

**DRAWING NO.** 71200

**Revision:** A

**Date:** March 16, 2018

**Title:** MASTER DRAWING, Engine Alteration for "switch-type" Starter

### Revision Highlights

REVISION LETTER	DESCRIPTION
A	<ul style="list-style-type: none"><li>- Revised Cover, Footers, and Headers to reflect current revision.</li><li>- Added Revision Highlights page</li><li>- Updated document in its entirety to Arial font type</li><li>- Updated steps 2 thru 4 to utilize a molded Shaft Removal Tray</li><li>- Added Step 5</li><li>- Added Part Number for Shaft Removal Tray.</li><li>- Removed Figures 1A thru 1E</li><li>- Added Figures 1 thru 5</li></ul>

**ELIGIBILITY:**

Per Approved Model List (AML) for STC # SE10076SC

**DRAWING LIST:**

<u>Drawing #</u>	<u>Revision</u>	<u>Date</u>	<u>Title</u>
70065	-	2-11-02	Cardboard template detail

**ALTERATION PROCEDURE:**

1. Remove existing starter.
2. Insert the shaft removal tray P/N 50767 through the starter mount opening, as shown in Figure 1, and position it against the case housing. Secure the tray using starter mount nuts. A stack of washers can be used as a spacer on the stud/bolt shank, as shown in Figure 2. This tray will temporarily block contaminants from entering crankcase.

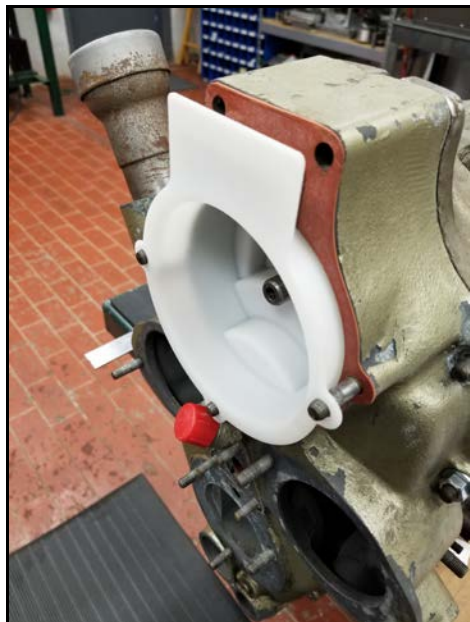


Figure 1 – Tray Insert



Figure 2 – Secure the Tray

3. Mark a cut line on the shaft at a MINIMUM depth of 2.60 inches, measured from the outside flange surface of the tray as shown in Figure 3. A straight edge may be used to ensure square measurement, so long as the added straight edge thickness is added to the 2.6 inch minimum. Cut off pinion shaft using a die grinder or high-speed motor with cut-off wheel. The cutting wheel diameter cannot exceed 0.75 inches. Ensure remaining shaft portion is ground smooth and free of burrs.



**Figure 3 – Measurement**

4. Use a hand file to break the edge of the shaft at cut-line. Confirm all burrs are removed from the cut-line edge.
5. Remove metal debris with shop vacuum and wipe out the inside of the tray using a damp paper towel or shop towel (See Figure 4). Remove the tray from starter mount opening (See Figure 5). Visually inspect inside the accessory housing to ensure crankcase is free from contaminants, and clean as required.



Figure 4 – Remove Debris



Figure 5 – Remove Tray

6. Install Sky-Tec FAA-PMA starter model # C12ST2/S or C12ST2/SR as eligible per PMA identification.
7. Complete FAA form 337 and record alteration in engine logbook.

NOTE 1: Airframe alteration per FAA approved data is required for installation of this engine on airplane.

NOTE 2: Alternate configuration: Omit installation of starter pinion shaft P/N 23487 at engine overhaul.