



Modification Bulletin

Aircraft Type
91B, 91B-2, 91C

Reference <u>Propeller, Hartzell HC with dural blade</u> Introduction of shoulders and chamfering of clamp hole.	Date Dec. 16, 1957	No 91.6/100
	Saab Service Dept. C Larsson	
	Saab Design. Dept. J Boklund	Page 1 of 2
Urgency III At propeller overhaul	Royal Swedish Board of Civil Aviation S Fogelström	
Marking -	Effect on weight distribution	
	Weight change lbs	Station In.
	-	-
		Moment change lbs.in.
		-

Time of delivery for necessary parts

-

K/K

Drawing not essential

Parts required per plane:

- 4 Shoulder Steel
 - Yield limit Min 100.000 psi
 - Ultimate strength 128.000-152.000 psi
 - Hardness H_v 280-330
- 4 Screw made of screws

Units concerned:

- Propeller SA 575198 } Hartzell HC
- Propeller 6100282 } 12x20-8C and -8D
- Clamp SA 576178

Support shoulders as per fig. 1 are to be introduced on clamp top half in order to reduce strain on clamp. Tightening torque for countersunk screws changed.

Work procedure:

Dismount clamps. Degrease clamp top halves and polish solder point. Heat top halves in oven to 175 - 200°C and place thin layer of tin on solder point and solder side of shoulder. Use acidless solder paste. Press on and solder shoulder as per fig. 2. Cool off top halves in air. Remove superfluous tin and wash off solder paste with alcohol. Cut out rubber packings SA 576169 (A-47-1) for soldered shoulders. Oil parting especially at solder point. Mill off material at holes for countersunk clamp screws as per fig. 2 and ream screw holes until surface is smooth. Coat top halves with acidiferous zinc after finishing. Finish screws SA 576160 (A-282) already available in a lathe as per fig. 3. Mount clamps and tighten countersunk screws with a tightening torque of 450 kpcm.

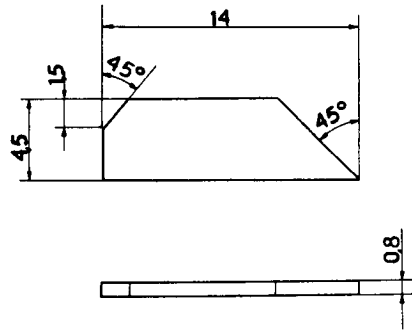


Fig 1

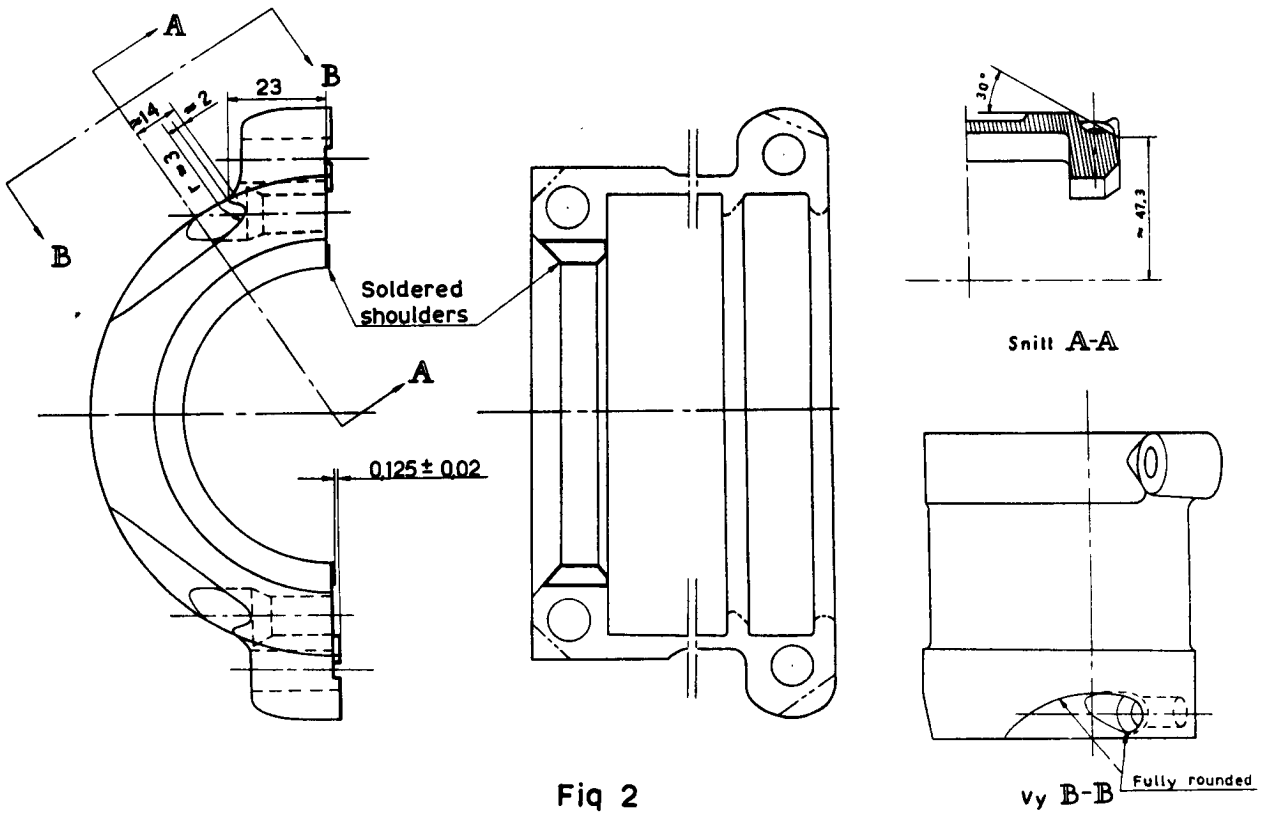


Fig 2

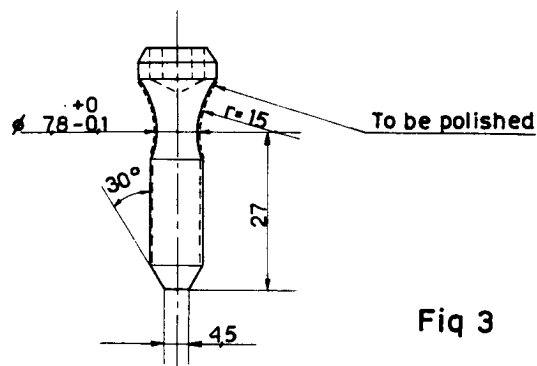


Fig 3