LRAUV PROP SHAFT ASSEMBLY

3/1/17

3 components-

P-200566-08 Prop Shaft FWD Journal

P-200568-08 Prop Shaft AFT Journal

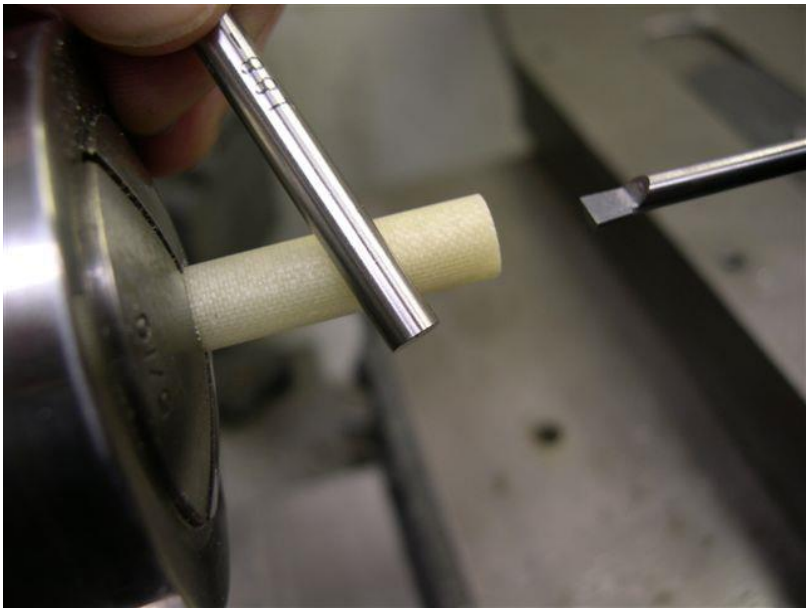
8668K11 McMCarr Epoxy shaft

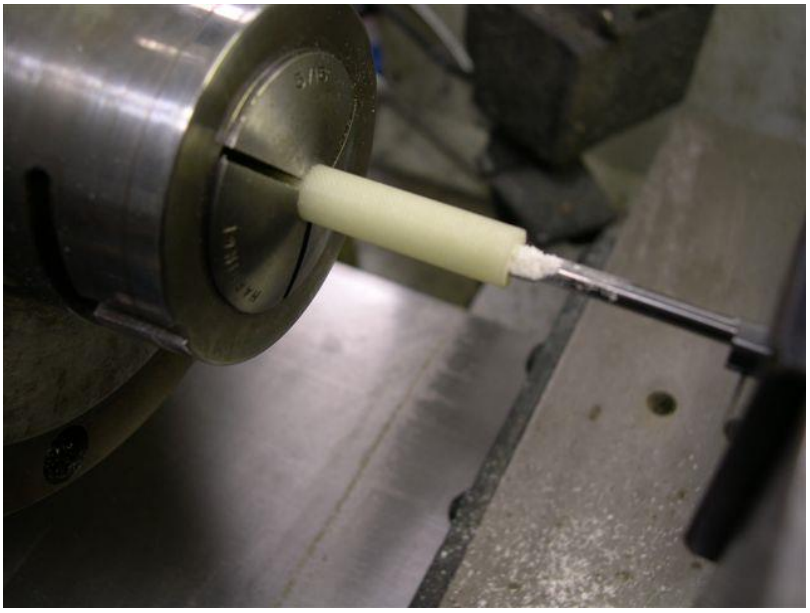
3M DP-420 epoxy and applicator

Preparation of Epoxy shaft-

Cut to 14.596” making sure both ends square. Use small Hardinge Lathe in model shop, 5/16 collet

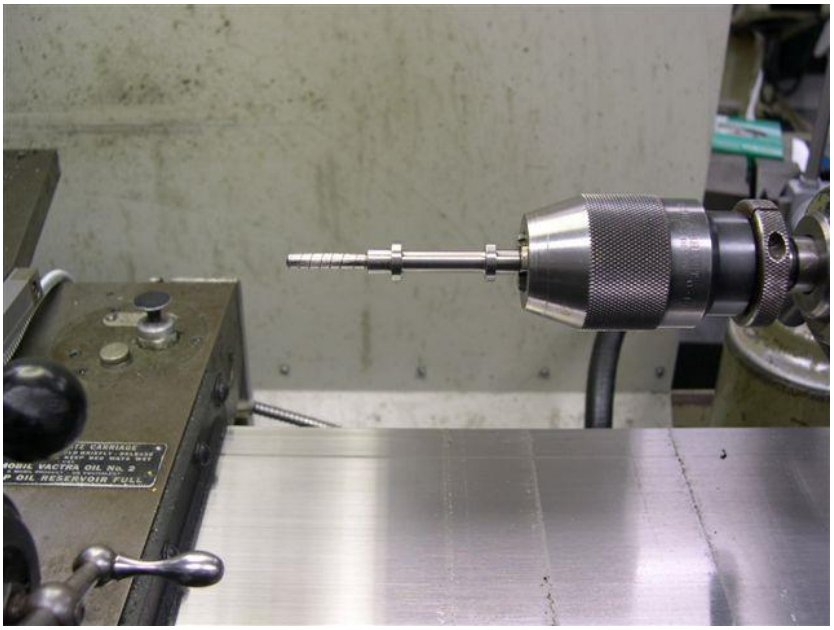
Ends bored with micro boring tool to 0.188 Dia. X 1.1+”Deep, a drill will not straighten out OEM bore. TOOL-Micro 100, BB-1801100-075U





Preparation of Journal inserts-

Sections to be inserted and bonded needs spiral grooving and or aggressive sanding to roughen surface for a more successful bond.



Forward journal in tailstock chuck

Bonding of components-

Roughen ID of tube and OD of shaft with 100-200 grit sand paper
Clean bonding surfaces with acetone
Use the small lathe in the Model Shop to align journal inserts.
Use 5/16 collet to hold AFT journal insert.
Apply and spread some DP-420 on the bonding surface and into the bore of the epoxy shaft.
Using a slow twisting motion run the shaft onto the insert, remove the same way, redistribute the epoxy to ensure good coverage and reinsert.

Similarly, Apply DP-420 to the FWD journal insert, slow twisting motion, repeat.
Tighten drill Chuck gently onto forward journal insert, lock the tailstock, run tailstock forward to fully engage inserts into epoxy shaft. Some epoxy will squeeze out, wipe this off. Leave in this position for a minimum of 2 hrs. before handling. Let sit 24 hrs prior to use.