

HARTZELL PROPELLER INC.
SERVICE LETTER
HC-SL-61-346
Spinner - Bulkhead Modification

1. Planning Information

A. Effectivity

- (1) Hartzell Propeller Inc. spinner bulkheads 104154 and 105178 that were manufactured without drain holes are affected by this Service Letter.
- (a) The affected spinner bulkheads are used in Hartzell Propeller Inc. 104552 and 105180 spinner assemblies and may be installed on, but are not limited to, the aircraft/propeller models listed below:

Aircraft Manufacturer	Tradename	Aircraft Model	Propeller Model	Spinner Assembly	Spinner Bulkhead
Socata	TBM900	TBM700N	HC-E5N-3C	104552	104154
Socata	TBM700 TBM850	TBM700A,B,C1,C2,N	HC-E5N-3C	105180	105178

WARNING: DO NOT USE OBSOLETE OR OUTDATED INFORMATION. PERFORM ALL INSPECTIONS OR WORK IN ACCORDANCE WITH THE MOST RECENT REVISION OF THIS SERVICE LETTER. INFORMATION CONTAINED IN THIS SERVICE LETTER MAY BE SIGNIFICANTLY CHANGED FROM EARLIER REVISIONS. FAILURE TO COMPLY WITH THIS SERVICE LETTER 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 LETTER INDEX FOR THE MOST RECENT REVISION LEVEL OF THIS SERVICE LETTER.

B. Concurrent Requirements

- (1) Additional service documents may apply to the components/propellers affected by this Service Letter. Compliance with additional service documents may be necessary in conjunction with the completion of the Accomplishment Instructions in this Service Letter. 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) Hartzell Propeller Inc. has received reports of water accumulating inside the spinner dome on spinner assemblies that use the affected spinner bulkheads.
 - (a) In certain conditions, the accumulated water can freeze and cause the propeller to be out of balance.
- (2) Hartzell Propeller Inc. has redesigned the 104154 and 105178 spinner bulkheads with evenly spaced drain holes to prevent water accumulation inside the spinner dome.
 - (a) Hartzell Propeller Inc. spinner assemblies 104552 and 105180 will include the redesigned 104154 and 105178 spinner bulkheads with drain holes when production/manufacturing changes are implemented.
 - (b) The spinner bulkhead modification procedure in this Service Letter provides instructions for drilling the drain holes in affected spinner bulkheads manufactured before the design change.
- (3) Regulatory action is not expected.

D. Description

- (1) This Service Letter provides Additional Maintenance Information (AMI).
- (2) This Service Letter provides instructions for adding drain holes to affected spinner bulkheads.

E. Compliance

- (1) Compliance with the spinner bulkhead modification is optional, but strongly recommended by Hartzell Propeller Inc.
 - (a) Complete the spinner bulkhead modification in accordance with the Accomplishment Instructions in this Service Letter.

F. Approval

- (1) This technical document is approved by Hartzell Propeller Inc.

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G. Manpower

Procedure	Allowable Man-hours
Spinner Removal and Installation	0.5 hour
Spinner Bulkhead Modification	1 hour

CAUTION: DO NOT USE OBSOLETE OR OUTDATED INFORMATION. PERFORM ALL INSPECTIONS OR WORK IN ACCORDANCE WITH THE MOST RECENT REVISION OF A DOCUMENT.

H. References

(1) Hartzell Propeller Inc. Propeller Owner's Manual 147 (61-00-47)

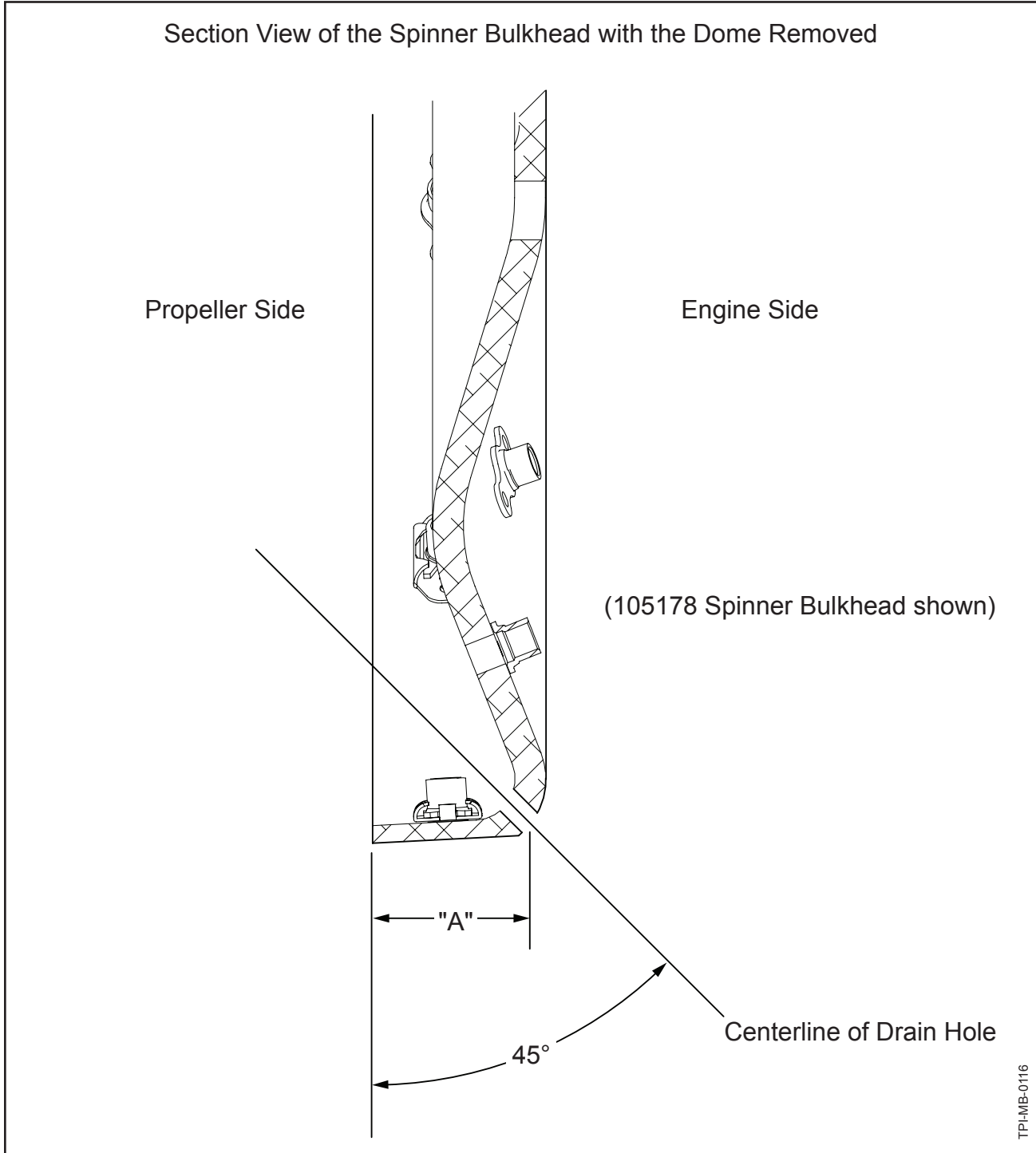
I. Other Publications Affected

(1) Hartzell Propeller Inc. Metal Spinner Maintenance Manual 127 (61-16-27)

2. Material Information

A. None

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Spinner Bulkhead Drain Hole Location
Figure 1

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3. Accomplishment Instructions

A. Spinner Bulkhead Modification

- (1) The following procedure may be performed on-wing by a certified aircraft mechanic with the appropriate rating or by a certified propeller repair station with the appropriate rating.
- (2) Remove the spinner dome in accordance with Hartzell Propeller Inc. Propeller Owner's Manual 147 (61-00-47).
- (3) Using a center punch, mark the location of the five holes to be drilled in the outside radius of the spinner bulkhead. Refer to Figure 1 and Table 1.
 - (a) The drain holes must be evenly spaced from each other at the midpoint between the blade cutouts.
 - (b) Refer to Table 1 for dimension "A"

CAUTION: DO NOT DAMAGE THE NUTPLATES WHEN DRILLING THE DRAIN HOLES THROUGH THE SPINNER BULKHEAD.

- (4) Using a 0.250 inch diameter drill bit, drill five holes through the spinner bulkhead.
- (5) Deburr both the inside (engine-side) and outside (propeller-side) of the holes using a deburring tool.
 - (a) If the inside of the bulkhead is difficult to access, it may be deburred the next time the propeller is removed. The outside must be deburred to avoid damage to the spinner.
 - (b) Remove all metal shavings caused by drilling/deburring the drain holes.

Spinner Bulkhead	Dimension "A"	Additional Instructions
104154	1.050 ±0.010 inch (26.67 ±0.25 mm)	Center the hole between the fixed nutplates
105178	0.950 ±0.010 inch (24.13 ±0.25 mm)	Center the hole over the fixed nutplate

Drain Hole Dimension "A"
Table 1

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- (6) Install the spinner dome in accordance with Hartzell Propeller Inc. Propeller Owner's Manual 147 (61-00-47).
- (7) Make an entry in the propeller logbook indicating the spinner bulkhead modification was completed in accordance with this Service Letter.

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

Hartzell Propeller Inc.
Attn.: Hartzell Propeller Inc. Product Support
One Propeller Place
Piqua, Ohio 45356-2634 USA
Phone: (001) 937.778.4379
Fax: (001) 937.778.4391
E-mail: techsupport@hartzellprop.com

HARTZELL PROPELLER INC.
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1. Eligibility

A. Hartzell Propeller Inc. spinner bulkheads 104154 and 105178 that were manufactured without drain holes are eligible for this warranty program.

- (1) The affected spinner bulkheads are used in Hartzell Propeller Inc. 104552 and 105180 spinner assemblies and may be installed on, but are not limited to, the aircraft/propeller models listed below:

Aircraft Manufacturer	Tradename	Aircraft Model	Propeller Model	Spinner Assembly	Spinner Bulkhead
Socata	TBM900	TBM700N	HC-E5N-3C	104552	104154
Socata	TBM700 TBM850	TBM700A,B,C1,C2,N	HC-E5N-3C	105180	105178

2. Warranty Expiration

A. This warranty program expires on October 31, 2016.

3. Recommended Service Facilities

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

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4. Warranty Program

A. Labor

- (1) Hartzell Propeller Inc. will authorize payment for the allowable labor charges when the spinner bulkhead modification is performed in accordance with the Accomplishment Instructions in this Service Letter.
 - (a) Refer to the Manpower section of this Service Letter for warranted procedures and allowable man-hours.
 - 1 Hartzell Propeller Inc. will authorize payment for warranty labor charges up to, but not to exceed \$100.00 USD per hour.
 - (b) Complete and sign the Compliance Form in this Service Letter Appendix.
 - 1 Send the signed Compliance Form and the invoice for labor charges associated with the spinner bulkhead modification to Hartzell Propeller Inc. for processing.

B. Contact Information

- (1) Fax, Email, or mail the Compliance Form to:

Hartzell Propeller Inc.
Attn: Service Bulletin 356 Coordinator
One Propeller Place
Piqua, OH 45356 USA
Phone: 937.778.4379
Fax: 937.778.4391 (Intl. 001.937.778.4391)
Email: techsupport@hartzellprop.com

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Compliance Form

Warranty Claim Number:		
Propeller Information:		
Propeller Model:	Propeller S/N:	
Aircraft Model:	Aircraft Registration #:	
Owner Information:		
Name:		
City:	State:	
Zip/Postal Code:	Country:	
E-mail:	Phone:	
Repair Facility:		
Company:	Contact Name:	
Address:		
City:	State:	
Zip/Postal Code:	Country:	
E-mail:	Phone:	Fax:
Labor Charges for Spinner Bulkhead Modification:		
<p>Refer to the Manpower section of this Service Letter for warranted procedures and allowable man-hours. Include a copy of the invoice for labor charges associated with the spinner bulkhead modification when sending this Compliance Form to Hartzell Propeller Inc. for processing.</p>		
Signature:		
Repair Technician's Signature:	Date:	
<p>Send this completed and signed form to Hartzell Propeller Inc. Product Support Department: Fax - (001) 937.778.4391 or E-mail - techsupport@hartzellprop.com</p>		

DO NOT WRITE BELOW THIS LINE - FOR HARTZELL PROPELLER INC. USE ONLY

Authorized By:

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