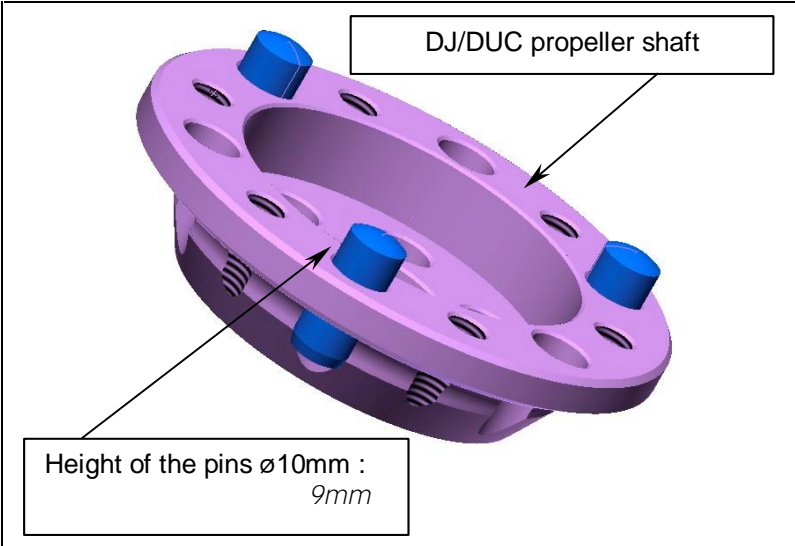


NOTE OF ASSEMBLY **DJ JABIRU-DUC** PROPELLER SHAFT/
SPINNER MOUNTING PLATE / **DUC** HUB

Note reference : DJ/DUC

Assembly with spinner mounting plate

Operation 1 : FIXING OF **DJ/DUC** PROPELLER SHAFT



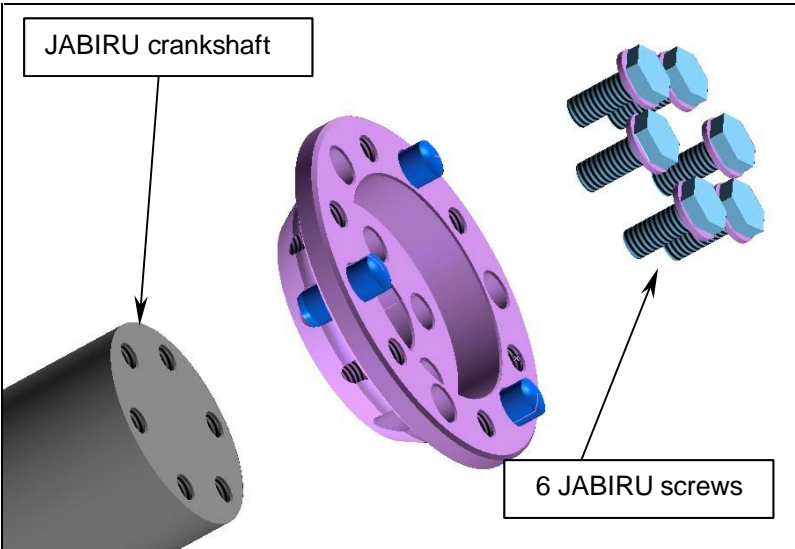
The DJ/DUC propeller shaft for JABIRU engines is available in 3 different lengths:

- 20mm - 01-58-106
- 45mm. - 01-58-107
- 60mm. - 01-58-113

Before the assembly of DJ/DUC propeller shaft, check the height of the 3 pins ø10mm compared to the propeller shaft.

In the case of the assembly of spinner mounting plate, the height is :

9 mm



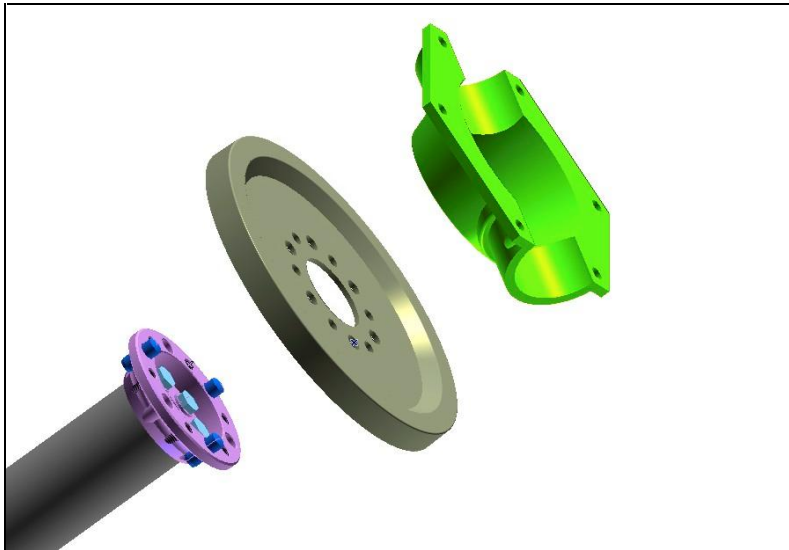
Fixing of the DJ/DUC propeller shaft :

- § dismantle the standard JABIRU propeller shaft,
- § Present the new DJ/DUC propeller shaft by checking the adjustment of the crankshaft in the lower escarpment,
- § Tighten the propeller shaft with the 6 hexagonal head screws with high strength threadlocking.

TIGHTENING

4.0 Kg/m
40 Nm

Operation 2 : CHECKING HEIGHT OF THE PINS $\varnothing 10\text{mm}$ OF INDEXING

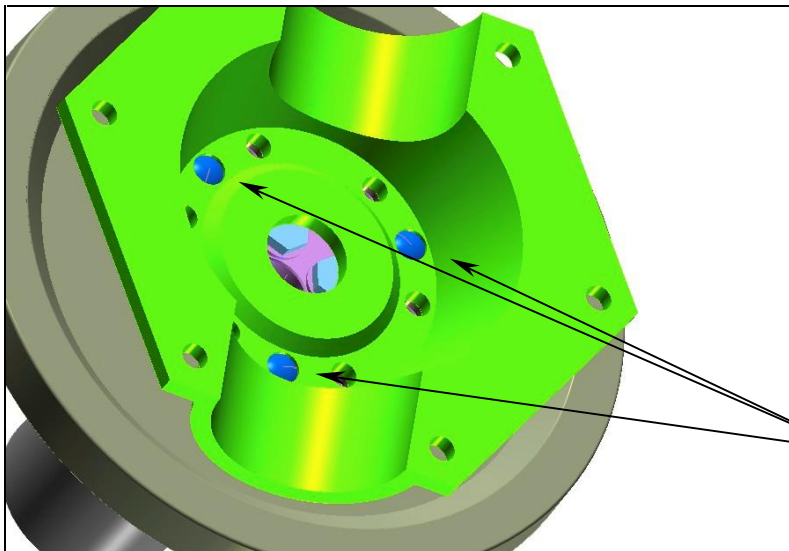


Before carrying out the assembly of the propeller, checking the height of the of indexing pins $\varnothing 10\text{mm}$ of DJ/DUC propeller shaft.

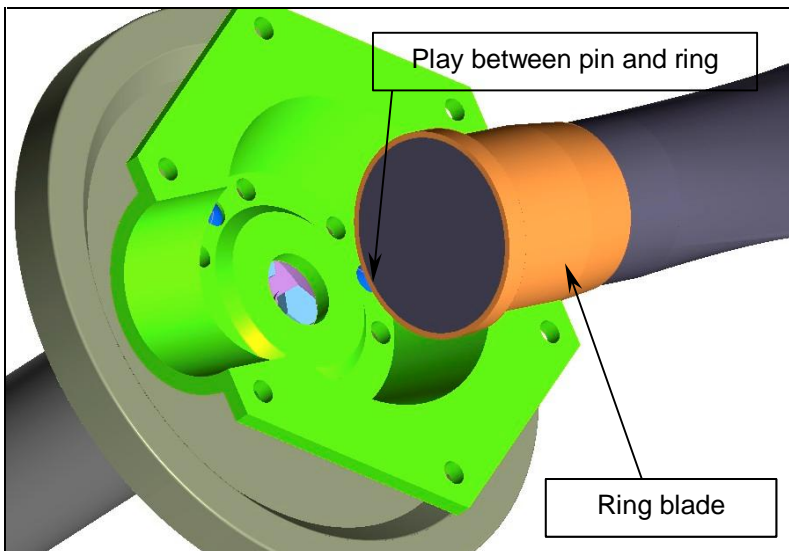
§ Present the mounting plate with the $\frac{1}{2}$ hub indexed by the 3 pins on the propeller shaft.

Note :

Not to assemble solely mounting plates of DUC spinner out of carbon fibers or aluminium mounting plates.



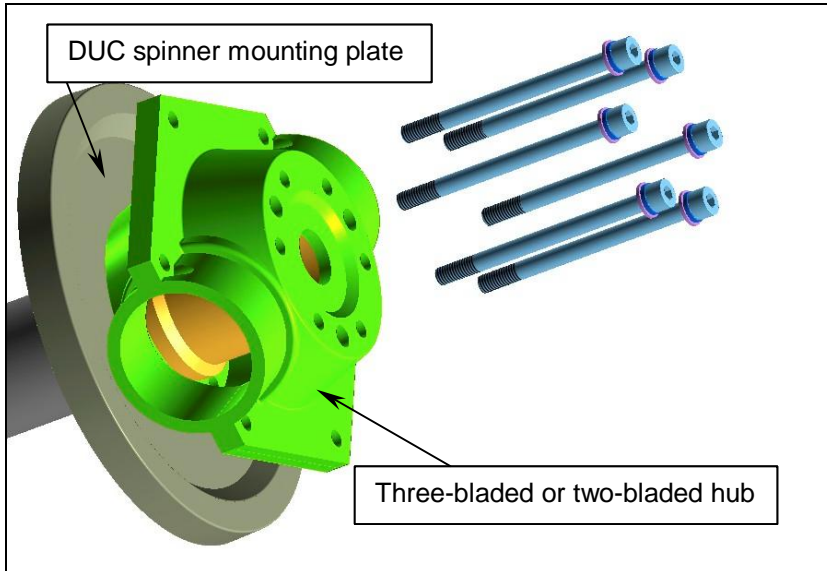
check that the head of the pin does not exceed the lower face of the $\frac{1}{2}$ hub.



If the head of the indexing pins $\varnothing 10\text{mm}$ exceeds, it risks to damage the ring of blade and especially to change the angle of attack of the propeller

With a height of 9mm, the heads of pins must be tangent with the lower face of the $\frac{1}{2}$ hub.

Operation 3 : ASSEMBLY OF THE DUC PROPELLER.



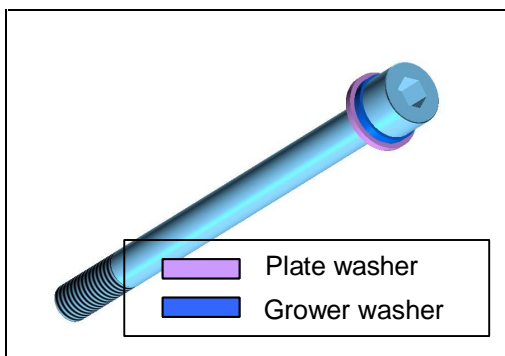
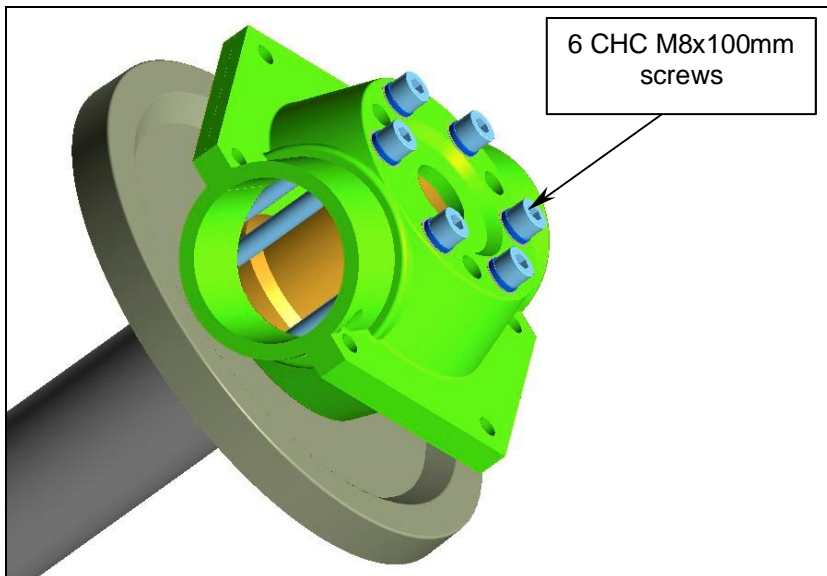
§ Once the tightened DJ/DUC propeller shaft and the checking carried out, present the mounting plate as well as the two-bladed or three-bladed hub on the propeller shaft

§ Index the mounting plate and the hub on the 3 indexing pins,

§ Tighten the 6 CHC M8x100mm on the M8 tapped holes of the propeller shaft.

TIGHTENING

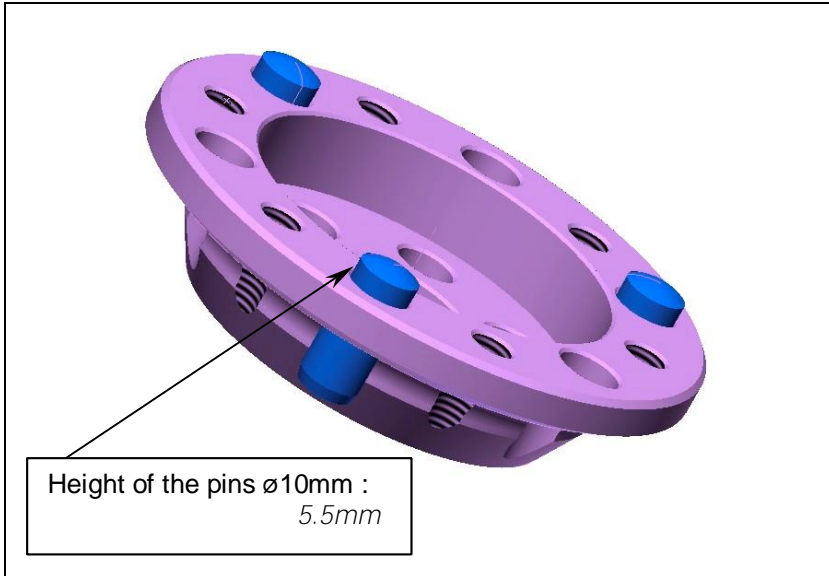
2.5 Kg/m
25 Nm



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

The characteristic of these screws is that the smooth body is sufficiently long to support the shear stress on the level of the hub and the mounting plate.

Assembly without spinner mounting plate

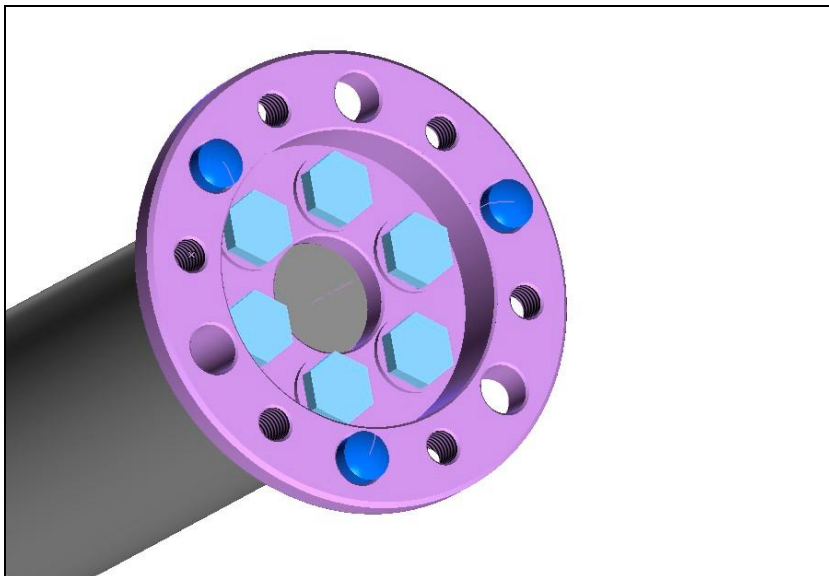


In the case of the assembly without spinner mounting plate, the height of the indexing pins is :

5.5 mm

This checking is very important because the DJ/DUC propeller shaft exists in two versions:

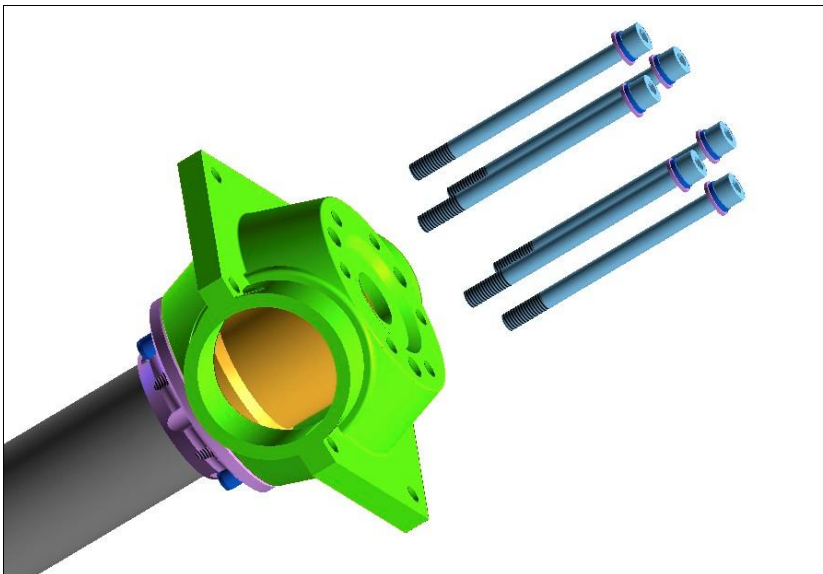
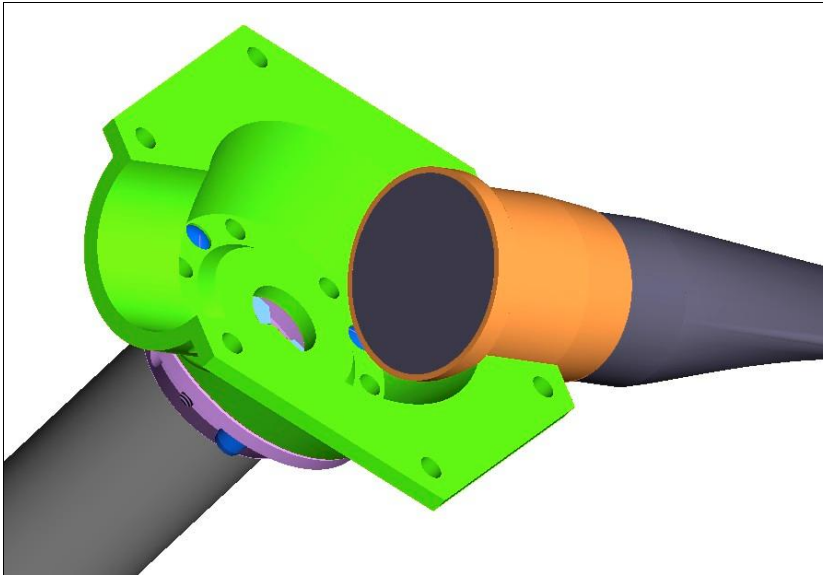
1. For the assembly of a spinner mounting plate, with a height of indexing pins of 9mm,
2. Without assembly of spinner mounting plate, with a height of pins of 5.5mm.



Carry out the assembly of the propeller shaft like previously.

TIGHTENING

4.0 Kg/m
40 Nm



§ Present the two-bladed or three-bladed DUC hub on the propeller shaft,

§ Carry out the same checking as previously with knowing the height of the indexing pins $\varnothing 10\text{mm}$

They should not be in contact with the rings of blades.

§ Tighten the 6 CHC M8x100mm on the M8 tapped holes of the 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 company.

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.