



## Fit Prop & Spinner Assy.

**Reference:** Drawing C009013-1

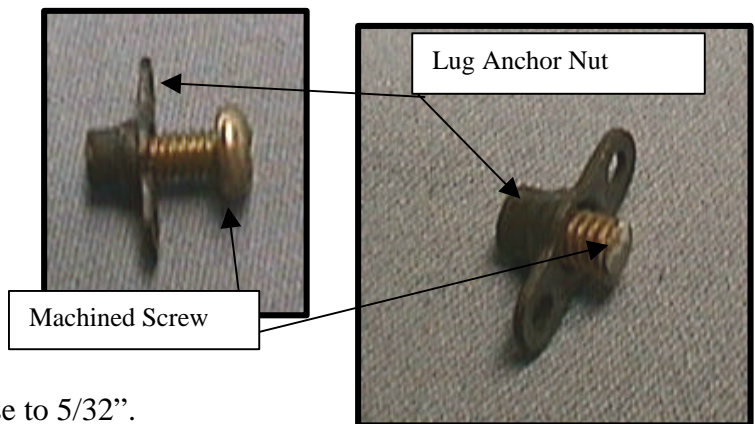
Photos

**Parts Required:** Spinner  
Spinner Backing plate  
Spinner Flange  
Lug Anchor Nut (Retained Nut)  
TAPK 3-3 Rivets

### **Material Required:**

### **Procedure:**

1. Make a drilling jig with a Lug Anchor Nut & Machined screw by inserting a screw into the retained nut & cut the head off. Refer Photo
2. Using the pre drilled pilot holes increase to 5/32".
3. Insert drilling jig into hole & drill the two 3/32" lug anchor holes into spinner flange.
4. Countersink 3/32" holes enough so that the rivet head is flush with the flange.
5. Drill out 5/32" hole to 11/64" or 3/16" so that you have clearance for you machined screw.
6. With the retained nut on the inside of the flange, rivet retained nut into position.
7. Repeat procedure for remaining 5 retained nuts.
8. Check to see if you have the best pre drilled hole alignment of the spinner flange holes & the Spinner. These holes should line up when assembling the prop, spinner flange & Spinner onto you engine.



Select the best alignment with the 6 holes. Mark the spinner & the prop flange with a black felt pen so you get the same position. (*You can track your spinner after assembling your spinner & Spinner flange on the engine.*)

9. Repeat procedures 2-8 for rear spinner flange.

10. Insert the prop guides into the prop flange.

11. Insert prop bolts from the

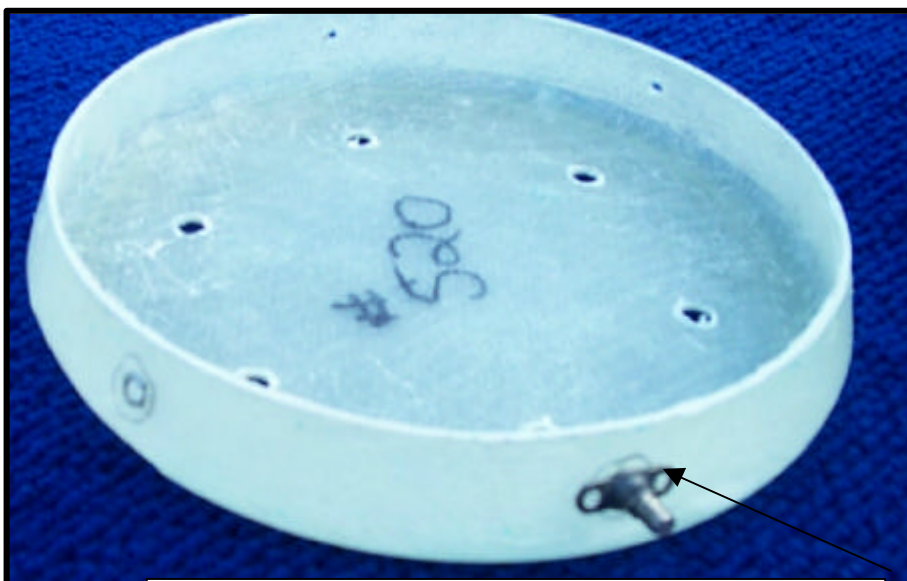
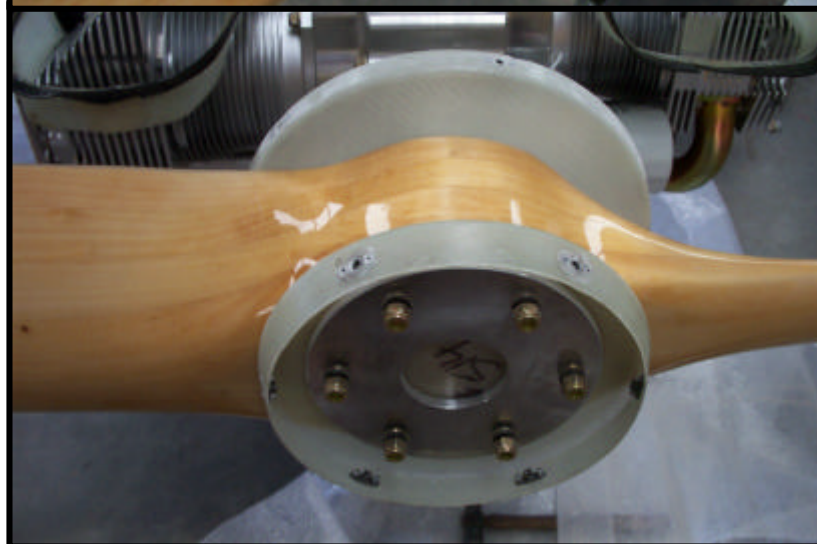


Photo of Spinner flange with drilling jig through 5/32" hole.

rear. See photo.



12. Attach spinner backing plate to Extension prop flange as per photo.



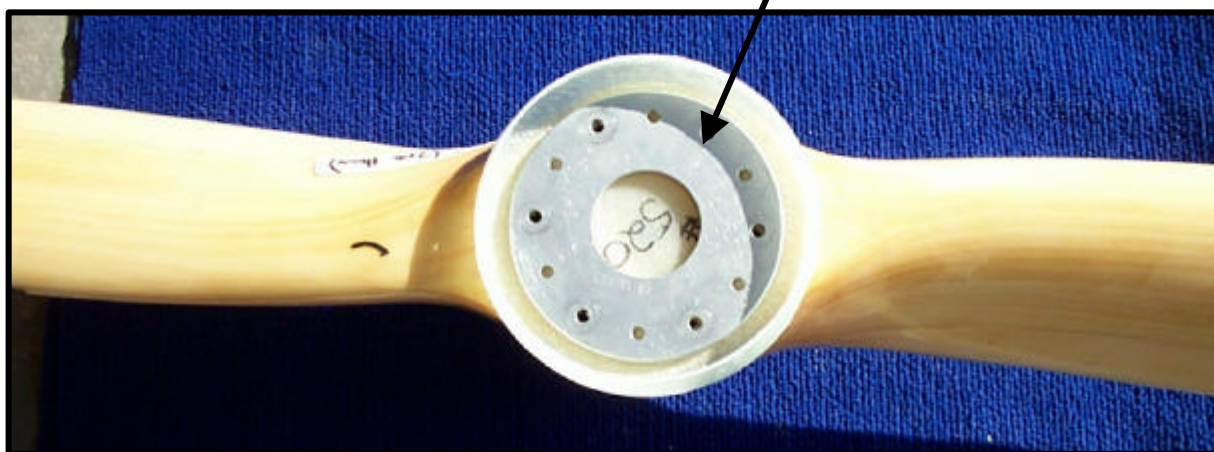
13. Attach your prop onto the flange, making sure the prop guides line up with the holes in the prop.

*Note: A little tip to ensure your prop will stop horizontal when the propeller stops. Looking at the engine from the front (Standing in front of the prop flange looking toward the flywheel, for pusher installations). Position the flywheel magnets so that they are vertical. Position prop so that it fits onto the closest prop guide when the prop is in the 11.00O'clock position.*

14. Attach prop flange onto prop lining up your marks.

Attach Aluminium prop flange backing plate. See photo\*

Attach Aluminum backing plate into spinner flange as per photo



15. Place a 1/4" washer then 2 x belleville washer toe tow to tow & finally a Nyloc nut.





16. Torque nuts to 8 foot pounds use a diagonal procedure. I.E. #1, #4, #2, #5, #3 & #6.

17. Track you prop from tip to tip  
Using a similar device to the  
photos below. Use the nose leg as  
your mounting point.

Check to see if you have the best pre drilled  
hole alignment of the spinner flange holes &  
the Spinner. These holes should line up when  
assembling the prop, spinner flange & Spinner  
onto you engine. Select the best alignment with  
the 6 holes. Mark the spinner & the prop flange  
so you get the same position.

