

DO - No. EASA.21J.020	Service Letter SL 50	Revision 2
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Pitch Change Pin Inspection during next Overhaul or Repair

<u>Affected Parts:</u>	All Pitch change pins which are installed on the following blade types and indicating some wear at the piston extension. Blade types: -37b, -55, -55a, -55d, -55f, -65, -65a, -66 , -103
<u>Affected Propellers:</u>	All MT Propeller installed with above listed blade types on turbo prop applications.
<u>Reason:</u>	During service it was found that the pitch change pin could slightly wear into the piston extension.
<u>Affected Publications:</u>	Overhaul Manual E-1290.

Work Procedure:

Check that the pin cannot be moved by hand. In case it can be moved by hand, replace blade ferrule and use a new pin according to Manual E-1290.

Check piston extension for wear. In case of wear, check pitch change pin length protruding the blade ferrule.

15,5mm **0,2mm** (0,61 inch **0,0078** inch) for pin diameter 12mm (0,47 inch) or

17,5mm **0,2mm** (0,68 inch **0,0078** inch) for pin diameter 14mm (0,55 inch)

In case the piston extension shows wear from pitch change pin, all pins must be exchanged on the affected blade set according the following work procedure.

1. Grind the pin flush on one side as shown in Fig.1a/1b



Fig. 1a



Fig. 1b

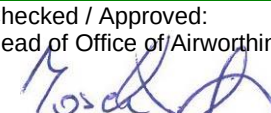
2. Fix the pin in a bench vise and punch on the blade ferrule bottom with a soft hammer until the pin is pulled out as shown in Figure 2.
Clean pitch change pin bore and the new pitch change pin with Acetone or similar as shown in Figure 3.



Fig. 2



Fig. 3

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DO - No. EASA.21J.020	Service Letter SL 50	Revision 2
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3. Mix the 2 components glue Hysol EA 9359.3 Part A and Part B according to the mix ratio. Use them as shown in Figure 4a and Figure 4b.

Attention:

Do not use too much glue as the glue is not compressible and this may result in the pin not being able to be installed correctly according to the dimensions given on page 1.

Figure 4a only in the inner bore of the blade ferrule!

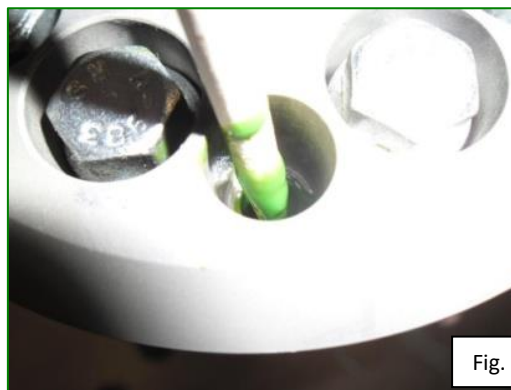


Figure 4b only at the bigger diameter of the pitch change pin!



4. Punch in the pitch change pin by a soft hammer using at first the longer bushing T-804-1 (diameter 12mm/0,47inch) or T-804-3(diameter 14mm/0,55inch) to guide and then secondly with the shorter bushing T-804 (diameter 12mm/0,47inch) or T-804-2 (diameter 14mm/0,55inch) as shown in Fig 5 to adjust the press in length.



DO - No. EASA.21J.020	Service Letter SL 50	Revision 2
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5. Check the pitch change pin for correct seat and length as shown on Fig.6 and let dry for minimum 12 hours at room temperature before use.
Crosscheck the correct pitch change block.

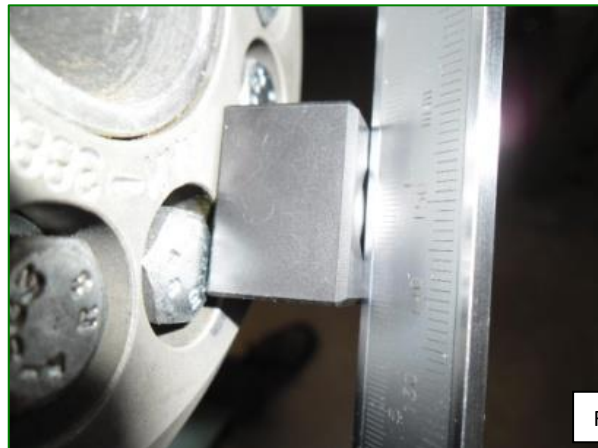


Fig. 6

Additional Information:

For new propellers, never in operation, check the dimension of the pin.

If the pin extends more than the following dimensions

- ✓ 15,5mm ±0,2mm (0,61 inch ±0,0078 inch) for pin diameter 12mm (0,47 inch) or
- ✓ 17,5mm ±0,2mm (0,68 inch ±0,0078 inch) for pin diameter 14mm (0,55 inch)

use a hammer and an old pitch change block and simply punch in the pin to the correct dimension and confirm by measuring the dimension.

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