

HARTZELL PROPELLER LLC
SERVICE INSTRUCTION INDEX - November 05, 2025
(excluding HD series propeller and systems)

1A	09/23/75	Installation of C-2052, C-2052-1, or C-2052-3 Governor and "T" Drive Kit on Bonanza.
2	03/01/55	Installation of Tee Drive C-192-2 for hydraulic & vacuum pump.
3	12/01/52	Installation of HC-12X20-8/8428 on Grumman G-44 and G-44A.
4	obsolete	Installation of HC-12X20-9 propeller and C-252-2 "T" drive with A-1 governor.
5	01/13/59	For -7 & -8 propellers.
6	obsolete	Hartzell model D-164 propeller spinner.
7	obsolete	Hartzell propellers HC-82XF-2, HC-82XG-2.
8	obsolete	Instructions for installation of propeller anti-icing equipment on Hartzell model HC-83XF-2/9333-3 propeller-spinner assembly for Beech Model D50 Twin Bonanza.
9	obsolete	Installation of propeller models HC-93Z20-2()/10152-5½, HC-B3Z30-2()/10152-5½, and HC-B3Z30-2()/10152-6 on Pratt & Whitney R-985 engine for use on Beech Model C-18S, E-18S, and D-18S, AT-11, C-45G, and C-45H, Lockheed 12A Aircraft and Grumman Goose G-21A.
10	obsolete	Retipping Hartzell propeller blades
11	01/16/59	HC-12X20-8D/8433-6 propellers.
12	obsolete	Hartzell models HC-82X series propellers.
13	obsolete	Installation instructions for Hartzell propeller model HC-93Z20-1A.
14	07/06/51	Installation of "T" Drive C-137-2 for governor & fuel pump.
15	obsolete	Installation instructions for Hartzell propeller HC-82X20-3/9333C on the Continental Artouse I turboprop.
16 thru 49	not issued	
50A	03/04/75	Installation of HC-83XF-2A/9333C-3, HC-A3XF-2()/9333C-3, or HC-A3VF-2()/9333C-3 propeller on Lycoming GO-480-F6 and GO-480-F1A6 engines installed in Beech Model C-50.
51	obsolete	Installation of Hartzell HC-12X20-8D/9333C propeller.
52B	04/02/62	Installation of Hartzell accumulator unfeathering kit SK-212-2 on PA-23.
53A	01/18/71	Hartzell Unfeathering Kit SK-212-2 & SK-212-1.
54	obsolete	Hartzell Cyclematic propeller.
55	obsolete	Replacing A-1307 Split Rings with A-1331 Rings in the HC-93Z20-2C and -2B Propeller.
56	obsolete	Replacing the A-159 Split Rings.
57	obsolete	Information is out of date. Replacement for A-1331 in the HC-93Z Propeller.
58	obsolete	Use of Proper O-ring on Spring Assemblies.
59B	obsolete	Installation of Rubber Ant-Icing Boots on Propeller Blades Goodrich Feed Shoe 37572-6-1 (C-2131).
60	obsolete	Two-position propeller Model HC-92ZK-2A (Special) installed on Lycoming O-360 engine.
61	obsolete	Increasing counterweight length on HC-92ZF-1D1/8447 (Beech 33).
62	obsolete	Installation of the HC-83XF-3A Reversible Propeller on the Lycoming GO-480 Engine.
63	obsolete	Instructions for propeller model HC-82XK-3A/8433P-23.8.
64	obsolete	Service Instructions for Propeller Model HC-A2X20-1.
65	obsolete	Service Instructions for Propeller Models HC-A3X20-2, -2L.
66	obsolete	Installation of B-1803-1 Cylinder on C-1853 Hub Spider of Propeller Models HC-B3Z30 and HC-93Z30.
67D	08/26/81	HC-A2(X,V)20-4() installed on Continental E-185, E-205, and E-225.
68C	obsolete	Installation instructions for propeller model HC-A2(X,V)20-4 installed on the Beech Models 35 to G35 aircraft.

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69	obsolete	Installation of Hartzell pressure sensitive decals.
70	11/13/61	Installation of A-2060 or A-2060-1 governor & "T" drive kit on Navion.
71	obsolete	Service instructions for propeller model HC-A3XF-2 in lieu of a new manual.
72	obsolete	Conversion of "Z" shank propellers to "W" shank propellers.
73	obsolete	Installation and operation of HC-A2X()-G propeller.
74	obsolete	Conversion of "X" shank propellers to "V" shank propellers.
75	obsolete	Conversion of the HC-B3TN-5 propeller to the HC-B3TN-5A propeller.
76	obsolete	Blade tape installation on "compact" propellers.
77	obsolete	Conversion of the HC-B3TN-5A propeller to the HC-B3TN-5B propeller.
78	obsolete	Instructions for Using C-845 Fixture.
79	obsolete	HC-B3TN-3B, -3C Propeller, Adjustment of the B-3001-2 Collar on Assembly.
80	obsolete	Removal and installation of the Hartzell propeller model HC-B3TN-5.
81	obsolete	Information is out of date. Installation of A-3238 counterweight slugs on early HC-F2YR-2/C7479.
82	obsolete	Mounting A-3432 or A-3433 stop mounting kit on HC-B3TN-3()Y propeller
83	06/04/68	Installation of D-2185 unfeathering kit on Beech 18 series aircraft.
84	obsolete	Replacement of bronze bushings in blade shanks of the "X" and "Z" types.
85	08/25/69	Installation of HC-B3WF-2 and spinner model 835-29.
86	obsolete	Instructions for Converting Right-Hand Rotation Propeller into a Left-Hand Rotation Propeller.
87	obsolete	Installation of B-3202 Counterweights
88	obsolete	Setting Sensitivity of Eddy Current Instrument.
89	obsolete	Coating Balance Hole in Blades
90	obsolete	Reassembly of propellers that have blades removed for convenience of shipping (Propeller models HC-B(3,4) () () series)
91A	obsolete	Installation of helicopter anti-overspeed kit D-3520-1
92B	obsolete	No longer applicable. Installation of helicopter anti-overspeed kit D-3520-2.
92Bs1	obsolete	No longer applicable. Supplement No. 1 - Installation of anti-overspeed kit on Hughes 300C.
93A	obsolete	Included in Hartzell Blade Manual 133B. Installation of helicopter anti-overspeed kit D-3520-2 onto the Hughes 300L model helicopter.
94	not issued	
95A	11/25/75	Installation of propeller damper kit A-1583.
96	obsolete	Installation of B-1963-1 restraint unit on the HC-B3()20 and HC-93Z20-2C1 propeller assembly right-hand rotation
97	not issued	
98A	obsolete	Blade Inspection.
99	obsolete	Operating advisory for air-charged propellers.
100	obsolete	Addition of counterweight mass to basic B-3202-6 counterweights on BHC-L2YF-4F/FC8468AR propeller installed on a Beech T-34.
101	obsolete	Set-up instructions for ED-520 test instrument.
102J Rev. 1	08/18/03	Installation instructions for A-1588D Feather Assist Spring Assembly Kit. (Ref. AD 75-22-14)
103	obsolete	Composite blade inspection.
104	obsolete	Incorporated in Manual 202A. Reposition of A-48-() balance weights on propeller blade clamps to bulkhead unit.
105A	obsolete	Incorporated in Manual 117D. Installation instructions for the A-1587 or A-1587-1 Feather Spring Kit.
106A	obsolete	Propeller Care and Inspection.
107	obsolete	Replacing slimserts installed in counterweighted blades that may have been inadvertently damaged and need replacement. Obsolete 06/30/22.

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108	obsolete	Overhaul procedures for the C-1576 Damper.
109	obsolete	Incorporated in Manuals 113B, Rev. 22 (Jun/00), 117D, and 202A. Installation of "rubbing plates" on the B-2457-3 Pitch Change Fork.
110	obsolete	Operation procedures for Hartzell DT-1724 machine for rolling "Y" shank blades.
111	obsolete	Operation of Hartzell DT-1724-1 machine for rolling "Y" shank blades.
112A	obsolete	Procedure to establish blade reference stations for "Y" shank blades.
113	obsolete	Field blade straightening limits for propeller blades.
114A	obsolete	Incorporated in Manual 202A (Mar/93). Mandatory Retirement Procedures for all Serialized Parts Which Are No Longer Airworthy.
115	obsolete	Operation of Hartzell DT1724-2 machine for rolling M, P, R, T, W, Y and Z shank blades.
116	obsolete	Bearing fit for Hartzell aluminum hub type propellers.
117	obsolete	Incorporated in Manual 202A. Approved application and procedures for adhesives and gasket compounds.
118	obsolete	Incorporated in Manual 115N, Rev. 6 (Jan/99). Procedure to change propeller spinner dome attaching lock nuts.
119	obsolete	Operation of Hartzell DT-1724-2 machine for rolling M, P, R, T, W, and Z shank blades.
120A	obsolete	Installation of lubricated propeller mounting bolts in turbine propellers.
121C	obsolete	Erosion protection of blade leading edges.
122A	obsolete	Eddy Current Blade Inspection Technique.
123	not issued	
124	obsolete	Cold Rolling Procedures for M, P, R, T, W, Y, and Z Shank Blades.
125	obsolete	Assembly and Field Adjustment of External Feather Stop on HC-B3TN-3() Series Propellers.
126A	obsolete	Replacement Instruction for the B-830-25 High Pitch Stop Assembly Installed on the HC-B3TN-5 () Propeller Assembly.
127	obsolete	Reassembly Procedures for Propellers Which have had blades Removed for convenience of Shipping (Propeller Models HC-B(3,4,5)() Series).
128	not issued	
129A	obsolete	Fit of A-3044 Carbon Block Assembly to Beta Low Stop Collar.
130	obsolete	Incorporated in Manual 115N, Rev. 6 (Jan/99). Spinner installation instructions for lightweight compact propellers.
131C	obsolete	Incorporated in Manual 133C. Operation Procedures for DT1724-() Blade Rolling Machine.
132	not issued	
133	not issued	
134A	obsolete	Information is out of date. Inner clamp bolt torque reproof procedure.
135	obsolete	Instructions to Remove Turbine Propeller Feathering Spring Assembly and Re-set Reverse and Feather Blade Angles.
136	10/23/81	Speedi-Sleeve, #249, installation on HC-A2(V,X)20-4A1.
137	obsolete	Replacement Procedures for the Installation of B-838-97L Blade Clamp Assembly on the HC-B4MN-5()/LM10585B+4 Propeller Assembly
138	obsolete	Blade Shank Rework Procedures for the LM10585+4 Propeller Blade.
139A	obsolete	Incorporated in Manual 118F. Procedure to replace B-830-34(L) Start Lock Assy. and set start lock blade angle, HC-B4()()-5(L).
140A Rev. 9	03/30/05	Propeller installation using B-3339 Attaching Bolt. (Ref. AD 83-08-01R2)
141	not issued	
142	not issued	
143A	obsolete	Obsolete information. Replacement of A-3026 Carbon Block in the A-3044 assembly.

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144G	obsolete	Incorporated in Manual 202A (Mar/93) - Aluminum Hub Overhaul section. Additional overhaul requirements for all aluminum propeller hubs.
145A	obsolete	Incorporated in Manual 118F, Rev. 4 (Oct/97). Procedures to establish proper fit between cylinder and hub when high pitch stop assemblies are installed on the piston guide collar of HC-B3TN-5N(), -5M() and -5P()
146B	obsolete	Incorporated in Manual 118F, Rev. 4. Inspection procedures for A-2620-1 Pin in the B-830-36 high pitch stop.
147A	obsolete	Incorporated in Manual 118F. Repairability scheme for C-3021-() Piston and C-2303-3() .
148B	obsolete	Incorporated in Manual 202A. Dynamic Balance Procedures.
149	obsolete	Incorporated in Manual 117D. Assembly procedures for the HC-C3YF-5F propeller.
150	obsolete	Incorporated in Manual 202A - Blade Clamp Overhaul (Rev.7). Inspection Procedure to Assure Adequate Counterweight/Clamp Contact.
151	08/31/83	Conversion of HC-A3VF-7 to HC-A3VF-7B on Nomad Aircraft.
152A	obsolete	Reuse of hub bolts in aluminum hub propellers. Obsolete 7/01/15 replaced by HC-SL-61-348
153	obsolete	Precautions, procedures, and tooling for removal of pilot tubes from the HC-B()()()-() steel hub.
154	obsolete	Repair of corroded leading edge securing screws on the LM10585()()+4 composite propeller blade.
155	obsolete	Nickel leading Edge Etching/Priming Procedure
156	obsolete	Removal of Adhesively Bonded Leading Edges
157	obsolete	Secondary Bonding of Nickel Leading Edges to Blade Model M10585A+4.
158	obsolete	Incorporated in Manual 118F. Assembly instructions for B-830-37(L) Start Lock and B-834-23 Guide Collar.
159C Rev. 1	06/26/08	Inspection procedures for all C-3-() double shoulder clamps. (Ref. AD 85-14-10R2)
160	obsolete	Incorporated in Manual 118F, Rev. 4 (Oct/97). Procedures for installation of external feathering stop on C-3021-() pistons on HC-B3TN-3() propellers.
161A	obsolete	Per Manual 135D. Identification, inspection and repair of composite blade delaminations.
162A	obsolete	Incorporated in Manual 202A - Blade Clamp Overhaul (rev. 7). Inspection Procedures on all C-3-() Double Shoulder Clamps.
163A	obsolete	Per Manual 135D. Repair procedures of debonds should they occur on composite blades which have nickel leading edge caps.
164	obsolete	Per Manual 135D. Repair procedures for all composite blades which have a high degree of erosion in the leading edge lap area.
165B	obsolete	Incorporated in Manual 133C. Paint Touch-Up Procedures on Aluminum Blades.
166	obsolete	Incorporated in Manual 118F and 132A. Repair procedures for the B-3001-() Low Stop Collar.
167D	12/31/87	Inspection procedures for the LT10574 (B) blade.
168	01/28/86	Wiring harness check.
169	05/02/86	Installation of A-1372 Clamp Bolts.
170	obsolete	Incorporated in Manual 202A. Inspection of aluminum hubs, model all 2, 3, and 4 blade ()HC-()Y()-() .
171B	obsolete	Incorporated in Manual 133C. Procedure for Use of Optical Comparators.
172	obsolete	Incorporated in Manual 202A - Blade Clamp Overhaul (rev. 7). Blade Clamp and Counterweight Assembly Instruction.
173	obsolete	Incorporated in Manual 135D. Recommended procedure for refinishing composite blades.

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174	No date	Not issued to field, for Cessna Caravan operators use only.
175	obsolete	Incorporated in Manual 202A (Rev. 2) - Steel Hub Overhaul chapter. Propeller mounting flange repair
176	obsolete	Information is out of date. Installation of C-453 and B-1061 Beta Rods in all HC-D4N-3()
177	obsolete	Per SB 160. Inspection and reinforcement procedures for Spinner Assembly filler plates installed on propeller model HC-A6A-3/A10460E
178A	obsolete	Incorporated in Manuals 133C, Rev. 1 (Feb/97) and 159. Modification of blade LT10574AS(B) to LT10574FS(B), Do 228 A/C.
179	08/05/88	Unfeathering Procedure for the HC-A6A-3 Propeller.
180	08/05/88	Procedure to remove D-451 and D-443 cylinders from HC-D4()-() series four blade propellers.
181	obsolete	Incorporated in Manual 133C. Shot Peened Blades - Inspection Criteria and Rework Limits.
182B	obsolete	Replaced by HC-SL-61-258 - Improved sealing of blade clamps.
183	obsolete	Incorporated in Manual 118F. New beta valve part for Allison engine propellers.
184A	obsolete	Incorporated in Manual 133C. Parts and Procedures for New T & M Shank Blades with N Suffix.
185	obsolete	Incorporated in Manual 133C. "D" & "Y" Shank Blades - Minimum Diameter.
186	obsolete	Incorporated in Manual 202A (Rev. 2) - Steel Hub Overhaul section. Sealing of Pilot Tubes in Steel Hub Propellers.
187B	obsolete	Incorporated in Manual 135F. External deice boots for HC-A6A-3 on Shorts SD3-60-300.
188	11/15/91	Improved deice wire harness for HC-A6A-3.
189	02/14/92	Heli-coil repair of cylinder screw holes in HC-D4N-().
190	obsolete	Incorporated in Manual 118F and 132A. Inspection of feathering spring A-3496 on HC-B(4,5)(T,M)()-(3,5).
191A	obsolete	Incorporated in Manual 202A. Propeller installation torque and torque decals.
192	obsolete	Incorporated in Manual 202A. HC-A6A-3 cylinder screw, grease fitting hole repair.
193A	obsolete	Incorporated in Manual 133C. D, A, E Shank Blade Pitch Change Knob Hole Repair.
194	03/12/93	HC-E4A-3 deice harness improvement on Beech 1900D.
HC-SI-61-195F	rev. 1 *	11/05/25 Hub inspection procedure MU-2B-60/840-91/840-139. Available to public.
196	obsolete	Per SB A190. Modification of blade pitch change knob attachment screw holes.
197	obsolete	Incorporated in Manual 133C. Alternate Cement & Procedures for Deicer Boot Installation.
198	obsolete	Incorporated into Manual 135F. HC-E4A-3/E10950 repair of pitch change knob screw holes

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199			not issued
200			moved Refer to Manual 166 (61-00-66) - Set of service documents for HD series propeller and systems.
201			obsolete Incorporated in Manual 202A. Repair of stripped grease fitting holes.
202A			obsolete Incorporated in Manual 202A. Repair of damaged wrench attachment holes in cylinders.
203			obsolete Incorporated in Manual 202A. Repair of damaged balance weight attachment holes in aluminum hubs.
204			not issued
205A			moved Refer to Manual 166 (61-00-66) - Set of service documents for HD series propeller and systems
206			obsolete Hub/rod bushing modification procedures (D4N, E4A) per SB 199 (not mailed to the field, available by request). Incorporated into Manual 202A, Revision 5. Obsolete 07/01/15.
207A			obsolete Incorporated into Manuals 143A, Rev. 11 (Dec/00) and 147. Acceptance criteria for "loose" blade in Beech 1900D, HC-E4A-3().
208A			moved Refer to Manual 166 (61-00-66) - Set of service documents for HD series propeller and systems.
209			obsolete Incorporated into Manual 202A. O-ring part number change.
210			obsolete Incorporated into Manual 159, original issue. Changing propeller model number HC-D4N-2A, -2D.
211B			obsolete Incorporated into Manual 135F. Alternate paint scheme beneath de-ice boot.
212A			obsolete Incorporated into Manual 143A. Alternate blade seal HC-E4A-3() (1900D)
HC-SI-61-213	rev. 2	10/06/21	Uncrating instructions for the DT-1724-5 Automated Rolling Machine
HC-SI-61-214	rev. 4	03/09/22	Packaging instructions and shipping crate specifications for the DT-1724-5 Automated Rolling Machine

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