

31 March 1945

AIRCRAFT AND MAINTENANCE PARTS

**NORTH AMERICAN—REPLACEMENT OF SPINNER FRONT SECTION DOWEL
RETAINING PLATE—P-51K**

NOTE As prescribed in T. O. No. 00-20A, appropriate reference to this Technical Order will be entered on AAF Forms 60-A for the aircraft affected. The work directed herein will be accomplished as soon as possible and not later than the next 100-hour inspection period by service activities with the aid of base maintenance facilities, if necessary.

1. To prevent failure of the spinner dowel retaining plates, replacement of all retaining plates made of .025 x 4130 material with plates made of .040 x 4130 material will be accomplished on the following airplanes in accordance with the instructions contained in paragraph 2.

MODEL	AF SERIAL NOS.
P-51K-1	44-11353 to 44-11552 inclusive
P-51K-5	44-11553 to 44-11555 inclusive

P-51K airplane, AF No. 44-11556 and subsequent, will be modified by the contractor prior to delivery.

2. The instructions for accomplishing this change, as contained in North American Service Bulletin P-51-262, are as follows:

a. Loosen the eight fastener nuts holding the spinner front section to the rear section.

NOTE In case the dowel retaining plate fails while loosening the fastener nut, permitting the shaft to turn freely, drill out the eight AN426AD5 rivets securing the casting to the spinner front section with a No. 21 (.159-inch) drill. After all fasteners have been loosened,

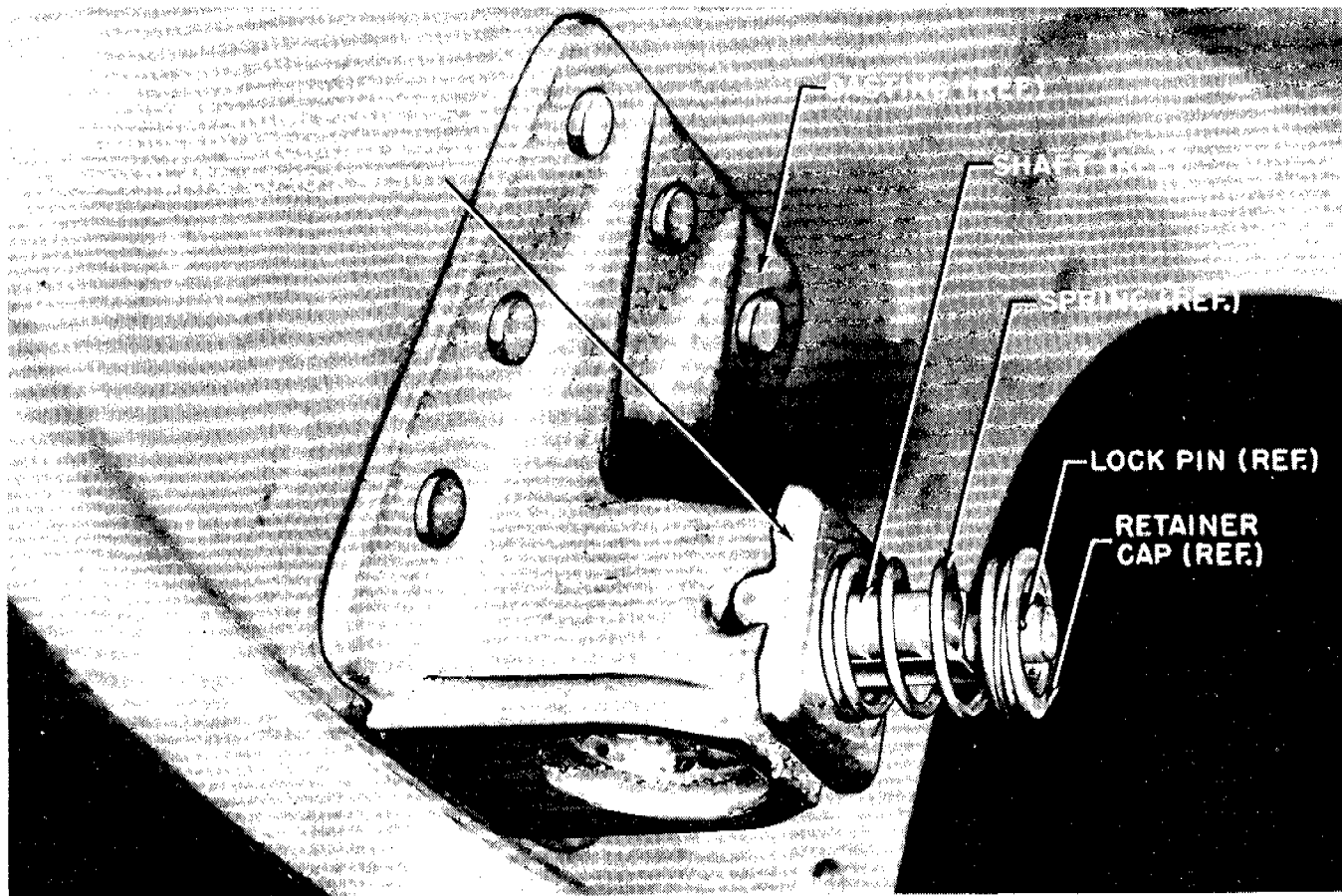


Figure 1

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RESTRICTED
T. O. No. 01-60J-49

remove the spinner front section. Holding the end of the shaft opposite the fastener nut securely, loosen the nut. Disengage the casting from the clevis on the aft section of the spinner and reinstall it in its original position with eight AN426AD5-9 rivets. Then proceed with replacement of the dowel retaining plate as follows:

(2) Lift the retainer cap, spring, and dowel retaining plate from the shaft.

(3) Install the dowel retaining plate fabricated from .040 x 4130 material in lieu of the plate previously removed and clamp the tabs of the plate into holes on the sides of the casting.

(4) Install the spring, retainer cap, and lockpin in their former positions.

b. Carefully rap on the reinforced part of the spinner with the palm of the hand; then, by pulling straight forward on any two diametrically opposite blade cut-outs, remove the spinner front section.

d. Reinstall the spinner front section.

c. Inspect the dowel retaining plates on the removed spinner section and determine the thickness of the plates. If the plates are .025 in thickness, replace them in the following manner:

3. a. The following parts are required per airplane to accomplish this change. These parts are furnished as complete kits for initial installation and will be requisitioned in accordance with T. O. No. 00-35A-15. Parts required for maintenance after the initial installation will be requisitioned from the property classes as indicated.

(1) Press the spring and retaining cap down and remove the lockpin from the shaft.

QTY	STOCK NO.	PART NO.	NOMENCLATURE	CLASS	SOURCE
1	1300TO-01-60J49		KIT, "Replacement of Spinner Front Section Dowel Retaining Plate - P-51K," consisting of the following parts:	15	AF Stock
8		125-13 (Air-craftsman Co.)	Dowel Retaining Plate	01-M	
32		AN426AD5-9	Rivet	29	

b. Dowel retaining plates removed in accordance with the preceding instructions will be condemned at once, and so tagged for disposition as condemned property.

c. One complete kit of parts packed for shipment is one envelope which measures 4 x 6 inches and weighs 1/2 pound.

4. Approximately 2-1/2 man-hours are required per airplane to accomplish this change.

5. Weight change is negligible.

BY COMMAND OF GENERAL ARNOLD:

Prepared by Associated Equipment
Section, Maintenance Div, Hq, ATSC.

B. E. MEYERS
Major General, U.S.A.
Deputy Director
Air Technical Service Command