

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

### Component Inventory:

- (2) Aluminum Hub Plates
- (6) Hub Spacers
- (1) Stainless Steel Support Plate
- (1 Pair per Blade) Clamping Blocks
- (4 per Blade) 1/4-in Clamping Bolts
- (4 per Blade) 1/4-in Nylon Nuts
- (8 per Blade) 1/4-in Washers

### Bolt Torque Values:

- 1/4-in Clamping-Bolts - 120 in-lbs
- 8mm Mounting-Bolts - 180 in-lbs

NOTE: Mounting-bolts and faceplate are not included.

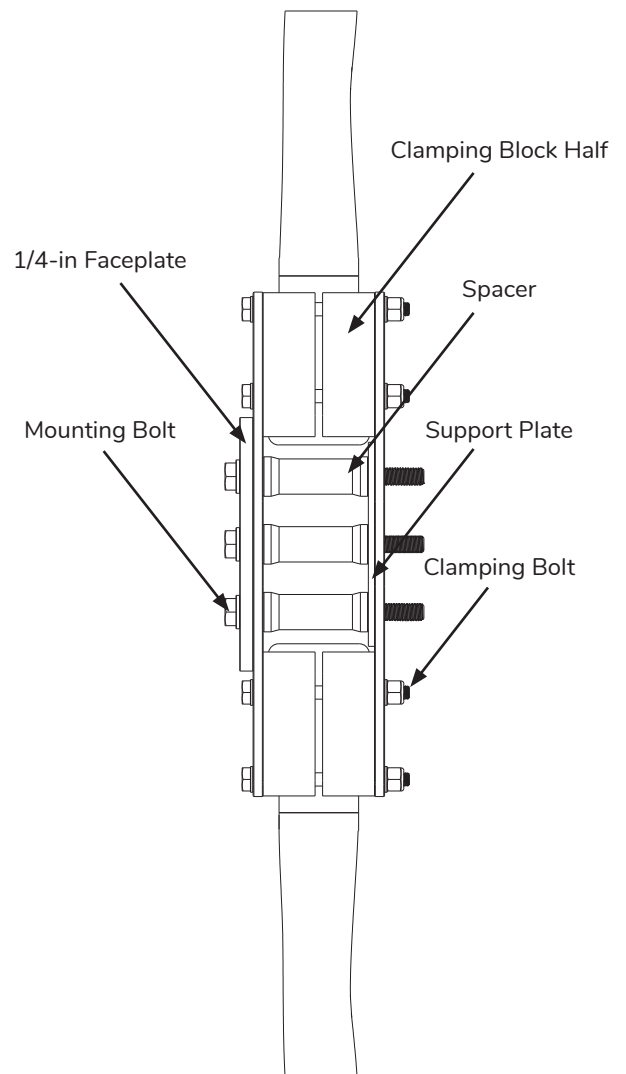
**1/4-in THICK FACEPLATE IS REQUIRED**

### Propeller Assembly:

1. Put one 1/4-in washer on each of the 1/4-in clamping-bolts.
2. Put one mounting-bolt washer on each mounting-bolt.
3. Insert the mounting-bolts and the clamping-bolts into one of the hub-plates.
4. Place the hub-plate and bolt assembly upside down on a flat surface with all bolt threads pointing upward.
5. Place one clamping-block-half on each set of clamping-bolts with the flat side downward.
6. Place a blade into each clamping-block.
7. Install the remaining clamping-block halves onto each blade.
8. Install the six hub-spacers over the mounting-bolts.
9. Install the stainless steel support plate onto the six mounting-bolts.
10. Place the remaining hub plate on top of the assembly.
11. Install the remaining 1/4-in washers and 1/4-in nylock nuts on each of the 1/4-in clamping-bolts.

### Propeller Mounting:

1. Mount the propeller to the engine flange using the six mounting-bolts. Tighten the bolts enough to keep the hub snug against the engine flange.
2. Adjust the pitch following the protractor instructions.
3. Tighten the clamping-bolts in 30 in/lb increments. DO NOT tighten the bolts in one step. Torque all bolts in a criss-cross pattern.
4. Re-torque the bolts after 1 hour, then every 10 hours.



# Standard Hub Assembly Instructions

