

"RSW"
2161 Cromwell
Houston, Texas 77093
Tel: 713-590-6428; Fax 713-590-6739

INSTALLATION INSTRUCTIONS NO. 2200A

Instructions to Install Improved Cylinder Bushing - Counterweight Bearing Shaft, "RSW" Part No. C.P. 22001-1 or C.P. 22001-2, into the Cylinder of Hamilton Standard Propellers (HSP) Model 2D30, 12D40, 2E40 or 3D40 in Place of the Hamilton Standard Propeller Bushing - Counterweight Bearing Shaft Part No. 51124 In Accordance With S.T.C. No. SP7836SW.

ESSENTIAL REFERENCE MATERIALS:

"RSW" Dwg No. C.T. 37200
HSP Manual 110D - Section VI, Page 80, Paragraph (d) to be replaced by "RSW" Installation Instructions No. 2200A.

TOOLS REQUIRED FOR CYLINDER MODIFICATION:

- 1 - 1" diameter, 82 degree countersink.
- 1 - 3/4" diameter H.S.S.- Co, 2 flute single-end long flute endmill (length of cut: 3. 0).
- 1 -13/16 x 16 T.P.I. plug tap.
- 1 -13/16 x 16 T.P.I. bottom tap.

INSTALLATION PROCEDURE:

1. Remove and discard HSP Bushing Part No. 51124. Ref: HSP Manual 110D.
2. Ream, drill and tap Hamilton Standard Cylinder per "RSW" Dwg. No. C.P. 22001-1 & -2 and "RSW" Dwg. No. C.T. 37200, taking care not to disturb HSP installed steel insert (Item "N" on "RSW" Dwg. No. C.T. 37200). After drilling and tapping of cylinder has been completed, clean the drilled and tapped holes with M.E.K. or equivalent solvent approved by propeller manufacturer, allow solvent to evaporate, and then coat the drilled and tapped areas with alodine.
3. Confirm that Installation & Disassembly Tool, Part No. C.T. 37200 is on hand and assembled as per "RSW" Dwg. No. C.T. 37200.
4. Insert and screw Installation & Disassembly Tool Part No. C.T. 37200 into Bushing-Cwt Bearing Shaft Part No. C.P. 22001-1 or C.P. 22001-2, leaving the Installation Bolt Part No. C.T. 37202 recessed 1/8" to 1/4" from bottom of Bushing Part No. C.P. 22001-1 or C.P. 22001-2.
5. Hand tighten Installation Tool Part No. C.T. 37201 against Bushing Part No. C.P. 22001-1 or C.P. 22001-2.
6. Lock Installation Tool Lock Nut Part No. C.T. 37203 against Tool Part No. C.T. 37201.
7. Apply Loctite No. 271 to the first four (4) threads of Bushing Part No. C.P. 22001-1 or C.P. 22001-2 as noted on "RSW" Installation Dwg. No. C.T. 37200.

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8. Screw "RSW" Bushing Part No. C.P. 22001-1 or C.P. 22001-2 into Cylinder until seated and then apply 10-15 ft. lbs. of torque on hex head of "RSW" Tool Part No. C.T. 37202.
9. Back up Lock Nut, "RSW" Part No. C.T. 37203.
10. Back up "RSW" Tool Part No. C.T. 37201 and remove Bolt Part No. C.T. 37202 from Bushing Part No. C.P. 22001-1 or C.P. 22001-2.

NOTE: Bushings must be installed in full sets only.

After "RSW" Bushing-Cwt Bearing Shaft Part No. C.P. 22001-1 or C.P. 22001-2 installation has been completed, refer to Hamilton Standard Propeller Manual 110D for Cylinder to Propeller Hub installation instructions.

The "RSW" Bushings Part No. C.P. 22001-1 or C.P. 22001-2 should be replaced at overhaul, or after 1200 hours.

INSTRUCTIONS TO REMOVE "RSW" BUSHING C.P. 22001-1 or C.P. 22001-2 FROM CYLINDER: submerge lower part of cylinder which contains the two cylinder bushings - counterweight shaft in M.E.K. solution or other solvent approved by propeller manufacturer for approximately twelve (12) hours to soften the Loctite No. 271 prior to unthreading the bushings. Clean the tapped holes with M.E.K. or equivalent. Remove any thread distortion, burrs or loctite trapped within threads with 13/16 x 16 T.P.I. bottom tap. With compressed air, blow out any foreign matter which may still remain in tapped cylinder hole. Clean once again with M.E.K. or equivalent and allow solvent to evaporate. Apply alodine to all machined and threaded surfaces to protect against corrosion prior to installation of new bushings.

