

SENENICH PROPELLER CO.

SENENICH PROPELLER MANUFACTURING COMPANY, INC.

INSTRUCTIONS FOR CONVERTING "M6" BOLT HOLES TO "M7" BOLT HOLES IN SENENICH FIXED PITCH METAL PROPELLERS

Note: This operation must be done on a drill press, CNC machining center or drilling jig that ensures that the holes are drilled perpendicular to the mounting face of the propeller.

- 1. Place the propeller to be machined on the work table under the machine spindle with the mounting face up.**
- 2. Using a dial indicator placed in the spindle, orient the propeller so that the hole to be drilled is concentric with the spindle within .002".**
- 3. Lock the propeller into place and replace the dial indicator with a 29/64" drill.**
- 4. Drill the bolt hole through making sure that the drill passes through the propeller completely.**
- 5. Repeat steps 1 through 4 for the remaining bolt holes.**
- 6. Apply a .030" x 45 degree chamfer to each hole on the propeller's round side hub face.**
- 7. Inspect the bolt pattern to ensure hole location and concentricity of the bolt circle to within .003".**
- 8. "X" out the "6" in the propeller model number and re-stamp the propeller with "7" above the "X" to indicate the new bolt hole size.**
- 9. Reapply the alodine coating to the newly drilled bolt holes.**
- 10. Remove the 3/8" torque decal from the propeller and replace it with a 7/16" torque decal.**

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