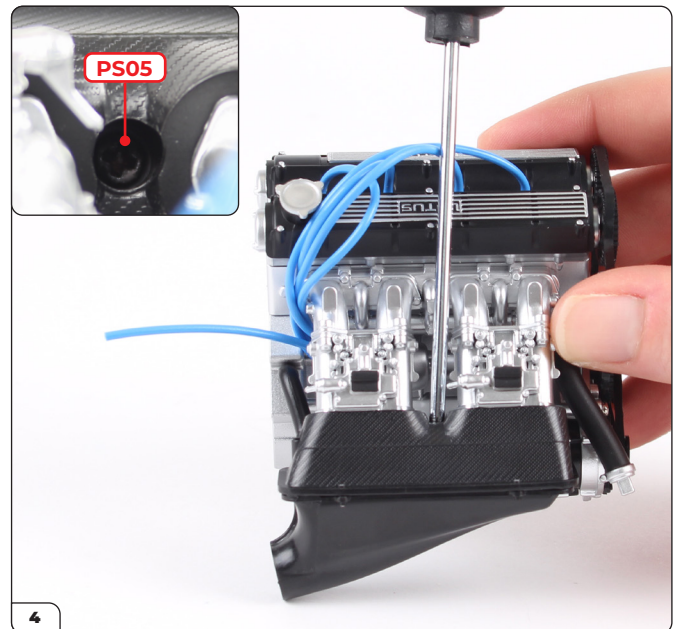
Fit the air box (22-B) onto the carburetors. Use the small holes and pins (circled) to find the correct orientation.



Secure using 2x PS14 screws.

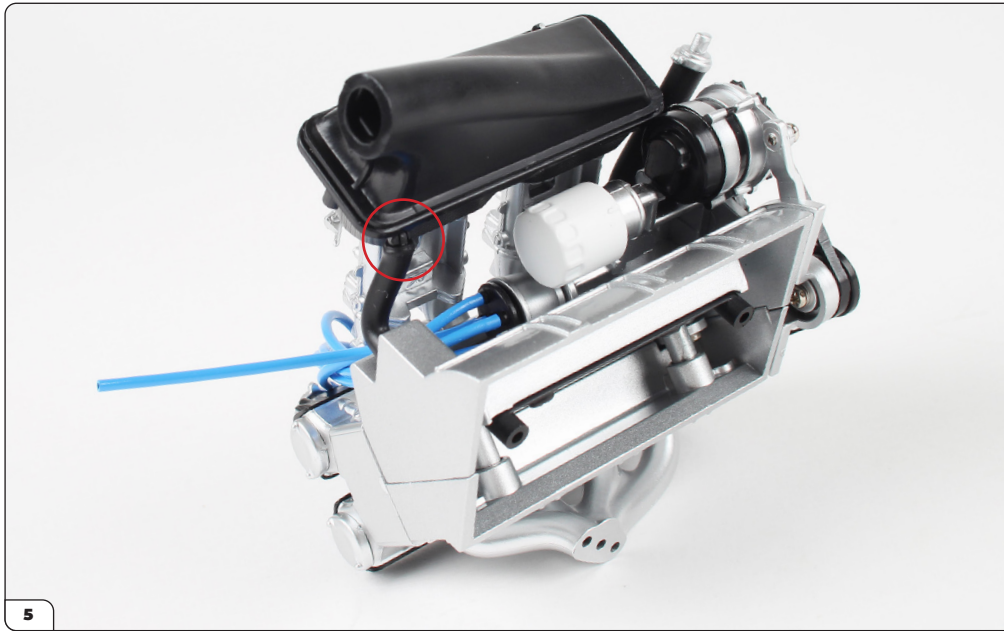


Align the air box cover (22-A) with the air box as shown then fit in place.

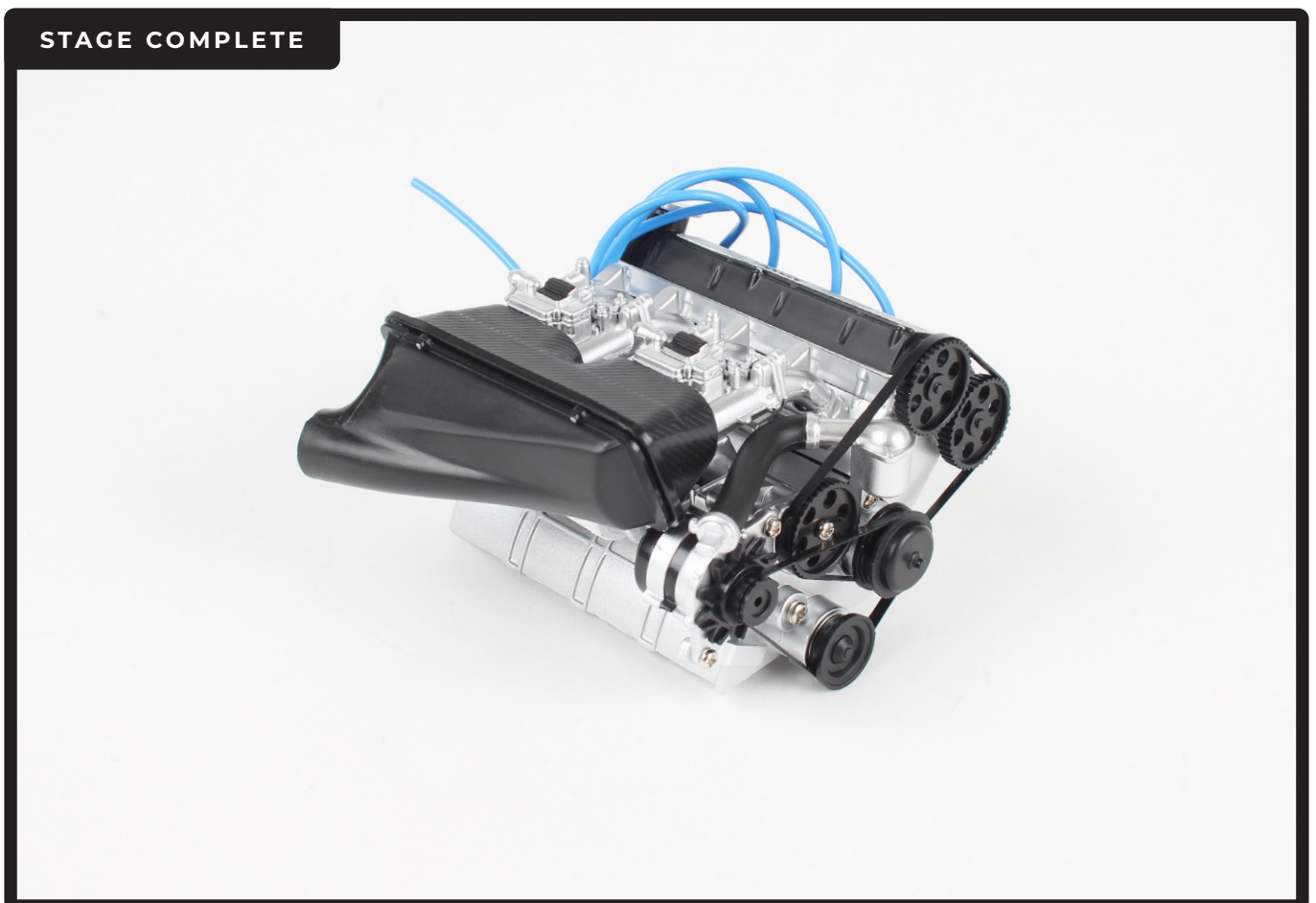


Secure the air box cover using a PS05 screw (inset) and a long screwdriver.

Stage 022: Attaching the Air Box

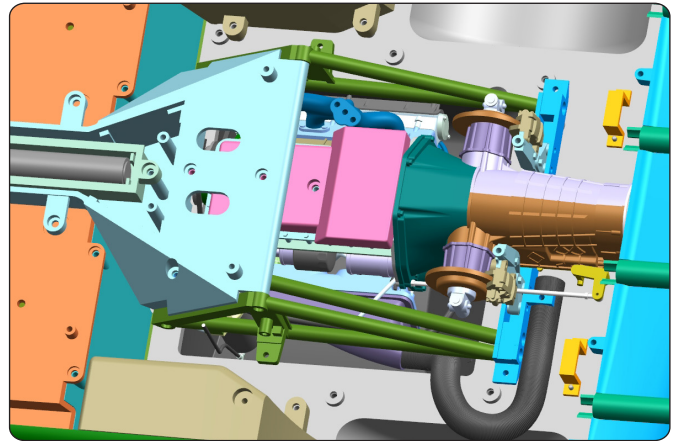


Fit the breather pipe into the recess on the airbox.



Stage 023: Fitting the Backplate and Gearbox

Continue working on the engine block by attaching the backplate then fitting the gearbox assembly.

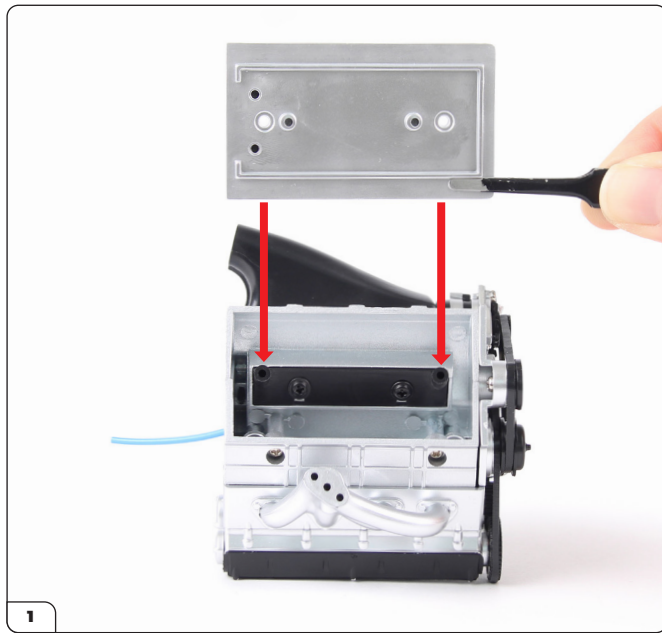


STAGE 023 PARTS LIST

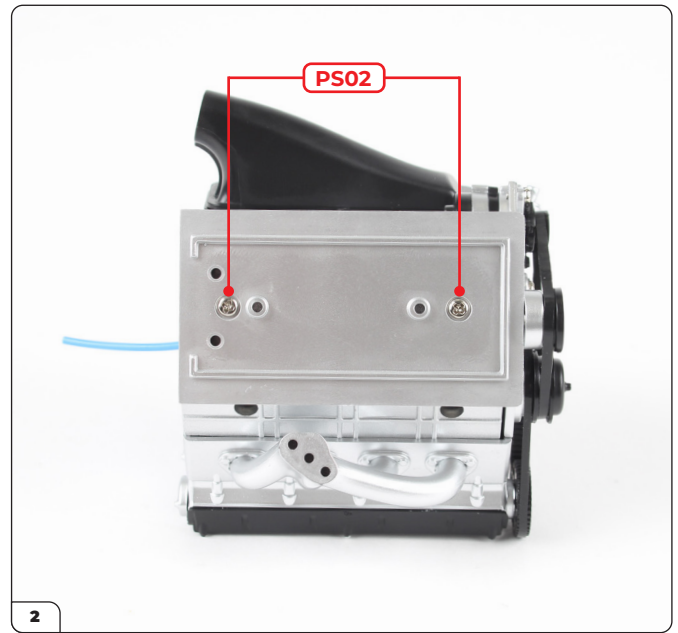
Name
23-A Backplate (A)
23-B Backplate (B)
PS02 screws x7



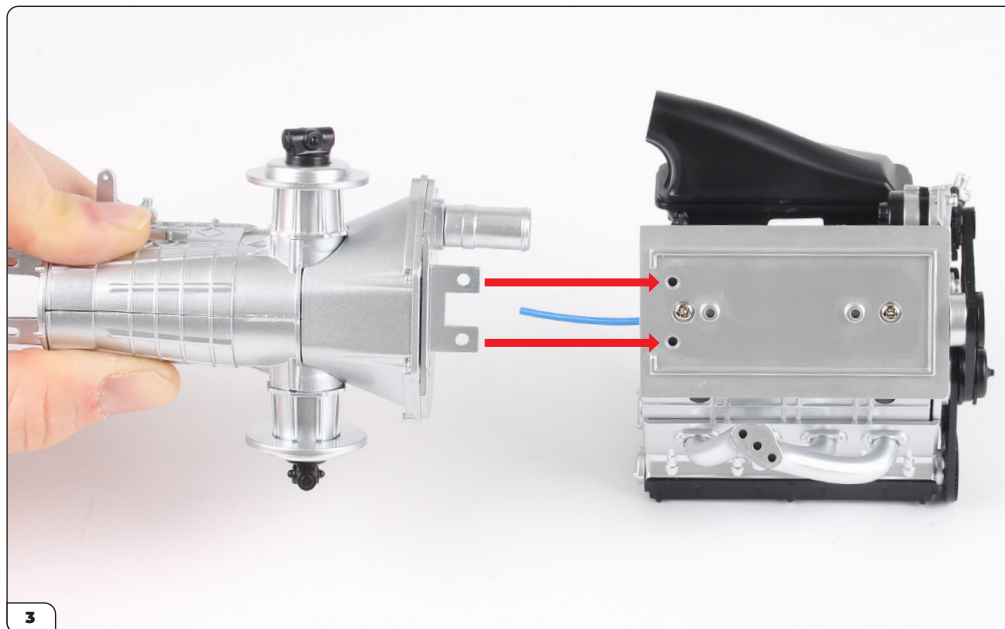
Stage 023: Fitting the Backplate and Gearbox



Align part B of the backplate (23-B) with the engine block bracket.

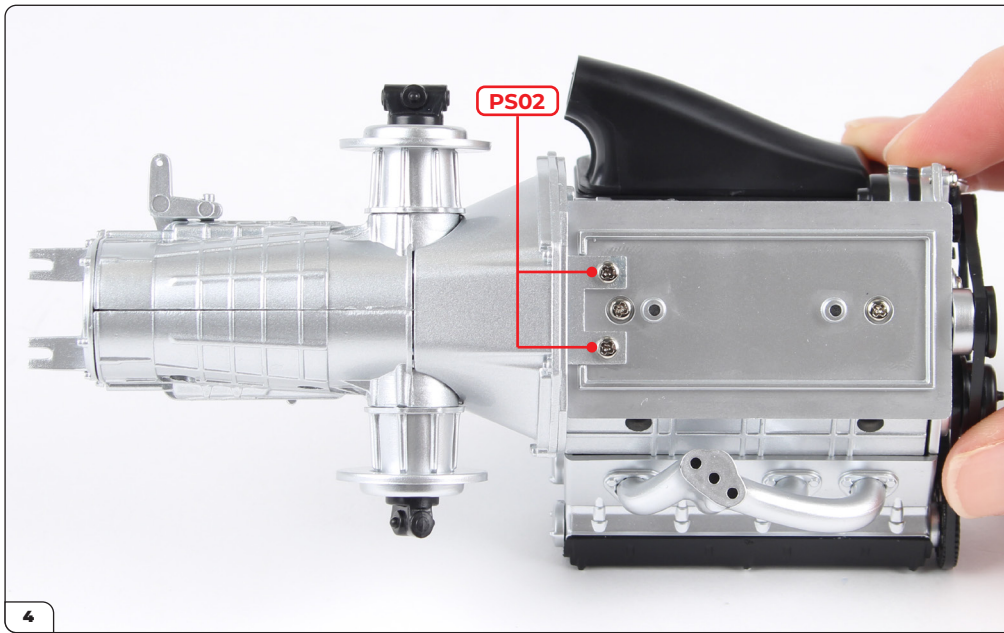


Fit in place then secure with 2x PS02 screws.

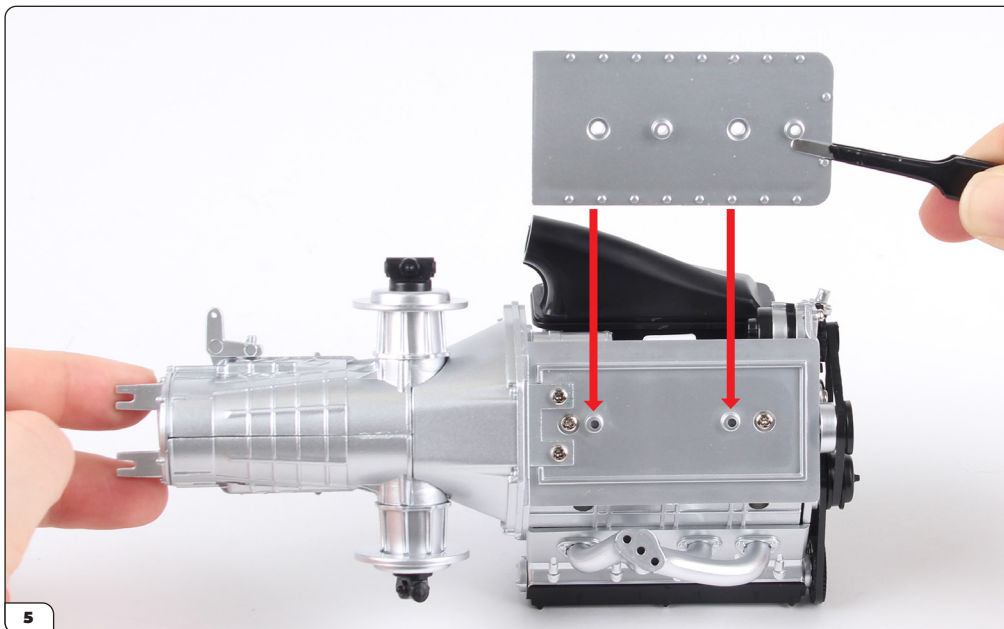


Take the gearbox assembly (stage 016) and fit the rectangular tabs over the screw holes in the orientation shown.

Stage 023: Fitting the Backplate and Gearbox

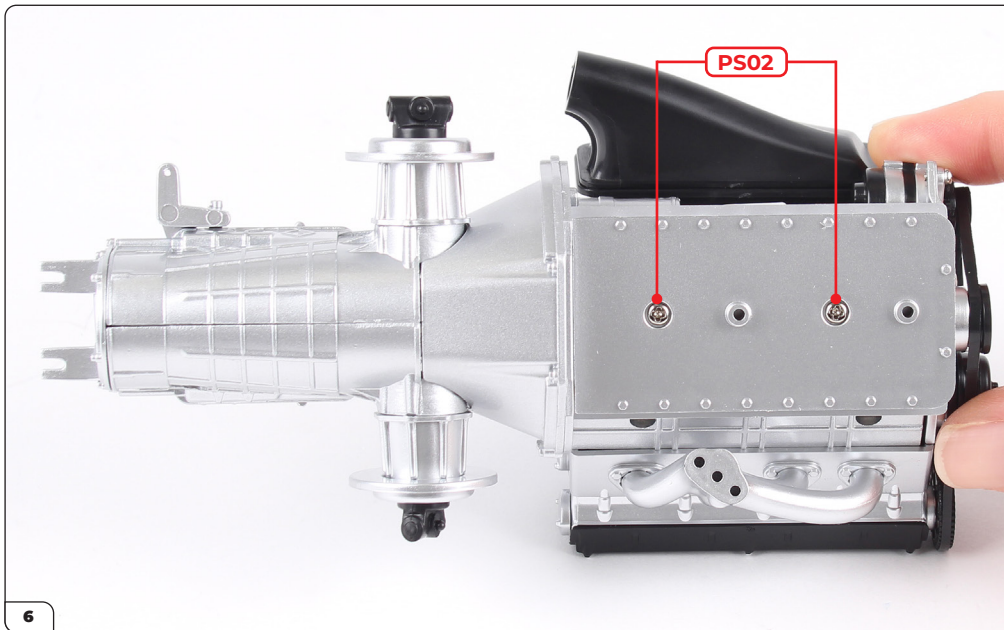


Secure with 2x PS02 screws.

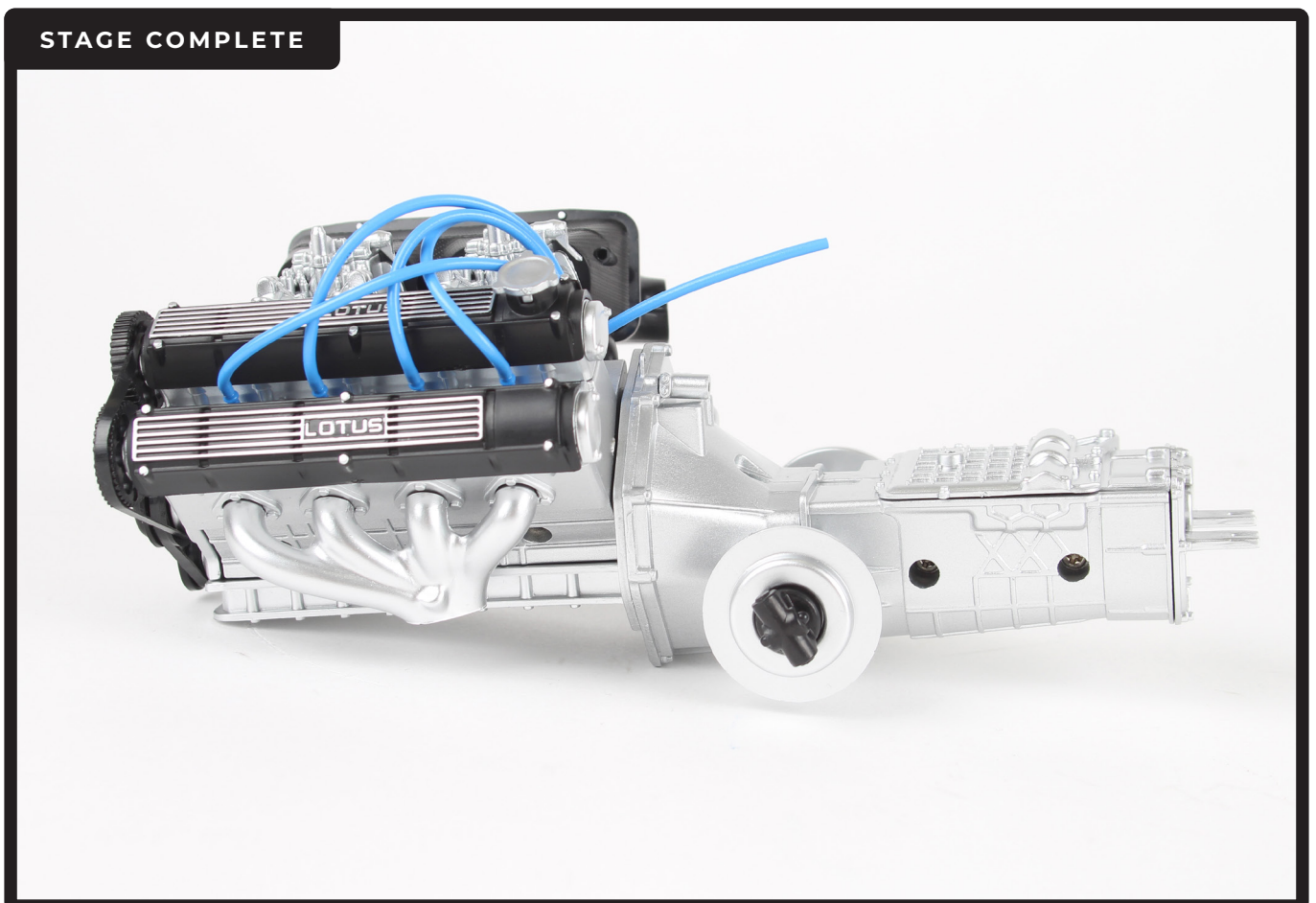


Align part A of the backplate (23-A) with the assembly as shown.

Stage 023: Fitting the Backplate and Gearbox

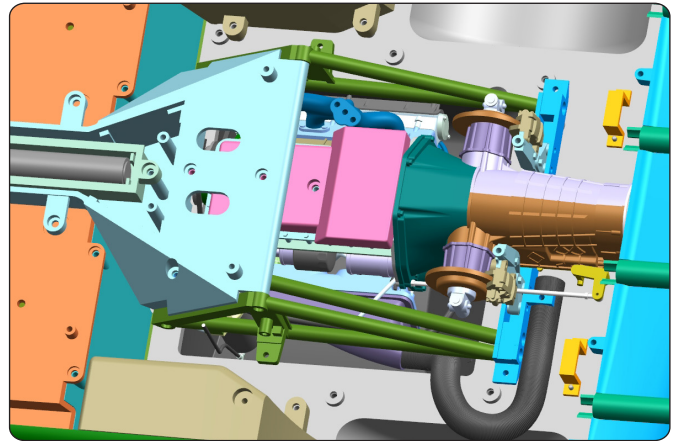


Secure with 2x PS02 screws.



Stage 024: Attaching the Oil Sump

In this stage you'll attach the oil sump to the backplate.

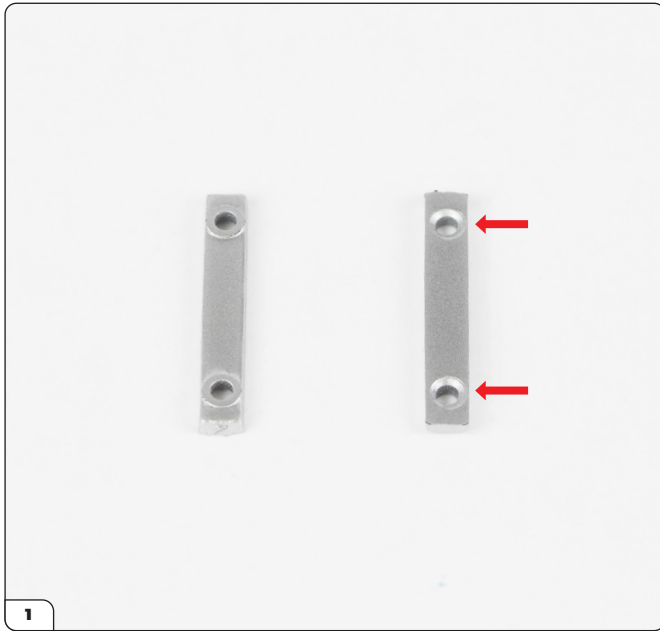


STAGE 024 PARTS LIST

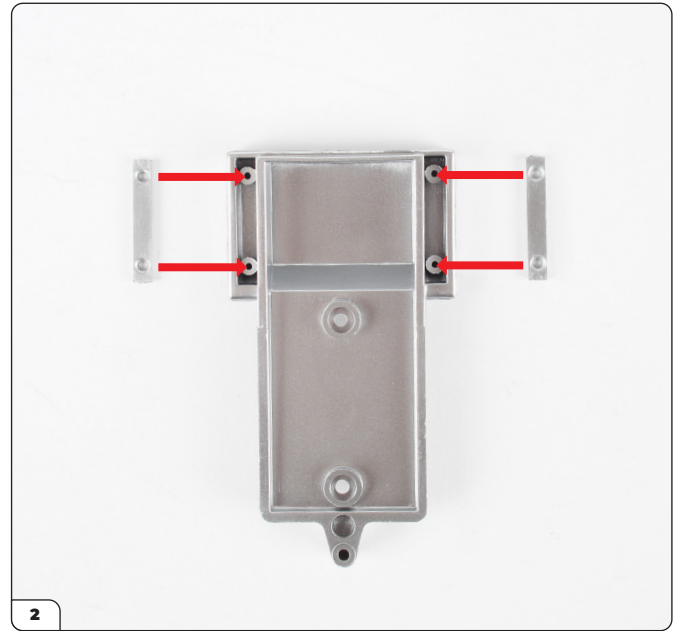
Name
24-A Oil sump
24-B Panel x2
PS02 screws x3
P827 screws x5



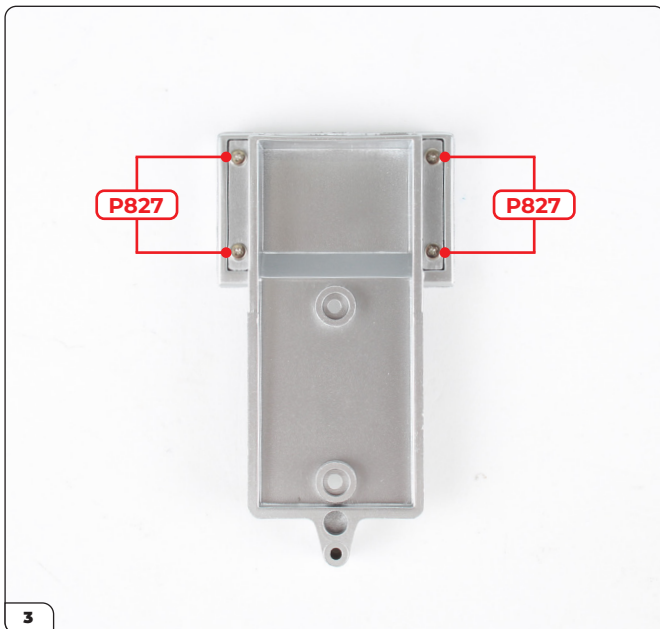
Stage 024: Attaching the Oil Sump



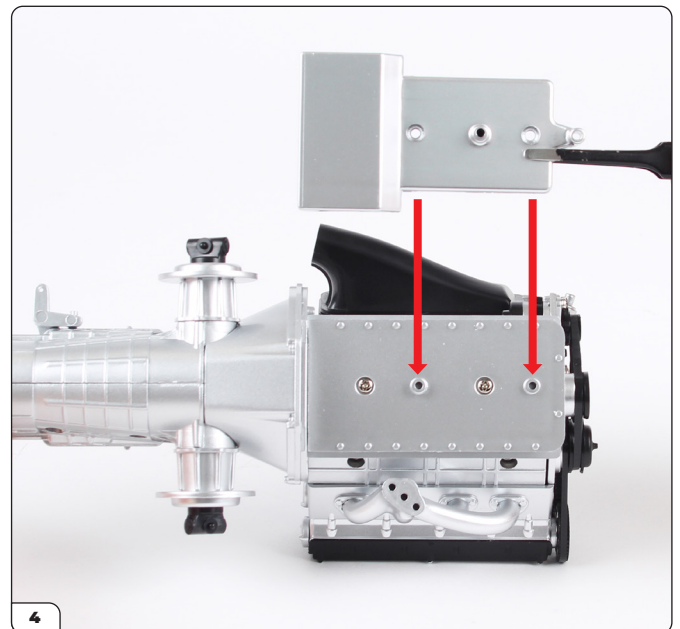
Take the two panels (24-B). Note that one side of the panels has recessed screw holes (arrows).



Align the panels with the oil sump (24-A) so that the recessed screw holes are face up.

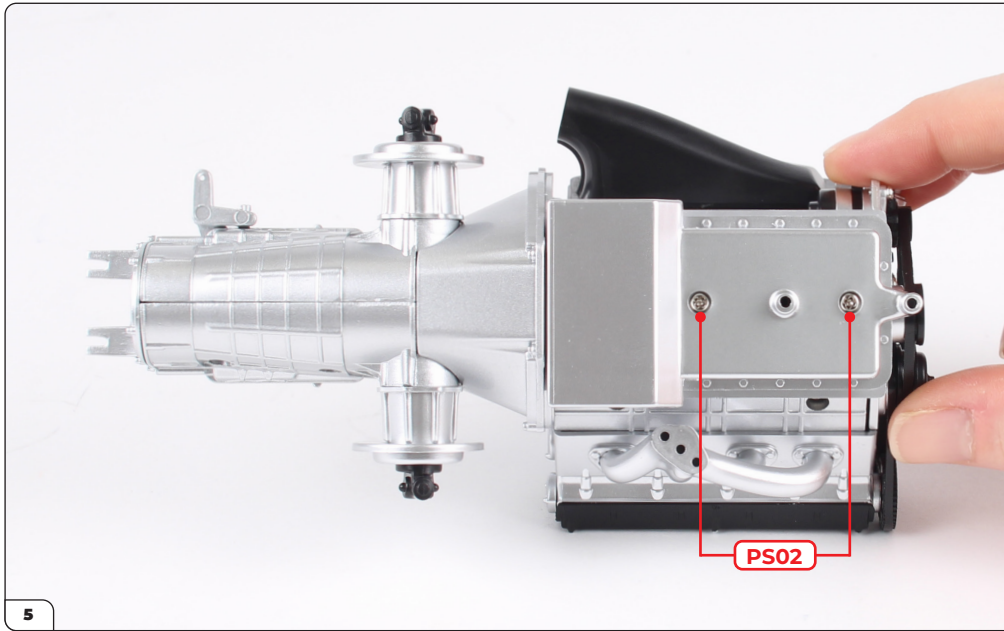


Fit the panels then secure with 4x P827 screws.

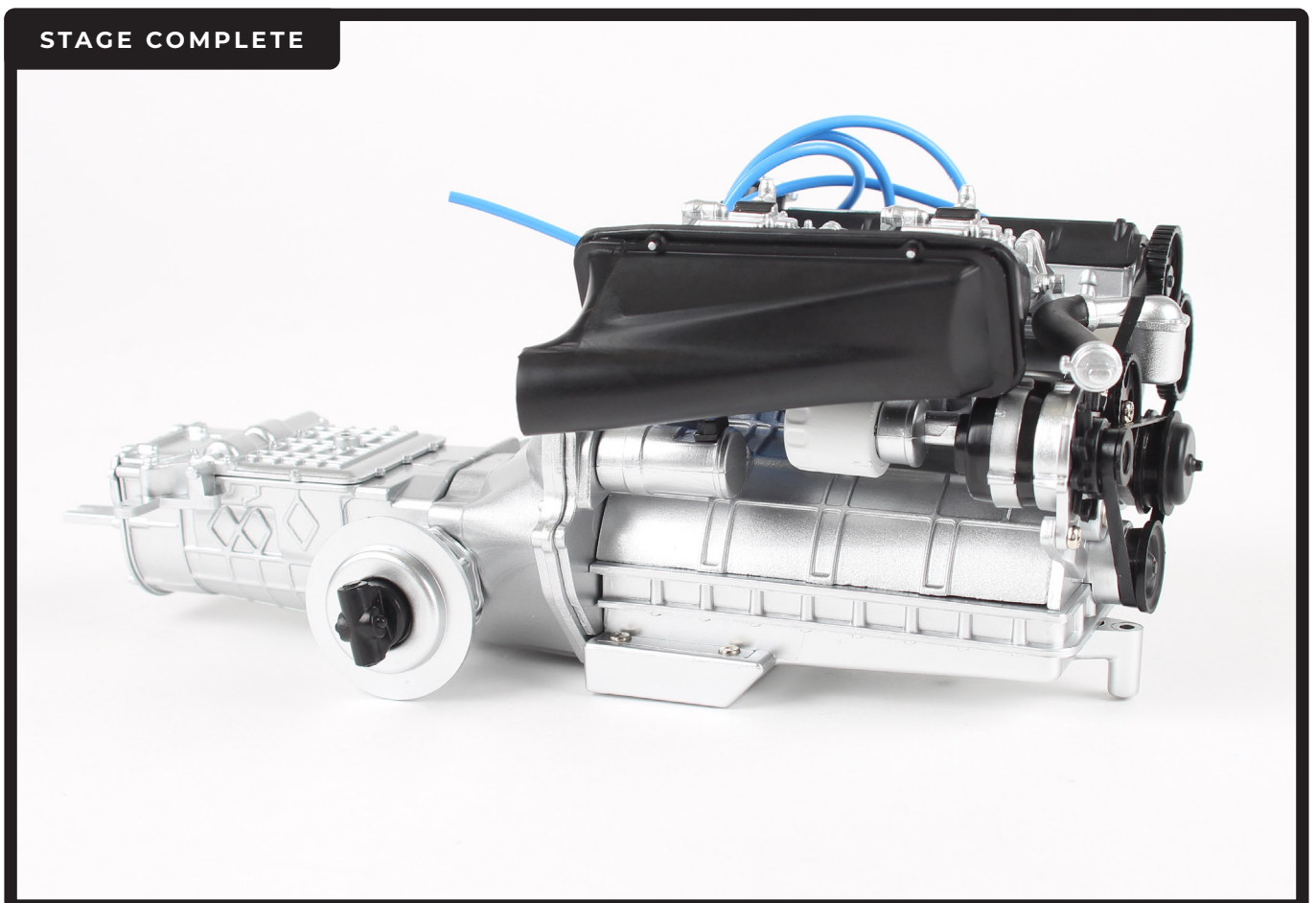


Align the oil sump with the engine block assembly (stage 023).

Stage 024: Attaching the Oil Sump

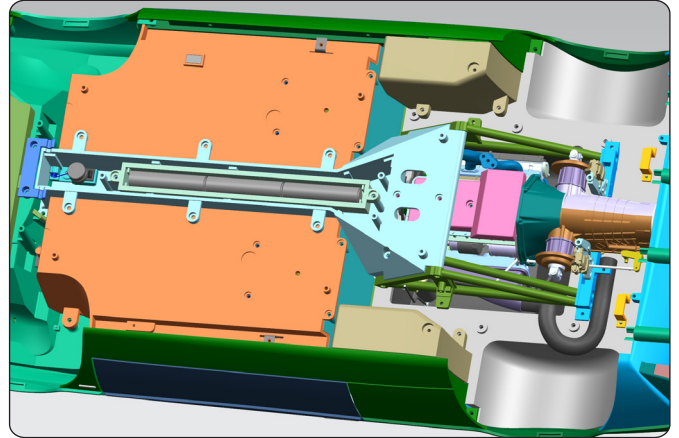


Secure with 2x PS02 screws.



Stage 025: Mounting the Engine Block onto the Chassis

In the last stage of this pack you'll secure the engine block onto the backbone chassis.

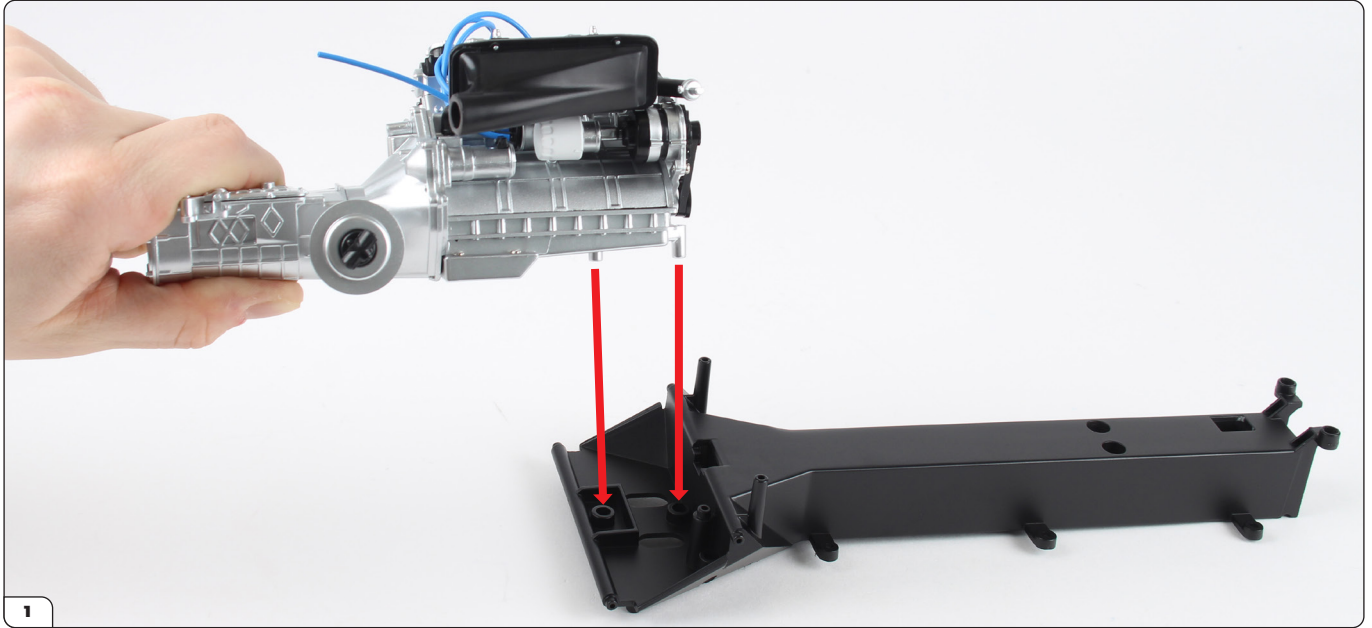


STAGE 025 PARTS LIST

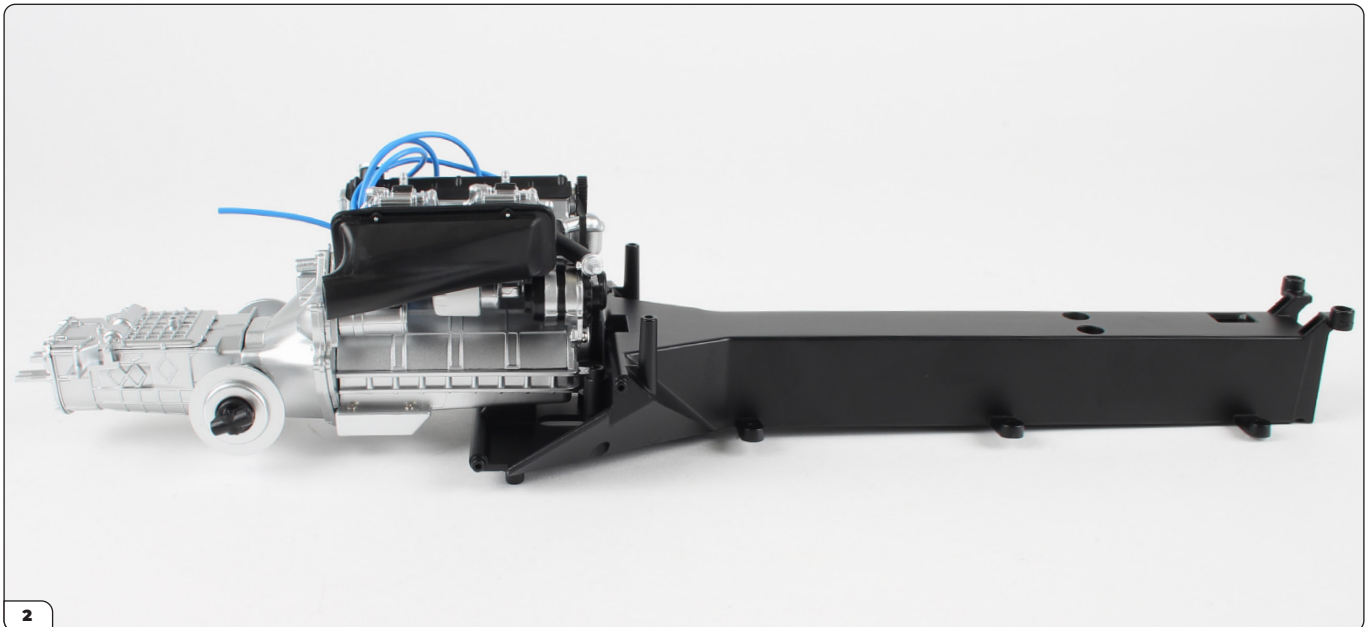
Name
25-A Backbone chassis
PS05 screws x3



Stage 025: Mounting the Engine Block onto the Chassis

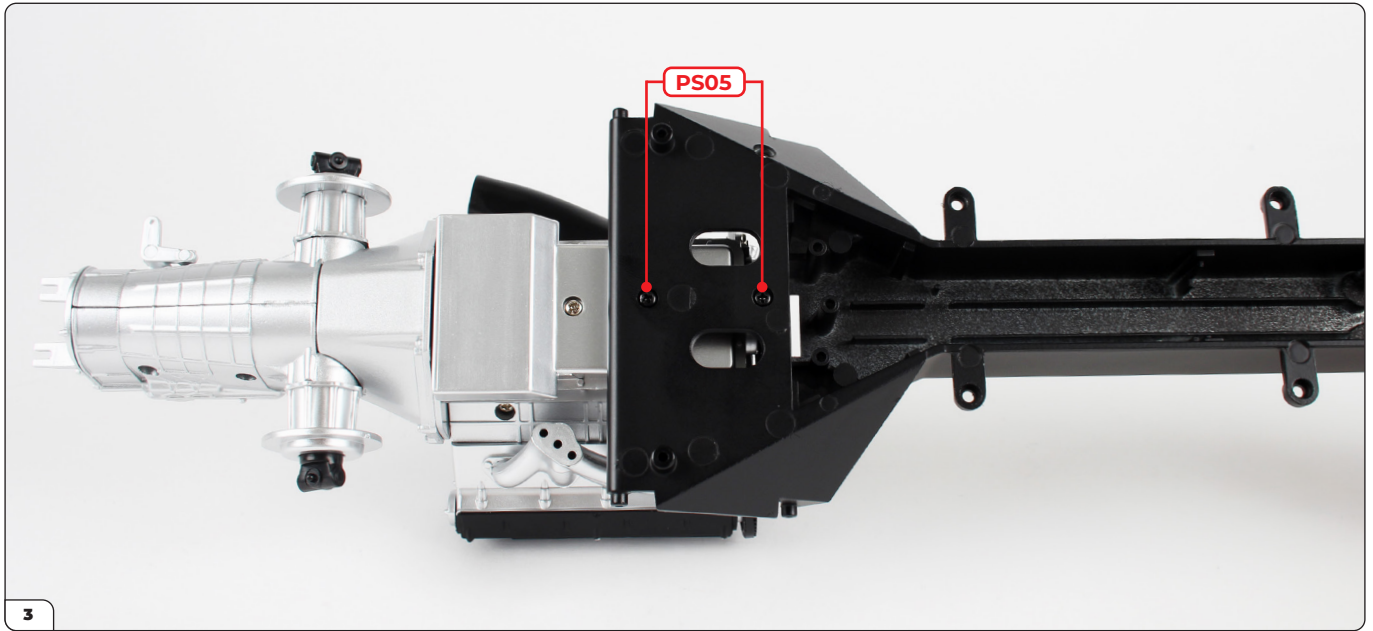


Take the engine block assembly (stage 024) and align it with the backbone chassis (25-A) as shown.



Fit the screw posts into the holes.

Stage 025: Mounting the Engine Block onto the Chassis



Secure from underneath using 2x PS05 screws.

