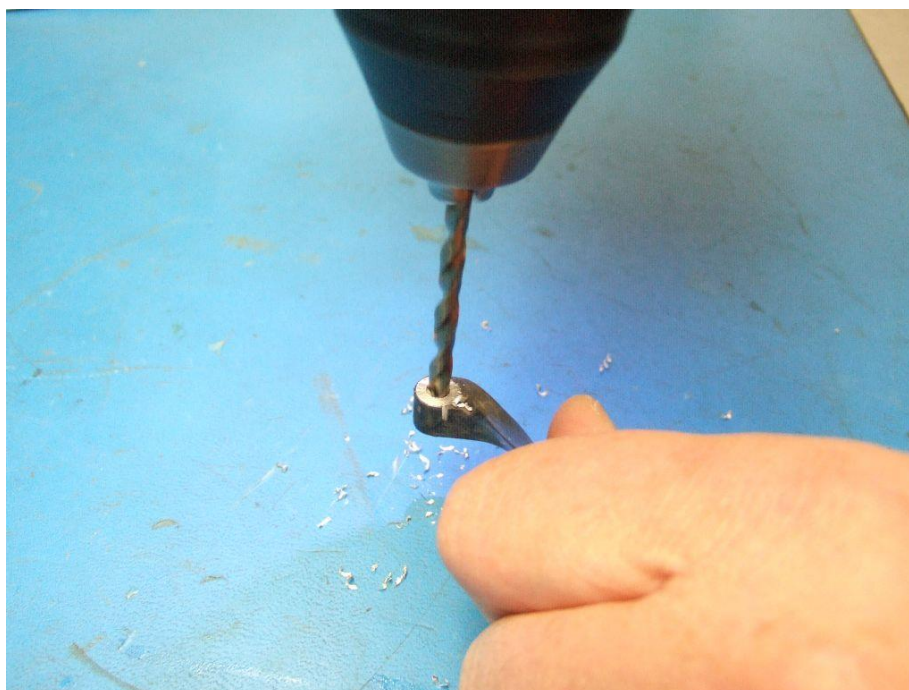


**7.30 Using a hand file round off tip of propellers as shown.**



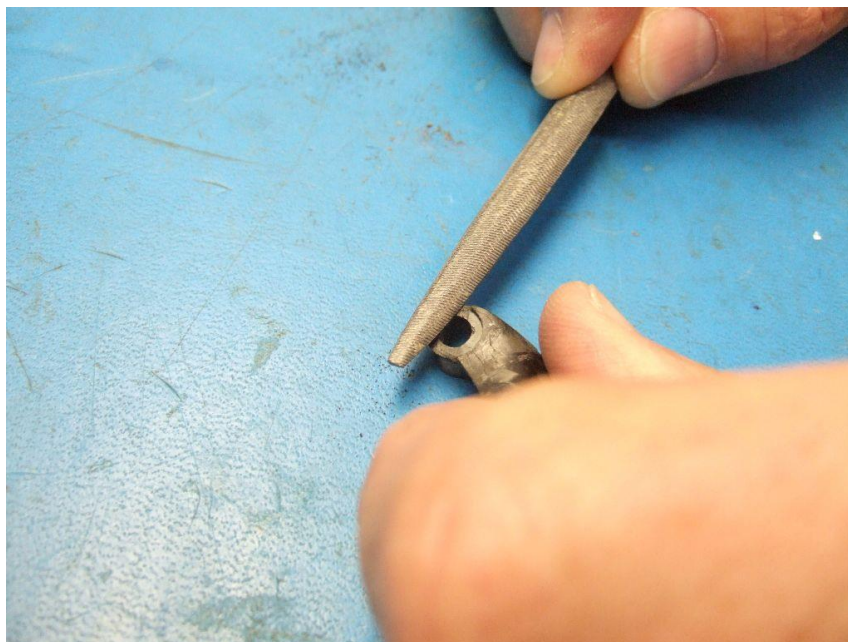
**7.31 Using a hand drill, drill propellers (05777) hole with #16 (11/64") drill to break loose the aluminum bushings.**



**7.32 Using a hand drill, drill propellers (05777) hole with #13 (.185") drill to make the hole wider.**



**7.33 Hand file the hole surface to make it flat so the bushing seats flat on the propeller hole.**







- 7.34 Press in bushing (05728) on each side of the propeller to check for a tight interference fit.**  
**NOTE: If the fit is loose in the hole, then bond the bushing in place with DP 460 epoxy (00958)**





**7.35 Ream through both bushings with 0.1270" ream.**





- 7.36 Test propellers with reamed bushings on dowel pin 05778. Verify free movement (propeller should rotate with just the force of gravity). The propellers are ready for installation. Keep the titanium Nylock nut 04743 with kit for the next level of integration.**



- 7.37 Assemble the propellers onto inside spinner 07903 using 2 titanium 1/8"X1.25" dowel pins 06365. Slide pins into inner spinner to capture propellers.**



- 7.38 Slide inner spinner on to shaft, align with the flats on the shaft and push in place. Note that there is an intentional gap of about 0.5" with the spinner fully seated.**



- 7.39 Slide outer spinner 07902 on to shaft. Secure with an M6 titanium Nyloc nut 04743. Tighten and torque to 30 in-lbs.**



- 7.40 Fully test the thruster assembly per released test procedure**

- 7.41 The thruster assembly is now ready for the next level of integration.**