Chemin de la Madone
69210 LENTILLY - FRANCE
Tèl : 00-33-(0)4-74-72-12-69
Fax : 00-33-(0)4-74-72-10-01
Contact@duc-helices.com

NOTE OF ASSEMBLY

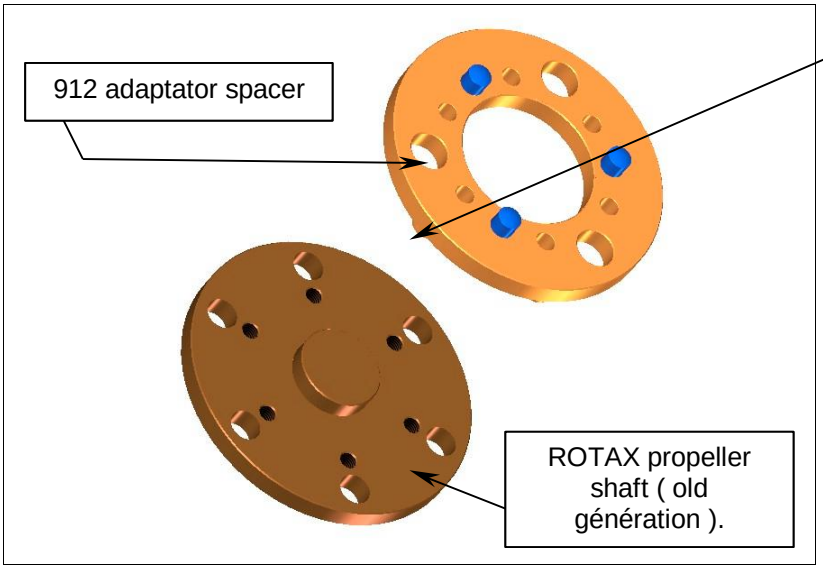
ADAPTATOR SPACER / SPINNER MOUNTING PLATE / DUC HUB on ROTAX 912 – 912S PROPELLER SHAFT old generation

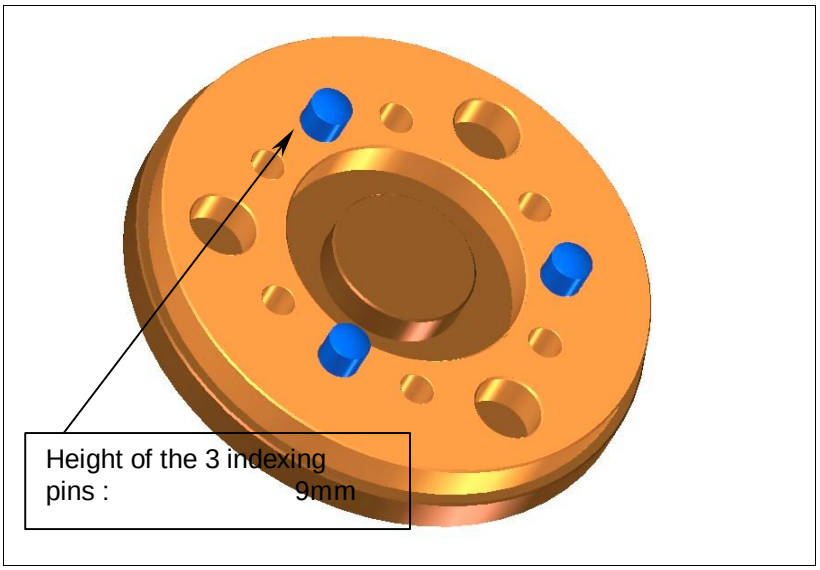
Note reference: 912-A / 10

Assembly of the 912 adaptator spacer with DUC spinner

The ROTAX 912 propeller shaft, *old generation*, presents 6 holes ø12mm on a distance between centers ø100mm and 6 M8 tapped holes on a distance between centers ø75mm for the fixing of the hub.

Operation 1 : *VERIFICATION OF THE ADAPTATOR SPACER.*





VERIFICATION :

§ Check the height of the 3 pins ø10mm compared to the 912 adaptator spacer.

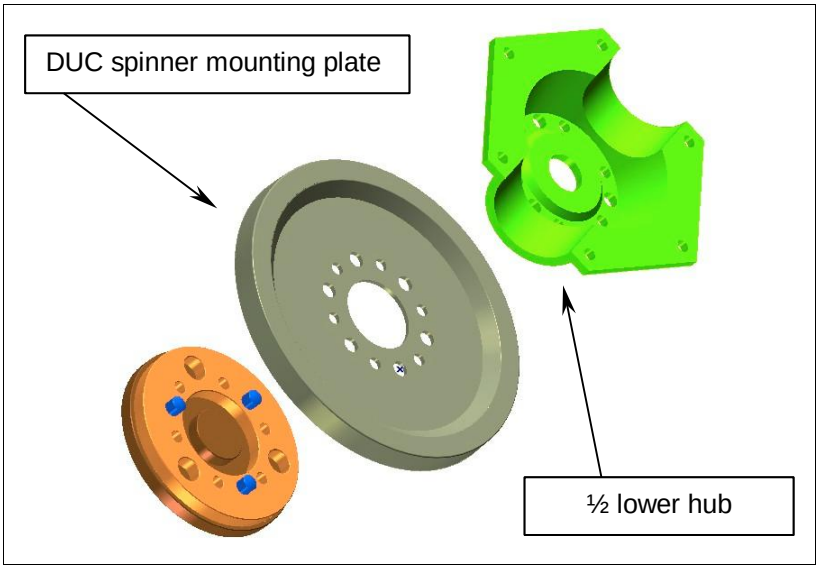
In the case of assembly with a DUC spinner mounting plate, the height of the pins is of :

9 mm

§ Position the spacer by indexing the 6 pawns out of the 6 holes ø12mm of distance between centers ø100mm on the ROTAX propeller shaft (old generation).

§ Position to the mounting plate of the DUC spinner with the ½ lower hub indexed on the pins ø10mm.

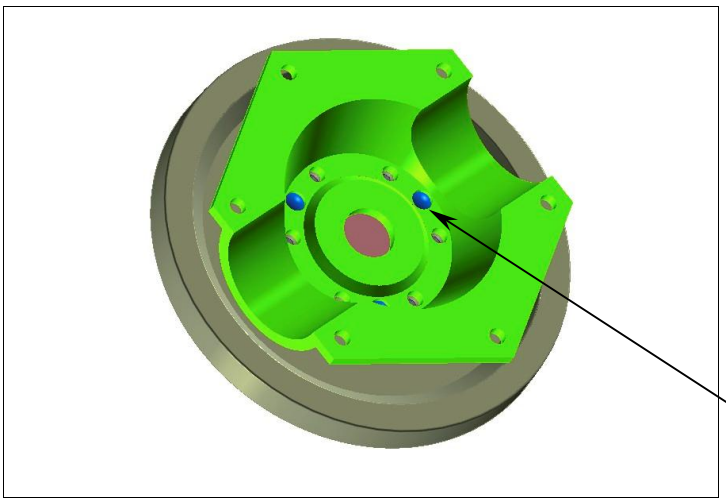
Chemin de la Madone
69210 LENTILLY - FRANCE
Tèl : 00-33-(0)4-74-72-12-69
Fax : 00-33-(0)4-74-72-10-01
Contact@duc-helices.com



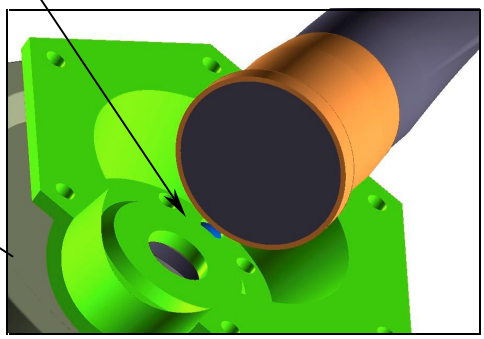
§ Once the mounting plate and the ½ hub positioned, *check that the head of the pins does not exceed the lower face of the ½ hub.*

If the head of the indexing pins ø10mm exceeds, it risks to damage the rings of blades and especially to put out of order the angle of attack of the propeller.

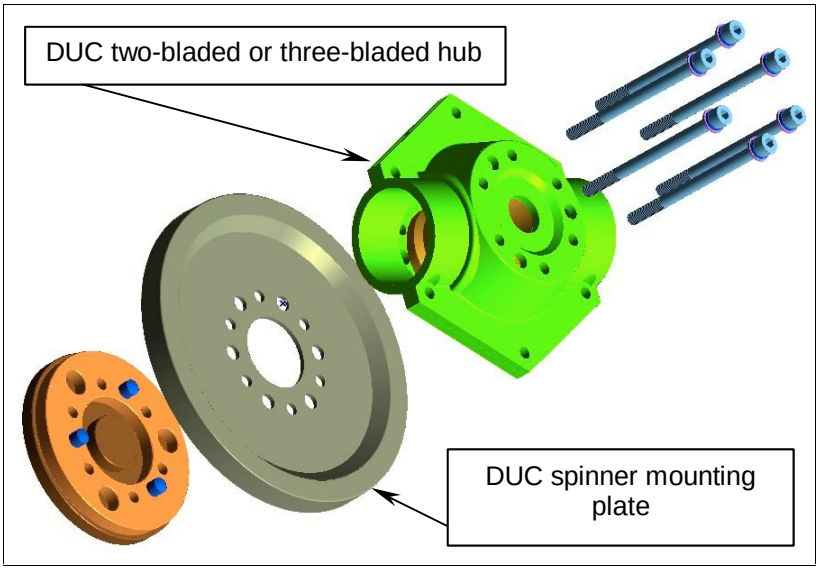
With a height of 9mm, the head of pins must be tangent with the lower face of the ½ hub



Play between pins and rings of blades



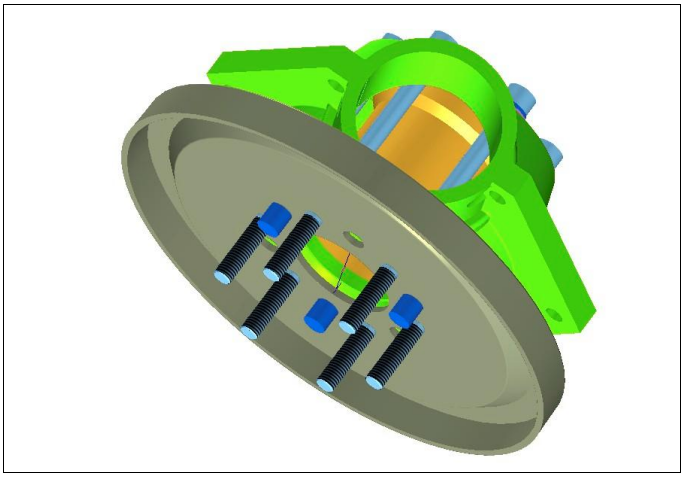
Operation 2 : *ASSEMBLY OF THE ADAPTATOR SPACER WITH THE COMPLETE HUB .*



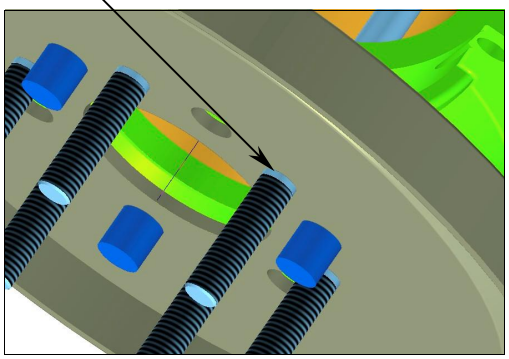
§ Once the checking carried out, position the spinner mounting plate and the complete hub on the spacer by indexing them on the 3 ø10mm pins,

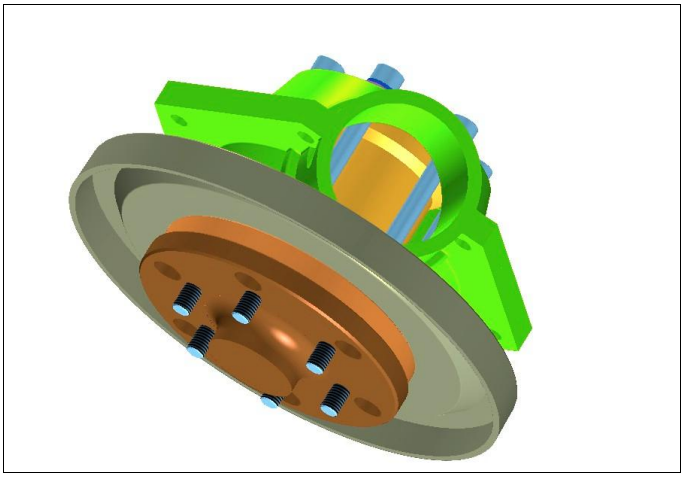
§ Present the 6 CHC M8 screws of the hub fixing.

Chemin de la Madone
69210 LENTILLY - FRANCE
Tèl : 00-33-(0)4-74-72-12-69
Fax : 00-33-(0)4-74-72-10-01
Contact@duc-helices.com



Shearing surface on the smooth body of 6 CHC M8 screws and not on threading.



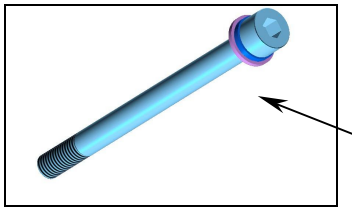


§ Respect the order of the washers at the time of the assembly of the 6 fixing screws of the DUC propeller hub.

§ Mount and tighten the 6 CHC M8 screws of fixing hub in the 6 M8 tapped holes of distance between centers ø75mm of the ROTAX propeller shaft.

TIGHTENING

2.5 Kg/m
25 Nm

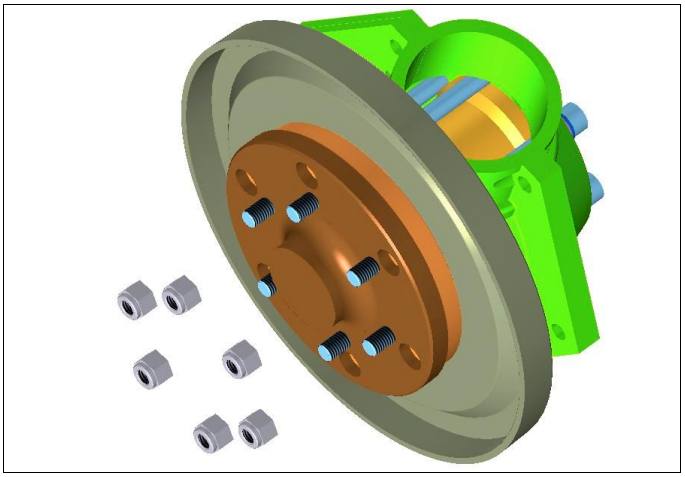


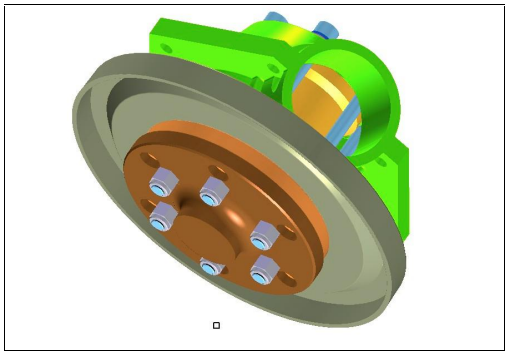
Flat washer
Grower washer

§ Once the 6 CHC M8 screws tightened, mount and tighten the M8 NILSTOP nuts on the back of the ROTAX propeller shaft.

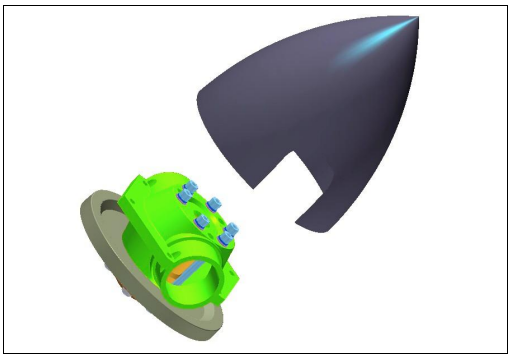
TIGHTENING

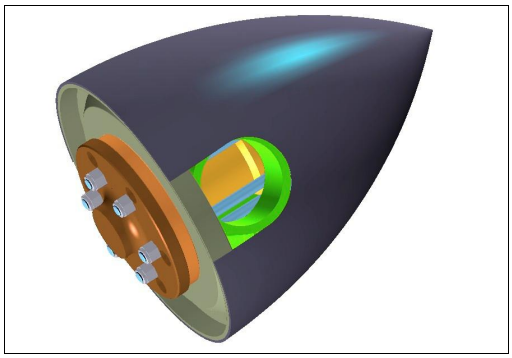
2.5 Kg/m
25 Nm





Chemin de la Madone
69210 LENTILLY - FRANCE
Tèl : 00-33-(0)4-74-72-12-69
Fax : 00-33-(0)4-74-72-12-01
Contact@duc-helices.com

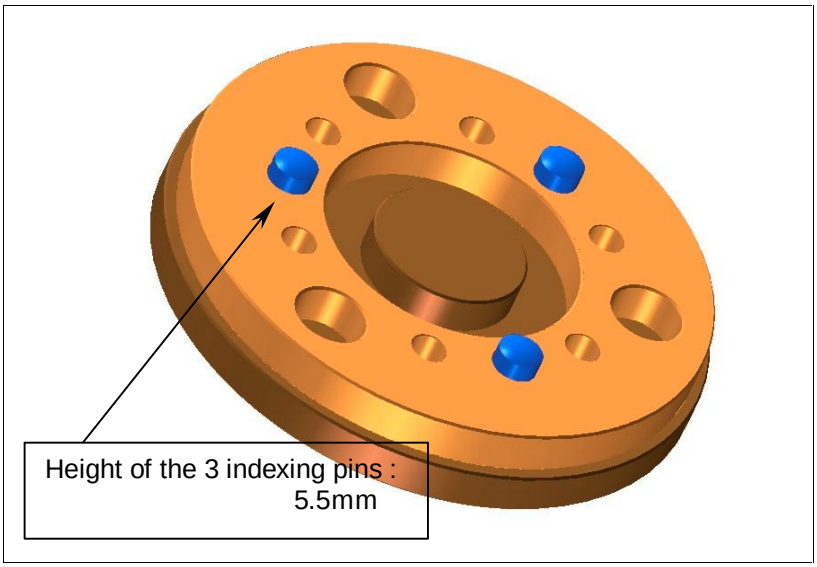




§ Carry out the assembly of the DUC spinner on the mounting plate by positioning correctly the openings of blades.

Assembly of the 912 adaptator spacer without DUC spinner

Operation 1 : *VERIFICATION OF THE ADAPTATOR SPACER.*

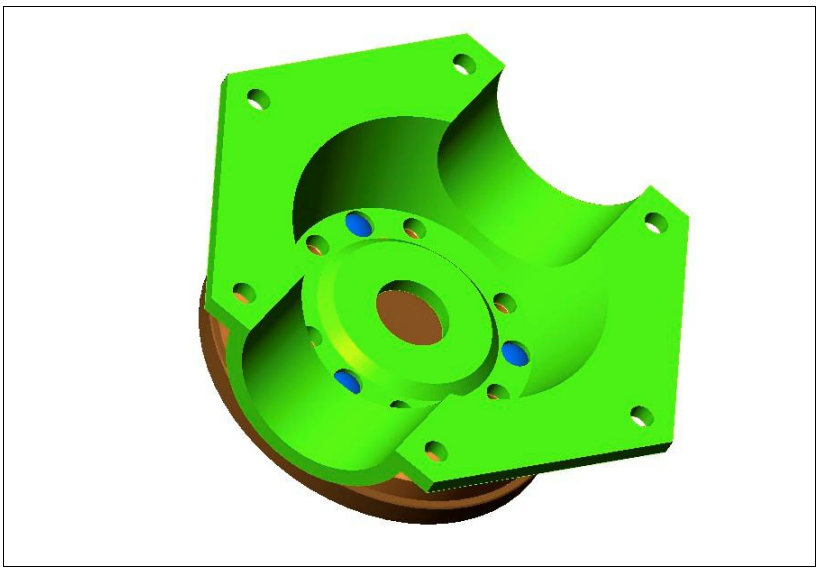


VERIFICATION :

In the case of the assembly without DUC spinner mounting plate, the height of the 3 indexing pins ø10mm is of :

5.5 mm

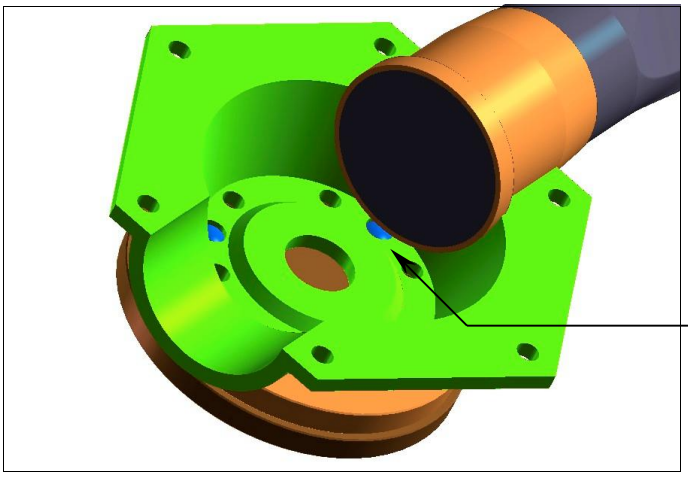
Position the spacer on the ROTAX propeller shaft old generation in the same way at previously.



Index the ½ lower hub with the 3 indexing pins ø10mm on the adaptator spacer.

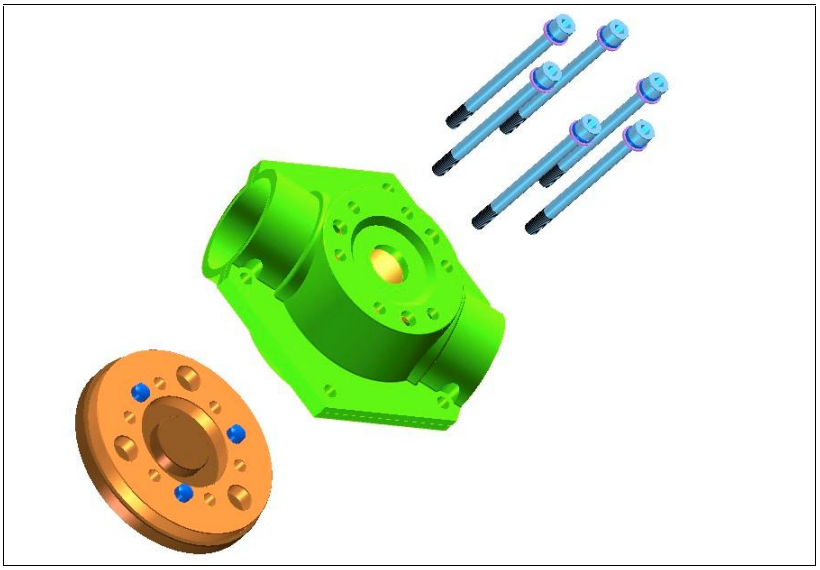
With a height of 5.5mm, the head of the 3 indexing pins must be tangent with the lower face of the ½ hub.

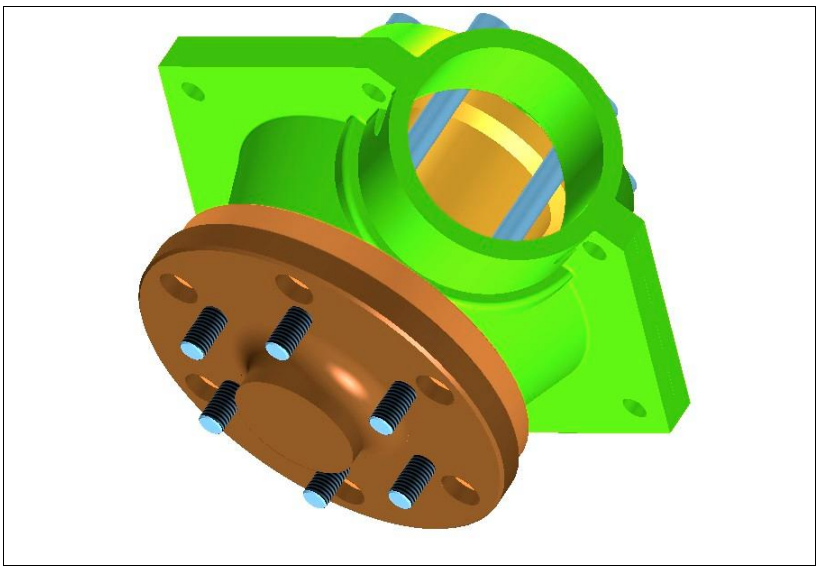
Chemin de la Madone
69210 LENTILLY - FRANCE
Tèl : 00-33-(0)4-74-72-12-69
Fax : 00-33-(0)4-74-72-10-01
Contact@duc-helices.com



If the head of the indexing pins ø10mm exceeds, it risks to damage the ring of blade and especially to put out of order the angle of attack of the propeller.

Operation 2 : *FIXING OF THE COMPLETE HUB ON THE ADAPTATOR SPACER .*





§ Once the checking carried out, position the complete hub on the spacer by indexing it on the 3 ø10mm pins.

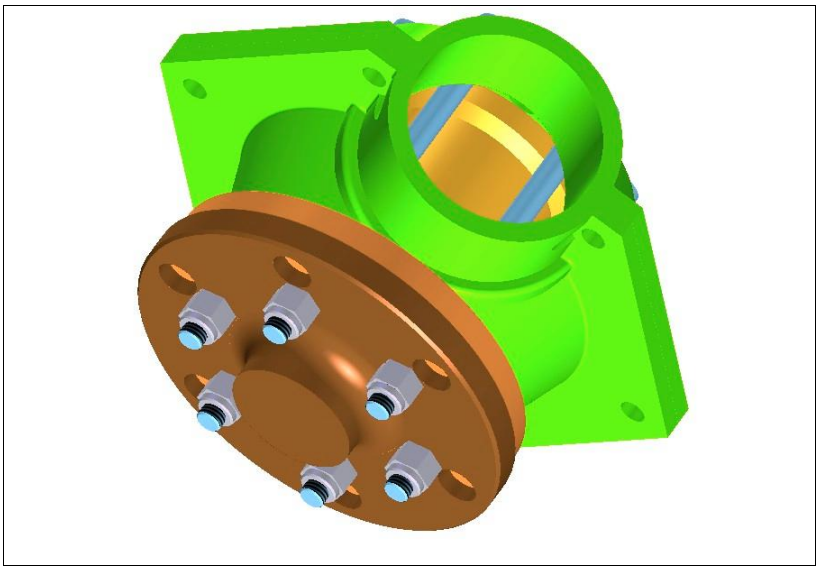
§ Mount and tighten the 6 CHC M8 screws of fixing hub in the 6 M8 tapped holes of distance between centers ø75mm of the ROTAX propeller shaft.

Attention with the order of the washers on the 6 fixing screws of the hub.

TIGHTENING

2.5 Kg/m
25 Nm

Chemin de la Madone
69210 LENTILLY - FRANCE
Tèl : 00-33-(0)4-74-72-12-69
Fax : 00-33-(0)4-74-72-10-01
Contact@duc-helices.com



§ Once the 6 CHC M8 screws tightened, mount and tighten the M8 NILSTOP nuts on the back of the VERNER propeller shaft.

TIGHTENING

2.5 Kg/m
25 Nm

If you note anomalies of assembly or operation, not undertake flight and contact immediately the DUC-HELICES compagny.

The accessories of assembly and the DUC propeller must be assembled in accordance with the technical notes of the DUC company.

The non-observance of these data would release from any responsibility the DUC company.

Chemin de la Madone
69210 LENTILLY - FRANCE
Tél : 00-33-(0)4-74-72-12-69
Fax : 00-33-(0)4-74-72-10-01
Contact@duc-helices.com

Lentilly,
March, 17th 2008

Our Ref. : VD/SC/CDH020-2008

Re. : Assembly of our spacers on 2 strokes engines (ROTAX 503 or 582 engines) and 4 strokes (ROTAX 912, 912S and 914 engines)

Dear Customer,

We remind you some indications to be respected during the assembly of our adaptator spacer and our intermediary spacer on your machines.

Engines 4 strokes (ROTAX 912, 912S and 914) :

REMINDER : On these engines, the propeller shaft of origin is made up of :
- *6 holes of 8 mm at a length from the center of 75 mm*
- *6 holes of 13 mm at a length from the center of 101.6 mm.*

If you want to fit a spacer between the propeller shaft and our propeller' hub, you have to fit a 912 H adaptator spacer (available in 10, 30, 45, 50 or 80 mm) with the ROTAX pawns (ø 13 mm).
You can also add a 912 H intermediary spacer (available in 30, 40 or 60 mm) if the spacing is not sufficient.
YOU MUST NEVER FIT AN INTERMEDIARY SPACER (INTEND TO 2 STROKE ENGINES) ON A 912, 912S or 914 ENGINE BECAUSE OF A RISK OF SHEARING. THEN, THE SCREWS CAN BREAK IN FLIGHT.

Engines 2 strokes (ROTAX 503 or 582):

If you want to fit a spacer, we remind you that you have to fit the intermediary spacer - 6 holes of 8 mm at a distance from center of 75 mm (available in 30 or 60 mm).

The non respect of all these indications would discharge the company DUC HELICES from any liability.

If you need any further information with regard to this note, please don't hesitate to contact us or our international representative: France Aviation Ltd, 0800 AVIATOR (NZ Only), +64 21887205, contactus@franceaviation.co.nz.

Best Regards

Vincent DUQUEINE
Manager