

Evolution Propeller Drill Guide

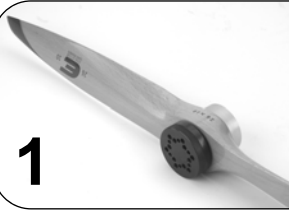
This Propeller Drill Guide is used to help drill accurate holes for the propeller screws so the propeller can be mounted securely and safely to the engine. It is specifically designed for use on the Evolution® line of gasoline engines, the **EVO45GX/GX2**, **58GX/GX2** and **116GX/GX2**.

Components:

EVO3380 Propeller Drill Guide, Complete
EVO33800101 Guide
EVO33800102 Washer, Fixing Screws (2 sizes)

EVO33800103 Drill Bits (3.9mm & 4.9mm)
EVO33800104 Chase Drill Bits (4.1mm & 5.1mm)
EVO33809999 Instructions

1



Place the guide on the front side of the propeller, so it is centered with the central fixing screw in the propeller center hole (diameter 10mm). Screw it together firmly.

2



Screw down the washer with one of the enclosed fixing screws (choose the one of the proper length).

3



Use of a drill press is recommended. Once the propeller blade is fixed in position, drill the first hole in full depth. Use the 3.9mm bit for the 58GX/GX2 propeller screws and the 4.9mm bit for the 45GX/GX2 propeller screws. A chase drill bit will be used to finish boring out the holes once the initial holes are all drilled. The 4.9mm bit is also for use on the 116GX/GX2. Pin the jig in place by placing one of the propeller bolts into the first full depth hole. This will ensure that the jig does not rotate during the drilling of the remaining holes.

4



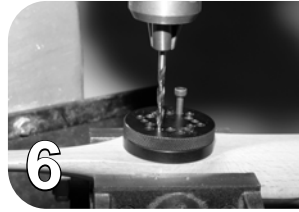
Drill all the other holes into depth about one half of the propeller thickness. The use of two bolts to pin in place will help ensure the rest of the holes line up when you go to step 6.

5



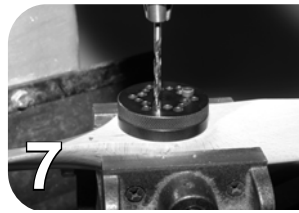
Unscrew the drill guide assembly, and reposition the guide portion of the jig to the opposite side of the propeller (Do not tighten the drill guide center bolt until the next step.)

6



Pin the full depth hole using a propeller bolt and then screw the guide firmly together and proceed to bore the other half of the propeller bolt holes.

7



Bore the other holes from the other side to full depth.

8



Remove the drill guide and replace bit with a chase bit to finish boring out the holes. The 4.1mm chase bit is used to drill out the 3.9 holes and the 5.1mm chase bit is used to drill out the 4.9 holes to the proper diameter for the propeller bolts.

OPTION: In case one has to use a hand drill (not recommended), repeat the above procedure, but mount the drill guide on the back side of the propeller. Use the drill guide with a bolt fastener as an arrestor pin and drill the holes from the back side of the propeller first.

IMPORTANT: Each bolt should be in place and tight, to prevent the propeller from bending or breaking the bolts.