

HARTZELL PROPELLER, INC.  
PIQUA, OHIO

Amended Dec. 28, 1959  
December 18, 1959

BULLETIN NO. 71

"FAA APPROVED"

SUBJECT: Replacement of Guide Collars With New Forged Collars On Certain Non-Feathering Flange Mounted Propellers.

EFFECTIVITY: Guide Collars Installed On Propeller Models Listed Below:

Propeller Models	Guide Collar	Serial Numbers of Propellers Having Cast Collars Affected By This Bulletin. These Collars Should Be Replaced In These Propellers.	Serial Numbers of Propellers Having Cast Collars Which Were Physically Tested and Stamped with "P", also, Propellers Having Forged Collars Stamped with "F". These are <u>not</u> affected by this Bulletin.
HC-82XF-1D	834-4	All Numbers	
HC-82XF-1DB	834-4	All Numbers	
HC-82XG-1D	834-4	All Numbers	
HC-82XG-6DL	834-4	All Numbers	
HC-82XL-1D	834-4	All Numbers	
HC-A2XF-1	834-4		All Numbers
BHC-A2XF-1, and -1A	834-4		All Numbers
HC-92ZK-8D	834-8	100L - 491L	492L and up
HC-82XK-1D	834-9	100G - 846G	847G and up
BHC-92ZF-1D1	834-9		All Numbers
HC-92ZK-8L	834-9	All Numbers	
HC-A2XK-1	834-9		All Numbers

DISCUSSION:

The guide collar which supports the rear ends of the piston guide rods, have been made from a heat treated aluminum alloy casting until recently. A number of these have cracked or broken in service. A decision was made early in 1959 to make the parts from forgings, and also to physically test every casting until the forgings were available. The forgings are uniformly much stronger than the castings. In view of the uncertain strength of some of the earlier castings used, it is necessary to replace them with forged parts as soon as practicable; even though failure of the part may not be serious because it is well secured with dowel pins.

RECOMMENDED  
ACTION:

Replace the cast guide collar on these models affected by this bulletin with a forged collar as soon as convenient; but not later than the next overhaul or January 1, 1961, whichever occurs first. Until the forged collar is installed, frequent visual inspections of the part is recommended. This can be done without removing the spinner, by looking through the spinner blade cut-outs. The cast parts which have been physically tested need not be inspected or replaced. These collars are marked with the letter "P". Forged collars are marked with the letter "F".

INSTRUCTIONS:

It is necessary to remove the propeller from the aircraft and disassemble according to instructions given in appropriate overhaul manuals.

When the new collar is installed, it will be necessary to spot face the edge of the new guide collar thru the two dowel pin holes and reinstall the dowel pins, as shown on Page 3.

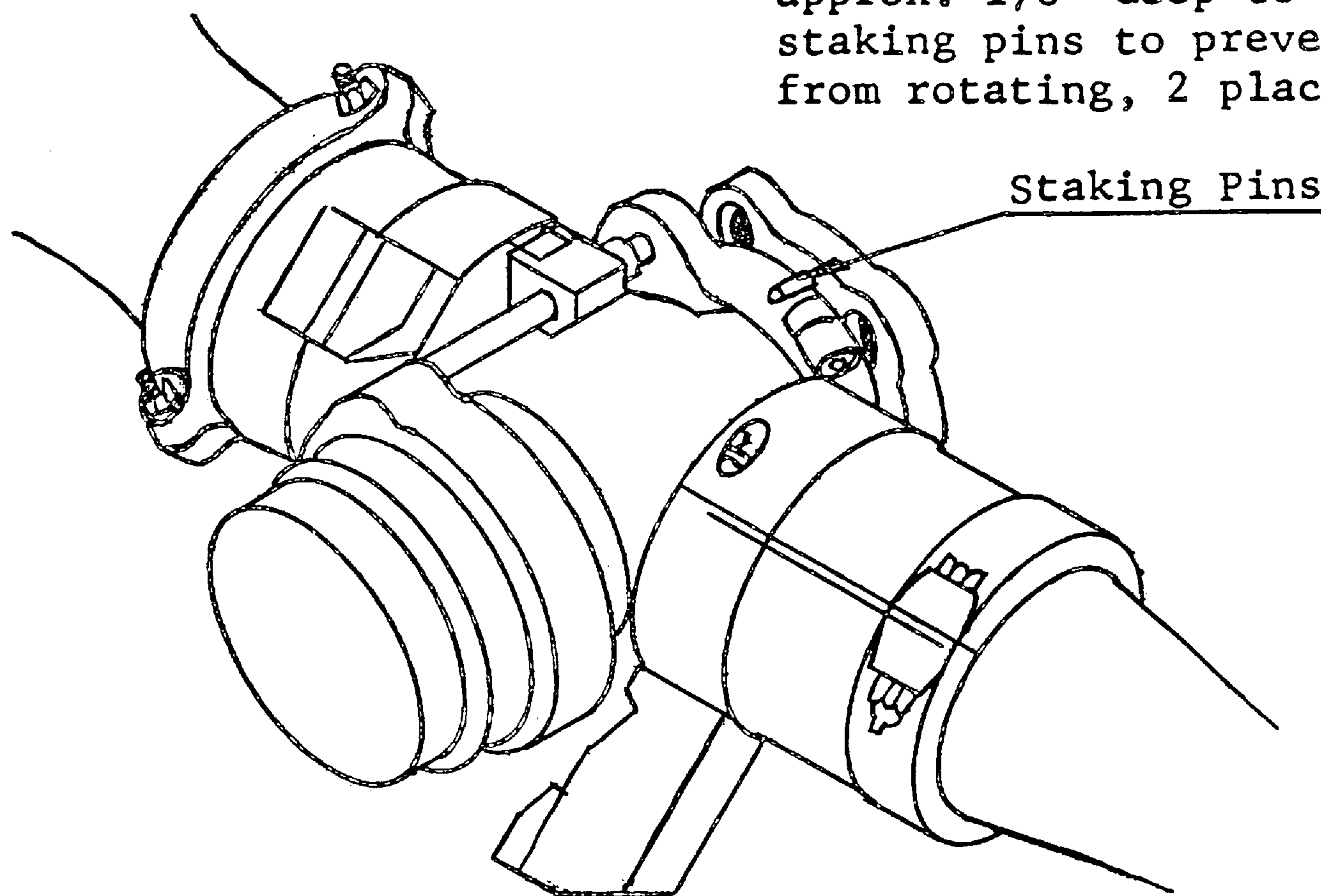
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After collar is properly located to receive piston guide rods, spot face edge of collar, approx. 1/8" deep to receive staking pins to prevent collar from rotating, 2 places.



Models

HC-82XG-1D  
HC-82XG-6DL  
HC-82XL-1D  
HC-92ZK-8D  
HC-82XK-1D  
HC-92ZK-8L

Models

HC-82XF-1D  
HC-82XF-1DB

First, install 4 spinner lugs, using new AN4H-4A bolts. After collar is properly located to receive piston guide rods, spot face edge of collar approximately 3/32" deep to receive staking pins to prevent collar from rotating, 2 places. CAUTION !!! - For Model HC-82XF-1DB, the two steel dowel pins inserted in both the engine and propeller flanges are located 60° from the aluminum staking pins shown. BE SURE TO REPLACE THESE PINS. For the other models, the dowel pins also serve as collar staking pins.

