

A116-52

STANDARD MANUFACTURING PROCEDURE - PROP INSTALLATION  
LYCOMING ENGINE

1. RECORD SERIAL NUMBER.
2. MAKE SURE THAT THE PROPELLER BEING USED IS RECOMMENDED BY THE ENGINE MANUFACTURER AND VICE-VERSA
3. INSTALL THE SPINNER BACK PLATE, ALIGN THE FLYWHEEL 25° MARK WITH THE SPLIT LINE ON THE TOP OF THE ENGINE CRANK CASE.
4. WITH THE CRANK SHAFT AT THIS POSITION INSTALL THE PROP AT THE 11:00 0'CLOCK POSITION.
5. INSTALL ALL PROP BOLTS AND TIGHTEN FINGER TIGHT.
6. TIGHTEN ALL BOLTS TO "SNUG" IN ALL ALTERNATING, OPPOSED SEQUENCE PATTERN, AS PER DRAWING 20-M-34.
7. TORQUE BOLTS AS SPECIFIED ON THE PROP LABEL.
8. SAFETY WIRE THE BOLTS AS PER DRAWING 20-M-34.

PROP. INSTALLED BY: \_\_\_\_\_ DATE: \_\_\_\_\_

INSPECTED BY: \_\_\_\_\_ DATE: \_\_\_\_\_

9. INSTALL PROP SPINNER

INSTALLED BY: \_\_\_\_\_ DATE: \_\_\_\_\_

INSPECTED BY: \_\_\_\_\_ DATE: \_\_\_\_\_