

HARTZELL PROPELLER INC.
SERVICE INSTRUCTION
TRANSMITTAL SHEET
HC-SI-61-213

DT-1724-5 Rolling Machine - Uncrating Instructions

October 06, 2021

This page transmits a revision to Service Instruction HC-SI-61-213.

- Original Issue, dated Sep/19
- Revision 1, dated Dec 17/20
- Revision 2, dated Oct 06/21

Changes are shown by a change bar in the left margin of the revised pages.

Revision 2 is issued to change the following in the Service Instruction:

- Revised Anticorit corrosion preventative to Corrosion Inhibitor where applicable.

This Service Instruction is reissued in its entirety.

HARTZELL PROPELLER INC.

SERVICE INSTRUCTION

TRANSMITTAL SHEET

HC-SI-61-213

DT-1724-5 Rolling Machine - Uncrating Instructions

(This page is intentionally blank.)

HARTZELL PROPELLER INC.
SERVICE INSTRUCTION
HC-SI-61-213

DT-1724-5 Rolling Machine - Uncrating Instructions

WARNING: THE DT-1724-5 AUTOMATED ROLLING MACHINE WEIGHS APPROXIMATELY 700 POUNDS.

NOTE: The DT-1724-5 automated rolling machine crate is designed for the removal of all four sides, if necessary.

1. Uncrating the DT-1724-5 Automated Rolling Machine Crate

A. Required Tooling

- (1) The following tools are necessary for the removal of the DT-1724-5 automated rolling machine.
 - 3/16 inch Allen Wrench
 - Torx Star Driver/Bit T25
 - Utility Knife

B. Procedure

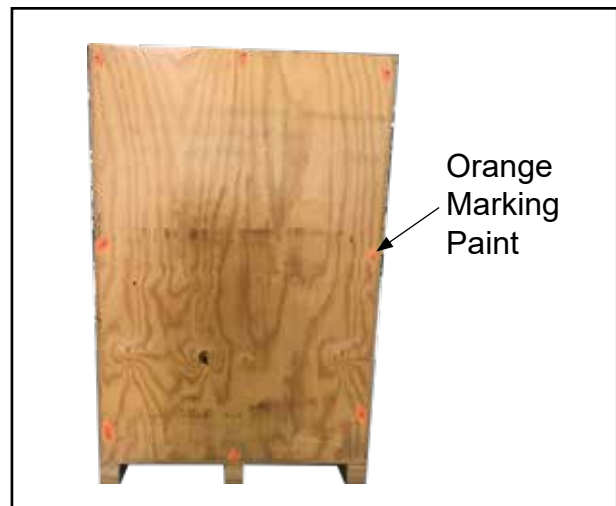
- (1) Remove the front panel of the crate. Refer to Figure 1.

NOTE: The paperwork will be attached to the front panel of the crate.

- (a) Remove all star drive screws marked in orange marking paint from the front crate panel.
 - (b) Remove the front crate panel.
- (2) Remove the back panel of the crate. Refer to Figure 2.
 - (a) Remove all star drive screws marked in orange marking paint from the back crate panel.
 - (b) Remove the back crate panel.



Crate Front
Figure 1



Crate Back
Figure 2

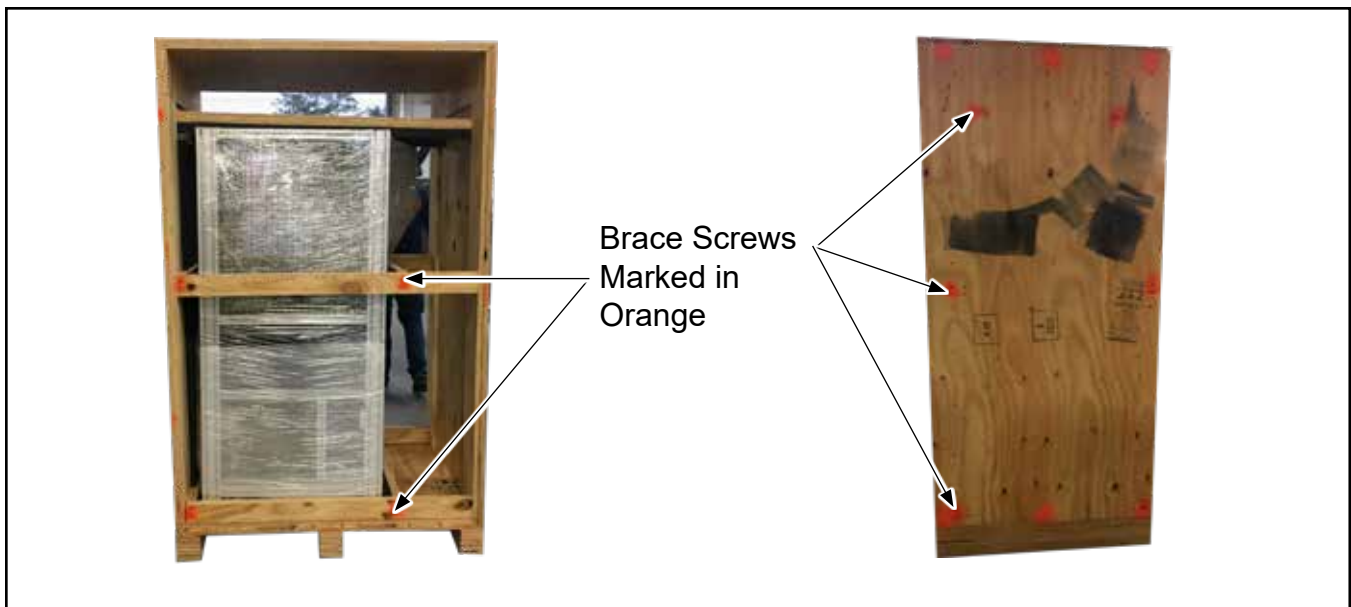
HARTZELL PROPELLER INC.
SERVICE INSTRUCTION
HC-SI-61-213

DT-1724-5 Rolling Machine - Uncrating Instructions

- (3) Remove the braces from the crate that hold the automated rolling machine in position. Refer to Figure 3.

NOTE: All brace screws to be removed are marked with orange marking paint

- (a) Remove the two plywood 2 x 4 braces from the inside sides of the automated rolling machine crate.
 - (b) Remove the two plywood 2 x 4 braces from the top of the automated rolling machine crate.
 - (c) Remove the two plywood 2 x 4 braces from the back of the automated rolling machine crate.
 - (d) Remove the two plywood 2 x 4 braces from the front of the automated rolling machine crate.
- (4) The automated rolling machine can now be removed from the crate with a tow motor or equivalent. If necessary, the crate sides and top can also be removed as a single U-shaped piece as follows:
- (a) Remove the orange marked screws from the both sides of the crate bottom.
 - (b) Move the sides and top of the crate off the crate base.



**Brace Screws
Figure 3**

HARTZELL PROPELLER INC.
SERVICE INSTRUCTION
HC-SI-61-213

DT-1724-5 Rolling Machine - Uncrating Instructions

- (5) Remove the automated rolling machine from the crate.

CAUTION 1: THE USE OF STRAPS WILL CRUSH THE AUTOMATED ROLLING MACHINE CAGE.

CAUTION 2: WHEN USING A TOW MOTOR, MAKE SURE THE TOW MOTOR FORKS GO UNDER THE FRONT OF THE DT-1724-5 AUTOMATED ROLLING MACHINE AND EXTEND SIX TO EIGHT INCHES OUT THE BACK.

NOTE 1: Lifting the rolling machine from the bottom will not damage the automated rolling machine.

NOTE 2: Hartzell Propeller Inc. recommends using a tow motor to move the automated rolling machine.

- (a) Using a tow motor, remove the automated rolling machine from the crate.
- 1 Make sure there is no interference with the automated rolling machine and the tow motor forks.
 - 2 Position the tow motor forks under the automated rolling machine.
 - 3 Lift the automated rolling machine slowly with the tow motor.
 - a Make sure the automated rolling machine stays on the tow motor forks.
 - 4 Move the automated rolling machine out of the crate.
 - 5 Carefully position the automated rolling machine in the applicable location. Refer to Figure 4.

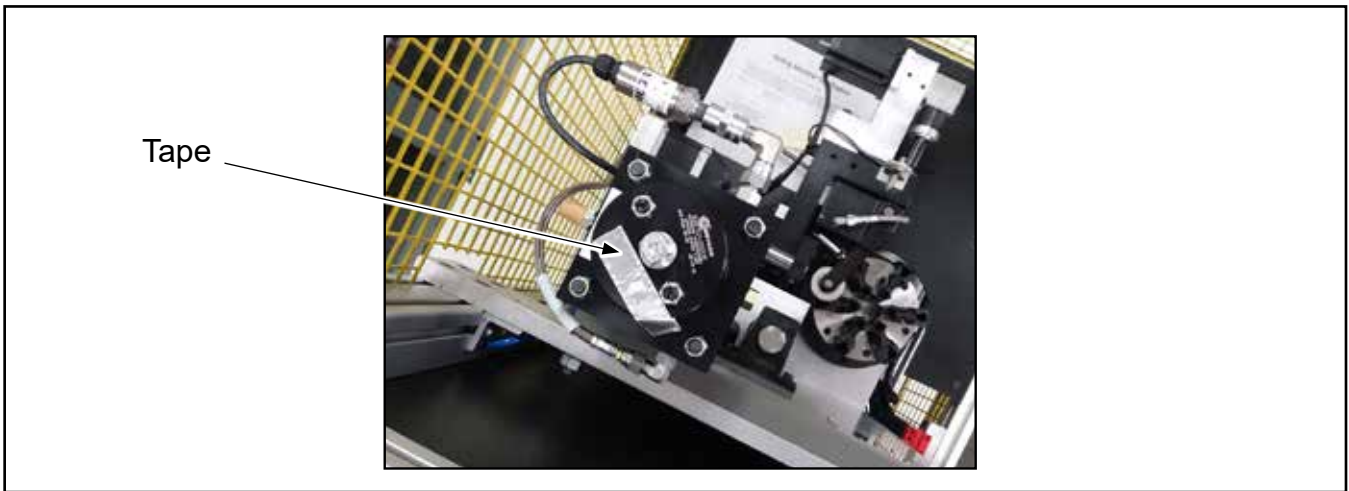


Rolling Machine Removal
Figure 4

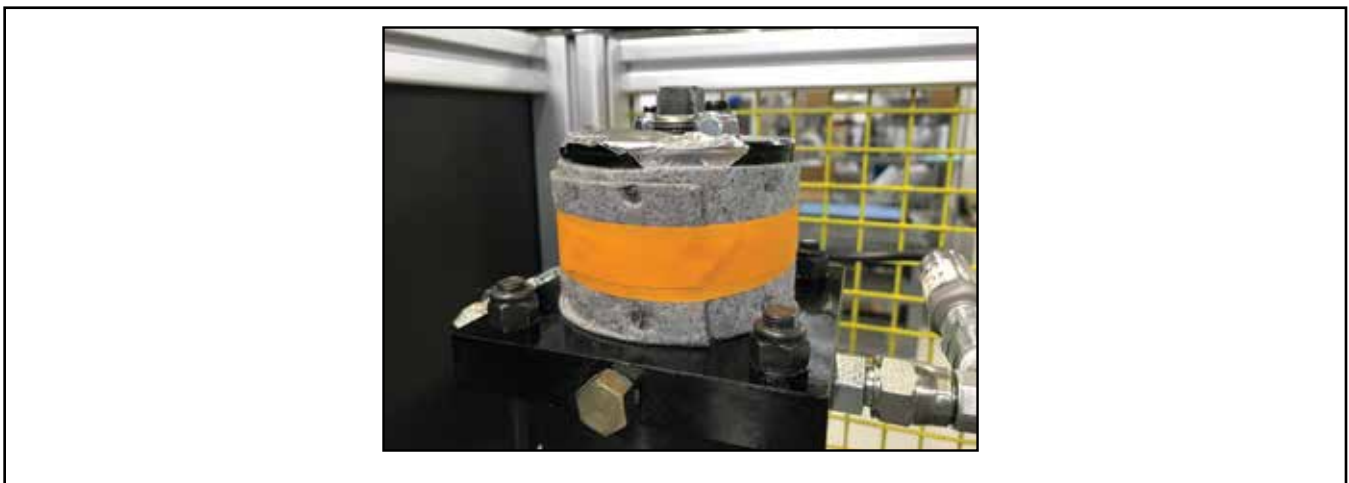
HARTZELL PROPELLER INC.
SERVICE INSTRUCTION
HC-SI-61-213

DT-1724-5 Rolling Machine - Uncrating Instructions

- (6) Remove the stretch wrap from the automated rolling machine.
- (7) Remove the foam from the bottom of the automated rolling machine.
- (8) Remove the protective PIGmat material and tape from the air/oil booster (410). Refer to Figures 5 and 6.
 - (a) Clean any residual oil and remaining adhesive left by the tape removal.



Tape Removal
Figure 5



PIGmat Material Removal
Figure 6

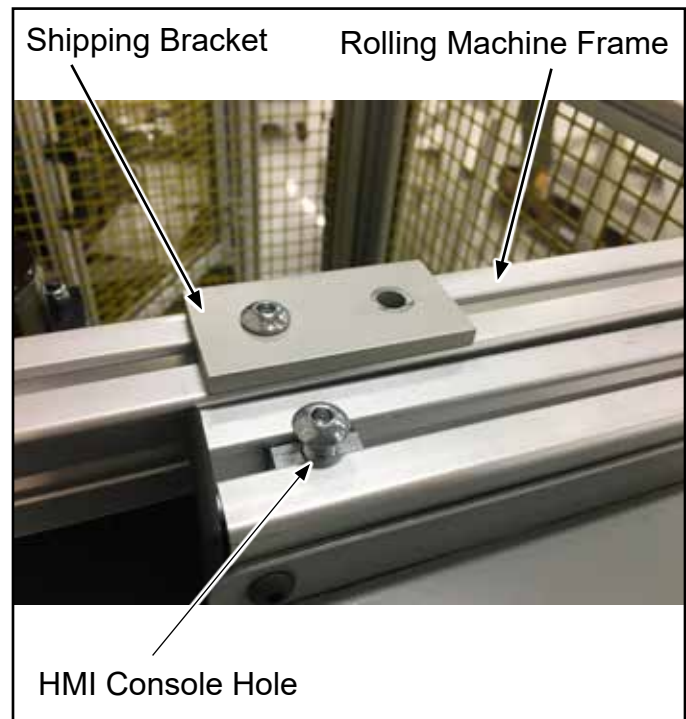
HARTZELL PROPELLER INC.
SERVICE INSTRUCTION
HC-SI-61-213

DT-1724-5 Rolling Machine - Uncrating Instructions

- (9) Many bare steel and black-oxide plated parts of this machine were preserved with Corrosion Inhibitor CM341 before shipment, leaving a waxy film.
 - (a) If desired, remove the Corrosion Inhibitor CM341 residue by wiping down the treated components with a clean towel/rag soaked in acetone CM11 or MEK CM106.
 - (b) While cleaning, avoid acetone CM11 or MEK CM106 contact with any electronic components.
- (10) Using a 3/16 inch allen wrench, remove the screw from the shipping bracket connecting the HMI console to the automated rolling machine. Refer to Figure 7.
- (11) Loosen the screw that is attached to the automated rolling machine frame.
- (12) Turn the shipping bracket so that it is parallel to the automated rolling machine frame.
- (13) Tighten the screw that is attached to the automated rolling machine frame.
- (14) Put the other screw into the open HMI console hole and tighten. Refer to Figure 8.
- (15) Refer to the DT-1724-5 Automated Rolling Machine Maintenance Manual 178 for the DT-1724-5 automated rolling machine setup.



Shipping Bracket Screw
Figure 7



HMI Console Hole
Figure 8

**READ
BEFORE
OPENING
THIS
CRATE**