

HARTZELL PROPELLER INC.
SERVICE BULLETIN
HC-SB-61-394

Propellers - Inspection and Modification of Guide Lugs

1. Planning Information

A. Effectivity

- (1) New, in-stock A-3067-() or A-1983 guide lugs
 - (a) New, in-stock A-3067-() guide lugs, Revision Y and prior are affected by this Service Bulletin.
 - (b) New, in-stock A-1983 guide lugs, Revision F and prior are affected by this Service Bulletin.
- (2) A-3067-() or A-1983 guide lugs in stock, inspected or overhauled before September 2020, are affected by this Service Bulletin.
- (3) A-3067-() or A-1983 guide lugs currently in service, or installed in propeller assemblies are NOT affected by this Service Bulletin.

WARNING: DO NOT USE OBSOLETE OR OUTDATED INFORMATION. PERFORM ALL INSPECTIONS OR WORK IN ACCORDANCE WITH THE MOST RECENT REVISION OF THIS SERVICE BULLETIN. INFORMATION CONTAINED IN THIS SERVICE BULLETIN MAY BE SIGNIFICANTLY CHANGED FROM EARLIER REVISIONS. FAILURE TO COMPLY WITH THIS SERVICE BULLETIN OR THE USE OF OBSOLETE INFORMATION MAY CREATE AN UNSAFE CONDITION THAT MAY RESULT IN DEATH, SERIOUS BODILY INJURY, AND/OR SUBSTANTIAL PROPERTY DAMAGE. REFER TO THE SERVICE BULLETIN INDEX FOR THE MOST RECENT REVISION LEVEL OF THIS SERVICE BULLETIN.

B. Concurrent Requirements

- (1) Additional service documents may apply to the components/propellers affected by this Service Bulletin. Compliance with additional service documents may be necessary in conjunction with the completion of the Accomplishment Instructions in this Service Bulletin. Refer to the Hartzell Propeller Inc. website at www.hartzellprop.com for a cross-reference of service documents.

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C. Reason

- (1) In September 2020, the inner diameter of A-3067-() and A-1983 guide lug bushings was changed. Guide lugs shipped from Hartzell, or overhauled, or inspected before September 2020 will have a smaller inner diameter.
- (2) The inner diameter of the guide lug bushing was enlarged to reduce possible interference between the guide lug and beta rod during propeller operation.
- (3) Regulatory action is not expected.

D. Description

- (1) This Service Bulletin provides Instructions for Continued Airworthiness (ICA).
- (2) This Service Bulletin provides inspection and rework procedures for the affected components.

E. Compliance

- (1) This Service Bulletin requires inspection of in-stock A-3067-() or A-1983 guide lugs.
 - (a) Guide lugs identified in the Effectivity section of this Service Bulletin require the inspection and rework specified by this Service Bulletin before installation.

F. Approval

- (1) FAA acceptance has been obtained on technical data in this publication that affects type design.

G. Manpower

Procedure	Man-hours
Inspection	One minute per part
Rework	Two minutes per part

H. Weight and Balance

- (1) Not changed

I. Electrical Load Data

- (1) Not changed

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J. References

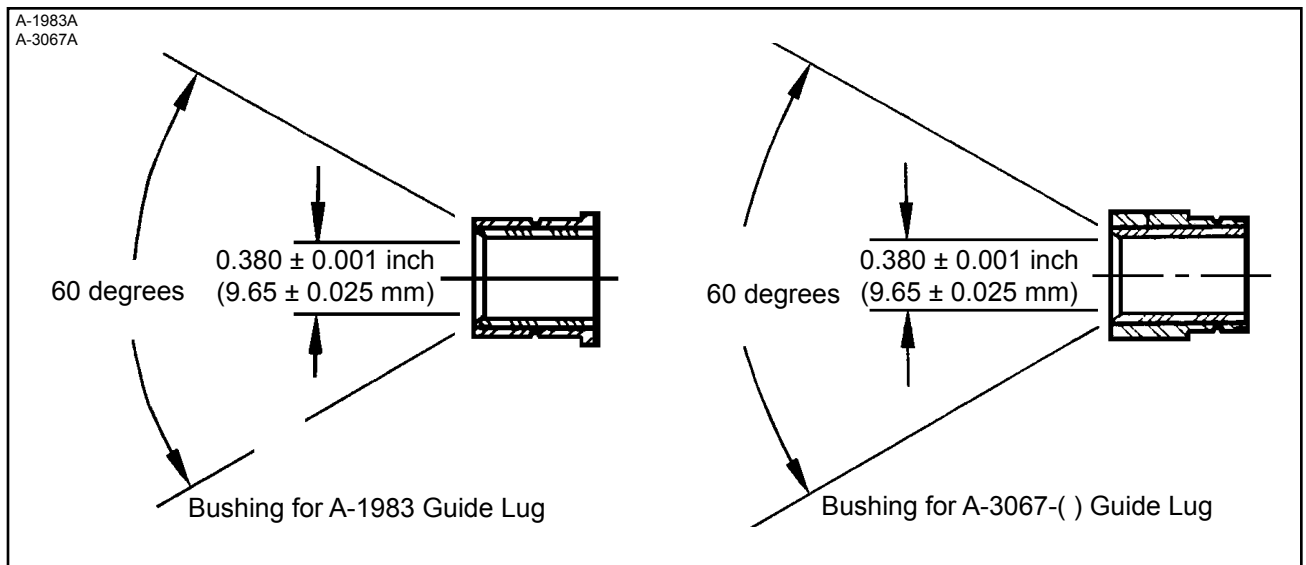
- (1) Hartzell Propeller Inc. Standard Practices Manual 202A (61-01-02) - Volume 8, Special Adhesive and Bonding Procedures.

K. Other Publications Affected

- (1) None

2. Material Information

A. None



Guide Lug Bushing Dimensions
Figure 1

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3. Accomplishment Instructions

CAUTION: INSTRUCTIONS AND PROCEDURES IN THIS ALERT SERVICE BULLETIN MAY INVOLVE PROPELLER CRITICAL PARTS. REFER TO THE APPLICABLE PROPELLER OVERHAUL OR OWNER'S MANUAL FOR INFORMATION ABOUT PROPELLER CRITICAL PARTS.

- A. Measure the ID of the guide lug bushing in accordance with Figure 1.
- (1) If the ID of the guide lug bushing is 0.380 ± 0.001 inch (9.65 ± 0.025 mm):
 - (a) Return the part(s) to stock. Bag the returned part(s) and indicate on the bag compliance with this Service Bulletin.
 - (2) If the ID of the guide lug bushing is less than 0.380 ± 0.001 inch (9.65 ± 0.025 mm):
 - (a) Ream the ID of the guide lug bushing using a self-centering reamer with at least four-flutes in accordance with Figure 1.
 - (b) Examine the ID of the bushing for burring.
 - 1 Deburr the bushing if necessary.
 - (c) Test the bushing in the guide lug with a press out force.
 - 1 Apply 225 pounds (1000 N) to the bushing.
 - (d) The bushing in the guide lug must pass the pressure test.
 - 1 If the bushing fails the pressure test:
 - a Remove and discard the bushing.
 - b Clean the guide lug.
 - c Replace the bushing in accordance with the Special Adhesive and Bonding Procedures chapter of Hartzell Propeller Inc. Standard Practices Manual 202A (61-01-02).
 - (e) Return the part(s) to stock. Bag the returned part(s) and indicate on the bag compliance with this Service Bulletin.

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B. Recommended Service Facilities

- (1) Hartzell Propeller Inc. has a worldwide network of Recommended Service Facilities for overhaul and repair of our products.
- (2) Each service facility must meet standard FAA requirements and additional Hartzell Propeller requirements before being recommended by Hartzell Propeller Inc. Each service facility is audited by Hartzell Propeller Inc. to verify the continuation of the standards.
- (3) Hartzell Propeller Inc. recommends that you use one of these service facilities when having your propeller overhauled or repaired.
- (4) For a current list of Hartzell Propeller Inc. Recommended Service Facilities, contact Hartzell Propeller Inc. Product Support or refer to the Hartzell Propeller Inc. website at www.hartzellprop.com.

C. Contact Information

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