



A GAME BY IVAN LASHIN AND ANDREY KOLUPAEV

FURNACE

GAME RULES

GAME OVERVIEW

In this 2-player follow-up to the popular *Furnace* board game you retake the roles of international capitalists in the late 19th and the first half of the 20th century. Travel around the world, purchase valuable assets and build profitable railways to outwit your opponent anywhere from New England to Australia and build a truly global industrial empire!

The game is played over 4 rounds and each round has 2 phases: Auction and Production. During the Auction Phase, the players bid on companies. The one with the highest bid receives the company, while the lower bid receives compensation in the form of building railways (which sometimes can be even more profitable). During the Production Phase, the players operate their companies in order to gain, process, or sell resources. Each player should optimize both their production chain and railway network to find the most effective way to gain money, as the wealthiest player wins the game.

Furnace Duel is playable both in standalone and campaign modes, in which you compete for global industrial domination in a series of games played on six different boards.



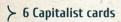


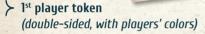


> 25 double-sided Company cards (including 4 Shipping Company cards)



→ 4 single-sided Start-up cards





> 2 Players' Color tokens



> 3 double-sided boards











> 2 sets of the Capital discs in players' colors Each set contains 4 discs of one color with the values "1", "2", "3", and "4".

> 32 wooden trains (16 of each color)



> 39 Coal tokens $(32 \times 1 \text{ Coal and } 7 \times 2 \text{ Coal})$





> 20 Tech tokens



Board-specific components:







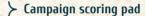
6 Research cards



15 Ferry tokens

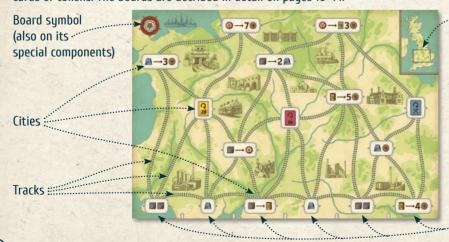


5 Campaign tokens



Board Anatomy

Each board is a map of a different area of the world with Cities and tracks linking them. When you are instructed to claim a route, you place your Train along a vacant track between two Cities and then you can use the effects of those Cities. Reference cards summarize special rules for each board. Some boards use special cards or tokens. The boards are decribed in detail on pages 10–14.

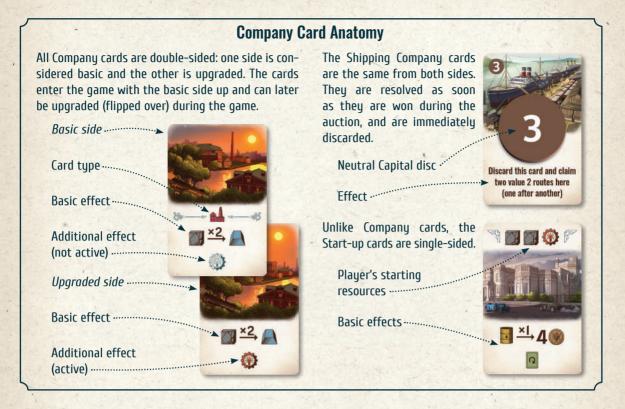


Minimap showing the region's location on a smaller scale.

The cards for the auction are placed below the six Cities at the bottom edge of the map.







IF YOU HAVE ALREADY PLAYED FURNACE

The core gameplay in *Furnace Duel* is the same as in the base *Furnace* game. You bid for Company cards, get them or receive compensation, then use your cards and manage resources in order to gain the most money by the end of the 4th round. Below you will find a short description of all gameplay changes, and you will be able to learn them in detail in the corresponding sections on the following pages.

There's no compensation effect on top of the Company cards. You receive compensation by claiming routes on the game board. The value of your disc shows how many times you may use the effects of connected Cities (in any order or combination). At the beginning of the game, the only available tracks are the ones leading from the City corresponding to the card in question, but as your network grows, you gain access to new tracks and more lucrative Cities (see pages 4 and 6).

Your Start-up card has a single free Upgrade effect. To upgrade more cards, you can use the City effects, but most of them upgrade only cards of a certain type. There are three card types in the game: blue, red and yellow (see above and page 4).

The **Shipping Companies** are one-shot cards with a neutral brown disc printed on them. The disc is considered a bid of a neutral player, and sometimes it helps you to get compensation (and claim a route). If you win

a Shipping Company its effect is resolved immediately and then it is discarded (see above and page 6).

Capitalist cards are used in the Auction Phase. To use your Capitalist's ability, you must choose one of the cards in the auction row with your color token (in a same way as you bid with your Capital discs). The Capitalist's ability works only on the chosen card (see pages 8 and 9).

There are **Tech tokens** instead of the Upgrade tokens. Tech tokens are mostly used in the Cities' effects. Also, remaining Tech tokens are worth extra money at the end of the game (see page 7).

Each game board has a set of special rules described both on its Reference card and in this rulebook. Some boards have extra components. You may choose any board if you play a single game, and you will play through all six boards in the Campaign mode (see pages 8 and 10–14).

In the Campaign mode, you accumulate Campaign points awarded for winning a game and for fulfilling Achievements, both general and board-specific. The runner-up gets a board-specific bonus that gives them a bit of the upper hand in the following games (see page 8).

Orange and purple player pieces from *Furnace Duel* may be used in usual *Furnace* games (note that they don't expand the number of the players, only give them more choice of color).





EFFECTS

During the game, the players will gain resources and use them to obtain other resources and money by resolving the effects of their Companies and Cities they connect. There are 2 types of effects: extraction and processing. All effects are optional. Each effect is shown within its own line.

Extraction — the line states the number and the type of resources (or effect) the owner of the card gains. You may refuse to extract resources or extract them partially, though in most cases it doesn't make sence.







Processing — if there is an arrow within a line, the player may choose to discard the resources listed to the left of it in order to gain the resources (or effect) listed to the right. The number above the arrow indicates the limit of such transactions in each Production Phase. The player may resolve their processing effect fewer times than listed above the arrow. In order to resolve an effect, the player must have the required resources (listed to the left of the arrow) before resolving it.



Also, on Company cards there are basic and additional effects. A basic effect is resolved by the owner of the card during the Production Phase. An additional effect is also resolved during the Production Phase, but only if the owner upgraded it (flipped it over).

Upgrading can be found on Start-ups, some Cities and tokens. When you are allowed to upgrade (for free or by spending resources) you may flip over one of your Company cards. You cannot upgrade Start-ups, Shipping Companies and already upgraded cards.











Upgrade any Company

Upgrade a Company of a certain type

In the **Auction Phase**, cards may be upgraded using Cities' effects. Using such an effect, you may upgrade even a card that you have just taken from the auction, but you can not save this effect and use it later to upgrade a card you'd get later during the same auction.

In each Production Phase, you may upgrade one card using the effect of your Start-up. If you resolve a basic effect of a Company card and then upgrade it during the same Production Phase, you can't go back to its additional effect, even though it is available now. However, if you upgrade it before using, you may resolve both of its effects.

CLAIMING ROUTES

At some points of the game you will be allowed to claim a route. Usually you claim a route when you get compensated for your non-winning bid. Each route has a certain value that depends on how you've got the right to claim it. If it is a compensation, the value of the route is equal to the value of your Capital disc. In other cases, the value of the route is set by the effect or ability.

To claim a route, place your Train along a vacant track between two Cities. Resolve these Cities' effects as many times in total as the value of the route, in any order or combination.



Example: Ivan claims a value 3 route. He can gain 6 (three times), or process to to token three times, or gain) and process twice, or gain 4 and process once.

Important: You can only use the effects of the Cities directly adjacent to your just-claimed route.

Before claiming a route, you need to find out where you can do it.

- ├─ If you claim a route here, you must choose a vacant track leading from the City where you have got the right to claim a route (as a compensation, by Shipping Company effect or Capitalist's ability), or a vacant track connected to that City by your already claimed routes.
- If you claim a route *anywhere*, you do so along any vacant track on board, provided that additional conditions are met.

You may refuse to claim a route if you don't want or you cannot do so. Some boards have additional conditions for claiming routes along certain tracks.





SETUP

- Choose a game board and place it in the middle of the table.
- Prepare all the components for the chosen board and resolve additional setup if needed.
- 3. Place Coal, Iron and Oil pieces, Money and Tech tokens next to the board.
- Each player takes all components of their chosen color: Capital discs, wooden Trains and the Player's Color token.

- 5. Toss the round 1st player token. The player whose color is on top takes this token and is to act first in the first round of the game.
- 6. Each player takes one random Start-up card and places it face up in front of them. Return the unused cards to the game box. Note: See Variant Rules on page 8 if you want to play with Capitalist cards.
- Each player recieves their starting resources shown at the top of their Start-up card.
- 8. Place the 25-card Company deck (including four Shipping Companies) next to the game board.

Setup Example



This setup features the Britain board recommended for beginners. There are no additional setup instructions for this board, so only the Reference card is placed at the upper right corner. The six Company cards for the first Auction Phase are already placed (see the next page for explanations).





GAME ROUND

Auction Phase

The first player takes the deck, shuffles it and then places six cards along the bottom edge of the board with the basic side up (form left to right, each card to a different City). These cards will be offered to the players at the auction.

Starting from the first player, both players take turns bidding on the cards with their Capital discs. During their turn, a player must place one of their discs on any available Company card, following two rules:

- There can't be 2 discs belonging to the same player on one card:
- There can't be 2 discs with the same value on one card. Note: If a Company card has a picture of a disc, treat is as a neutral disc already placed on that card.

After both players have placed all their discs, proceed with resolving the results of the auction.

The cards in the auction row are resolved one by one in order from left to right. If your disc is *not the highest bid* on the card, you get compensated. If your disc is *the highest bid* on the card, you win this card.

- If you win a non-Shipping Company, place it in front of you with the basic side up. From now, it is your Company and you will be able to use it in the Production Phase (from current round).
- ├ If you win a Shipping Company, immediately resolve
 its effect and discard it.
- When you get compensated for a card, you must claim a route here with the value equal to your Capital disc on the card. Remember that this route should be connected with the city corresponding to this card by your already claimed routes.
- ├ The discs on a card are resolved in ascending order. If both players get compensated for a card (it is possible if they both couldn't outbid the neutral disc on the Shipping Company card), the player whose disc's value is lower gets compensated first.

Important: It's crucial to resolve the cards in the auction row one by one in order from left to right as you may gain resources by one City effect and then spend those resources by another City effect. In order to do this, you gain the resources before spending them.

When all cards from the auction row are resolved, the players discard all remaining cards from the row, take their discs back and proceed with the Production Phase.



- 1. Ivan gets compensated for the leftmost card, and he chooses a track connecting this City with the City to the right. He places his Train on the track. He has a value 2 disc on the leftmost card, so the value of the route is 2. He can distribute this value as he wishes between these two Cities. He chooses to gain from the leftmost city and from the right one. Andrey takes the card.
- The next card has a neutral value 4 disc. Ivan has a value 1 disc on it, while Andrey has his 2. They both get compensated but Ivan goes first. As this

City is already connected with the leftmost one, Ivan continues his already-claimed route and chooses the track between the leftmost City (A) and the City above it (exchange To C). He resolves the latter effect once, spending one of his just-gained That and gaining To instead.

3. Andrey has no routes leading from that City, so he has to start a new one from it. He chooses the track between this City and the City allowing to upgrade a blue card. He gains from the first City and upgrades his just-won card.





Production Phase

During this phase both players resolve their Company cards (including their Start-up card) which allows them to gain and/or process resources. In order to save time, players may resolve the cards simultaneously since there is no interaction between the players in this phase.

The Company cards (including the Start-up card) must be resolved one by one. Each card can only be activated once per Production Phase. The cards can be activated in any order, but once you start resolving the next card, you can't get back to the previous ones, even if their effects weren't resolved completely. When a card is resolved, slide it up a little bit (or rotate it 90 degrees) to show that it can't be resolved again during this phase.

Hint: At the beginning of the Production Phase, you may line up your cards in the order you wish to resolve them.

If a card is placed with its basic side up (the same way it was placed during the auction), you may resolve its basic effect only (the one with the fully colored symbols). Transparent symbols show the additional effect that will become available once the card is upgraded, but it can't be resolved while the card is placed with its basic side up.

If a card is placed with its upgraded side up, you resolve both the basic and the additional effects of the card since they are both fully colored. In this case, the effects are resolved from top to bottom.

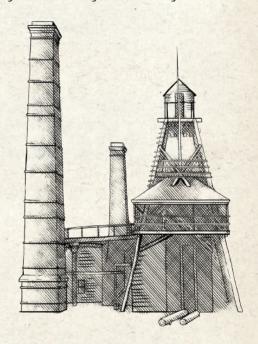
Important: No effect can be "inserted" between the two effects of one card. You must first resolve all effects from one card before proceeding with another.

Round End

When both players are done with the Production Phase, the round is over. If it was the 4th round (only one Company card left in the deck), the players proceed with scoring. Otherwise, the 1st player token is flipped and given to the other player, and a new round begins.

GAME END

Each player totals up their cash, board-specific bonuses and money for leftover Tech tokens (each is worth 2). Whoever has the most Money wins. In case of a tie the player with the most Company cards wins. If there is still a tie, the player with the most total resources () wins. In case of an absolute tie, the player who currently has the 1st Player token wins.



Production Phase Example



1. Using his leftmost Company, Andrey processes into twice. Then he sells one of this Iron using his Start-up and upgrades the Company to the left of it.



After that, he converts the remaining into and 2 and also gains. He cannot process this using his leftmost Company because he has already used it in this phase.





VARIANT RULES

Upon discretion of both players, you may use any of the following variants of the game. You may combine them freely to find the level of difficulty and variety suitable for you.

Trackage Lease

When claiming a route, you may connect through your opponent's Trains as well as yours. To do so, you must pay your opponent for or for each their Train you use.

Production Chain

In this variant, during the Production Phase you use your Companies in a strict order. The rules are modified as follows:

- All your Company cards (including your Start-up) must form a horizontal Chain.
- After each Auction Phase you must assign places for the newly received cards in your Chain by placing them either on the left of it, on its right, or somewhere in between.
- The relative order of the cards in the Chain must stay the same.
- In the Production Phase, the cards in your Chain are resolved one by one, in order from left to right.

Capitalist Cards

The Capitalist cards give players unique abilities that are used in the Auction Phase.

During setup, instead of giving each player a random Start-up card, make three face-up pairs of random Capitalist and Start-up cards. The last player chooses their pair of Capitalist and Start-up first, then the first player does the same. The unused pair of cards is discarded. **Note:** You may also deal both Capitalist and Start-up cards randomly.

During the Auction Phase, in addition to placing four Capital discs, each player must place their Color token to choose the card where their Capitalist's ability is used. On your turn, you can place your Color token pointing at a card where you already have a disc (both players may choose the same card for their tokens). Therefore, each player has five turns during the Auction: four with their discs and one with their Color token (in any order). At the end of the Auction Phase take your Color token back.

Each Capitalist card specifies how and when in the Auction Phase its ability is used. The Capitalists' abilities are fully described on the next page.

CAMPAIGN MODE

The Campaign lasts six games, and each game takes place a different board. The first game mist be played on the Britain board . The winner of the current game chooses the board for the next game.

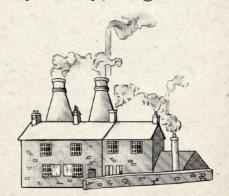
If you play using Capitalist cards, after the first game of the campaign the runner-up of the previous game chooses their pair of Capitalist and Start-up cards first. The first player is determined randomly, as usual.

After each game except the last one the winner gains Campaign Points and the runner-up gains a specific bonus that remains in effect until the end of the Campaign. The Campaign Points and the runner-up bonus are indicated both in the board description in this rule-book and on its Reference card. The players also gain Campaign Points for Achievements, both general and board-specific. Write down your Campaign Points in the Campaign scoring sheet. At the end of the last game each player writes down their final score instead of Campaign Points, totals up their column and the winner is determined. In case of a tie, the player who has more Campaign Points wins.

Achievements

The board description includes its specific Achievement and how many Campaign Points it is worth. There are also General Achievements that can be fulfilled in any game of the Campaign. Each player can gain Campaign Points for each General Achievement only once during Campaign. Each General Achievement is worth 5 Campaign Points. The General Achievements are:

- → Have a continuous chain of 8 or more claimed routes of your color on the board.
- Upgrade three or more Company cards at once using a City effect(s) on the board.
- \rightarrow Have 20 or more leftover resources at the end of the game ($\boxed{1} + \boxed{1} + \boxed{1} + \boxed{1}$).
- Win a game with a gap of 30 or more.







CAPITALIST CARDS

In the Auction Phase, when resolving a card chosen with your color token, you use the ability of your Capitalist card. *This card* in the ability text means the card which your color token is pointed at.



- If you don't win this card the Capitalist's ability is not resolved.
- If this card is a Shipping Company resolve its effect first, then the Capitalist's ability.



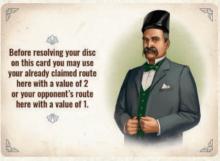
- You resolve the basic effect of this card immediately, before proceeding to the next card in the row.
- If this card is a Shipping Company the Capitalist's ability is not resolved (as you don't *get* the card).



- The Capitalist's ability is resolved immediately after you place your color token pointing at the card. You don't get anything when resolving the auction.
- You resolve the effect of the City at the bottom edge of the map corresponding to this card. You don't resolve any other Cities' effects even if those Cities are connected.



- If you win this card the Capitalist's ability is not resolved.
- If you claim a route because of the effect other than getting compensated (e.g. by a Shipping Company) this ability is not resolved.



- When you use an already claimed route you resolve the effects of the two connected Cities as if you have just claimed that route with a given value. You don't place any Trains.
- Remember that Capital discs on a card are resolved in ascending order.
- If you use the opponent's route it must be connected to the City corresponding to this card with your already claimed routes (or start from that City).



- The second part of the Capitalist's ability allows you to get compensated as if your disc is *not* the highest bid on this card. Because it is a compensation the first part of the ability still applies.
- ├ If this card is a Shipping Company you may either discard it for its own effect, or for the the second part of this Capitalist's ability, but not for both.





BOARDS DESCRIPTION

Britain

The Industrial Revolution starts here, and so does your game experience. There are no special rules for this board and it is recommended for beginners.



Additional Components

Reference card, Campaign token.





Campaign Mode

The first game of any Campaign is played on this board.

Special Achievement: None.

The winner gains 7 Campaign Points.

The runner-up takes the Campaign token. In each remaining game of the Campaign, after taking a Start-up card, they place this token on it and gain the starting resources shown on the token () () () instead of those shown on the card.

Alps

To drill through the greatest mountains of Europe, you need modern technology. As a reward for connecting cities of Northern Italy, Switzerland and Austria, local authorities give you access to money, resources and more.



Special Rules

Tunnels: To claim a route through a tunnel, you must spend . You cannot claim a tunnel route if you don't have . Right after claiming a tunnel route resolve the effect depicted inside the tunnel symbol (earn money, gain resources, upgrade a Company card).

Additional Components

Reference card, Campaign token.





.Tunnel track

Campaign Mode

Special Achievement: The first player to claim four tunnel routes gains 5 Campaign Points.

The winner gains 10 Campaign Points (except for the last game of the campaign).

The runner-up takes the Campaign token. In each remaining game of the Campaign, after the cards for the first Auction Phase are placed, the player claims a value 2 route starting from any City at the bottom edge of the map (they resolve the effects of the connected Cities, as usual).





Baltic Sea

Heavy marine traffic of the Western Baltic poses new challenges for transport companies. Use ferries to connect Cities of Northern Germany, Denmark and Southern Sweden across the Baltic Sea.



Additional Components

Reference card, 15 Ferry tokens (including 10 with 3 and 5 with 3).



Crossings (treated as tracks)

Special Rules

Setup: Shuffle the Ferry tokens face down (don't mind the **t** for now). Place one random Ferry token on each crossing: face up on the white ones and face down on the black ones. Place the remaining Ferry tokens face down in the reserve.

Ferries: Once you get a Ferry token place it face up in front of you. You may use its effect at any point of the game. Flip the token face down right after using it.

Crossings: To claim a route via a crossing, you must decrease its value by the number of on the Ferry token placed on this crossing. You cannot claim a route via a crossing if the decrease drops the value of your route below 0. Take the Ferry token from the crossing and place it face up in front of you.

Anchors: Right after you have claimed a route that gives you any number of , you may spend these to gain one Ferry token from the reserve. The price of the token is equal to the number of on it. Any unspent are immediately lost.

Game End: The player who has the most \updownarrow on their Ferry tokens (both face-up and face-down) gains 10 **3**0.

Campaign Mode

Special Achievement: The player who has three Ferry tokens with gains 5 Campaign Points.

The winner gains 10 Campaign Points (except for the last game of the campaign).

The runner-up chooses and keeps one of the Ferry tokens they have gained in this game. In each remaining game of the Campaign they may use it once at any point of the game. If the runner-up has no Ferry tokens the winner chooses one of theirs and gives it to the runner-up.

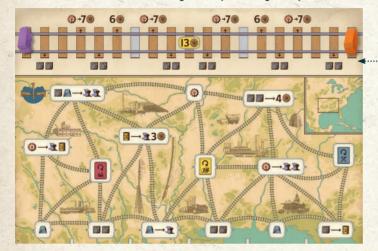
Example: Getting compensated for his "2", Andrey claims a route via crossing 1. The on the Ferry token decreases the route value by 1 but considering +2 from the Capitalist's ability the final value is 3. Andrey places his Train on the crossing and takes the Ferry token 2. In the City to the left, he converts into and also gains in the City to the right. Then he buys one Ferry token with from the reserve. Finally, he uses the first Ferry token to sell the just-gained for 6 and flips the Ferry token face down 3.





Transcontinental Railroad

Build a railroad between the Eastern an Western Coasts of North America. Both players gain resources and profit during the construction, and the one who drives the golden spike will get a special award.



Additional Components

Reference card, Campaign token.



···· Transcontinental Railroad

Special Rules

Setup: Each player places one of their Trains on the Transcontinental Railroad track at the top of the board. One player takes the rightmost space, while the other takes the leftmost one. These Trains serve only for tracking the construction progress.

Construction: *Right after* you have claimed a route that gives you any number of move your Train on the Transcontinental Railroad track the same number of spaces towards the opponent's Train. If you reach a position with an associated effect (or go past it), immediately resolve it if you can.

If the opponents' Trains are on adjacent spaces of the track, the Railroad is completed and the Trains don't move any more. After this happens you take 2 for each received instead of moving your Train.

Game End: If the Railroad is completed (i.e. the opponents' Trains are on adjacent spaces of the track), the player who has reached the central space gains 13 . This award is not an effect and it is gained only at the game end.

Campaign Mode

Special Achievement: The player whose Train has reached the silver space on the opponent's side of the Transcontinental Railroad track gains 5 Campaign Points.

The winner gains 10 Campaign Points (except for the last game of the campaign).

The runner-up takes the Campaign token. In each remaining game of the Campaign, each their leftover is worth 1 more at the game end (i.e. 3 instead of 2).

Example: Ivan wins a Shipping Company, immediately discards it and gains . The Capitalist's ability lets him claim a value I route after winning a card 1. Ivan claims a route and converts one of his just-gained into . Then he moves his Train to the next space of the Transcontinental Railroad 2 and resolves the effect of that space, selling his second for 7 . As the next space is already occupied by the opponent 3, Ivan gains 2 instead of moving his Train another time.







Victoria, Australia

The discovery of gold deposits in southeastern Australia led to an economic and industrial boom in the state of Victoria. Investments in railroads to the mines would pay off a hundredfold.



Special Rules

Gold Mines: Round Cities with golden background have no effects during the game but provide **30** at the game end.

Double Routes: When you gain \gtrsim you may immediately place one of your Trains next to any of your Trains on the board, on the same track. There may be no more than two Trains on a single track. This placing is not claiming a route and the effects of Cities are not resolved.

Game End: Each gold mine brings 10 to the player with most Trains on the tracks leading to that mine. Each mine is scored separately. These awards are not effects and are gained only at the game end.

Additional Components

Reference card, 2 Campaign tokens.





Gold Mines

Campaign Mode

Special Achievement: The first player to place four Trains using the ≥ effect gains 5 Campaign Points.

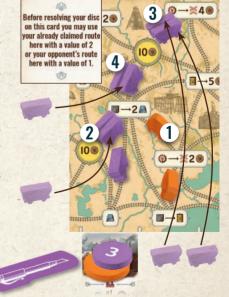
The winner gains 10 Campaign Points (except for the last game of the campaign).

The runner-up takes the Campaign token of their color. In each remaining game of the Campaign, after the cards for the first Auction Phase are placed, the player places this token next to any City without the symbol in its effect. Each time this (and only this) player resolves the effect of that Clty they gain additionally.

Example: Ivan is getting compensated for his "3" but he should use his Capitalist's ability first. Using his opponent's track 1 with a value of 1 he converts $\textcircled{\bullet}$ into $\textcircled{\times}$ and $2\textcircled{\bullet}$. The $\textcircled{\times}$ effect allows him to place another of his Trains on the track to the left 2 (without resolving the Cities' effects as this is not claiming a route).

After that, Ivan gets compensated and claims a value 3 route in the upper part of the board 3. He processes \bigcirc into \ge and 4 two times and places another of his Trains on the same track where he just claimed a route and also on the track below it 4. Ivan doesn't resolve the City's effect for the third time because all his routes leading to gold mines are already doubled, and there's no point in doubling other routes.









New England

This region of the United States is well-known for its many universities and research centers. Working with scientists and engineers may result in high profits.



Special Rules

Setup: Shuffle Research cards and place one face-up card above each of the three universities along the top edge of the map. Return the unused cards to the game box.

Universities: The effect of the university lets you spend to resolve the corresponding Research card. As with other City effects, you may use it several times as long as you have enough value of your route and Tech tokens.

Additional Components

Reference card, 6 Research cards.





University

Campaign Mode

Special Achievement: The first player to claim four routes leading to universities gains 5 Campaign Points.

The winner gains 10 Campaign Points (except for the last game of the campaign).

The runner-up chooses and keeps one of the Research cards used in this game. In any of the remaining games of the Campaign they may spend to resolve that card once at any point of the game (once per Campaign).



Example: Andrey claims a value 3 route between two universities 1 and may use the effects of corresponding Research cards up to three times (provided he has enough). To begin, he spends to exchange 3 and 2 for 5 in the City to the right 2. Then he spends another to sell 3 and in the City to the left 3 (he has no). Finally, for a third he exchanges 5 from his just-gained money for 5 in the City to the right 4.





CREDITS

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