

# SERVICE BULLETIN

NUMBER: M20-219-1

DATE: 8-1-72

**SUBJECT:** PROPELLER SPINNER BULKHEAD INSPECTION  
AND MODIFICATION

**MODELS  
AFFECTED:** M20J S/N's 24-0001 thru 24-0786

**COMPLIANCE:** As soon as practical within the next 25 hours  
of operation.

**INTRODUCTION:** In order to prevent the possibility of cracking  
of the 680031-3 or -17 spinner aft bulkhead  
assembly around the attachment bolts, the  
following inspection and modification should  
be implemented.

**NOTE:** S.B. No. 201, Propeller Spinner  
Inspection and Modification, should  
be accomplished in conjunction with  
this Service Bulletin if not already  
complied with.

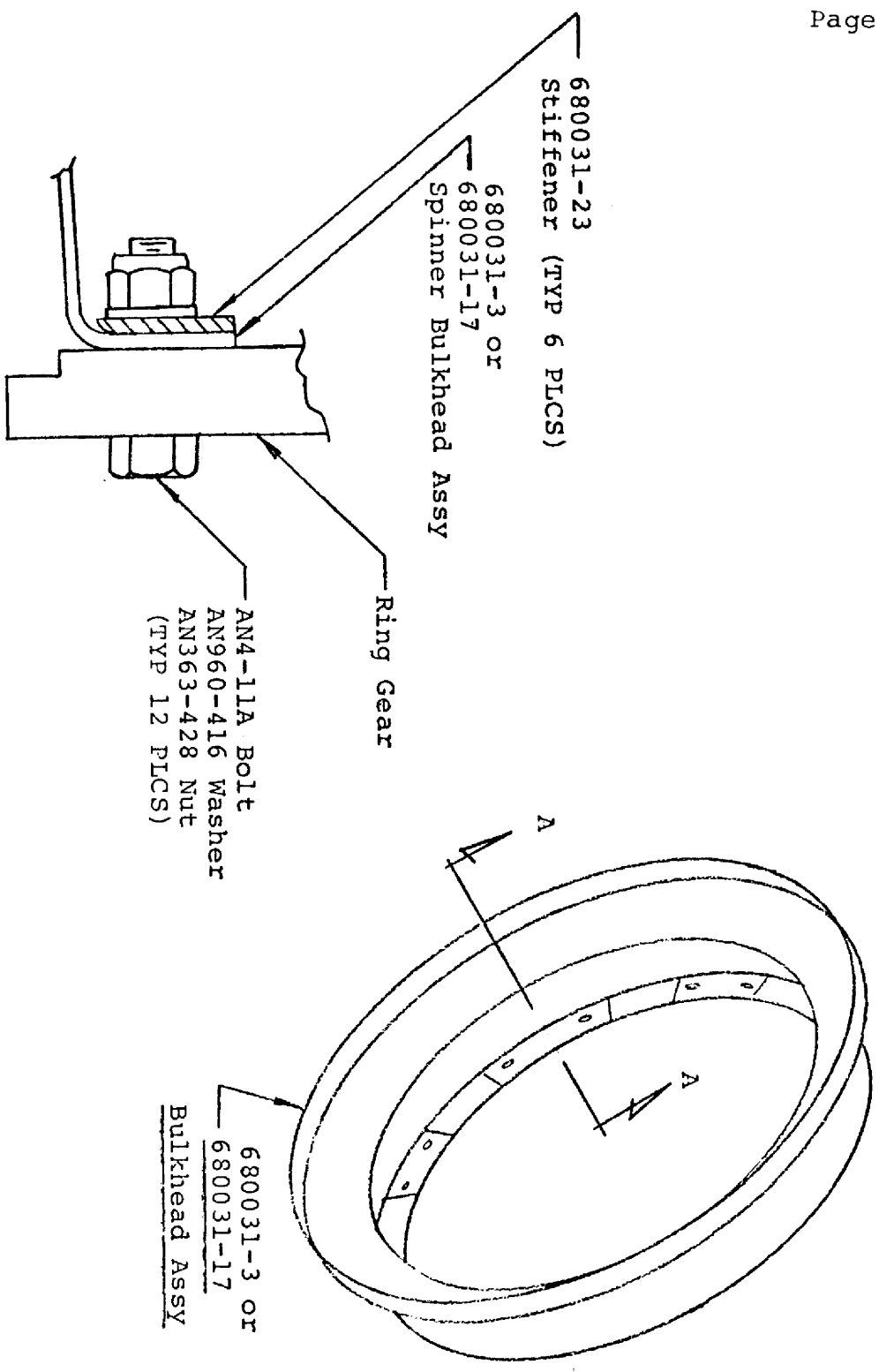
1. Remove the 680031-7 or -19 propeller spinner.
2. Remove the propeller assembly.
3. Remove (12) AN4-10A bolts attaching  
680031-3 or 680031-17 bulkhead assy to  
the engine ring gear.
4. Inspect 680031-3 or 680031-17 bulkhead  
assy for cracks; if cracked, replace bulkhead.  
If no cracks are found, proceed with instal-  
lation of Service Bulletin stiffeners  
680031-23 (6 each as shown in Figure 1).
5. Reinstall propeller and spinner removed per  
Steps 1 and 2 with existing hardware. (Torque  
all bolts to specified torque. AN4-11A 50 to  
70 in-lbs., prop attach bolts 55 to 65 ft-lbs.,  
and spinner screws 30 in-lbs. +5 in-lbs.).

**CAUTION:** The forward spinner bulkhead should have a  
snug fit on the propeller dome. Install  
6.5 MIL x .50 wide "Scotch Brand" No.  
549 pressure sensitive tape, mfg. by 3M  
Co., St. Paul, Minnesota, on propeller  
dome as required to provide a snug hand  
press fit.

6. Make appropriate log book entry and fill out  
and return compliance card.

SERVICE BULLETIN

KIT NO. M20-219-1 680031-23 Stiffeners . . . . . 6 ea.  
AN4-11A Bolt . . . . . 12 ea.



Section A-A

Figure 1