

Standard Hub with Support Plate

Assembly Instructions

Instructions for 2, 3 and 4 blade configurations

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Component Inventory

2ea – 1/4" Aluminum hub plates

6ea – Hub spacers

1ea – 1/8" Spacer support plate

1 set per bld – Clamping blocks

4 per bld – 1/4" clamping bolts

4 per bld – 1/4" nylock nuts

8 per bld – 1/4" washers

Bolt Torque Values

1/4" Clamping bolts 120in/lbs 10ft/lbs

5/16" or 8mm Mounting bolts 175in/lbs 15ft/lbs

****MOUNTING BOLTS AND FACEPLATE ARE NOT
AUTOMATICALLY INCLUDED AND MUST BE
ORDERED SEPARATELY**

***** ALL PROPELLERS MUST HAVE THE OUTER 1/4" FACEPLATE INSTALLED *****

Assembly:

- Put one 1/4" washer on each of the 1/4" clamping bolts and insert them into one of the aluminum hub plates. You will also want to insert the six mounting bolts into the faceplate, then into the aluminum hub plate. Place this hub plate upside down on a flat surface with the bolt threads pointing upward.
- Place one half of the clamping block on each set of clamping bolts with the beveled edge of the block toward the inside.
- Set the blade collars into the clamping blocks making sure the leading edges are all facing the same direction.
- Place the other half of the clamping blocks on the top of each blade.
- Install the six hub spacers over the mounting bolts
- Install the 1/8" spacer support plate.
- Install the remaining 1/4" aluminum hub plate making sure that the bolt pattern lines up.
- Install the remaining 1/4" washers and 1/4" nylock nuts on each of the clamping bolts.

Mounting your propeller:

- Mount the propeller to the engine flange using the six mounting bolts. Tighten the bolts only enough to keep the prop hub snug against the engine flange.
- Adjust the pitch following the protractor instructions on the opposite side of this page.
- Tighten the clamping bolts in 20in/lb increments. **DO NOT** tighten the bolts in one step. Tightening too much on one side can change the pitch. Torque in a criss-cross pattern.
- Re-torque the bolts after 1 hour, then every 5 to 10 hours.

