

Standard Hub with Support Plate Assembly Instructions for 2, 3 and 4 Blade Configurations

Component Inventory:

- 1/4" Aluminum Hub Plates, 2 each
- Hub Spacers, 6 each
- Stainless Steel Support Plate, 1 each
- Clamping Blocks, 1 pair per blade
- 1/4" Clamping Bolts, 4 per blade
- 1/4" Nylon Nuts, 4 per blade
- Washers, 8 per blade

Bolt Torque Values:

- 1/4" Clamping Bolts - 120 in-lbs
- 5/16" or 8mm Mounting Bolts - 175 in-lbs
- Washers, 8 per blade

NOTE: Mounting bolts and faceplate are not included and must be ordered separately.

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

Assembly:

1. Put one 1/4" washer on each of the 1/4" clamping bolts and insert them into one of the aluminum hub plates. Insert the six mounting bolts into the faceplate, then into the aluminum hub plate. Place the hub plate upside down on a flat surface with the bolt threads pointing upward.
2. Place one clamping block half on each set of clamping bolts with the beveled edge of the block toward the inside.
3. Set the blade collars into the clamping blocks making sure the leading edges are all facing the same direction.
4. Place the other clamping block half on top of each blade.
5. Install the six hub spacers over the mounting bolts.
6. Install the stainless steel support plate.
7. Install the remaining 1/4" washers and 1/4" nylock nuts on each of the clamping bolts.

Mounting:

1. 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.
2. Adjust the pitch following the protractor instructions.
3. Tighten the clamping bolts in 20 in/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.
4. Re-torque the bolts after 1 hour, then every 10 hours.

