	<b>Manufacturing Work Instruction</b>				Pg 1 of 7
	101698	IF1200	Station	Phase	
<b>Date</b>	<b>Rev</b>	<b>Title</b>			
2/23/22	A	IF1200 - Installing 101824, 101826 - Folding Props			

**Engineer:** Tyler VanDenBerg


**Approved Engineering:** C.Elder

**Approved Manufacturing:**

---


**Revision History:**

Date	Rev	ECO#	Description
2/23/22	A		Initial Release

	<b>Manufacturing Work Instruction</b>				Pg 2 of 7
	101698	IF1200	Station	Phase	
<b>Date</b>	<b>Rev</b>	<b>Title</b>			
2/23/22	A	IF1200 - Installing 101824, 101826 - Folding Props			


**Parts Required:**

Item No.	Part No.	Description	LOC	Qty
1	101824	ASSY, FOLDING PROP, 18.5X6.3, CW		3
2	101826	ASSY, FOLDING PROP, 18.5X6.3, CCW		3

	<b>Manufacturing Work Instruction</b>				Pg 3 of 7
	101698	IF1200	Station	Phase	
<b>Date</b>	<b>Rev</b>	<b>Title</b>			
2/23/22	A	IF1200 - Installing 101824, 101826 - Folding Props			

**Tools Required:**

Hardware:	Consumables:
.9 Nm - 2.5mm Male Hex Torque Driver	
Blue Loctite	


	Manufacturing Work Instruction				Pg 4 of 7	
	101698	IF1200	Station	Phase		
Date	Rev	Title				
2/23/22	A	IF1200 - Installing 101824, 101826 - Folding Props				

**Procedure:**

Step 1:

Apply blue loctite to the four motor mounting screws.




	Manufacturing Work Instruction				Pg 5 of 7
	101698	IF1200	Station	Phase	
Date	Rev	Title			
2/23/22	A	IF1200 - Installing 101824, 101826 - Folding Props			

Step 2:

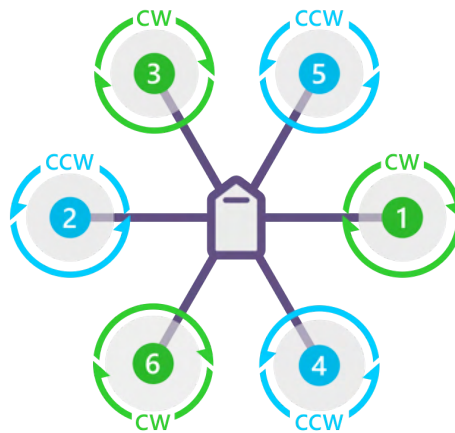
Make sure the torque driver is set to .9Nm




	Manufacturing Work Instruction				Pg 6 of 7
	101698	IF1200	Station	Phase	
Date	Rev	Title			
2/23/22	A	IF1200 - Installing 101824, 101826 - Folding Props			

Step 3:

Mount the propeller assembly to the motor. Make sure the propeller direction (noted below) is mounted on the correct motor.



	Manufacturing Work Instruction				Pg 7 of 7
	101698	IF1200	Station	Phase	
Date	Rev	Title			
2/23/22	A	IF1200 - Installing 101824, 101826 - Folding Props			

### QA Checks

- Make sure the propeller direction (noted below) is mounted on the correct motor.

