

Propeller Drill Jig User's Instructions

Item Catalogue Number #3380

Version 1.2

This Propeller Drill Jig is used to help drill accurate holes for the propeller screws so the propeller can be mounted securely and safely to the engine. It is designed for use with MVVS 45, MVVS 50, MVVS 58, MVVS 80, MVVS 116 and MVVS 152.

The package contains:

- #3380 0101 - Guide
- #3380 0102 - Washer and Fixing Screws
- #3380 0103 - Drill Bits (4.2mm and 5.2mm)

1. Place the guide on the front side of the propeller, so it is centered with the central fixing screw in the propeller center hole (diameter 10mm). Screw it together firmly.
2. Screw down the washer with one of the enclosed fixing screws (choose the one of the proper length).
3. Use of a drill press is recommended. Once the propeller blade is fixed in position, drill the first hole in full depth. Use the 4.2mm bit for the MVVS 58 and MVVS 80 propeller screws and 5.2mm bit for the MVVS 45, 50, 116 and 152 propeller screws. A chase drill bit will be used to finish boring out the holes once initial holes are all drilled. Pin the jig in place by placing one of the propeller bolts into the first full depth hole. This will ensure that the jig goes not rotate during drilling of the remaining holes.
4. Drill all the other holes into depth about one half of the propeller thickness. The use of two bolts to pin in place will help ensure the rest of the holes line up when you go to step 6.
5. Unscrew the drill jig assembly, and reposition the opposite side of the propeller (do not tighten the drill guide center bolt until the next step).
6. Pin the full depth hole using a propeller bolt and then screw the guide firmly together and proceed to bore the other half of the propeller bolt holes.
7. Bore the other holes from the other side to full depth.

For any questions please contact:

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