

18DO-Dortmund – Heat, Sweat and Beers

Draft - Rules

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1. Introduction

18DO-Dortmund is a strategic economy game, which reflects the development of the most important industries in Dortmund during the 19th century.

Dortmund has been a town of beer brewers since the medieval age. About 1840 the first underground mining started and the first steel mill has been build. The connection with the German railway net pushed the industrial development of Dortmund furthermore. The upgrading of coal mines and steel mills led to a population increase. From the latter the Dortmund breweries benefitted as the demand for beer boosted. At the end of the 19th century the Dortmund breweries used refrigerator cars to transport the Dortmund Export beer by railway to distant regions.

In 18DO-Dortmund the players are investors who invest in both, breweries and Railway Corporations. Each player starts with a Minor Brewery. In addition every player may found a Railway Corporation. Coal mines and steel mills have a passive role only, but their locations have an impact on the game's development. All breweries are located in the hex "Dortmund City". They produce and supply beer and during the course of the game they improve their brewery equipment in order to scope with the increasing requirements of the beer market. The Railway Corporations are more dynamic. From their starting field at the border of the map they lay tracks to the coal mines and steel mills. On this tracks they run their trains virtually and achieve income according to the value of the hexes which are part of their trains' routes. When connecting the locations of coal mines and steel mills with the railway network the demand for beer will be increased. This reflects that the coal mines/steels mills with a railway link are able to increase their capacities and the consequently needed higher workforce will trigger an increase of beer consumption.

While the railway companies start the game as corporations the brewery corporations will be founded later during the game. When a corporation pays dividends the owner of its shares receive the due payment by the bank. In addition the stock value of these shares will be increased. At the end of games all players accumulated their possessions' which consists of their private cash plus the value of their share portfolio. This richest player has won!

18DO-Dormund consists of several variants of different complexity.

- **18DO - The Introduction Game** is designed for newbies which enter the complex world of 18xx games for the first time. This variant is based on an 1830 variant developed by Daniel W. Farrow, IV which has been published in the Rail Gamers Magazine. **under construction**
- **18DO- The Railway Game** is a classic 18xx game with some new features applying to the Dortmund area (*see separate rules*)
- **18DO - Heat, Sweat & Beer** implements the Dortmund brewery industry into 18xx. This variant increases the complexity of the railway game due to the comprehensive new elements/rules for the breweries.
- **18DO – The Expert Game** adds additional rules which increase the challenge.

2. Game Material Overview

The game materials are summarized in a separate table which also shows which material will be needed for the individual variants. Below please find a short description of the game materials.

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2.1 The Map

There are two maps, one for 18DO – The Railway Game and one for the other game versions. Both maps show the area of Dortmund today and the close surrounding. The historical center of Dortmund is in hex D13. This is also the location of the breweries. The map shows a hex raster where the railway companies place tiles in order to build routes for their trains. The hexes with a “K”-symbol are the locations of the coal mines. There are “place of landing” which have the same function as the small towns in other 18xx games. The steel mills are in the hexes showing an “S”-symbol. They are the equivalent of the cities. In addition there are three grey hexes which represent “freight yards”

2.2 The Stock Table

The Stock Table is used for several purposes. These various boxes are explained from top to bottom as follows

- a) The top row box is used for indicating the stock market value of Railway Corporations.
- b) The second row box is used for indicating the stock market value of brewery corporations
- c) Below is a box for display of the Minor Capital Expenditure Markers (MCM) and the Special Event Markers (SEM), only used for 18DO - Heat, Sweat & Beer Expert Game.
- d) The Bank Pool is used to deposit discarded or sold stock certificates
- e) To the left of the Bank Pool there are six boxes to hold the unsold Capex cards.
- f) Below d) and e) there are thirteen boxes where the stock certificates are placed at the start of the game.
- g) At the bottom there are two rows with boxes which are used to indicate the game rounds. This part of the Stock Market table is not used for the Introduction Game.
- h) Along the right border there are several sets of “bidding boxes” in horizontal order. Adjacent to each box a Minor Brewery charter will be placed for the Starting Round (see section 7.3).

2.3 The Beer Market

The Beer Market Table is only needed for 18DO - Heat, Sweat & Beer. On the beer market table both the demand and supply of beer will be regulated. The beer market consists of three areas:

- Regular customers: these are the customers who prefer the beer produced by the breweries present in the game. The demand area for regular customers is yellow.
- New customers: these are Dortmund beer consumers who are drink partly or completely beer from other breweries not present in the game. The demand area for the new customers is orange. The income for deliveries to the new customers is lower than that for regular customers which reflects the additional efforts and costs which are necessary to turn them into regular customers
- Export market: this shows the demand for Dortmunder Export Beer in more distant locations. In order to supply to this locations the railway is needed. Deliveries to the Export Market will start in phase 5. The demand for Dortmunder Export Beer is only limited by the production capacities of the breweries and/or by the transport capacities of the railway companies.

The Dortmund beer market, for both regular and new customers is split in segments from **1 to 6**. These segments reflect the changes in the beer industry such as: improved quality of the beer, new types of beer, new types of delivery (by horse wagon, by car, by lorry and by train), and new development of containers (barrel, bottle, and canister) and last not least the effect of inflation. For the Export Market there is only one segment.

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For each market segment of the Dortmund beer market there is a separate demand box for regular customers and new customers. Next to each demand box there is a supply box and to the right of each supply box the income for each delivery is stated. At the start of each brewery round there are blue beer cube in the demand boxes. This represents the demand for the individual market segments. When a brewery delivers beer to the Dortmund Beer Market the beer cubes from the demand boxes will be moved onto the adjacent supply boxes of the same market segment.

When a brewery supplies to the Export Market, the beer cubes are taken from the box “Stock” and moved onto the Capex cards possessed by the Railway Corporations.

The process of delivering beer to the markets segments will be explained in detail in section 7.8.3.

At the start of the game there is demand for market segment 1 and 2 only. In the other demand fields a red “No Demand” marker is placed. As soon as the first type of a Capex card has been acquired the “No Demand” marker in the correspondent demand field is removed. Some phase changes will close the lowest demand segment which is indicated by a “No Demand” marker as well.

2.4 The Capex cards

The Capex cards (abbreviation of capital expenditure cards) replace the train cards of other 18xx games. The Capex cards are multifunctional as explained below:

- a) As train cards they represent the rolling stock of Railway Corporations. Trains may be owned by Railway Corporations only. Train cards can be sold between the Railway Corporations
- b) When acquired by breweries they are turned to the backside and represent brewery equipment (BEC). Once owned by a brewery BECs may not be sold to another brewery. Railway Corporations cannot acquire BECs.
- c) Railway Corporations may use a Capex card alternatively for building or extending a railway link to a coal mine or a steel mill location.

Capex card must be acquired in ascending order, e.g. first all type 2 Capex card must have been used before the first type 3 Capex card becomes available.

2.5 Stock Certificates

In 18DO-Dortmund there are several historical corporations. For each of these corporations there are stock certificates which represent a total 10 shares per corporation. The stock certificates may represent a different number of shares. Stock certificates are always bought from or sold to the Bank. They may never be sold between players.

2.6 Companies' Charters

Each company which performs actions during the Operating Round will have a charter. All properties of the company (Capex cards, owned certificates, tokens, markers and money) will be placed on its charter.

The charter of a floated corporation is always in possession of its Director. When another player becomes the new Director of a corporation the charter is moved to that player.

The charter of a Minor Brewery is owned by a player until the Minor Brewery has been exchanged against a Brewery Corporation's certificate.

Directors of corporations and owners of Minor Breweries must keep their private cash completely separated from the treasuries of companies they possess or manage.

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2.7 The Track Tiles

There are hexagonal track tiles in yellow, green, brown and grey. These tiles show railway tracks and will be placed during the game on the map hexes. First only yellow tiles may be used which can be upgraded with green tiles. These can be replaced by brown tiles which can be upgraded by grey tiles. The track tiles may be placed by Railway Corporations only. In section 5.6.1.1 the rules for placing track tiles are described in detail.

2.8 Tokens

Tokens are the round discs. There are the following different types of discs:

- a) Stock value tokens which are used to indicate the stock market value of a corporation on the Stock Market table. Each Railway Corporation and Brewery Corporation has one stock value token.
- b) Station tokens which represent stations of the Railway Corporations on the map. Each Railway Corporation has a specific number of these station tokens
- c) Brewery order tokens are used to display the order of breweries during a Brewery Round. There is one token for each Minor Brewery and each Brewery Corporation.
- d) Location tokens are used to indicate a railway link of a coal mine (black token) or a steel mill (red token).

2.9 The Beer Cubes

The light blue cubes are the beer cubes. Each cube represents an unspecified volume of beer. They are used to

- a) Indicate the demand of beer on the Beer Market table
- b) The breweries delivery of beer to the beer market
- c) The beer transport by the Railway Corporations

2.10 The Other Markers

There are several types of other markers:

- “No Demand” markers are used for the Beer Market table to indicate that there is no demand for certain market segments.
- The Minor Capital Expenditure markers are used for 18DO – The Expert Game (see 8.1).
- The Special Event markers are used for 18DO – The Expert Game (see 8.2).

3. The Companies

3.1 Railway Corporations

Railway Corporations build track and stations. They buy trains and let them run via track links from town to town in order to generate revenue.

Railway Corporations are used for all game variants. Depending on the game variant different rules apply to the Railway Corporations.

There are seven Railway Corporations available in 18DO-Dortmund:

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Code	Name	Start	Stations	Commentary
CME	Cöln-Mindener-Eisenbahn	A2 / B3	1+5	- available from the start - may buy a train after floating
BME	Bergisch-Märkische Eisenbahn	I11	1+5	- available from the start - may buy a train after floating
RhE	Rheinische Eisenbahn	H2 / I3	1+5	- available from the start - may buy a train after floating
KWE	Königlich-Westfälische Eisenbahn-Gesellschaft	E21	1+3	- available from the start - comes with a location token
DEEG	Dortmund-Gronau-Enscheder Eisenbahn	A 21	1+2	- available after 4 Railway Corporations have been floated
DHB	Dortmunder Hafenbahn	C9	1+2	- available when the DEEG has been founded
HBB	Dortmunder Hansabahn*)	H20	1+2	- available when the DEEG has been founded

*) for 5 player game only

3.2 Breweries

The breweries are a unique element of 18DO-Dortmund – Heat, Sweat & Beer. At the start of the game there are only Minor Breweries active. When the game commences Brewery Corporations may be founded.

Breweries do not build track. They only buy Brewery Equipment and deliver beer to the beer market. In 18DO-Dortmund – The Expert Game breweries may buy Minor Capital Expenditures and acquire Special Event marker.

3.2.1 Minor Breweries

Each player must acquire one Minor Brewery in the Starting Round. The following Minor Breweries may participate in the game:

No.	Name	Price	Brewery Equipment
B1	Brauerei Ross & Co.	80 Mark	2x BE 1 / 0x BE 2
B2	Privatbrauerei Kronen	90 Mark	3x BE 1 / 0x BE 2
B3	Brauerei von Hövel, Thier & Co	100 Mark	0x BE 1 / 1x BE 2
B4	Borussia Brauerei	120 Mark	1x BE 1 / 1x BE 2
B5	Bürgerliches Brauhaus Eduard Frantzen	135 Mark	1x BE 1 / 1x BE 2
B6	Quellen-Brauerei	155 Mark	2x BE 1 / 1x BE 2
B7	Bierbrauerei Herberz & Co.	165 Mark	0x BE 1 / 2x BE 2
B8	Dortmunder Löwenbrauerei	185 Mark	1x BE 1 / 2x BE 2

The Minor Breweries begin the game with brewery equipment. The charter of a Minor Brewery accounts against the certificate limit and may not be closed voluntarily. However it may be dealt-in against shares of Brewery Corporations.

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3.2.2 Brewery Corporations

After the beginning of the green phase any of the following brewery corporations may be founded:

Name	Certificate Split	#
Dortmunder Union Brauerei	30% / 5 x 10% / 20%	7
Dortmunder Aktienbrauerei	20% / 2x 20% / 4x 10%	7
Ritterbrauerei	30% / 5 x 10% / 20%	7
Dortmunder Kronen-Brauerei	30% / 5 x 10% / 20%	7
Stifts-Brauerei	40% / 4 x 10% / 20%	6
Dortmunder Hansa-Brauerei *)	30% / 7 x 10%	8

**) for 5 player game only*

Brewery Corporations have the same functionality as Minor Breweries however they can generate more funds and therefore are able to buy better Brewery Equipment and earn higher income.

3.3 Coal Mines & Steel Mills Locations

The location of coal mines are marked on the map with a “Hammer & Pike” symbol in a white circle. The locations of the steel mills’ are indicated by pink circle with a black “S” in a red pentagon. All map hexes of the steel mills’ locations are already yellow and have already some tracks.

The coal mines and steel mills play only a passive part in the game.

4. Game Phases

The game phases are named after the type of Capex card the start with. The game begins with phase 2 and ends with phase 8. Capex card must be acquired in ascending order. The first type 3 Capex card becomes available when all type 2 Capex cards have been removed from the display on the Stock Market table. After all type 3 Capex cards have been removed the first type 4 Capex card may be acquired. This procedure will be continued until the second type 6 Capex card has been acquired. The first type 8 Capex card however becomes available after the second type 6 Capex card in addition to the remaining type 6 Capex cards.




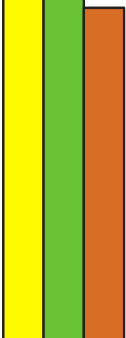
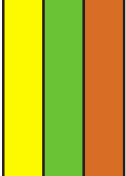
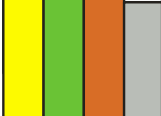
When a new phase is triggered by the first Capex card of a type acquired a change of some rules takes place. For details of these effects see the tableau “18DO – HS&B - Game Phases Overview”.

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18DO - Heat, Sweat & Beer Game Phases Overview

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Capex Cards	Phases	The following will happen after the first Capex card of a new type has been removed from the display on the Stock Market table
2		<ul style="list-style-type: none"> - Only yellow tiles are available. - Train limit for Railway Corporations is 4. - Trains may be purchased from other Railway Corporations. - Railway Corporations may connect one coal mine or steel mill location per RR to the railway net (=> location token value "10"). - The lower value of the off-board destinations is valid. - Brewery Equipment limit for Minor Breweries is 3. - A company may buy a maximum of two type 2 Capex Cards per RR/BR from the bank.
3		<ul style="list-style-type: none"> - Yellow and green tiles are available. - Railways may upgrade location tokens value "10" to location token value "20" - Train limit for Railway Corporations is 4. - Brewery Corporations may be founded. - Remove "No Demand" token from market segment 3. - Brewery Equipment limit for Minor Breweries is 3. - Brewery Equipment limit for Brewery Corporations is 4. - A company may buy only 1 Capex Cards per RR/BR from the bank.
4		<ul style="list-style-type: none"> - Type 2-trains become obsolete. - Train limit for Railway Corporations is 3. - Remove "No Demand" marker from market segment 4 and place it onto market segment 1; any beer cubes in market segment 1 move into stock immediately. - Brewery Equipment limit for Minor Breweries is 2. - Brewery Equipment limit for Brewery Corporations is 3.
5		<ul style="list-style-type: none"> - Yellow, green and brown tiles are available. - Train limit for Railway Corporations is 2. - The higher value of the off-board destinations is valid. - Railway Corporations may upgrade location token value "20" to location token value "30". - Remove "No Demand" marker from market segment 5 and place it onto market segment 2; any beer cubes in market segment 2 move into stock immediately. - Brewery Equipment limit for Minor Breweries is 1. - Brewery Equipment limit for Brewery Corporations is 2. - Deliveries of beer cubes to the Export Market become possible.
6		<ul style="list-style-type: none"> - Type 3-trains become obsolete. - Remove "No Demand" marker from market segment 6. - Move the beer cubes from Export Market price box into stock. - After the removal of the 2nd Capex card type 6 from the Stock Market Table Capex cards type 8 become available.
8		<ul style="list-style-type: none"> - Yellow, green, brown and grey tiles are available. - Type 4-trains become obsolete but have a final run. - Place "No Demand" marker onto Market segment 3. Move all beer cubes still in market segment 3 into stock.

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Corresponding to the colour of the Capex cards' type numbers there is a second classification which refers to the colour of the track tiles which become available:

- Yellow phase => Capex cards type 2
- Green phase => Capex cards type 3 and 4
- Brown phase => Capex cards type 5 and 6
- Grey phase => Capex cards type 8

In the rules both phasing classifications are used.

5. 18DO – Heat, Sweat & Beer

5.1 Game Preparations

5.1.1 Preparing the Map

- Place one station token onto each of the home station locations of the railway companies upside down. This will help the players to recognize where every railway is going to start and they can judge their potential.
- For a 5 player game place the overlay for hex H 20 on the map.

5.1.2 Preparing the Stock Market table

- Place the **round marker** onto the white circle „AR/SR“
- Sort the **Capex cards** by type. The Capex cards type 1 and 2 with a green border place at the side of the Stock Market table (they are only used for the Starting Round). The other Capex cards will be placed on the indicated boxes, the side with the train faced up.
- For a game with **3 players** remove the Capex card with “4 Spieler/Player” and “5 Spieler/Players” printed on the side with the trains.
- For a game with **4 players** remove the Capex card with “5 Spieler/Players” printed on the side with the trains.
- Place the **“Phase Change” cards** under the Capex card as mentioned.
- For a game with 3 or 4 player remove the railway certificates of the Hansabahn Dortmund and the brewery certificates of Dortmunder Hansa- Brauerei.
- Sort the **railway certificates** by corporations with the Director certificate on top of each stack per corporation and place them onto the corresponding boxes of the Stock Market table.
- Sort the **brewery certificates** per corporation and ascending number (lowest number on top) and place each stack on the corresponding box as well.

5.1.3 Preparation of the Beer Market Table

Place the one “No Demand” marker in each of the new customers' demand fields of market segment 3 to 6.

Place a number of beer cubes on the Beer Market table according to the table below:

Player #	Demand Segment 1	Demand Segment 2	Export-Market *)	Stock
3	3 each**)	3 each	6	8
4	4 each	3 each	6	8
5	4 each	4 each	8	10

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**) the white field with the value “100”*

***) Regular customers and new customers*

Put the remaining beer cubes back into the game box.

Commentary: For the game a maximum of 34 beer cubes are needed. The surplus is a reserve for lost beer cubes

5.1.4 Preparation of the Starting Package

- Take the charter of the Minor Brewery Private Kronenbrauerei and place it adjacent to the top “bidding box” at right border of the Stock Market table.
- Shuffle the other charters of the Minor Breweries and lay out randomly a number of charters equally to the number of players adjacent to a “bidding box” each.
- The Banker selects the indicated Brewery Equipment cards with the green border and places them onto each Minor Brewery charter. Any remaining BECs with a green border are removed from the game.

The not selected Minor Brewery charters are removed from the game.

5.1.5 Miscellaneous

- The banker pays out the starting capital to each player according to the table shown on the Stock Market table.
- The Banker shuffles the player order cards and deals one to each player. The dealt cards determine the player order for the Starting Round.

5.2 Game Procedure

The game begins with a Starting Round which is followed by the First Stock Round. After the First Stock Round there will be a set of Operating Rounds. Stock Rounds and sets of Operating Rounds will alternate until the game ends after the 6th set of Operating Rounds. The current type of round is indicated by the round token on the table at the bottom of the Stock Market table.

A set of Operating Rounds consists of two and later three Operating Rounds. Each Operating Round begins with a Railway Round and ends with a Brewery Round.

5.3 Starting Round

Each player selects a station token of a different Railway Corporation as bidding token. Beginning with player number one and then in player number order each player places her/his bidding token on one of the boxes adjacent to the Minor Brewery of her/his choice. If there is already another bidding token placed for this Minor Brewery the active player must chose a box with a higher value.

The bidding continues when there are more than one bid on any Minor Brewery in player order. When it is a player's turn who has bidding token in a lower position, this player must make a new bid, either for the same Minor Brewery or choose another Minor Brewery. In both cases the bidding token must be placed at a higher value than any bidding token already there.

In the very moment all bids are on different Minor Breweries, the bidding process is finished. The charter of the Minor Brewery for which no bid has been made is removed from the game.

Each player pays the printed value plus the bid to the bank. The Banker pays out the starting capital for each Minor Brewery onto that brewery's charter.

The Minor Breweries' order token are placed onto the box “Brewery Order” of the Beer Market table in descending order, highest number on the most left position.

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The player order for the following First Stock Round is determined by the players' remaining private cash. The player with the most private cash becomes player no. 1. The other players follow in decreasing order of their private cash.

Commentary: If there are players who are new to 18D-Dortmund – Heat, Sweat & Beer it is recommended to shuffle the Minor Breweries' charters and deal one to each player. The players pay the price for the Minor Brewery they have been dealt with.

5.4 First Stock Round

Beginning with the player No. 1 and then in player order the players may do one of the following:

- Found one of the available Railway Corporations (*according to table in 3.1*) by buying its Director certificate (*details see 5.5.1*).
- Acquire a certificate of an already founded Railway Corporation (*details see 5.5.2*)
- pass

During the First Stock Round no certificates may be sold. The certificates of the Brewery Corporations are not available.

The First Stock Round continues until all players have passed consecutively. The player to the left of the player who performed the last purchase of the First Stock Round receives the "Priority Deal" card.

After the First Stock Round as well as the other Stock Rounds two, later three Operating Rounds will be performed. Every Operating Round consists of one Railway Round and one Brewery Round each.

5.5 Other Stock Rounds

The holder of the "Priority Deal" card starts other Stock Rounds, the other players follow clockwise in seating order. During the other Stock Rounds a player may now choose between the following actions:

- Either sell any number of certificates they possess to the Bank Pool and then acquire a single certificate
- Or acquire one certificate by
 - Either founding a corporation when buying the Director certificate from the bank
 - Or buying a certificate from a corporation
 - or buying a certificate from the Bank Pool
 - Or deal-in an owned Minor Brewery against a 10% share of a Brewery Corporation.
- or pass

A Stock Round ends when all players have passed in continuous sequence. The player to the left of the last player who performed an action during the Stock Round will receive the Priority Deal. If no action has taken place during a Stock Round the Priority Deal remained with the current owner.

5.5.1 Founding a Corporation

The founding of a corporation takes place when a player acquires the Director certificate from the bank. The player chooses the starting value of a 10% share among the colored stock values of the Stock Market table which are equal to the current or the preceding phase(s). The Banker hands over the charter of the founded corporation together with the remaining shares which will be placed on the corporation's charter. In the case of a Railway Corporation the station tokens are placed on the charter as well.

According to the shares represented by the Director certificate the player pays a multiple of the starting value into the corporation's treasury.

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The Banker places the stock value token of the new corporation on the box with the starting value. If there are already other stock value tokens, the new one will be placed underneath. Now the Director receives

5.5.2 Purchase of Certificates of founded Corporations

All certificates will be bought at current stock value. When acquiring certificates some rules have to be obeyed:

- The purchase price for certificates owned by corporations will be paid into the corporation's treasury.
- The purchase price for certificates from the Bank Pool will be received by the bank.
- When buying a certificate that represents several shares, a 10% certificate may be dealt-in.
- If a player has already sold certificates of a corporation in the ongoing Stock Round she/he may not buy certificates of this corporation before the next Stock Round.

5.5.3 Certificate and Share Limit

A player may not possess more certificates than these limits allow.

- The certificate limit is the total number of certificates (including charters of Minor Breweries) a player may own at any time of the game. If this limit has been exceeded due to the change of Directory (see 7.5.7) the affected player must sell the surplus at the next opportunity.
- The share limit is the maximum number of shares a player may own from a single corporation which depends on the number of players:

	Certificate Limit	Share Limit
3 players	26	70 %
4 players	19	60 %
5 players	18	60%

3

5.5.4 Trade-in of a Minor Brewery

There are three different cases when a Minor Brewery is traded in for a certificate of a Brewery Corporation:

- a) The Minor Brewery is traded-in when a Brewery Corporation is founded.
The price for the Director share is reduced by the equivalent of one 10%. The total possessions of the Minor Brewery will be transferred to the charter of the newly founded Brewery Corporation. The charter of the Minor Brewery is removed from the game.
- b) The Minor Brewery is traded-in against a 10% share owned by a Brewery Corporation.
The possessions of the Minor Brewery will be transferred to the charter of the Brewery Corporation. However the Brewery Corporation may already own the maximum of brewery equipment cards (BEC). In this case the Director decides which brewery equipment cards will be discarded and removed from the game.
When a Minor Brewery has been trade-in against a 20%-certificate the owner of the Minor Brewery has to pay the equivalent for the other 10% into the Brewery Corporation's treasury.
- c) The Minor Brewery has been traded-in against a certificate from the Bank Pool.
The Minor Brewery's treasury goes to the bank and its brewery equipment cards are removed from the game.

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5.5.5 Floating a Corporation

As soon as 5 shares of a corporation have been acquired (either by purchase or trade-in) this corporation has been floated. In the next Operating Round the floated corporations will be active for the first time.

When a Railway Corporation has been floated its home station token will be turned to its labeled side.

When a Brewery Corporation is floated its brewery order token will be placed on the Brewery Market table in the field "Order of the Breweries". When a Minor Brewery had been traded-in during the purchase of the Director certificate the Brewery Corporation's order token takes over the position of the Minor Brewery's order token. Otherwise the corporation's brewery order token will be placed last. When a Minor Brewery has been traded in against a non-Director certificate, the Director may decide to use the position of the Minor Brewery in question. In any case the order token of a trade-in Minor Brewery is removed from the game.

Directors of corporations which are being floated in the brown or grey phase can immediately (*that is during the Stock Round and out of order*) sell up to 20% shares owned by this corporation into the Bank Pool. This does not count as the Director's turn for the Stock Round. Exceptionally this sale will not change the stock value.

5.5.6 Selling Certificates

A player may during her/his turn in the Stock Round sell any number of certificates into the Bank Pool providing the following restrictions:

- a) No certificates may be sold during the First Stock Round.
- b) No certificates of corporations may be sold which have not been active in an Operating Round.
- c) The Director certificate may never be sold into the Bank Pool.
- d) There may be no more than 50% of a corporation's shares placed into the Bank Pool.

Partial sale of certificates into the Bank Pool is possible, e.g. a player may sell a 20% certificate and take back a 10% certificate from the Bank Pool.

The stock market value of certificates is only changed when the sale has been done by the Director either from the player's portfolio or from the certificates owned by a corporation. In both cases the stock value token will be moved one space per 10% share to the left.

The bank pays out the certificates' value before the stock value adjustment.

5.5.7 Change of Director

The founder of a corporation is its first Director, which is indicated by the ownership of the Director certificate. Only the Director decides what a corporation does and what it does not. However the shareholder may advise the Director.

If a player owns more shares of a corporation than its Director does, a transfer of Directorship takes place immediately. This can either happen through purchasing of certificates by other players or selling of certificates by the Director. The player with the highest number of shares of a corporation becomes its new Director. If several players hold more shares than the Director but the same number of shares then the player closest to the left of the former Director takes over.

There is no transfer of Directorship if another player owns the same number of shares as the Director of the company.

A Director may only voluntarily give up his Directorship by selling sufficient shares. However he can do this only if:

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- Another player owns at least the same number of shares as represented by the Director certificate.
- There is space in the Bank Pool for the shares necessary to sell (50%-Limit see 7.5.6)
- The Director will hold less shares after the sales than at least one other player

If all conditions are met, the current Director announces how many shares he intends to sell. As the Director certificate cannot be sold, he first exchanges it for normal certificates, which represents the same number of shares as the Director certificate, with the player who will become the new Director. The current Director then carries out his announced sales and placed the corresponding certificates into the Bank Pool.

The corporation's charter with all its possession is handed over to the new Director.

5.5.8 Bankruptcy of a Corporation

In case the a stock value token is moved into the space „bankrupt“ of the Stock Market table, the corresponding corporation will be closed. All certificates of the bankrupt corporation still owned by players will be given back to the Bank without compensation. The charter with all possessions is returned to the Banker as well. Treasury goes into the bank, Capex cards and the station tokens already placed on the map with the exception of the home station token will be removed from the game. When a Brewery Corporation becomes bankrupt its brewery order token is removed from the box “Brewery Order”.

Commentary: If a Director sells shares during the Stock Round and the stock value token is moved onto the “bankrupt” box, the Director will receive the stock value of all the shares sold!

5.5.9 Reopen a bankrupt Corporation

A bankrupt corporation may be founded again in the next Stock Round following the bankruptcy. The rules for founding and floating such a corporation are the same as for new corporations. However the once bankrupt corporation will start with a handicap:

- Railway Corporation will only receive the station tokens which have not been removed due to the bankruptcy
- Brewery Corporations will have 8 shares only. Two of its shares are removed from the game.

5.6 The Operating Rounds

During the Operating Rounds the companies take actions decided by their Owners/Directors. An Operating Round consists of a Railway Round followed by a Brewery Round. After two and later three sets of Operating Rounds a Stock Round takes place.

5.6.1 Railway Rounds

Floated Railway Corporations must carry out some or all of the following actions during a Railway Round. These actions must be carried out in the given order.

1. Lay one track tile
 - Either one yellow tile
 - Or one track upgrade
 - Or promote one yellow pre-printed hexes
2. Purchase and place a station token (*optional*)
3. Build or upgrade one railway link to a coal mine or steel mill (*optional*)
4. Run train(s) (*mandatory*)
5. Calculate income and either pay as a dividend or withhold (*mandatory*)
6. Adjust the stock value on the Stock Market table (*mandatory*)

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7. Purchase train(s) by acquiring Capex cards (*mandatory if no train owned*)

Once during its turn in the Operating Round a Railway Corporation may deal with its own certificates:

- Either sell one of its certificates into the Bank Pool
- Or buy one of its certificates from the Bank Pool.

The certificate-dealing activity can be performed at any time during the Railway Corporation's turn.

5.6.1.1 Laying Tiles

5.6.1.1.1 General Rules for Tile Placement

Hexagonal tiles representing railway track may be placed on the hex grid of the map. Grey hexes represent track already laid and may not be built on.

At the start of the game (*yellow phase*), only yellow tiles are available. During the yellow phase a Railway Company may lay one yellow tile on a light green colored hex.

The track on the tile must be a direct continuation of a route already accessible to the company laying the tile. The new track must be connected with a station token of that company and may not be laid if a station token of another company blocks this connection. Yellow tiles may not be placed on preprinted yellow hexes.

With the exception of the DHB (Dortmunder Hafenbahn) all Railway Corporations start from their home station in a red border field. The black arrows in the red fields indicate against which side a track link can be built and is hence connected to the home station. The home station of the DHB is connected with all tracks going through **hex C9**.

Yellow tiles **without** a „Hammer & Pick“-symbol **may not** be placed on hexes with such a symbol.

Yellow tiles **with** a „Hammer & Pick“-symbol **may only be** placed on hexes which show the same symbol. These tiles show a black dot indicating a place of loading.

Some hexes show amounts in Mark which represent higher construction costs due to difficult landscape or areas with housing estates. The tile laying company must pay the amount from the treasury before placing a tile here. This cost is only applicable for the first tile placement on such a hex.

No tile may be laid so that track runs into a blank side of a grey or red hex or runs off the hex grid, except for the red off-board destinations marked by a black triangle.

A tile may be laid so that it does not connect with track of adjacent tiles provided that all other rules have been observed.

5.6.1.1.2 Upgrading Track Tiles

Instead of laying a yellow tile a Railway Corporation may upgrade a track tile already on the map or a preprinted yellow hex.

- **Yellow** tiles/preprinted hexes may be upgraded with **green** tiles after the first type **3** Capex card has been acquired.
- **Green** tiles may be upgraded with **brown** tiles after the first type **5** Capex card has been acquired,
- **Brown** tiles may be upgraded with **grey** tiles after the first type **8** Capex card has been acquired.

A Railway Corporation may only upgrade a tile if it has an unblocked route from one of its own station tokens to the tile after the upgrade. Existing track must be preserved during tile promotion.

Tiles without a location symbol or location token of coal mines/steel mills may only be upgraded with tiles without a location symbol.

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Hexes with a “K Hammer & Pick” symbol may only be upgraded if there is a location token present which indicates that the coal mine on this hex has been connected with the railway net.

Similarly the upgrade of hexes with an “S” symbol is only permitted when there is a steel mill’s location token on this hex. The yellow hex tiles with the steel mill locations have a red, an orange or a pink border. Upgrade of these hexes/tiles is only possible with tiles showing the same border color.

There are special tiles for the hex C9 (D-Hafen) which can only be used for this hex. No other tiles may be placed there.

5.6.1.2 Placing Station Tokens

Each Railway Corporation starts from its home hex which shows the corporations logo in grey in the reserved station space. Its home station token has already been placed when the company has been floated in a Stock Round. During every Railway Round a Railway Corporation may place one station token as long as there is a station token available from its charter. Once placed on the map a station token may not be moved. Station tokens may be placed on the white circles of hexes or tiles only.

Station tokens have the following functionality:

- Each route run by a company’s train must contain a station token of that company.
- When all of the white circles on a hex are occupied by station tokens this tile is blocked. Only trains of those companies with a station token there may run a route through this hex. Other companies’ trains must end or begin their routes on this hex.
- Every tile placed by a corporation must be connected by an unblocked track link to a station token of that company after the tile placement.
- A station token on the red off-board destination does not block this destination and hence the income value.

The home station token is for free. The second station costs 60 Mark to build; the third 80 Mark and any further (if available) station token cost 100 Mark.

A company may not build more than one station token on any hex.

The home station token of the DHB does not block any route in hex C9.

In the “Dortmund City” hex no station token may be placed. Consequently every Railway Corporation may run its trains through this hex.

5.6.1.3 Creation and Extension of Railway Links

At the start of the game the locations of the coal mines/steel mills have no effect on the income of the Railway Corporations. This will change when a location has been linked to the railway net. These links are indicated by placing a location token of the corresponding color onto the locations symbol of a hex (*there will be no visible track leading to the location token!*). The income for all routes which include a coal mine/steel mill hex with a location token will be increased by the amount stated on the location token.

5.6.1.3.1 Creation of a Railway link

The building of a railway link is already possible in the yellow phase. In every Railway Round each Railway Corporation may build **one** railway link. There must be an unblocked track link between one of the Railway Corporation’s stations and the track on the hex where the railway link will be created. The next available Capex card is taken from the display and removed from the game. The Railway Corporation must pay the 30 Mark shown below the track symbol on the Capex card from its treasury.

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The creation of the railway link is indicated by placing a location token with the value “10” onto the location logo shown on the hex. For coal mines the black location tokens with a “K” are used, for the steel mills the red with an “S”.

5.6.1.3.2 Extension of a Railway Link

With the beginning of the green phase a Railway Corporation may extent **one** existing railway link instead of creating a new one. The location token value “10” will be replaced by a location token with the value “20” faced up. The following restrictions have to be obeyed:

- There must be an unblocked track link from one the Railway Corporation’s stations to any track on the hex/tile where the location link will be extended.
- The higher value location token must have the same colour as the replaced one (either red or black).

A further extension is possible from the brown phase onwards. A location token with the value “20” may be replaced by one with the value “30”.

Each time a Railway Corporation extends an existing railway link a Capex card will be removed from the game and the building Railway Corporation has to pay 30 Mark from its treasury to the bank.

5.6.1.3.3 Consequences for the Beer Market

Due to the building and extension of railway links the coal mines and steel mills will have better access to their markets and can expand their production. This will led to an increase of their workforce and consequently to a population increase in Dortmund. From the latter the breweries will benefit as the demand for beer will increase as well.

In 18DO-Dortmund only the last aspect of the economic growth will be reflected. Each time when a railway link has been created or extended the next available Capex card on the Stock Market tableau will be removed from the game. According to the beer cubes in the right lower corner of this Capex card the demand on the Beer Market tableau will be increased. The type of the Capex card determine in which market segment the demand will be increased and the background of the beer cubes states whether the number of pictured beer cubes will be added to the demand of regular customers or new customers.

The beer cubes for the increase will be taken from the box „Stock“. If there are not sufficient beer cubes available take the shortfall from the demand field with the lowest price (*lowest segment first*).

5.6.1.4 Operating Trains

A Railway Corporation must run each of its trains along one route once per turn in a Railway Round.

A route comprises of at least one hex or red off-board destination with a station token of the operating Railway Corporation and another hex with an income value which are connected by an unblocked track. A route which consists only of two red off-board destinations is not valid.

The number of the train type in the top left corner of the Capex card indicates how many hexes with an income value the route of the train may include. A route may not skip any hexes with an income value and may not run through red off-board destinations.

A route may start or end at an income hex whose station spaces are entirely occupied (blocked) by station tokens of other Railway Companies but **may not** run through such a hex.

A train may run through a hex where the places for station tokens not fully occupied or where an own station token has been placed.

No route may use the same piece of track twice, no matter how short. However, separate pieces of track on the same tile may be used.

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A route may not include the same income hex or read off-board destination more than once.

When a company owns more than one train then their routes must be entirely separate from each other. Routes may cross or meet at hexes with income values as long as they use separate tracks into and out of the center. Thus, a company can only use a branching off with a single train. Red off-board destinations may be used by several train routes as long as each route begins/ends at a different hex side.

A train which has been loaded with **beer cubes** (see 5.6.1.5.2) is bound to run a route which includes the hex E13 "Dortmund City" and a red off-board destination. If the only available route has been blocked by other Railway Corporations' station tokens, the train may run this route as an exception.

5.6.1.5 Income Calculation and Usage

5.6.1.5.1 Income Calculation

A Railway Corporation's income is the value of all the routes its trains have run during a Railway Round.

The value of a route is the sum of all hexes with an income value plus the value of coal mines/steel mills' locations markers and red off-board destinations which the train has run to. In addition there may be income from transport of beer cubes (see below).

The red **off-board destinations** have different values according to the game's phase. The lower value is valid during the yellow and green phase while the higher value counts from the brown phase onwards.

The basic income for the **freight yards** is 20 Mark. This will be increased by 10 Mark for every station token placed there, but only for those Railway Corporations which own one of these station tokens.

5.6.1.5.2 Beer Transport

For the **Export Beer transport** only trains of type 5, 6 and 8 may be used. The breweries can place beer cubes onto these train cards up to the number of blue squares shown in the top left corner. When there are beer cubes placed on a train, that train must run a route which includes both, the hex "Dortmund City" and a red off-board destination. For each beer cube transported the Railway Corporation will earn 40 Marks. If the transport ends in the off-board destination with the home station of the Railway Corporation the income will be 50 Mark per beer cube.

The income for the beer transport is always in addition to the value of the hex "Dortmund City".

A train which is forced to run a route through a blocked hex must count this hex against its route length capacity but may not count the hex value for income.

After the transport the beer cubes are move from the train card onto the field "Vorrat/Stock" of the Beer Market table.

5.6.1.5.3 Paying Dividends or Withholding

Depending on the Director's decision the bank either pays out the income completely as dividends to the shareholder or pays it into the company's treasury.

When a dividend is paid every owner of a certificate of the acting company will receive a portion of the income which is equal the percentage stated on the certificates. The dividend for certificates owned by the company is paid into its treasury. Dividend for certificates in the Bank Pool remains with the bank.

Example: the Company's income of 150 Mark is going to be paid out as dividend. The Director owns 40% and will receive 60 Mark. Two other players hold 10% each and will receive 15 Mark per certificate. For the 3 shares in the Bank Pool (=30%) no dividend is paid. At least the bank pays 15 Mark for the 10% certificate owned by the company into the company's treasury.

5.6.1.6 Stock Value Changes during the Operating Rounds

When a corporation does not pay out dividend because there has been no income or the Director decides to save the income, the stock value token of the company will be move one space to the left.

In the case the dividend was lower than the current stock value the stock value token remains in the same field of the Stock Value table.

When a corporations pays out a dividend which is at least as high as the current stock value but less than the threefold of the stock value the stock value token will be moved one field to the right.

After a dividend payment **threefold** of the current stock value or higher the stock value token moves **two spaces** to the right.

When a stock value token moves into a space containing other stock value tokens, the stock value token of the active corporation will be placed below them. This applies also for a stock value token which remains after dividend payment in the same space.

5.6.1.7 Train Purchase

Trains will be purchased by a Railway Corporation at the end of its turn during the Railway Round by acquiring a Capex card. Therefore a newly bought train may only be used in the next Railway Round. The purchase price must be paid from the corporation's treasury. The only exception to this rule is a "forced train purchase" (see 5.6.1.7.5).

A corporation may never own more trains than permitted by the "train limit" of the current game phase (stated on the corporations' charters). A corporation which has already achieved its train limit may not buy another train even if this purchase would trigger the obsolescence of other train(s) it its possession.

Due to a phase change corporations may be obliged to reduce the number of trains they own. The Director decides which trains (Capex cards) are put into the Bank Pool. Trains placed into the Bank Pool remain trains and may not be purchased as Brewery Equipment! The trains in the Bank Pool may be purchased by other Railway Corporations at printed price.

A corporation may not discard its trains voluntarily or sell it back to the bank.

5.6.1.7.1 Purchase of new Trains

New trains are bought from the bank at the price stated in the upper right corner of the Capex card. The new trains must be bought in ascending order. Therefore the first type 3-train may not be bought before the last type 2 Capex card has been removed form display, the first type 4-train may not be acquired before no more type 3 Capex card is on offer on the display on the Stock Market tableau. The first type 8 Capex card is available after the purchase of the second type 6 Capex card.

A Railway Corporation may buy up to two type 2-trains or one train of the other types from the Bank in a single turn.

5.6.1.7.2 Purchase of Trains from other Railway Corporation

As an alternative to the new trains from the bank a Railway Corporation may buy a train from another Railway Corporation. The price is a matter of negotiations but must be at least 1 Mark. Train purchases from other Railway Corporations take always place during the turn of the buying company. A train which carried beer cubes may not be sold. There is no restriction on the number of trains bought from other corporations.

5.6.1.7.3 Obsolete Trains

With the purchase of the first train of particular train types other train types become obsolete as stated on the Railway Corporations' charters.

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Train Type	Becomes obsolete due to	Effect
2	first type 4 train	immediately removed from the game
3	first type 6 train	immediately removed from the game
4	first type 8 train	Final run, then removed
5 / 6 / 8	none	permanent

While obsolete type 2 trains and type 3 trains are removed immediately from the game without any compensation an obsolete type 4 train will have a “Final run”. The train card will be rotated by 90 degrees. When the owning Railway Corporation has its next turn during an Operating Round, an obsolete type 4 train may run a route after which the train card is removed from the game. Obsolete type 4 trains may not be sold to other Railway Corporations.

5.6.1.7.4 Mandatory Train Ownership

Every floated Railway Corporation must own a train at the end of its turn in the Railway Round. When a Railway Corporation is constrained to buy a train, the Director may purchase either a new train from the bank, a train from the Bank Pool or a train from another Railway Corporation. Buying a train from another Railway Corporation is only possible with the buying corporation's treasury.

If the Corporation does not have enough treasuries to acquire the mandatory train, the Director must sell one certificate in possession of the company into the Bank Pool. If there is still not sufficient treasury available to purchase a train a “forced train purchase” takes place.

5.6.1.7.5 Forced Train Purchase

The Director is not obliged to buy a train from the Bank Pool. When buying a new train from the Bank only the cheapest may be acquired in the case of a forced train purchase. In order to obtain the necessary funds the Director has to carry out the following actions in the stated order:

- At first the Director must use the Railway Corporation's complete treasury.
- Then the Director has to sell certificates owned by the Railway Corporation. The stock value token will be moved one space to the left for each 10% share sold. In this case more than 50% of corporations' shares may be placed into the Bank Pool exceptionally. However the Director may not sell more certificates than necessary for the purchase.
- Then the Director has to spend her/his private cash.
- At least the Director has to sell her/his own certificates of the active Railway Corporation but may not sell the Director certificate nor may a change of Director be triggered. As for b) the 50% share limit for the Bank Pool is suspended.

If the corporation has still not enough money the Bank will give a credit for the shortfall. The credit has to be written down and the double amount will be subtracted from the player's final scoring at game end.

Commentary: Consequently a player may never go bankrupt!

5.6.2 The Brewery Round

Each Railway Round is followed by a Brewery Round, in which the breweries become active. According to the field “Order of the Breweries” each brewery carried out all of its actions before the next brewery does so. After all breweries have had their turn the order of breweries for the next Brewery Round will be rearranged (see 7.8.6) and the Beer Market will be prepared (see 7.8.7).

5.6.2.1 Brewery Activities

During its turn of the Brewery Phase each brewery executes the below stated activities exactly in this order:

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- Voluntarily disposal of brewery equipment
- Deliveries to the Beer Market
- Calculation of the income and pay-out by the bank
- Purchase of new Brewery Equipment
- Once during its turn a Brewery Corporation may deal with its own certificates. It may
 - Either sells one certificate from the Initial Offering into the Bank Pool; the stock value token is moved one space to the left.
 - Or buys one of its certificates from the Bank Pool. The certificate will be placed in the box appropriate box on the certificate.

The certificate deal may take place any time during the brewery's turn.

5.6.2.1.1 Disposal of Brewery Equipment Cards (BEC)

Brewery equipment does not become obsolete in the way trains do. The disposal will be triggered by different incidents:

- a) At the beginning of its turn in a Brewery Round a brewery can dispose one of its BECs (brewery equipment cards) **voluntarily**. This may be due to several reasons:
 - A brewery already owns the maximum of BECs but would like to buy a new type of BEC at the end of its turn.
 - A Brewery Corporation possesses only one BEC for the lowest market segment with a demand and consequently will generate a low income. However there is not enough in the treasury to buy a BEC for a higher market segment. When voluntarily disposing the only BEC the Director may trigger a forced BEC purchase (see 7.8.5.2) which allows her/him to subsidize the purchase of a BEC with private cash. Using this option the brewery may also move to a higher position in the brewery order.
- b) Breweries will be **forced** to dispose brewery equipment when one of the following events happen:
 - There is a limit of BECs a brewery may hold at the same time dependent on the game phase. When the BEC limit has been changed due to a phase change any surplus BECs owned by the breweries must be disposed immediately. The BEC limit is different for Minor Breweries and Brewery Corporations!
 - When there is no demand for a beer market segment at the **beginning** of a Brewery Round all BECs of the correspondent type will be removed from the game immediately.
 - When a BEC could not be used **during** a Brewery Round as the owning brewery has been late in the brewery order and all demand for the BEC in question has been gone this BEC will be turned by 90 degrees. This indicates that this BEC has not been used to move at least one beer cube into a supply field. A BEC turned by 90 degree is regarded as idle capacity and does still count towards the brewery ranking. If an idly BEC does not deliver any beer cube during the next Brewery Round it will be removed after the owning brewery's turn.

All disposed BECs are removed from the game. No BEC will ever enter the Bank Pool.

5.6.2.1.2 Deliveries to the Beer Market

The delivery of beer to the Dortmund Beer Market takes place by moving beer cubes from the demand fields onto the supply fields within the same market segment. In the case of the delivery to the

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Export Market the beer cubes were taken from the Stock field and placed onto the blue squares at the top of the train cards type 5, 6 and 8.

The number of blue cubes on the brewery equipment cards indicates the number of beer cubes which can be delivered by using the BEC's capacity to the Dortmund Beer Market.

On Brewery Equipment cards type 5 to 8 there read arrows above some of the blue cubes pointing to the beer wagon in the right top corner. Only the blue cubes below a red arrow may be used for delivery to the export market.

A brewery always begins with the delivering to the highest segment for which it has the appropriate BEC and continues with the next lower segment useable. In this respect the Export Beer Market has to be regarded as highest segment.

A BEC can be used to deliver beer cubes to a lower market segment then indicated on the BEC but never for a higher market segment.

Commentary: It is recommended to move the beer cubes delivered by on BEC completely before starting with the next BEC.

5.6.2.1.2.1 Deliveries to the Dortmund Beer Market

A brewery always tries to deliver beer cubes to the regular customers first. If there is still capacity for delivery left but the demand of regular customers within the market segment has ceased (e.g. there are no cubes left in the demand field) delivery will be continue to the new customers. If both demand fields empty delivery will be continued for the demand fields of the next lower market segment. Again the regular customers will be delivered to first and then to the new customers. This will be continued until either all capacity of the brewery has been use or there is no demand left.

5.6.2.1.2.2 Deliveries to the Export Market

Deliveries to the Export Market take place in two steps. The first step is the loading of beer cubes onto the train cards of the Railway Corporations. These beer cubes are then considered "Export Beer Cubes" (= EBCs). The second step takes place in the following Railway Round when the trains "loaded" with EBCs run a route including both, the hex "Dortmund City" and a red off-board destination.

Beer cubes for the Export Market are taken from the field "Stock" on the Beer Market table and moved onto the empty blue squares on the train cards. If there are not sufficient beer cubes available in „Stock“ beer cubes from the demand fields will be used for the shortfall. The cubes from the demand fields are taken from the section with the lowest price. I the case of a tie use lower segment first.

In order to load beer cubes onto trains for delivery to the Export Market a brewery must meet the following requirements at the time of loading:

- a) The brewery must own a brewery equipment card which shows at least one blue cube with a red arrow above.
- b) The capacity of this square(s) may not already be used for deliveries to the Dortmund Beer Market.
- c) A track link between hex E13 „Dortmund City“ and a red off-board destination must exist.
- d) A train for the transport of EBQs must be available which is
 - A train card with a blue square in the top left corner which is not already occupied by a beer cube.
 - The train must have route length ability for the required track link and there must be at station token of the train owning Railway Corporation on that route.
- e) The Director of the Railway Corporation which owns the chosen train card must agree with the transport.

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Supposed all requirements mentioned above have been met the loading of the beer cubes can be carried out:

- A brewery may load its EBCs onto different trains as long as there are free blue squares available.
- A brewery may load its EBCs onto trains which have already been loaded with EBCs of other breweries.
- A brewery is not forced to use its total capacity of EBCs for deliveries to the Export Market. It may either use a part or all of this capacity for supplies to the Dortmund Beer Market.

5.6.2.2 Calculation of Income and Payment by the Bank

A brewery receives for every beer cube it delivers to a supply field the amount stated to the right of this field as income paid out by the bank.

For every Export Beer Cube a brewery loaded onto a train cards it receives an income of 100 Mark.

The income may be used as follows:

- a) **Minor Breweries** may either pay 50% to the owner and 50% to the treasury or withhold 100% for the treasury
- b) **Brewery Corporations** may pay 100% as dividends or keep 100% for the treasury. The dividend for certificates still owned by the company is paid into its treasury. Dividend for certificates in the Bank Pool remained with the bank.

When the income will be paid out to the owner or to the shareholders the total income has to be rounded down to the next full 10 Mark amount. The rounding-off difference goes to the brewery's treasury.

Depending on the usage of the income the stock market value of the Brewery Corporation will be adjusted in the same way as described for Railway Corporations (see 7.7.5.4).

5.6.2.3 Purchase of Brewery Equipment

A brewery may buy brewery equipment cards (BEC) from the bank only. In every Brewery Round a brewery may purchase one or two BEC type 2. Of all the other types only **one** BEC may be bought per Brewery Round. A brewery which owns already the maximum number of BECs may not buy another BEC.

Owners of a Minor Brewery may subsidize up to 50% of the price of a Capex card even when the Minor Brewery already owns brewery equipment. However the Minor Brewery must use its complete treasury for the purchase first.

A Brewery Corporation, which owns at least **one** BE card, can only buy another BE from its treasury. But a Brewery Corporation may sell one of its certificates still in its possession into the Bank Pool prior the purchase of a BEC (stock value token move one space to the left).

Minor Breweries may not buy BECs of type 6 and 8.

5.6.2.3.1 Mandatory Ownership of Brewery Equipment

A **Minor Brewery** without a BEC at the end of its turn is only obliged to buy a Capex card from the bank even when the price can be paid from its treasury. When there are insufficient funds the owner may pay up to 50% of the purchase price with private cash but may not sell any certificates to do so. Does the owner not wants to grant private cash or is not able to do so or the treasury is lower than 50% of the purchase price the Minor Brewery finishes its turn without brewery equipment. It will not be closed and counts against the certificate limit of its owner. The latter may deal-in the Minor Brewery during the next Stock Round.

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5.6.2.3.2 Forced Purchased of Brewery Equipment

A **Brewery Corporation** is obliged to own at least one BEC at the end of its turn. When it has no BEC at this stage it is forced to buy a BEC with its funds in the treasury. In the case of forced BEC purchase a Brewery Corporation may only buy the cheapest available BEC.

When the treasury is insufficient for the purchase of a new BEC the Director has to carry out the following actions in the stated order:

- a) At first the Director must use the Brewery Corporation's complete treasury.
- b) Then the Director has to sell certificates owned by the Brewery Corporation. The stock value token will be moved one space to the left for each 10% share sold. In this case more than 50% of corporations' shares may be placed into the Bank Pool exceptionally. However the Director may not sell more certificates than necessary for the purchase.
- c) Then the Director has to spend her/his private cash
- d) At least the Director has to sell her/his own certificates of the active Brewery Corporation but may not sell the Director certificate nor may a change of Director may be triggered. As for b) the 50% share limit for the Bank Pool is suspended.

If the corporation has still not enough money the Bank will give a credit for the shortfall. The credit has to be written down and the double amount will be subtracted from the player's final scoring at game end.

Commentary: Consequently a player may never go bankrupt!

5.6.2.4 Brewery Order for the next Brewery Round

After all breweries have finished their turn in the current Brewery Round the order for the next one will be determined.

The BECs of each brewery are sorted in descending order of their type, highest first. The new brewery order is based on the first BEC of each brewery. Any draws will be resolved by comparing the second BEC. If there is still a tie the previous order of the tied breweries remains.

Place the brewery order tokens in descending order, highest value first, onto the field "Breweries' Order" of the Beer Market.

5.6.2.5 Preparation of the Beer Market for the next Brewery Round

In this „clearing phase“ at the end of every Brewery Round the demand for each segment of the Beer Market will be newly established. The procedure is as follows:

1. All beer cubes still on the yellow and orange demand fields are moved to the field „Stock“
2. All beer cubes on the supply fields of regular customers are moved to the demand fields of regular customers within the same market segment.
3. All beer cubes on the supply fields of new customers are moved to the demand fields of regular customers within the same market segment.
4. If there is now a market segment with no beer cubes in the regular customers' demand field, below the lowest segment containing beer cubes, place a white "No Demand" marker onto the figure of that new customers' demand field (see example 1 below).
5. Now the empty demand fields of new customers without a "No Demand" marker will be filled with beer cubes according to the number printed in each demand field. The placement of beer cubes started with the highest market segment. The beer cubes are taken from the field "Stock". When there is no beer cube left in the field "Stock",

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use beer cubes from the demand field of the lowest segment, but never take beer cubes from the same segment (see example 2 below)

Example 1: At the end of step 3 there are beer cubes in the regular customers' demand fields of segment 3 and 4. In the new customers' demand field of segment 1 there is already a "No Demand" marker from a previous Brewery Round. As there is no beer cube in the demand field of segment 2 as well, place a "No Demand" marker in the new customers' demand field of this segment.

Example 2: The highest new customers' demand field without a "No Demand" marker is for segment 5. The first new customers' demand field to filled with beer cubes from stock is that of segment 5 (four beer cubes) followed by that of segment 4 (three beer cubes). Assuming that there is only one beer cube left in stock, take the two other beer cubes from the demand field of segment 3. No beer cubes are placed in the new customers' demand field of segment 3 as they can only be taken from the same segment!

After the purchase of the first type 8 Capex card the six beer cubes in the price field for the Export-Market are moved into the filed „Stock“.

Commentary: At the end of the Beer Market preparation beer cubes are only in the demand fields, the "Stock" field and the price field of the Export Market (until the start of the gray phase.

6. End of the Game

When the last Operating Round is over all players compile their private property which consists of their private cash and the value of their certificates. If a player still owns a Minor Brewery only the printed value on the charter counts for this purpose.

The richest player will win 18DO-Dortmund.

7. Miscellaneous

Players must reveal their private capital and treasury of their companies on request.

Agreements between players must be made public. They may not result in payments of any kind between players or players and companies. The duration of an agreement may be defined; otherwise it will last for the rest of the game if it is not suspended by all involved players.

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8. 18DO-Dortmund – The Expert Game

18DO – The Expert Game adds new features to 18DO – Heat, Sweat & Beer which apply primarily to the Brewery Round. The following changes take place:

- Use the Minor Capital Expenditure Marker (MCM) as described in section 8.1
- Use the Special Even Marker (SEM) as described in section 10.3.x
- The Starting Round will be changed slightly
- During the Brewery Round the breweries may purchase one MCM and acquire one SEM.
- The breweries may deal with the MCMs
- The Railway Corporations may purchase one MCM type 4 (Beer Wagon) per Railway Round

8.1 Minor Capital Expenditures Marker (MCM)

The MCM represents minor investments made by breweries. The numbers of the MCM markers a brewery can purchase are limited to the boxes shown on the charters in the “Equipment/Ausstattung” section.

The MCM can be acquired during the “purchase BEC” step. A brewery may either buy a BEC or a MCM. During the yellow phase a brewery may buy one BEC and one MCM instead of two BECs.

MCM may be sold to other breweries during the buying brewery’s “purchase BEC” step in the Brewery Round. The price must be between 50% and 150% of the face value.

MCMs never become obsolete. A brewery which owns already its allotment of allowable number of MCMs may buy another one only when discarding one it has in possession. The discarded MCMs are placed back onto the display area of the Stock Market table.

There are three different types of MCMs: Pubs, Bottling lines and Beer Wagons. Corporations which are allowed to own two MCMs may possess MCMs of the same type.

8.1.1 Pubs

Pubs generate fix revenue for the owning breweries which is paid by the bank at the start of each Brewery Round into the breweries treasury. The amount is shown in the white circle of the MCMs.

MCM Code =>	A1	A2	A3	A4
Phase	yellow	green	brown	grey
Price	30 Mark	60 Mark	80 Mark	120 Mark
Revenue	5 Mark	10 Mark	20 Mark	40 Mark
# for 3 players	2	2	1	1
# for 4 players	2	2	1	1
# for 5 players	3	3	2	1

8.1.2 Bottling Lines

A bottling line is always aligned to one of a brewery’s BECs. The revenue stated below will be multiplied by the number of beer cubes sold to the Dortmund Beer Market produced by the aligned BEC. Therefore a bottling line cannot be used for deliveries to the Export market! The revenue generated by bottling lines is part of the breweries’ revenue.

First bottling line becomes active during the green phase.

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MCM Code =>		B2	b3	B4
Phase	yellow	green	brown	grey
Price	-	50 Mark	100 Mark	120 Mark
Revenue	-	5 Mark	10 Mark	20 Mark
# for 3 players	-	2	1	1
# for 4 players	-	2	1	1
# for 5 players	-	3	2	1

8.1.3 Beer Wagons

Beer Wagons were primarily owned by the breweries. The beer wagon shown on a BEC indicates that this BEC includes not only brewing equipment but also beer wagons. The transport capacity of the beer wagons of a BEC is indicated by the yellow-blue squares in the bottom right corner.

The MCM with a beer wagon represent additional transport capacity only. The owning brewery may use the Beer Wagon MCM to transport (and sell) the capacity of a yellow square to an Export destination.

Commentary: With a beer wagon MCM a brewery may sell a yellow square of a type 3 or 4 BEC to the Export market although these BECs do not show a yellow-blue square.

A Beer Wagon MCM may even being purchased by a Railway Corporation during its “purchase train” step of the Railway Round. The Railway may buy a Beer Wagon MCM either from the bank or from a brewery. It is also possible that a brewery purchased a Beer Wagon MCM from a Railway Corporation.

Commentary: This is the only possibility in the game that money can be transferred between railways and breweries.

MCM Code =>			C	
Phase	yellow	green	brown	grey
Price	-	-	100 Mark	
Revenue	-	-	variable	
# for 3 players	-	-	2	
# for 4 players	-	-	3	
# for 5 players	-	-	3	

8.2 Special Events Marker (SEM)

As the name already foretells a SEM represents an event. The following rules apply to the SEMs:

- A brewery may acquire one SEM per turn after the “purchase BAC” step for free.
- The SEM is placed onto the head section of the brewery’s charter.
- A brewery may not hold more than one SEM at the same time.
- A brewery which owns already a SEM can only acquire a new one when it discarded the one it owns onto the display area.
- A brewery is not obliged to use a SEM it owns.
- A SEM can be used once after which it was be placed back onto the display area.

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- A brewery which has used a SEM may not acquire the same SEM again in the same turn.

Commentary: In order to avoid this used SEM should be placed back into the Bank Pool. After the brewery has finished its turn that SEM is moved back onto the display area. .

There is only one SEM for each event. The following SEMs are available:

SEM Code	Event	Effect	Available Phase	Restrictions
G	Fair	Revenue 10 Mark	yellow	Into treasury
H	Advertising	Deliver one beer cube at the start of a Brewery Round ¹⁾	yellow	Not to Export market
I	BA deal in	When purchasing a new BAC the director may deal in one of the brewery's BACs. ²⁾	yellow	The dealt in BAC may not be used for delivery in the same turn ²⁾
J	BA upgrading	A brewery may replace a BAC which has been used during the same Brewery Round by purchasing a new one. ³⁾	yellow	
K	Premium Beer	Achieve price for the next higher section with demand. ⁴⁾	yellow	For one beer cube only
L	Marketing	Move one place ahead after the new brewery order has been established	green	Can only be used at the end of a Brewery Round
M	Investor	The Director may sell 1 or 2 certificates of the owning brewery without reducing the stock market value.	green	Applies to the Brewery Round only.
N	Tool Production	The brewery receives ½ price for 1 or 2 production units not used for delivery to the beer market	green	Not for Export market: No beer cubes are moved
O	Second shift	The brewery produces one additional beer cube with one of its BACs and delivers it for ½ price ⁵⁾	green	Beer cube is taken from the stock and placed into the corresponding delivery field
P	Transport Contract	Brewery may place beer cubes for Export market delivery onto a train card w/o permission of the railway's director	brown	For one railway only

Commentaries:

- 1) One beer cube is taken from the corresponding demand field and placed onto the BAC in order to indicate that one of the BAC's capacity has already be used.

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- 2) Effect: The price for the new BAC will be reduced by the dealt in BAC's type number multiplied by 20 Mark. Restrictions: In order to avoid any confusion the director should turn the BAC which is designated for deal in by 90 degrees.
- 3) This SEM is only useful if the owning brewery possesses already BAC up to the limit.
- 4) This cannot be used for a section which still has the "No demand" marker in the demand field for new customers.
- 5) With this SEM it is possible to use a BAC for which no beer cube in the demand fields has been left. If there are no beer cubes in stock take it from the demand field with the lowest price.

8.3 Game Preparations

There are two additional actions for game preparations:

- a) Place the MCMs in the appropriate box of the Stock Market table
- b) Place the SEMs in the corresponding box of the Stock Market table.

8.4 Starting Round Changes

The Starting Round is performed as described in section 7.3. Before the game commences with the First Stock Round each player may acquire a MCM for her/his Minor Brewery with the private cash. Beginning with the owner of the Minor Brewery with the lowest number and then in ascending order of the Minor Breweries' numbers. Thereafter the First Stock Round starts.

8.5 Brewery Round

During its turn of the Brewery Phase each brewery performs now the below stated activities exactly in this order:

- Disposal of brewery equipment (see 7.8.2)
- Deliveries to the Beer Market (see 7.8.3)
- Calculation of the income and pay-out by the bank (see 7.8.4)
- Purchase of new Brewery Equipment (see 7.8.5) or purchasing a MCM
- Acquiring one SEM
- Once during its turn a Brewery Corporation may deal with its own certificates. It may
 - Either sells one certificate from the Initial Offering into the Bank Pool; the stock value token is moved one space to the left.
 - Or buys one of its certificates from the Bank Pool. The certificate will be placed in the box appropriate box on the certificate.

The certificate deal may take place any time during the brewery's turn.

8.6 Railway Round Changes

During the "train purchase" step a Railway Corporation may purchase a type C "Beer Wagon" MCM instead of buying a train. The Railway Corporation may purchase the Beer Wagon

- a) From the Stock Market table at face value
- b) From a brewery for a price between 50 Mark and 150 Mark

The purchase from another Railway Corporation is not possible.

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9. Definitions

BE	Brewery Equipment
BE capacity	Number of blue cubes in the lower right corner of a BE card. A brewery supplies one beer cube for each square.
BE card	Capex card owned by a brewery
BE limit	Maximum of Capex card a brewery may own in a certain game phase..
Beer cubes	Blue wooden cubes which are used to indicate both, the demand of beer of the market segments and the supply to the Beer Markets.
Blocked Hex	All station placed in this hex are occupied by stations markers of other Railway Corporations.
Brewery Round	Section of the Operating Round where the breweries are active.
Brewery order token	They are used to document the order in which the Breweries are operating during the brewery Round.
City Dortmund	Hex where the breweries are located.
Demand fields	Fields of the Beer Market. The number of beer cubes on these fields indicating the demand of beer for each market segment. At the end of the every Brewery Round the demand fields will be refilled.
EBCs	Export beer cubes =>beer cubes which are placed onto train cards
Export Market	The Export Market has an unlimited demand. Deliveries can begin in the brown phase by using the Railway Corporations for transport.
Freight yards	Three grey hexes with three station places and the code „Gbf“. This hexes count against a train's route length capacity. Increased income for Railway Corporations which have a station token there.
Hex	Description of a part of the map grid, either empty or with a tile placed on it.
Location Tokens	These are red with an „S“ for steel mills and black with a „K“ for coal mines. They are placed onto the locations of coal mines/steel mills when a railway link has been established to that location.
Locations of coal mines/steel mills	They are marked on the map and the tiles with a „K“ for coal mines and an „S“ for steel mills.
Market segment	Part of the Beer Market. The different types are identical with the game phases and reflecting the development of the Beer Market.
New customers	Part of the Beer Market which represents customer not yet regular customers. After the first supply they will become regular customers. Income for deliveries to these customers is lower as it always takes some efforts/costs to make them regular customers.
Off-board destinations	Red fields at the order of the map
Operating Round	Consists of one Railway Round and one Brewery Round.
Railway link	Connection of coal mine/steel mill location to the railway net
Railway Round	Section of the Operating Round where the Railway Corporations are active.
Regular customers	Part of the Beer Market which represents customer preferring the consumption of beer from the breweries active in the game.
Segment	See market segment
Station token	Stations build by Railway Corporations
Station place	Large white circle where a station token may be placed
Stock Round	Here the players act as investors and deal with certificates.
Supply field	Fields on the Beer Market tableau onto which beer cubes being moved from the demand fields when a brewery delivers beer.
Trains	Capex cards which show a train after purchased from the bank.

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