

Caution! Motor is hot after firing! Allow motor to cool before handling.

FOR YOUR SAFETY ALWAYS WEAR EYE PROTECTION

After Firing Cleanup

When the motor has cooled, remove both retaining rings and the nozzle washer (wear eye protection).

Remove the bulkhead from the motor case and discard the primary O-ring and the delay O-rings. Using a wood dowel, push the nozzle end and liner tube out of the head end of the case.

Remove the nozzle O-ring and discard the liner and all of the O-rings in a proper receptacle. Clean all motor parts with soap and water except nozzle.

Before firing again, remove large deposits of slag from the nozzle face with a razor blade and jeweler's screw driver. Small slag deposits can be ignored, but the nozzle throat hole must be clear. Slag often loosens on its own over several days. Please see www.lokiresearch.com for more information on nozzle maintenance and best practice.

Compare the two retaining rings and if their shape differs, replace both with new parts. Inspect the nozzle washer to ensure it is flat and not bent or warped.

Disposal

In the unlikely event that a Loki Research reload kit needs to be disposed of due to damage or defects, it should be returned to Loki Research. Please contact Loki Research prior to shipment for instructions in this regard.

Safety & First Aid

Keep all reload kits away from sources of heat and flames and out of reach of children. When ignited, Loki Research propellant will burn slowly and will not explode. In case of accidental ignition, fight any fires with water. Foam and carbon dioxide are not effective against propellant fires. In the case of minor burns, apply first aid techniques and consult a physician. For more serious burns; immerse in cold water and seek immediate medical attention. Do not eat any part of a reload kit. In case of accidental ingestion, induce vomiting and call a physician immediately. Propellant consists mainly of ammonium perchlorate dispersed in a polyurethane synthetic rubber.

Disclaimer

Loki Research states that it has taken reasonable care in the design and manufacture of its products. However, as we cannot control the storage and use of our products, Loki Research cannot be held responsible for any personal injury or property damage resulting from storage, handling, or use of its products. Purchasers of Loki Research products hereby acknowledge this, and will hold Loki Research, LLC, it's owners, employees, and subcontractors, blameless and harmless for any and all actions of the purchaser and user.

Limited Warranty

What does this warranty cover? We warrant each reload to be free from defects in material and workmanship. Our obligation under this warranty is limited to replacement or repair, at our discretion, of the reload and/or the Loki Research motor hardware only. Proof of purchase required.

How long does the warranty last? This warranty runs for one year from the date of original purchase.

What does the warranty not cover? This warranty does not cover defects or damage to airframes, vehicles, or other devices in which a rocket motor may be used, or to any support equipment they may require. This warranty does not cover defects or damage which result from abuse, misuse, negligence, or accidents. Also, consequential and incidental damages resulting from the use of this product or arising out of any breach of contract or breach of this warranty are not recoverable under this warranty. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above may not apply to you.

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BORN ON:

Made in USA
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**LOKI RESEARCH
ROCKET MOTORS**

High Power Reload Kit
This package contains one reload kit for use with Loki Research
38mm rocket motors or equivalent*

*see www.lokiresearch.com Tech Page for hardware specifications

K-627

Delay time is XL ONLY at 17 seconds

Loki Red Propellant: Red flame with little smoke

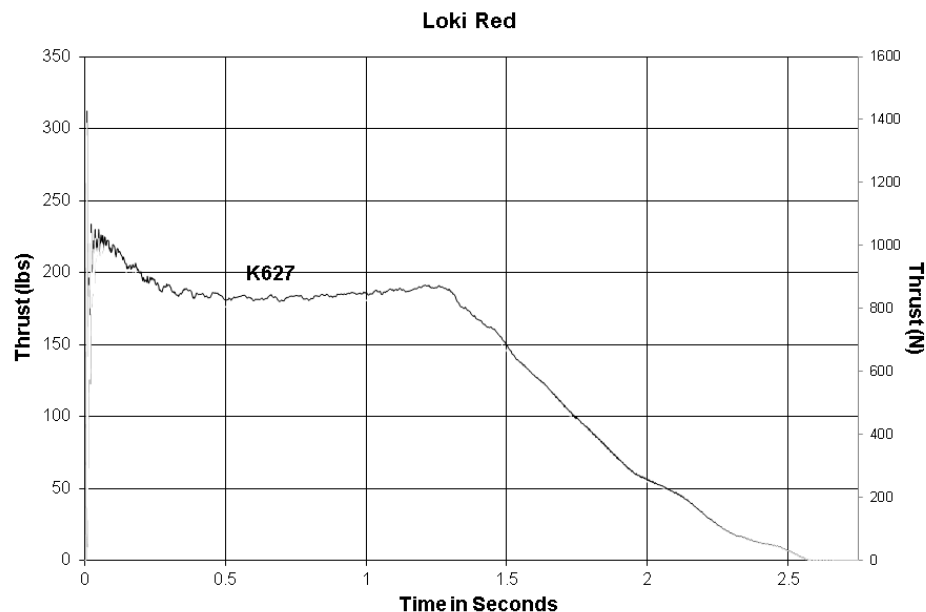
WARNING-FLAMMABLE

Keep out of reach of children. Do not use near open flame. Not for sale to persons under 21 years of age. For use by certified High-Power users only.

Do not open until ready for use.

	Nozzle Size	Case Length	Total Impulse	Loaded Motor Weight	Propellant Weight	Delay Times (Seconds)				
						X	S	M	L	XL
K-627	#25 0.390"	24.625"	1519 N-sec	1242g	674 g	-	-	-	-	17

Important! The correct nozzle must be used or motor failure may occur! Check the number engraved on the nozzle against this table



Before you begin:

Read the instructions completely and study the diagrams. Use the reload kit only in accordance with all instructions. Review the parts list and if any parts are missing or damaged, contact your Loki Research dealer for replacements. Note that in some reloads the liner tube is packaged separately from the other parts.

Parts List

Motor Hardware	
Motor Case with thrust ring	1
Graphite Nozzle	1
Nozzle Washer	1
Retaining / Snap Rings	2
Reload Kit	
Liner Tube containing propellant	2
Primary O-Rings (1/8" thick)	2
Delay O-Rings (3/32" thick)	6
Delay Element	1
Red Cap containing Black Powder	1

Required, but not supplied:

Internal retaining ring pliers*
 Loki Research Delay Adjustment Tool (Loki-DAT)
 O-Ring lubricant**
 Electric Motor Igniter
 Protective Eyewear

* We recommend "Knipex" brand retaining ring pliers. These may be purchased from www.mcmaster.com, use part #5449A92.

** Use petroleum jelly, synthetic automotive grease, silicone based greases

Assembly Instructions

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Red Motors: Install all grains in the order and placement in which they are labeled. Assemble the motor with the 3 short grains at the forward end of the motor, and the 2 long grains at the bottom, nozzle end of the motor. Note that the largest core grain is placed next to the nozzle. If placed improperly the motor will fail.

This motor requires grain bonding before motor assembly. Please refer to the included 38/1200 grain bonding instruction sheet before proceeding with motor assembly.

1. Check that all hardware pieces are clean and free of grease and soot. In particular, check and clean both retaining ring grooves and the delay cavity in the bulkhead. Next, rub a very thin layer of grease on the inside of the bulkhead and each end of the case.
2. Run your finger around the inside ends of the motor case. Feel for any nicks or sharp raised metal that may cut or tear the o-rings. If found, remove them with a sharp knife or small file prior to motor assembly.
3. Rub a light coat of grease on the six delay o-rings (small, 3/32" thick) and place them on a flat surface. With a clean hand, push the delay down into each o-ring one at a time. Avoid getting grease on the ends of the delay element (Figs 1 & 2).
4. Place the delay element stack on end, on a flat surface. Place the bulkhead over the stack and press down until the end of the delay element is flush with the bulkhead (Fig 3).
5. If desired, use the delay adjustment tool (Loki-DAT) to reduce the delay time.
6. Coat the primary O-rings (large, 1/8" thick) with grease. Install the black Primary O-ring onto the bulkhead O-ring groove and the orange silicone Primary O-ring onto the nozzle O-ring groove.
7. Grease the entire length of the motor liner in a thick coat of grease. High temperature axle grease is recommended. Slide the nozzle end of the liner into the forward end of the motor case and push it all the way in until the top of the liner is flush with the front end of the motor case. Wipe off the excess grease.
8. Push the recessed shoulder of the nozzle into the thrust ring end of the motor case (see diagram below). Be sure to use the correct size nozzle, #28 (see table on front page).
9. Place the nozzle washer against the nozzle and install the retaining ring using appropriate retaining ring pliers.
10. Install the assembled bulkhead into the top of the motor. Push the bulkhead down until the nozzle and washer are firmly seated against the aft retaining ring, then install the second forward retaining ring. (see diagram below)
11. Fill the ejection well with the desired amount of black powder (or leave empty for no ejection). Place some wadding on top of the black powder to hold it against the touch hole before installing the red plastic cap over the ejection well.
12. Make a final physical inspection to ensure that both retaining rings are fully seated in their grooves. The motor can now be installed in the rocket. Use positive mechanical means to prevent the motor from being ejected during flight.
13. Install an electrical igniter only when at the launch pad or in a safe area designated by the range safety officer. Slide the igniter through the nozzle all the way up until it touches the delay element. Then pull it back 1/2 inch. Secure in place with tape or use other means to prevent the igniter from sliding down.
14. Fire from a safe distance in accordance with NFPA code 1127 and the rules of your launch site. CAUTION! Motor will be hot after firing! Allow to cool before handling.

