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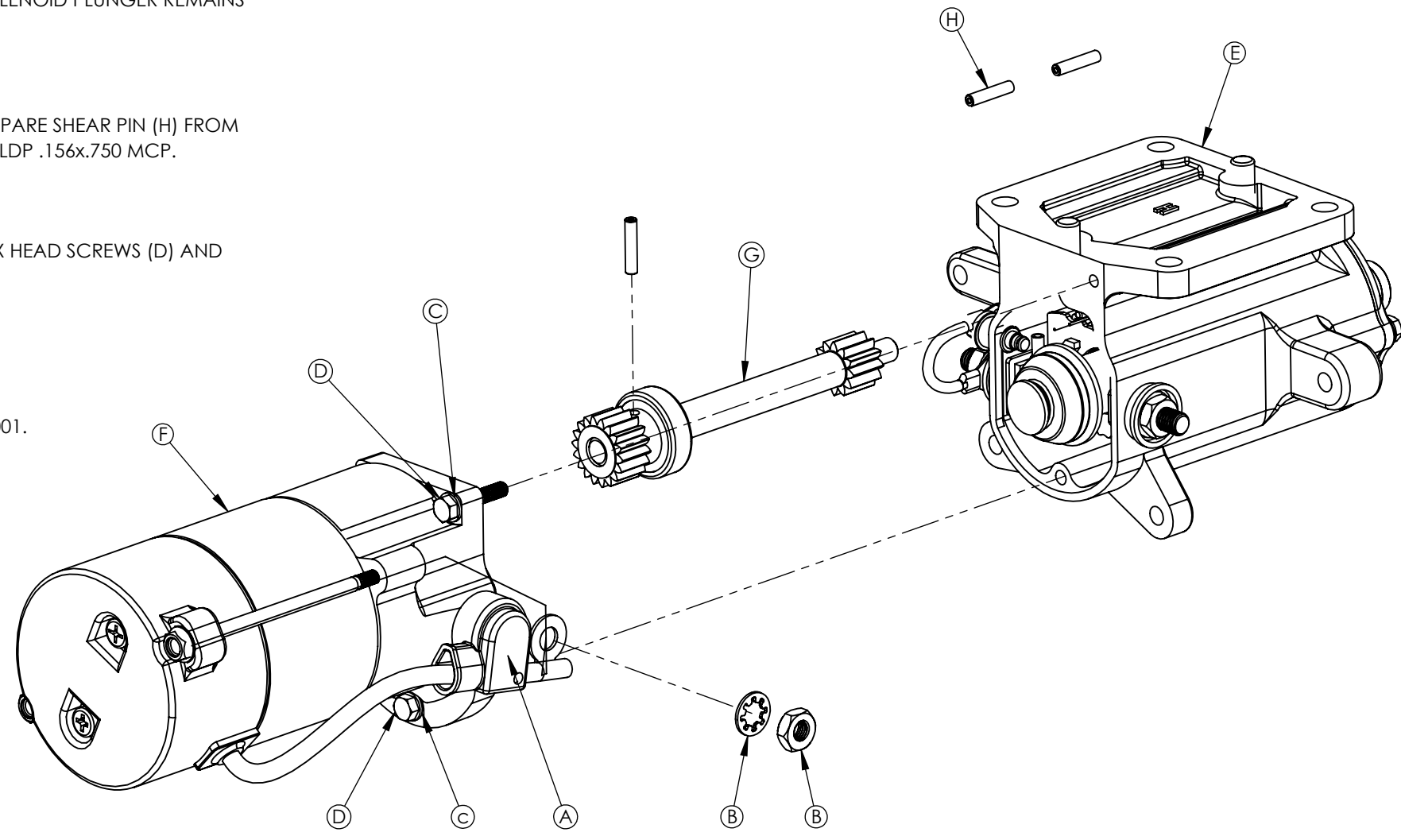
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SHEAR PIN REPLACEMENT INSTRUCTIONS

1. REMOVE STARTER FROM AIRCRAFT.
2. LIFT & SLIDE THE INSULATING BOOT (A) BACK ALONG THE MOTOR LEAD. REMOVE M8 NUT AND WASHER (B) USING 13mm WRENCH. REMOVE MOTOR LEAD FROM STUD.
- 3 REMOVE M5 HEX HEAD SCREWS (D) AND WASHERS (C) USING 8MM WRENCH.
4. SEPARATE SOLENOID SECTION (E) FROM MOTOR SECTION (F). ENSURE SOLENOID PLUNGER REMAINS INSIDE SOLENOID SECTION (E).
5. EXTRACT LAY SHAFT (G).
6. TAP OUT OLD SHEAR PIN FROM LAY SHAFT (G) AND REPLACE WITH NEW SPARE SHEAR PIN (H) FROM TOP OF SOLENOID SECTION E OR WITH HET P/N ST4301 OR WITH SPIROL CLDP .156x.750 MCP.
7. REASSEMBLE STARTER.
8. APPLY HIGH STRENGTH THREAD LOCK COMPOUND AND TORQUE M5 HEX HEAD SCREWS (D) AND WASHERS (C) TO 55-60 INCH-lbs.
9. TORQUE M8 NUT AND WASHER (B) TO 75-80 INCH-lbs.
10. SLIDE AND RESEAT INSULATING BOOT (A)
- 11 REINSTALL STARTER ON AIRCRAFT PER HET INSTALLATION DRAWING ST25001.

REVISIONS				
ECO	REV	DESCRIPTION	BY	DATE
129569	NEW	INITIAL RELEASE	RDN	02/18/20



UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES AND APPLY AFTER HEAT TREAT AND PLATING
.X ± .015 .XX ± .010
.XXX ± .005 ANGLES ± 1°
BREAK ALL EDGES AND MACHINE ALL INSIDE CORNER
FILLETS .015 MAX; SURFACE FINISH $\sqrt{125}$
GEOMETRIC SYMBOLS PER ASME Y14.5

SPECIFICATION CLASSIFICATION

CLASSIFICATION	DIMENSION CALLOUT	NOTE NO. CALLOUT
CRITICAL	<XX.XX>	<#>
MAJOR	[XX.XX]	[#]
MINOR	XX.XX	#
REFERENCE	(XX.XX)	(#)

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DRAFTER	RDN	02/18/20
ENGINEER	B. HENARD	
APPRVD.	129569	
FINISH	N/A	
WEIGHT	N/A	
MATERIAL	N/A	
SCALE	SIZE	SHEET
1:2	B	1 OF 1
CODE ID	65PY1	

2900 Selma Highway
Montgomery, AL 36108

NL SHEAR PIN INSTALLATION INSTRUCTIONS

DRAWING NO.	REV
ST25003	NEW

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