

SUBJECT: PROPELLER SPINNER INSPECTION AND MODIFICATION

MODELS
AFFECTED: M20J S/N's: 24-0001 thru 24-0499

TIME OF
COMPLIANCE: As soon as practical within the next 25 hours of operation.

INTRODUCTION: There have been instances where the propeller spinner has cracked just forward of the two attachment holes adjacent to the propeller opening. This bulletin will provide instructions for inspection and modification of the spinner (with Kit S.B. 201, available from the factory).

- INSTRUCTIONS:
1. Remove the (14) MS 51958-62 screws attaching the 680031-7 spinner to the 680031-3 aft bulkhead behind the propeller.
 2. Inspect the spinner for cracks, paying particular attention to the area of the attachment holes adjacent to the propeller cutouts. Inspect the aft spinner bulkhead for cracks. If cracks are detected, replace the spinner and/or the aft bulkhead.

If no cracks are detected, proceed with the installation of the two (2) doublers of Kit S.B. 201 per following instructions.

3. Remove (8) NAS 686A3 nutplates, (2 on each side of the propeller cutouts) from the aft spinner bulkhead. Retain for reinstallation to -501 doubler assy per step #12.
4. Align nutplates of 940003-501 doubler with holes in rear bulkhead and temporarily secure doubler in place.
5. Drill a .190/.197 dia. hole through bulkhead and doubler at prop blade centerline, see Figure 1.
6. Remove doubler - deburr and install NAS 686A3 nutplate to underside of doubler using MS 20426AD3 flush rivets.
7. Repeat steps 4, 5, 6 above for other doubler.
8. Layout and drill 8 ea. .190/.197 dia. holes in spinner as per Figure 2 and deburr.

Instructions cont...

9. Attach both 940003-501 doublers to rear bulkhead with 1 ea. MS 51958-62 screw and fiberwasher at the prop blade centerline for each doubler.
10. Install the spinner to the rear bulkhead and doubler assy with 8 ea. MS 51958-63 screws (1/2" grip) and fiber washers, 2 ea. on each side of prop cutout at the rear bulkhead.
11. Match drill 8 ea. .190/.197 dia. holes in both doublers with holes drilled by Step 8 in spinner.
12. Remove spinner and both doublers. - Deburr doubler holes drilled in Step 11 and install 8 ea. NAS 683A3 nutplates using MS 20426 AD3 flush rivets - see Figure 1 for positioning.
13. Repeat steps 9 and 10 and install remaining 14 ea. MS 51958-62 (7/16" grip) screws and fiberwashers.

NOTE: Prior to final installation of the spinner dome, check to assure that prop dome fits spinner bulkhead snugly. This may be accomplished by slipping the spinner into place over the rear bulkhead as verified by alignment of the mounting holes. Grasp the tip of the spinner and apply a firm alternating up and down pressure. No movement, as evidenced by the feel of a slight "thump" and/or slippage of the alignment of the screw holes, should be seen. If movement occurs, add additional layers of 6.5 MIL X .50 wide Scotch Brand No. 549 tape to prop dome until a snug fit is obtained.

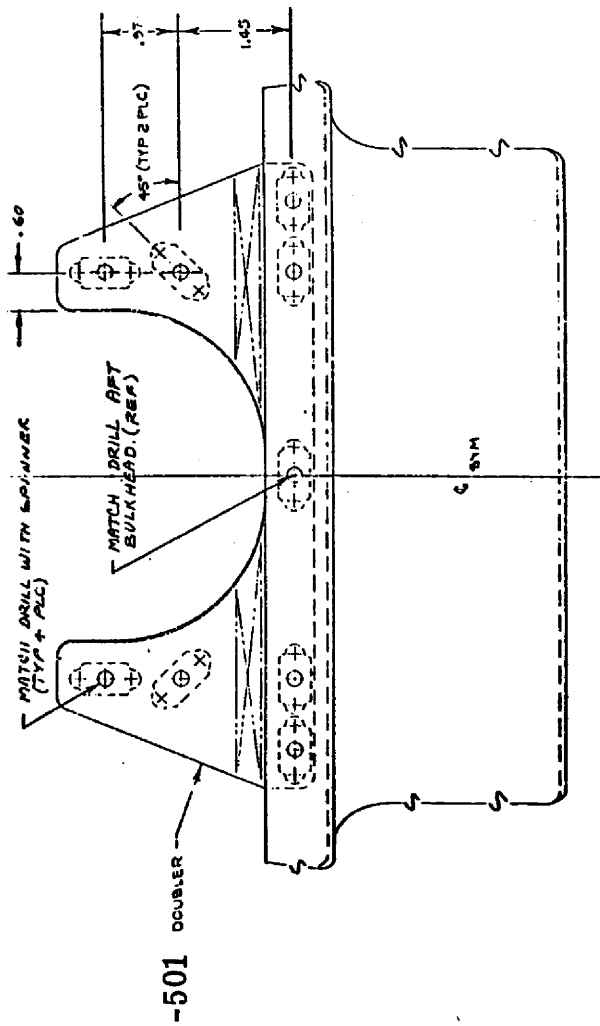
14. Torque all screws to 30 \pm 5 in. lbs.

NOTE: Screw heads and doublers may be painted prior to final installation as required.

15. Make appropriate Log Book entry and fill out and return Compliance Card.

S.B. Kit
No. 201:

940003-501 Doubler	2 ea.
NAS 686A3 Nutplates	2 ea.
MS 51958-63 (1/2 in. grip) Screws	8 ea.
MS 51958-62 (7/16 in. grip) Screws	2 ea.
#6515 Fiber Washer	10 ea.
MS 20426 AD3-5 Rivets	20 ea.



940003-501 Doubler Instl

Dimensions shown are thru spinner & doubler. (Spinner not shown for clarity.)

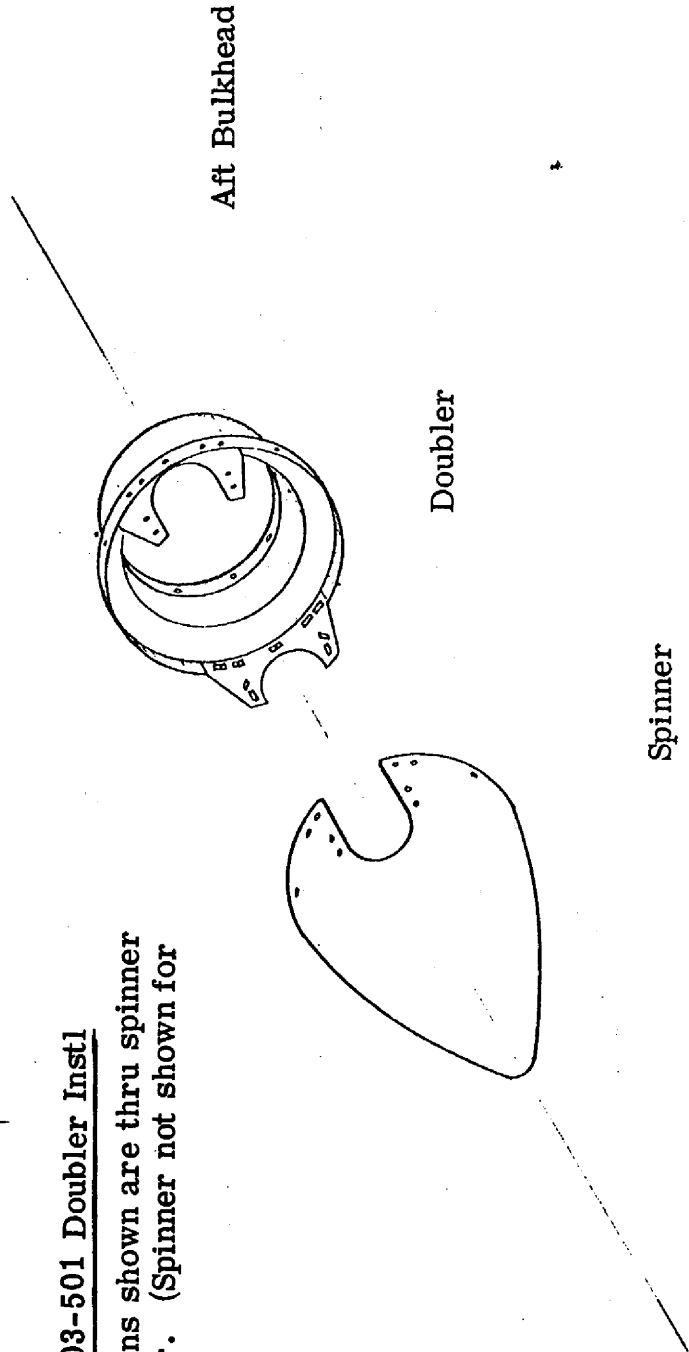


FIGURE 201-1
680031-505 Assembly

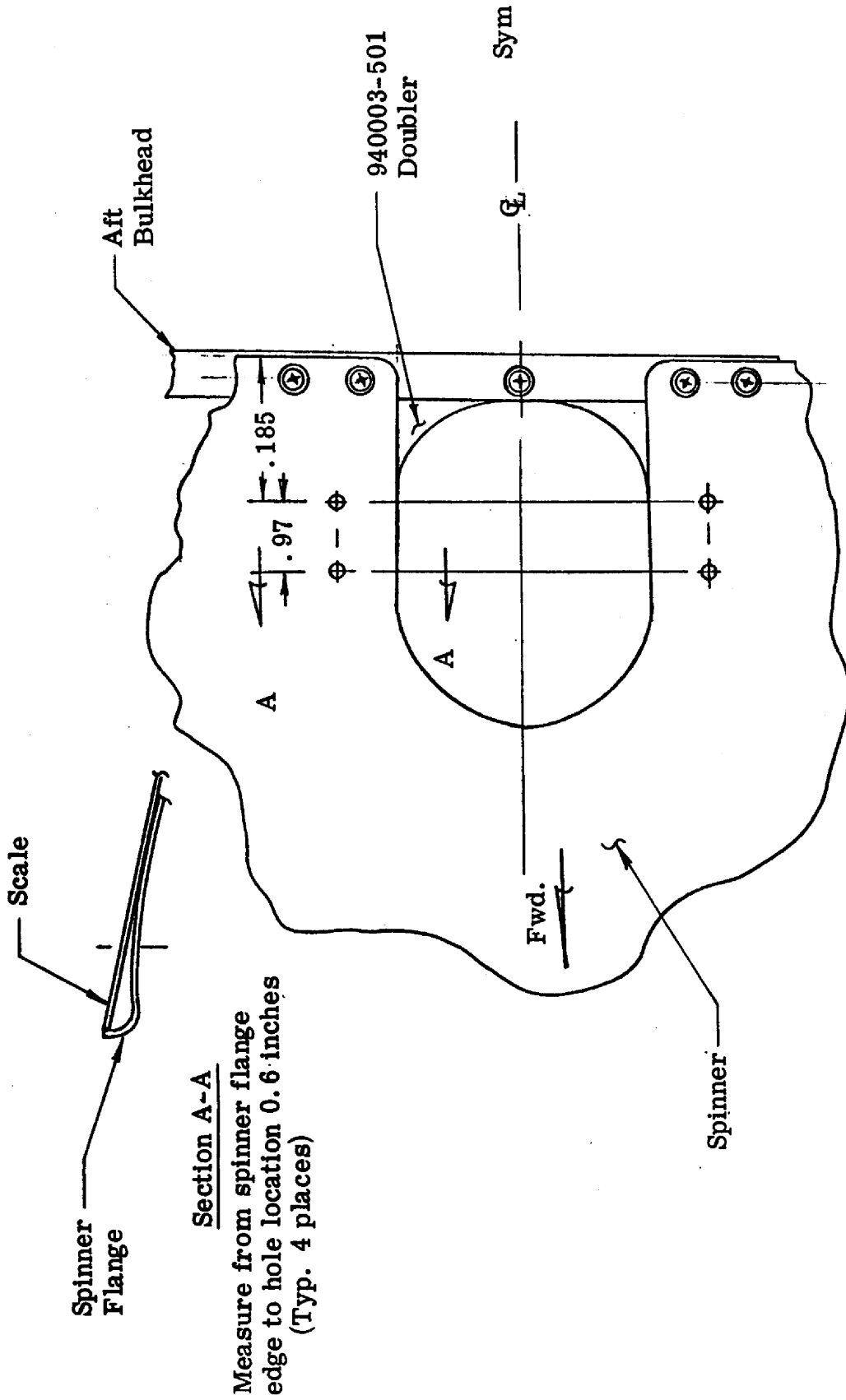


FIGURE 201-2

Spinner Hole Locations