Bendix
Electrical
Components
Division

Sidney, New York 13838

SERVICE BULLETIN NO. 605A
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Engineering Aspects
are FAA Approved

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AIRCRAFT

SUBJECT:

1. Inspection of D-2000/D-2200 Series Magnetos for possible housing distortion (Ref. Section 2)
2. Use of Coil Retention Kit, Bendix P/N 10-382939 (Ref. Section 3)
3. Use of Bendix Cover Sealing Kit Bendix P/N 10-682007 (Ref. Section 4)
4. Method of return for magnetos found to be outside the housing distortion limits set forth in this Bulletin (Ref. Section 6)

GENERAL INFORMATION

1. Investigation has revealed that tightening of the four center magneto cover screws can cause a dimensional change in the magneto housing distributor block pilot diameter. Should the distributor block be loosened or removed and then reinstalled, the possibility then exists that misalignment of the rotating magnet within the magneto housing may result in rotating magnet to housing interference.

   It has also been determined that removal of the four center magneto to harness/cover screws will eliminate the primary force that causes housing distortion.

   Removal of the four center attaching screws requires closing of these four holes in the cover. To accomplish this, Section 4 of this Service Bulletin describes the procedure for installation of a Dome Head, Aluminum Closed-End, Aluminum Mandrel "POP" Rivet ("POP" Rivet is the registered trademark of the USM Corporation, Pop Rivet Division, Shelton, CT 06484) or equivalent in each of the four open screw holes. Bendix Cover Sealing Kit P/N 10-682007 is to be used for this operation if certain conditions exist as described under Section 1. Compliance.

   Incorporation of the latest method for coil securing has also been found to further reduce the effect on housing distortion. Installation of Coil Securing Kit, Bendix P/N 10-382939 is detailed in Section 3 of this Bulletin.

   The following Table of Contents will assist in locating the one or more Sections found by inspection to be applicable to the magneto or system being checked for Bulletin compliance.

*"POP®" Rivet is the registered trademark of the USM Corporation, Pop Rivet Division, Shelton, CT 06484

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SECTION 1 COMPLIANCE

1.1 Equipment Affected

1.1.1 This Service Bulletin applies to all D-2000/D-2200 Series Magnetos or Ignition Systems.

1.2 Time Compliance

1.2.1 At first opportunity, but in any case no later than 100 operating hours after receipt of this Service Bulletin.

1.3 Compliance Extent

1.3.1 The extent of compliance required shall be determined by first identifying the magneto system to be checked as being in one of the following "Categories" and then adhering to the applicable requirements as stated.

1.4 Category 1

1.4.1 These magneto systems can be identified by the presence of four "POP" (Reg. TM) rivets in place of the four center screws in the magneto/harness cover. The letter "D" will also be stamped on the bottom line of the magneto nameplate.

1.4.2 The "system" as described above is in full compliance with this Service Bulletin and previously issued Bendix Service Bulletins 584B, 587, 590A, 600 and 606.

1.4.3 Make an engine log book entry signifying full compliance with Bendix Service Bulletin 605A.

1.5 Category 2

1.5.1 These magneto systems can be identified in one of the three following ways.

1.5.2 By the presence of unbroken orange TORQUE SEAL (Reg. TM of the USM Corporation, Pop Rivet Division, Shelton, CT 06484) on the four center screws of the magneto cover.

1.5.3 By the presence of the letter "K" stamped after the serial number on the magneto nameplates.

1.5.4 By the presence of four "Pop" Rivets in place of the four center cover screws and the letter "K" after the Serial Number.

1.5.5 If the conditions described in 1.5.2 and 1.5.3 above exist, remove the four center screws and install a "Pop" rivet in each of the four open cover holes as described in Section 4 of the Bulletin. Magneto Systems as described in 1.5.4 above, comply with Section 4 of this Service Bulletin. Make an engine log book entry indicating compliance with Section 4 of this Service Bulletin.

1.5.6 However, at the next 100 hour inspection period, or at the next removal or loosening of the magneto distributor block, compliance with Sections 2 and 5 must be accomplished and an engine log book entry then made signifying compliance with this Bulletin 605A.

1.6 Category 3

1.6.1 All D-2000/D-2200 magnetos or systems not covered in Category 1 or 2 fall in this Category and shall first be checked for compliance with Section 2, "Housing Distortion".

1.6.2 If the magneto exceeds the specified limits of housing distortion, the magneto must be returned to Bendix for repair. Procedure for return is covered in Section 6 of this Service Bulletin.

1.6.3 If the magneto is within the specified limits, check the magneto nameplate for Code letter identification and Serial Number applicability for compliance with previously issued D-2000/D-2200 Series Service Bulletins and comply as required. Table 1 provides a step-by-step check procedure for this purpose.

*"POP®" Rivet is the registered trademark of the USM Corporation, Pop Rivet Division, Shelton, CT 06484
** TORQUE SEAL is the registered trademark of Organic Products Inc., Irving TX 75060

1.6.4 If a Category 3 magneto inspection indicates compliance with all the aspects of Section 2 and Table 1, comply with Section 4 and identify the magneto per Section 5.

CAUTION

Do not install a magneto/harness cover to a magneto having the letter D stamped on the nameplate without first installing the POP rivets contained in Bendix Cover Sealing Kit P/N 10-682007.

TABLE 1

Step No.	* Control Code Ltr.	Acceptable Serial No. Range	Magneto is identified with Control Code Ltr.		Magneto Falls within Acceptable Serial No. Range			
			Yes	No	Yes	No	If Both No	If One Yes
1	D	Not Applicable				X	Comply with SB No. 605A in its entirety	Indicates complete compliance with SB No. 605A
2	K	Red Label – 25001 & above or Blue Label - 901001 & above or Any magneto regardless of S/N, with unbroken torque seal on 4 center cover screws					Comply with SB No. 605A in its entirety	Comply with SB No. 605A Section 4
3	C	Red Label – 17815 & above or Blue Label – 806001 & above					Comply with SB No. 584B (Covered in SB No. 605A Section 3)	Proceed to Step 4
4	B	Red Label – outside S/N range X2455 – X2561 and -outside S/N range 3001 – 17509 or Blue Label – 806001 & above					Comply with SB No. 600	Proceed to Step 5
5	A R	Red Label or outside S/N range 3001 – 17509 and outside S/N range 5145-11, 744 Blue Label 701001 & above					Comply with SB No. 590A	Proceed to Step 6
6	None	All	Note: Compliance required to 100 operating hours and at 100 hour periods thereafter. Refer to SB No. 599					
7	S	Red Label –11,744 & above					Comply with SB No. 587 Parts 1 & 2	Proceed to Step 8
8	S	Red Label (4 cyl) – outside S/N range 8618 – 9823 or Red Label (6 cyl) – outside S/N range 7544 - 9823					Comply with SB No. 587 Part 3	

* Control Code Letter found stamped on magneto nameplate outside “Chg.” Block area indicates compliance with applicable reference Bendix Service Bulletin.

SECTION 2 HOUSING DISTORTION CHECK

2.1 General Instructions

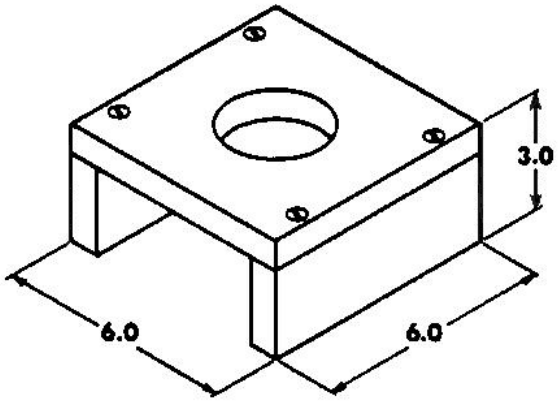
2.1.1 This section provides instructions to determine if the distributor block bore of the magneto housing has been distorted beyond specified limits.

2.1.2 Remove cover from the magneto and magneto from the engine.

CAUTION

Do not hold magneto by clamping in a vise of by holding the drive end components.

2.1.3 Support magneto in a work stand and in an upright position, distributor block facing the operator. A suitable work stand can be constructed as shown in Figure 2-1.



Material 0.750 in. thick wood
Hole in center top surface 3.1250 in. diameter

Dimensions for Constructing Suitable Work Stand

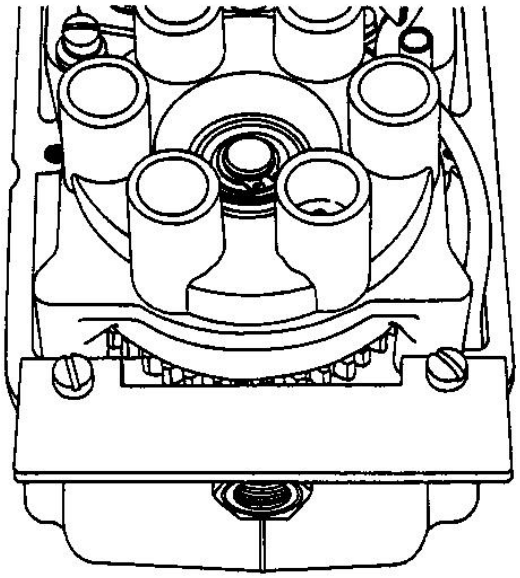
Figure 2 – 1

2.1.4 Using any one of the three following alternative methods, check the distributor block to housing clearance and center the block as instructed. Method 1. Using locally fabricated gage plate; Method 2. Using a depth micrometer; or Method 3. Using a dial indicator.

2.2 Method 1

Using a locally fabricated gage plate as described in Section 8, Appendix, Attach it to either end of the magneto housing with two 0.50 or 0.625 inch long, fillister head 10-32 screws. The heads of the chosen screws must not project beyond the edge of the gage plate when they are at the extreme limits of the holes in the plate. Leave the two screws just loose enough so the gage plate can just slide in the 0.250 inch holes.

2.2.2 Gage plate position as installed is shown in Figure 2-2. Loosen the two distributor block securing screws just enough to remove the spring lock washer compression.



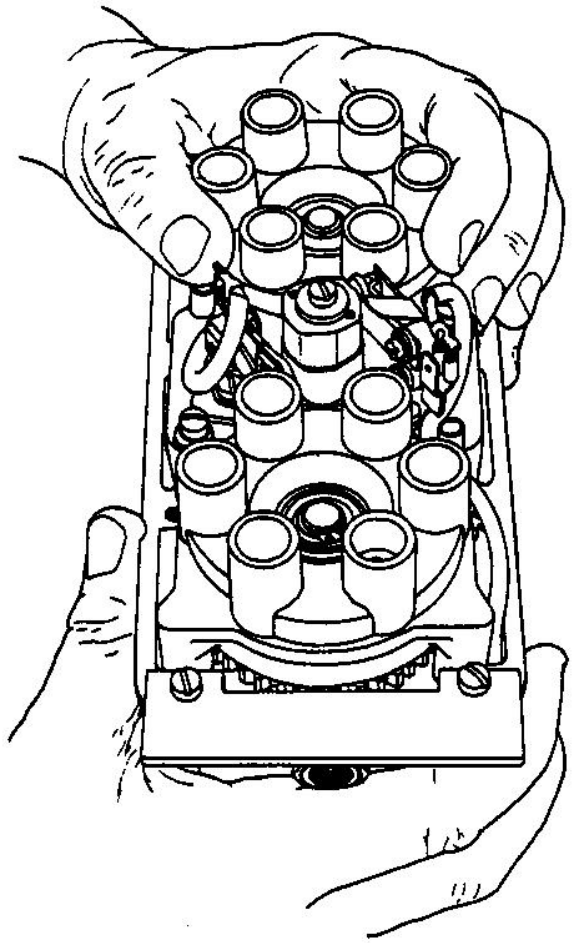
Gage Plate in Position on Housing
Figure 2-2

2.2.3 Steady the magneto housing with one hand at the gage plate end.

CAUTION

Pressure applied in either direction should not exceed 2.50 pounds.

2.2.4 With the other hand, and with finger pressure only, attempt to shift the distributor block endways in the distributor block pilot bore of the housing as shown in Figure 2-3.



Using Finger Pressure to Check Distributor Block Shift
Figure 2-3.

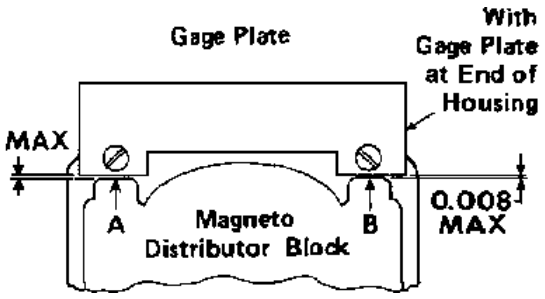
2.2.5 If there is no evident shift or block movement, remove the gage plate and proceed to paragraph 2.2.11.

2.2.6 If a shift is present, move the distributor block with finger pressure only, first away from the gage plate.

Next move the gage plate toward the block as far as it will go. Then move the distributor block endways and straight back to the limit of its shift. Allow the gage plate to move with the distributor block. Make sure the gage plate is contacting both corners of the distributor block and then tighten the gage plate securing screws. After tightening the securing screws, recheck to make sure the gage plate is still in contact with both ends of the block and that it did not move when the screws were tightened.

2.2.7 With the gage plate secured, now shift the distributor block straight away from the gage plate to the full extent of the shift, again using a maximum of 2.50 pounds to accomplish the block shift.

2.2.8 While holding the block in this position, measure at points "A and B" as shown in Figure 2-4 the extent of the block shift. Using two sets of feeler gages check the clearance between both of the block corners and the gage plate at the same time. Figure 2-5 illustrates this gaging operation.

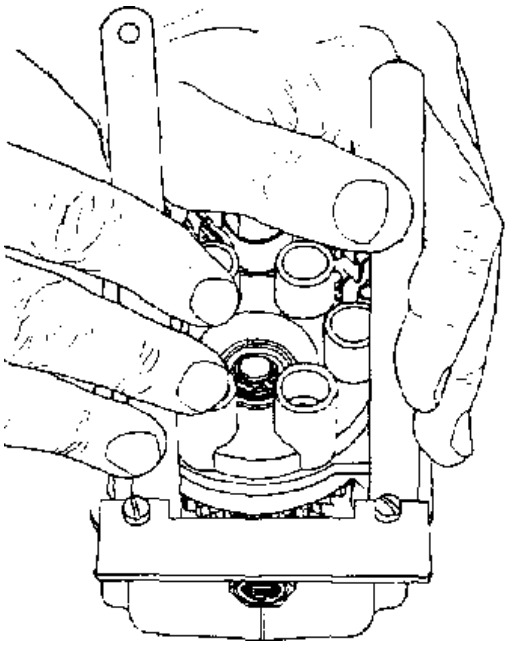


Use Feeler Gages at Points A & B

Gage Plate Position and Measuring Points

Figure 2 – 4

2.2.9 If more than 0.008 inch feeler gage stock can be inserted between the block corners and the gage plate at points "A" and "B" return the magneto to the factory for correction.



Feeler Gage Check at Points A and B
Figure 2 – 5

2.2.10 Refer to Section 6 of this Service Bulletin for procedure to follow when a magneto has been examined and found to exceed the limits as specified in 2.2.9 above.

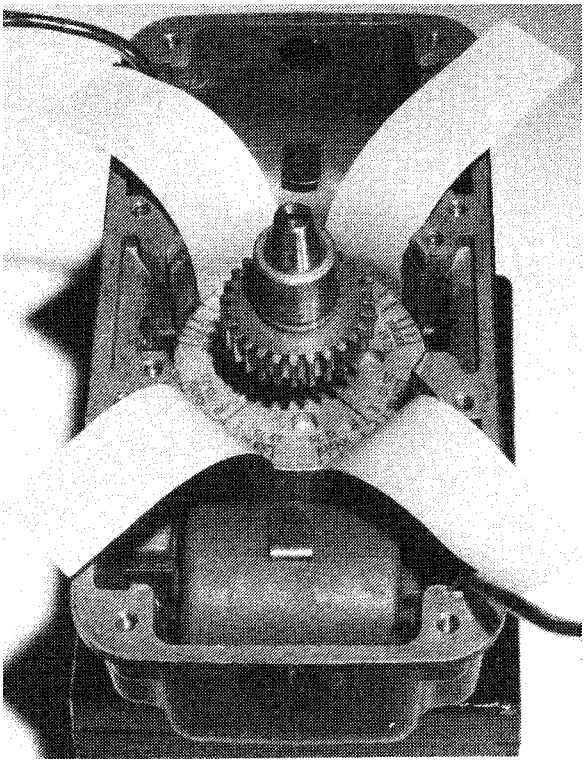
2.2.11 If the results of the feeler gage check indicates that the distributor block shift is within the limits specified in 2.2.9 the magneto housing is suitable for continued use.

2.2.12 Before proceeding with reassembly, comply with the instructions of Section 3 of this Service Bulletin if applicable.

2.2.13 Prepare 4 pieces of shim stock 0.007 inch thick x 1 inch wide x 4.5 inch long. The shim stock to be used should be non-magnetic. Brass, plastic or flexible hard surface card stock such as used for computer keypunch cards is acceptable.

2.2.14 Position the rotating magnet so the "K" mark on the rotor aligns with the internal timing pointer on the data plate side of the housing. This is the No. 1 neutral position of the magnet. With the rotating magnet stabilized in this "neutral" position, center the rotating magnet in the housing using the shim stock as follows.

2.2.15 Insert one piece of the shim stock between each pole piece of the housing and the rotating magnet. Angle the shim stock so the exposed ends come out between the cover attaching holes in the magneto housing. Positioning of the 4 pieces of shim stock is shown in Figure 2-6.

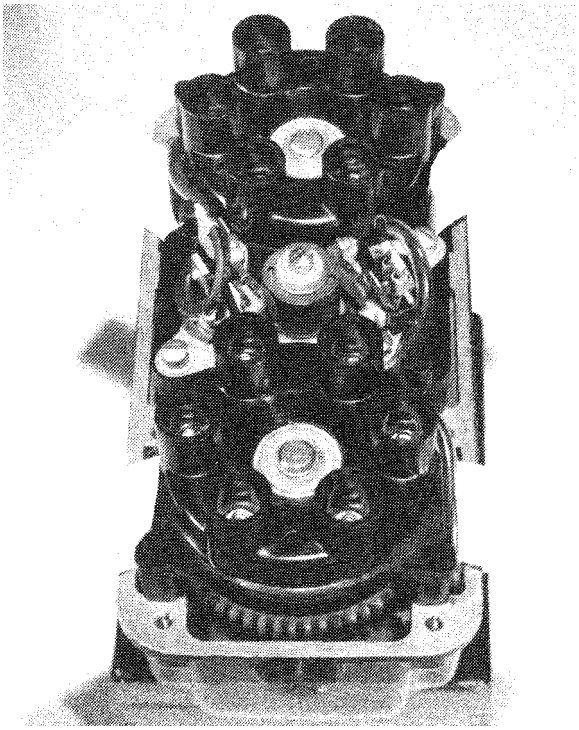


Shim in Position Around Rotating Magnet

Figure 2 – 6

2.2.16 Before assembling the distributor block-gear assembly to the magneto, inspect the block itself. Remove the distributor gears and check the block for cracks in the block pilot skirt and for cracks around the rear bearing inserts. (Refer to Bendix Service Bulletin 588 for cracks and limits.) Also check for carbon tracking between electrodes and any other characteristic which might cause operational difficulties. Replace any components found to be defective.

2.2.17 Leave the shims in position as described in 2.2.15 and time the distributor gears to the rotating magnet pinion gear a described in the D-2000/D-2200 Series Magneto Overhaul Manual, Bendix Publication Form L-945. Seat the distributor block to the housing making sure none of the four shims are caught between the distributor block and the magneto housing. See Figure 2-7 for shim positioning after installation of distributor block.



Distributor Block Secured and Centering Shims Ready to be Withdrawn
Figure 2 – 7

2.2.18 Install the two distributor block securing screws with flat washers and lock washers. Evenly tighten the block securing screws to the recommended torque value of 25 - 30 pound inches.

2.2.19 Carefully pull, one at a time, the four shims from the assembly. Observe the shims when removed to insure that each shim was removed intact and no part of the shim stock remained inside the magneto assembly. If any piece of shim stock remains inside the magneto, it will be necessary repeat paragraphs 2.2.14. 2.2.15, 2.2.17, 2.2.18 and 2.2.19 before proceeding.

2.2.20 When the distributor block is secured to the magneto housing, the magneto assembly can be completed and retimed following the instructions contained in the D-2000/D-2200 Series Magneto Overhaul Manual, Bendix Publication Form L-945.

2.2.21 Observe all torque values specified by the Overhaul manual when tightening any and all securing screws.

2.3 Method 2

2.3.1 Checking distributor block to housing clearance and centering using a Depth Micrometer. See Figure 2-8

2.3.2 Remove the timing plug from the end of the magneto housing. This will be the work reference end.

2.3.3 Loosen the two distributor block securing screws just enough to remove the spring lock washer compression.

2.3.4 Steady the magneto housing with one hand. With the other hand, and with finger pressure only, attempt to shift the distributor block endways in the distributor block pilot bore of the housing as shown in Figure 2-3, Method 1.

CAUTION

Pressure applied in either direction should not exceed 2.50 pounds.

2.3.5 If there is no evident shift or block movement proceed to 2.3.12 of this section.



Depth Micrometer Positioned Against Housing
Figure 2 – 8

2.3.6 If a shift is present, move the distributor block away from the working end of the housing where the timing plug was removed.

2.3.7 Position the bar of the depth micrometer against the working end, centering the depth rod against the center of the distributor block end surface as shown in Figure 2-8.

2.3.8 With the depth micrometer bar held against the housing set the micrometer rod so it contacts the distributor block. Record the reading obtained.

2.3.9 Move the distributor block back toward the working end of the housing and then take another reading.

2.3.10 Subtract the reading obtained in 2.3.9 from the obtained in 2.3.8. The result is the total block shift.

2.3.11 If the result is more than 0.008 inch, return the magneto to the factory for correction using the procedure outlined in Section 6 of this Service Bulletin.

2.3.12 If the result of the depth micrometer check indicates that the distributor block shift is 0.008 inch or less, the magneto housing is suitable for continued use.

2.3.13 Before proceeding with reassembly, comply with the instructions of Section 3 of this Service Bulletin if applicable.

2.3.14 If Section 3 compliance is not required, the distributor block may be centered at this time. Using the depth micrometer, move the distributor block back to a halfway reading and evenly tighten the distributor block screws to the recommended torque of 25-30 pound inches.

2.3.15 When the distributor block is secured to the magneto housing, the magneto assembly can be completed and retimed following the instructions contained in the D-2000/D-2200 Series Magneto Overhaul Manual, Bendix Publication, Form L-945.

2.3.16 Observe all torque values specified by the Overhaul manual when tightening any and all securing screws.

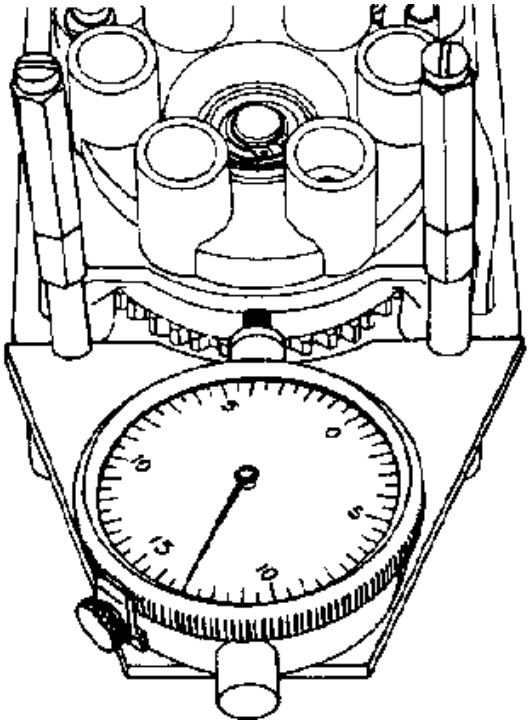
2.4 Method 3

2.4.1 Checking distributor block to housing clearance and centering using a Dial Indicator.

2.4.2 Provide a rigid flat mount for a dial indicator and attach it to the magneto housing in a manner to that showing the indicator in use in Figure 2-9.

2.4.3 Follow the same general procedures and instructions described in Method 1, paragraph 2.2.2 through 2.2.7 and applicable CAUTION note.

2.4.4 Check the block to housing clearance by observing the total indicator reading (TIR) registered when the block is moved to the extreme shift limits.



Dial Indicator Mounted on Housing
Figure 2 – 9

2.4.5 If TIR is more than 0.008 inch return the magneto to the factory for correction using the procedure outlined in Section 6 of the Service Bulletin.

2.4.6 If the result of the dial indicator check indicates that the distributor block shift is 0.008 inch or less, the magneto housing is suitable for continued use.

2.4.7 Before proceeding with reassembly, comply with the instruction of Section 3 of this Service Bulletin if applicable.

2.4.8 If Section 3 compliance is not required, the distributor block may be centered at this time by moving the block to a halfway indicator reading then evenly tighten the distributor block securing screws to the recommended torque of 25 - 30 pound inches.

2.4.9 When the distributor block is secured to the magneto housing, the magneto assembly can be completed and retimed following the instructions contained in the D-2000/D-2200 Series Magneto Overhaul Manual, Bendix Publication, Form L-945.

2.4.10 Observe all torque values specified by the Overhaul Manual when tightening any and all securing screws.

2.5 Testing

2.5.1 If a test bench and slave harness with capacitors is available, perform an operational check of the magneto before reinstalling it to the engine.

CAUTION

When installing a slave harness to a magneto on a Test Bench, use the Corner Screw Location Only. Do not exceed a tightening torque of 30 to 35 pound inches when tightening the cover attaching screws.

SECTION 3 INSTALLATION OF COIL SECURING KIT

3.1 General Information

3.1.1 The coils in the D-2000/D-2200 Series Magneto, Serial Nos. 17815 and up are retained with a clamp, spring, screw and elastic stop nut. Magnetos not in this serial number range, and not already field modified, must be modified at this time to incorporate the parts in Coil Securing Kit P/N 10-382939.

3.1.2 This Service Bulletin mandates installation of the Coil Securing Kit P/N 10-382939 regardless of Magneto Serial Number unless the Kit has already been installed.

3.1.3 Looking into the magneto, after removal of the distributor block, the presence of four elastic stop nuts, one at each end of each coil core indicates that Coil Securing Kit P/N 10-382939 has already been installed. If the four stop nuts cannot be seen, the kit parts must be installed.

3.1.4 The procedures for installation of Coil Securing Kit, P/N 10-3822939 are contained in Bendix Service Bulletin No. 584B, Part 3.

3.1.5 Follow the instructions of part No. 2 and part No. 3 of Service Bulletin 584B, whichever is applicable to the magneto under work.

3.2 Parts Required Per Magneto:
One 10-382939 Coil Securing Kit.

3.1.1 The 10-382939 Coil Securing Kit may be obtained from Authorized Bendix Electrical Components Division Distributors and their Authorized Outlets. (Reference: Distributors Directory, Bendix Publication L-606.)

3.1.1 The kit will be supplied at no charge for those magnetos still under the Bendix Warranty of 1000 hours or one year, whichever occurs first.

3.2.3 For those magnetos outside the stated warranty period a charge will be made for the 10-382939 Coil Securing Kit.

SECTION 4 INSTALLATION OF COVER SEALING KIT AND COVER DECALS;

4.1 Detailed Instructions, Rivet Installation

4.1.1 Before attaching the magneto cover to the magneto accomplish the following:

4.1.2 Install and seat in each of the four center cover holes a Dome Head, Aluminum "Pop" (Ref. TM) rivet, Bendix P/N 10-682005 or USM "Pop" rivet (USM P/N AD-64AH or equivalent) as illustrated in Figure 4-1.

4.1.3 Cover Sealing Kit 10-682007 consists of 5 each Dome Head, Aluminum "Pop" Rivets, 10-682005 and Bendix publication, Form L-1163. The 5th rivet is included as a spare.

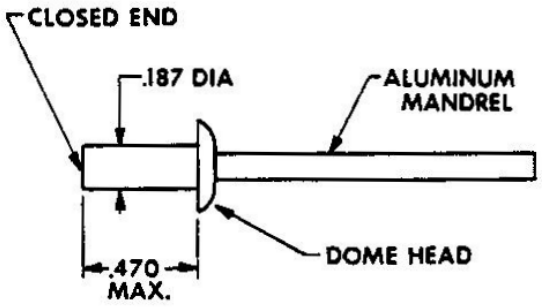


Figure 4-1
Dome Head Closed-End “Pop” Rivet

4.1.4 The location for the installation of the four specified rivets is shown in Figure 4-2.

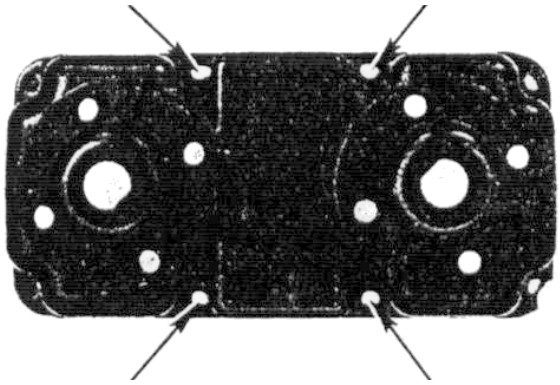
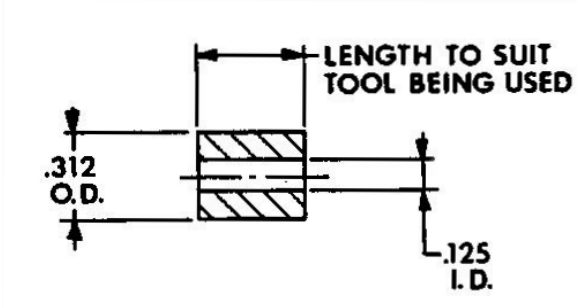


Figure 4-2
Location of four rivets

4.1.5 Due to the depth of the alcove in which the rivet must be seated it may be necessary to make short steel adapter sleeve to be placed over the rivet mandrel next to the rivet head. The steel adapter sleeve (Figure 4-3 - should have a center hole of 0.125 (1/8 in.) diameter and a 0.3124 (5/16 in.) O.D. and length to suit riveting tool being used.



Adapter Sleeve
Figure 4-3

The adapter will move the pulling head of the riveting tool to a position where seating of the rivet and separation of the aluminum mandrel can be accomplished. To guard against loss of the adapter, it is suggested that it be securely taped to the riveting tool during seating installation of the four rivets. Use "Pop" (Reg. TM) Riveting Tool PRP-26A, PRG 402 HD or PRG 111 or equivalent for seating the rivet.

4.1.6 When seated, the underside of the rivet head should be flush with the outside of the magneto cover surface.

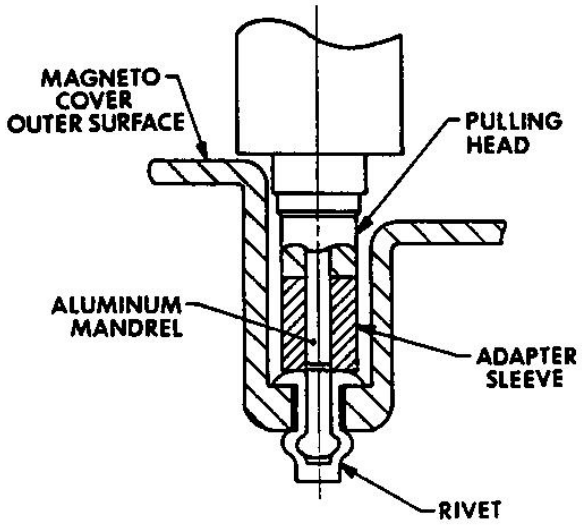
4.1.7 It is permissible for the mandrel portion to extend slightly above the rivet head after installation. Breakage of the mandrel below the rivet head surface or complete separation of the mandrel from the rivet is also acceptable.

4.1.8 Figure 4-4 illustrates in cross section the fully seated position of the "Pop" rivet as well as the position of the adapter and tool pulling head just before mandrel separation from the rivet proper.

4.1.9 Assemble the cover to the magneto using only the four outer corner screws. Use a torque wrench and a criss-cross pattern to squarely draw the cover down to the magneto housing. Evenly tighten the screws to the following torque values:

Non-Pressurized Magneto (Painted Black)
30 - 35 Pounds Inches

Pressurized Magnetos (Painted Gray)
40 - 45 Pounds Inches



Cross Sectional View of “Pop” Rivet
Installed in Magneto Cover (4 places)
Figure 4-4

4.2 Detailed Instructions, Decal Installation

4.2.1 After compliance with this Service Bulletin affix a Decal as specified below to the Left magneto end of the magneto cover. Decal P/N 10-382993 must be used only on Black painted covers and Decal P/N 10-282995 only on Gray painted covers as indicated by the information printed on the illustrated decals in Figure 4-5.

4.3 Parts Required per Harness Cover:

4.3.1 Cover Sealing Kit, Bendix P/N 10-682007, Cover Decal 10-382993 (Non-Pressurized Magneto) or 10-382995 (for pressurized magneto).



10-382993 Decal 10-382995 Decal
Figure 4-5

4.3.2 Cover Sealing Kit 10-682007, and decals may be procured on request to an Authorized Bendix Electrical Components Division Distributor.

SECTION 5 IDENTIFICATION AFTER COMPLIANCE

5.1 If the magneto or system has been examined and found to be in complete compliance with TABLE 1 and Section 2 (Housing Distortion Check) and is or has been altered to be in compliance with Section 3 (Coil Securing Kit inclusion) the letter "D" should be permanently stamped approximately central on the bottom line of the magneto nameplate.

5.2 When the letter "D" is on the nameplate, Section 4 (Cover Sealing Kit Installation) must be accomplished prior to the magneto/harness cover installation, if not already done.

SECTION 6 PROCEDURE FOR RETURN OF D-2000/D-2200 SERIES MAGNETOS FOR FACTORY REPAIR AND COMPENSATION POLICY

6.1 Return

6.1.1 When it is found that a magneto does not comply with the guidelines herein established by Section 2 the complete magneto with the two capacitors from the harness cover should be returned directly to the factory for repair. DO NOT RETURN THE IGNITION HARNESS. (Ref: Section 5, paragraph 5.2)

6.1.2 Protective packaging should be used since replacement of components damaged during shipment will not be covered by warranty repair.

6.1.3 Shipment should be by fastest transportation, prepaid and the package clearly addressed and identified as follows to assure rapid handling when received.

SHIP TO: THE BENDIX CORPORATION
ELECTRICAL COMPONENTS
DIVISION
SIDNEY, NEW YORK 13838

ATTN: Product Support Manager
D-2000 Magneto Service Bulletin
605A

6.2 Warranty Repair

6.2.1 D-2000/D-2200 Series Magnetos with 1000 hours or less of accumulated operating time and having been in service one year or less, will be repaired under full warranty coverage.

6.3 Non Warrantable Repair

6.3.1 D-2000/D-2200 Series Magnetos with over 1000 hours of accumulated operating time or having been in service for more than one calendar year will be repaired and returned on a charge basis. For repair of those magnetos in this category a Blanket Charge of $75.00 will be in effect for one calendar year after the issuance of this Service Bulletin.

6.3.2 When returning a D-2000/D-2200 Series Magneto which is out of warranty, it must be accompanied by a statement on your company letterhead providing the following information.

a. Magneto Part Number and Serial No.
b. Time since magneto placed in Service.
c. Make, Model and Year of Aircraft from which magneto was removed.
d. Engine make and Model data.
e. Aircraft Registry No. (Tail No.).

f. Repair Purchase order No. from an Authorized Bendix Electrical Components Distributor or their Authorized Branch which will be used for billing the repair charge back to the sender.

6.3.3 In those cases where the foregoing procedure is not followed, billing for the repair charge will be made through the Authorized Bendix Electrical Components Distributor serving the area from which the magneto was originally returned.

6.4 Compensation

6.4.1 Compensation for the work involved in complying with this Service Bulletin for those magnetos under warranty will be made upon the submission of a Warranty Claim submitted through a currently Authorized Bendix Electrical Components Division Distributor. Compensation will be made in accordance with established Bendix Warranty procedures.

6.4.2 Authorized Distributors are listed in Bendix Publication, Form L-606 contained in the Bendix Electrical Components Aircraft Master Manual. Form L-606 may be obtained at no charge by request to the Bendix Corporation, Electrical Components Div., Sidney, N.Y. 13838.

SECTION 7 MAINTENANCE (Spare) PARTS AFFECTED, WEIGHT CHANGE, TIME REQUIRED.

7.1 Maintenance (Spare) Parts Affected:

7.1.1 Screw P/N 10-382933
Wedge P/N 10-382930
(Replaced by Coil Securing Kit P/N 10-382939)
Reference Section 3.

7.1.2 Cover Screws P/N 10-382871, 10-382881, Washer 10-55501, Lockwasher 10-92879-43 (Usage - 4 instead of 8 each per Magneto Cover) Reference - Section 4.

7.2 Weight Change
Negligible

7.3 Man Hours Required:
2 1/2 hours maximum

SECTION 8 APPENDIX

8.1 Locally Fabricated Gage Plate (ref. Section 2, paragraph 2.2.1)

8.1.1 INSTRUCTIONS FOR GAGE PLATE FABRICATION

8.1.2 From 0.1250 inch aluminum, brass or steel, locally fabricate gage plate as follows:

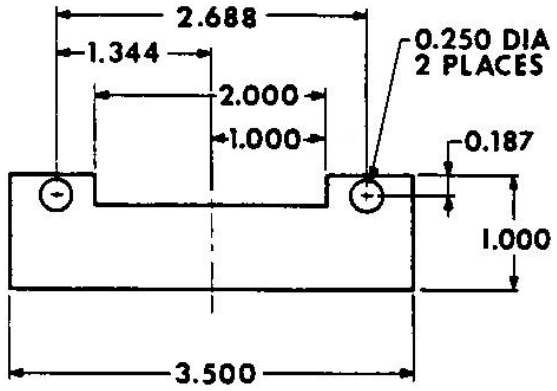
8.1.3 Cut a full size paper template per the full size template sketch and cement it to the selected material.

8.1.4 Cut the material to the form of the paper template.

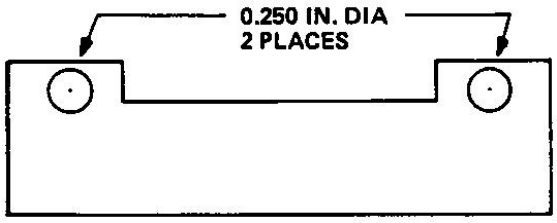
8.1.5 Drill the metallic gage plate in the positions shown on the template using a 0.250 inch drill.

8.1.6 Lightly deburr all edges of the finished gage plate.

8.1.7 For those desiring to fabricate a more precise gage plate, a dimensioned sketch is shown in Figure 8-1



Dimensions for Template
Figure 8-1



Full Size Template Cut Out