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Modification of the Starter Gear Ring installed on Lycoming Engine for electrically controlled variable pitch Propeller Systems or hydraulic variable pitch Propeller Systems equipped with electric de-ice

Accomplishment:

Procedure during conversion to an electrically controlled variable pitch MT Propeller, or installation of a de-ice slip ring for hydraulic propellers.

Affected Propeller:

Electric or hydraulic MT constant speed propellers

Affected Parts:

Lycoming starter rings, i.e. P/N 76628 but not limited to this.

Required Tools:

1x Drill Ø5,2mm(0.204")
1x Centering Bushing Ø6,4/Ø5,3x25
(Ø0,251"/Ø0,208"x0,984", self made)
1x Drill Ø6,0mm(0.236")
1x Clamp tool (according picture, self made)
1x Deburring Tool
1x Standard Drill Machine
1x Tap ¼"-28 UNF
1x Vertical Drill Press



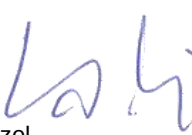
Work procedure:



1)
Mark the drill position according the drawing A-542- (), the positions are at 30° and 39° away from the Index bushing



2)
The distance from flange surface is 15mm (0,590")

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3)
Bore two holes with a $\varnothing 6,0\text{mm}$ (0,236") drill



4)
Deburr the holes on both ends



5)
Position the slip ring that the starter gear aligns with the holes



6)
Fix the slip ring into the starter gear with the self made clamp tool



7)
Bore all 6 holes with the $\varnothing 5,2\text{mm}$ (0,204") drill
Note: Use for drill cooling ethyl alcohol



8)
For the thread use the $\frac{1}{4}$ "-28 UNF tap

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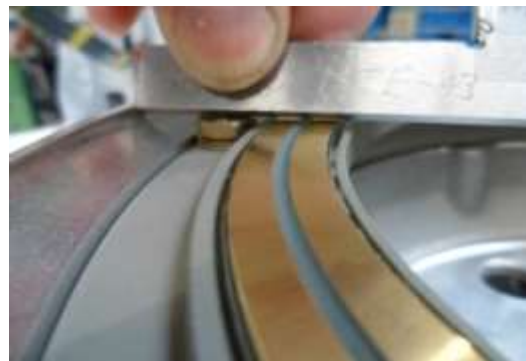
9)
Remove the slip ring from the starter gear for cleaning. Install the slip ring back again in convenient position and install the electrical connection according the drawing A-542-().



10)
Mark the polarity on the starter gear with + / -.
Note: The outer slip ring is +



11)
Install the 6x screws C-315-1,5 with 6x washer C-338-4 and 6x teeth washer C-352-40 with PERMATEX No.2 according the drawing A-542-()
Torque value screws 9-10 Nm (6,6-7,4 ftlbs)



12)
Make sure that the screw head(6x C-316-1,5) is flush with the slip ring surface

Note: All mechanic are allowed to do this modification

Contact: e-mail: techsupport@mt-propeller.com

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13) Drawing A-542-()

