

REVISION	CHANGE	APPROVED	DATE
1	Published release	JTS	26/11/2025

Airmaster

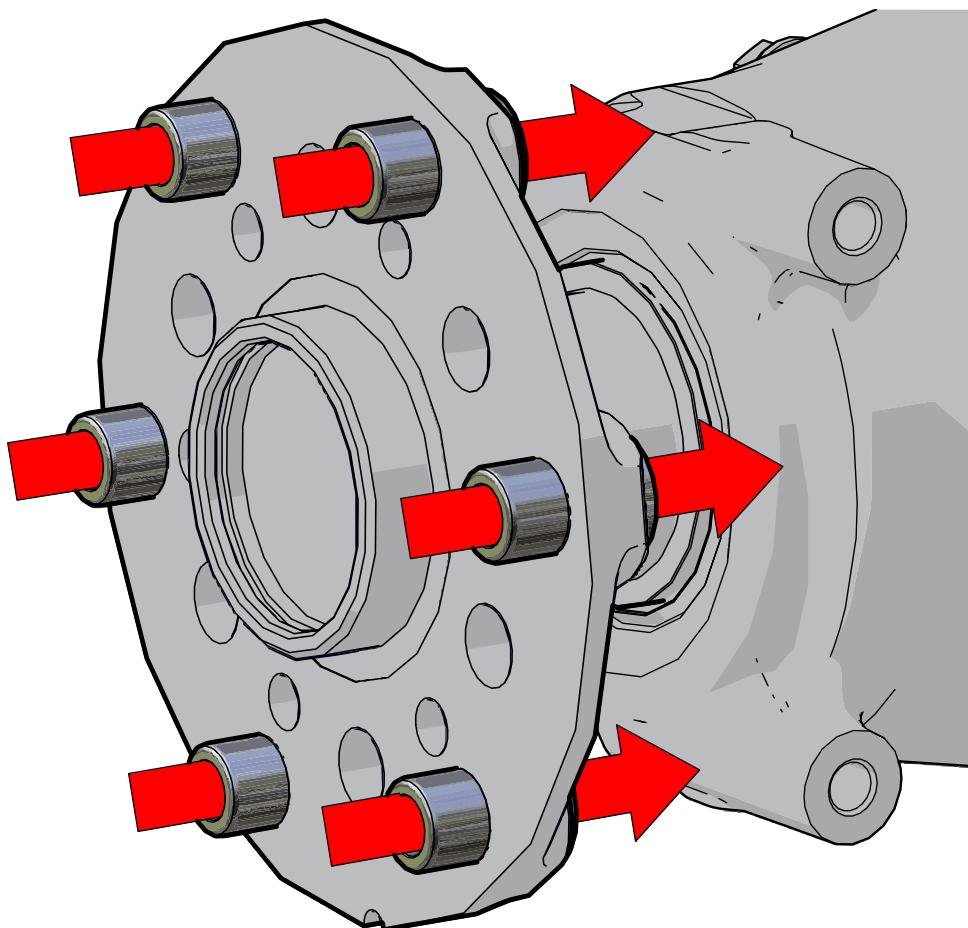
Airmaster Propellers Ltd
20 Haszard Rd, Massey,
Auckland 0614, NZ

Phone: (+64) 9 833 1794
E-mail: support@propeller.com
Web: www.propeller.com

ASI-4-1-2

DRIVE LUG REMOVAL

PROCEDURE



SUBJECT:

Mount Kit Installation

ASSEMBLY NO:

AE-xxx

APPLICABILITY:

All propeller models excluding
some which use an extension kit
assembly

1. TOPIC

1.1 Introduction

This document covers the recommended procedure for removing drive lugs (bushings) from the engine flange. Two methods are provided, based on whether the drive lugs are internally threaded. Installers should refer to the method that is relevant for their setup.

1.2 Drive Lug Requirements

The engine flange is often fitted with drive lugs to locate the propeller hub and transmit power to it. In some cases, the existing drive lugs supplied by the engine manufacturer should be removed from the engine flange and replaced with alternative drive lugs supplied for use with an Airmaster propeller.

When applicable, the propeller's mount kit assembly (AE-xxx) includes alternative Airmaster drive lugs, and a drive lug replacement kit may be provided for this purpose. A variety of bolts, nuts, washers, and spacers are supplied with the drive lug replacement kit to match with possible configurations of existing drive lugs. The drive lug replacement kit is a multi-purpose tool, and not all parts are used at once.

① Note The procedure for installing Airmaster drive lugs is covered separately in **ASI-4-1-3**.

1.3 Prerequisites

Complete the following tasks before proceeding:

- If applicable, replace OEM engine flange with Airmaster-supplied engine flange.

① Note

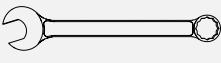
Currently this only applies to some Jabiru engines. The Jabiru flange is replaced with the Airmaster-supplied flange in accordance with procedure **ASI-4-1-1**.

2. MATERIAL REQUIREMENTS

2.1 Parts

ITEM	QTY	PART NO.	DESCRIPTION	IMAGE
1.	1	A0210-xx or A0211-xx	Airmaster Drive Lug Replacement Kit	

2.2 Tooling

ITEM	QTY	DESCRIPTION	IMAGE
1.	As required	Spanner (1/2" or 9/16" depending on flange type)	

2.3 Paperwork

ITEM	QTY	CODE	DESCRIPTION
1.	1	AE-xxx	Airmaster Mount Kit Assembly Drawing & BoM

3. PROCEDURE

① WARNING

Ensure aircraft power is turned off throughout this procedure, especially before rotating engine flange.

① WARNING

Take care when working with the engine flange and inspect its condition closely. Any damage observed at this region should be considered highly significant and the engine manufacturer's advice should be sought immediately.

3.1 Remove Non-Threaded Drive Lug (As Applicable)

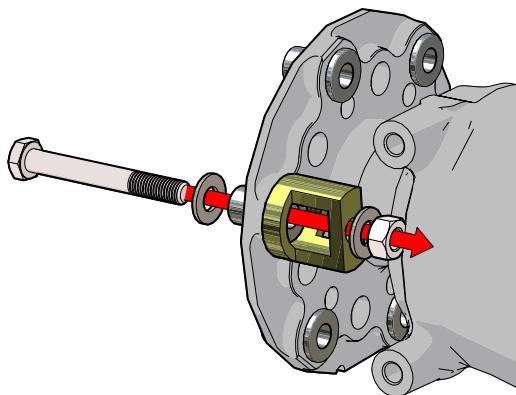
PROCEDURE

Step 1 Assemble Drive Lug Replacement Kit

- Assemble drive lug replacement kit through the (non-threaded) drive lug in engine flange as shown, using the 2.5in bolt provided.

④ Note

Typically, this is a 5/16 UNF bolt (P3303-2.5) for Rotax flanges, or a 3/8 UNF bolt (P3304-2.5) for SAE-1/SAE-2 flanges. Exceptions may apply.



④ Attention

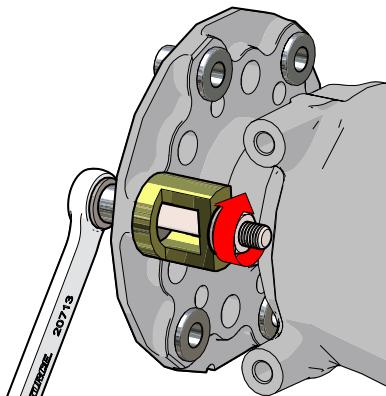
Drive lug replacement kit (A0210-x or A0211-x)

Step 2 Extract Drive Lug

- Restrain bolt head with a spanner to prevent it rotating during the extraction process.
- Gradually tighten nut to extract drive lug from engine flange.

④ Note

Due to the short, threaded section of the bolt, the spacer(s) supplied with the drive lug replacement kit may need to be assembled beneath the bolt head during the extraction process to ensure that the nut maintains sufficient thread engagement.



④ Attention

For 5/16 UNF bolt: use (2) 1/2" spanners

For 3/8 UNF bolt: use (2) 9/16" spanners

3.2 Remove Threaded Drive Lug (As Applicable)

① Note

*If an extension kit assembly is incorporated with the propeller, and replacement drive lugs and nyloc nuts are not provided for the hub mounting bolts, do **not** remove the OEM threaded drive lugs from the engine flange. In this case, the threaded drive lugs should remain installed for use with the Airmaster propeller, and this procedure is not required.*

PROCEDURE

Step 1 Assemble Drive Lug Replacement Kit

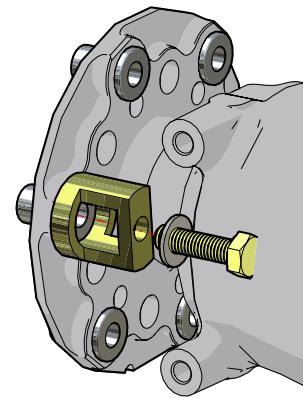
- Assemble drive lug replacement kit through the (threaded) drive lug in engine flange as shown, using the shorter, fully threaded bolt provided.

① Note

Typically, this an M8 bolt (P0323) for Rotax flanges, or a 3/8 UNF bolt (P0326) for SAE-1/SAE-2 flanges. Exceptions may apply.

① Attention

Drive lug replacement kit (A0210-x or A0211-x)



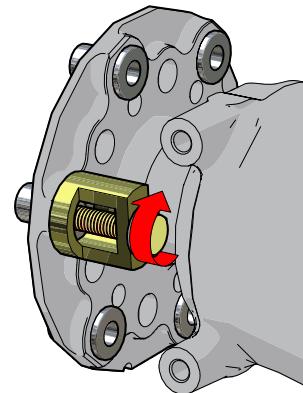
Step 2 Extract Drive Lug

- Gradually tighten bolt head to extract drive lug from engine flange.

① Attention

For M8 bolt: use 13mm spanner

For 3/8 UNF bolt use 9/16" spanner



3.3 Subsequent Action

Perform the following tasks once this procedure is complete:

- Repeat this procedure to remove remaining drive lugs from engine flange.

① Note

Installers may protect the OEM drive lugs afterwards with a thin film of anti-corrosive lubricant. Store these parts inside a sealed, identifiable container in case needed for future use.

- Install (6) Airmaster drive lugs into engine flange in accordance with procedure **ASI-4-1-3**.