

# PRATT & WHITNEY CANADA

## SERVICE BULLETIN

P&WC S.B. No. 13093R2

### ENGINE TURBINE/TURBOPROP IMPROVED COMPRESSOR ROTOR BALANCING ASSEMBLY - INTRODUCTION OF

#### 1. Planning Information

##### A. Effectivity

R All model PT6A-60,-60A Engines Serial No. PC-E95262 thru PC-E95279  
R inclusive, except Serial No. PC-E95276  
R All model PT6A-61,-61A Engines prior to Serial No. PC-E99092

##### B. Reason

To improve compressor performance and cyclic fatigue life.

##### C. Description

The existing compressor rotor balancing assembly is removed and replaced with a new assembly featuring a first-stage rotor with integral blades.

##### D. Compliance

R Group/Code Recommended - Incorporation applicable on prior  
R B4 configuration parts when supply of such items is depleted.

##### E. Approval

D.O.T./D.A.R. approved.

##### F. Manpower

No additional man-hours required if accomplished at engine overhaul.

##### G. Material - Cost and Availability

Refer to Section 3, Material Information.

##### H. Tooling - Price and Availability

PWC32437 Balancing Adapter, PWC32329 Puller, both tools required to further balance first-stage rotor at engine overhaul.

##### I. Weight and Balance

Incorporation of this bulletin will decrease engine weight by 0.06 pound.

83-313  
C00-603

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# PRATT & WHITNEY CANADA

P&WC S.B. No. 13093R2

## ENGINE TURBINE/TURBOPROP IMPROVED COMPRESSOR ROTOR BALANCING ASSEMBLY - INTRODUCTION OF

### J. References

Overhaul Manual P/N 3034343 for Turboprop Gas Turbine Engine  
(Models PT6A-60/-60A/-61/-61A)  
Service Bulletin No. 3032845-72-2 (P&WC SB13002)

### K. Other Publications Affected

Illustrated Parts Catalog P/N 3034344 for Turboprop Gas Turbine Engine  
(Models PT6A-60/-60A/-61/-61A)

## 2. Accomplishment Instructions

- A. At engine disassembly in accordance with Overhaul Manual instructions, remove and discard the following parts from the compressor rotor balancing assembly:

	<u>P/N</u>	<u>QTY</u>	<u>NOMENCLATURE</u>
	3106901-01	16	Blade, Compressor
R	3102921-02	REF	Hub, Compressor, Assy of
	AN123154	6	Rivet, Solid
	3030354	1	Ring, Blade Retaining
	3036011	1	Hub, Compressor, Rear

- (a) Retain for reuse the following parts:

	3014018	1	Seal Air, Compressor, Rear, Rotor
	3021460	1	Coupling Compressor, Rear, Hub
	MS171625	1	Pin, Spring

- B. At engine assembly, install the following new and retained parts in compressor rotor assembly:

R	3104821-01	REF	Rotor Assy, Compressor
	3033801	1	Rotor, Compressor
	3014018	1	Seal, Air Compressor, Rear, Rotor
	3021460	1	Coupling, Compressor, Rear, Hub
	MS171625	1	Pin, Spring

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# PRATT & WHITNEY CANADA

P&WC S.B. No. 13093R2

## ENGINE TURBINE/TURBOPROP IMPROVED COMPRESSOR ROTOR BALANCING ASSEMBLY - INTRODUCTION OF

### 3. Material Information

The quantity of material listed in this section is on a per engine basis.

	<u>New</u> <u>P/N</u>	<u>Qty</u>	<u>Est. Unit</u> <u>List Price</u>	<u>Keyword</u>	<u>Old</u> <u>P/N</u>	<u>Instructions -</u> <u>Disposition</u>
R	3106896-01	REF		Rotor Balancing Assy, Compressor	3106859-01 or 3106859-02	Reference
		16		.Blade, Compressor	3106901-01	Discard
R		1		.Hub, Compressor	3102921-02 or 3102921-04	Discard
		6		.Rivet, Solid, 0.062 x 0.312	AN123154	
	AN123152	5 Max.		.Rivet, Solid, 0.062 x 0.188 Universal		
				.Rivet, Solid, 0.062 x 0.375 Universal	AN123155	
	AN123154	9 Max.		.Rivet, Solid, 0.062 x 0.312 Universal		
				.Rivet, Solid, 0.062 x 0.344 Universal	AN123161	
	AN123153	9 Max.		.Rivet, Solid, 0.062 x 0.250 Universal		
	Z3014018	1		.Seal, Air, Compressor Rear, Rotor	3014018	Retain for reuse
		1		.Ring, Blade Retaining	3030354	Discard
		6		.Rivet, Solid	AN123154	Discard
R		1		.Hub, Compressor, Rear	3036011 or 3037311	Discard

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# PRATT & WHITNEY CANADA

P&WC S.B. No. 13093R2

## ENGINE TURBINE/TURBOPROP IMPROVED COMPRESSOR ROTOR BALANCING ASSEMBLY - INTRODUCTION OF

<u>New</u> <u>P/N</u>	<u>Qty</u>	<u>Est. Unit</u> <u>List Price</u>	<u>Keyword</u>	<u>Old</u> <u>P/N</u>	<u>Instructions -</u> <u>Disposition</u>
%3021460	1		.Coupling, Compressor, Rear, Hub	3021460	Retain for reuse
%MS171625	1		.Pin, Spring	MS171625	Retain for reuse
R 3104821-01	REF		.Rotor Assy, Compressor		Reference
3033801	1		.Rotor, Compressor		

% Existing parts retained for reuse.

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PRATT & WHITNEY CANADA

ENGINE BUILD RECORD STATUS

THE FOLLOWING SERVICE BULLETINS ARE BASIC TO :

ENGINE SERIAL NO. PCE-PK0999

ENGINE MODEL PT6A-60A

BUILD SPEC 1024

SERVICE BULLETINS

13006	13008	13009	13010	13011	13015	13018	13019	13021
13023	13025	13026	13028	13031	13032	13034	13038	13043
13046	13047	13048	13050	13052	13053	13055	13058	13059
13062	13065	13066	13067	13068	13069	13071	13072	13080
13082	13086	13089	13093	13096	13105	13108	13109	13115
13116	13121	13124	13126	13128	13129	13130	13131	13134
13135	13136	13141	13144	13148	13152	13155	13159	13161
13163	13172	13173	13174	13175	13177	13179	13181	13188
13189	13190	13191	13192	13193	13197	13201	13205	13206
13207	13208	13214	13217	13221	13223	13224	13225	13226
13227	13228	13232	13234	13235	13240	13241	13242	13243
13249	13252	13255	13256	13258	13263	13266	13267	13268
13270	13274	13275	13277	13280	13282	13287	13290	13293
13297	13301	13302	13312	13313	13319	13321	13323	13337
13338	13346	13352	13354	13355	13356	13357	13359	13360
13365	13369	13371	13379	13385	13386	13392	13399	13400
13401	13405	13414	13416	13422	13423	13425	13426	

APPROVED BY :  T.C. 4-58  
NO-029  
K. PIVIDOR

DATE : 2008.06.26

## PRATT &amp; WHITNEY CANADA

## ENGINE BUILD RECORD STATUS

THE FOLLOWING SERVICE BULLETINS ARE BASIC TO :

ENGINE SERIAL NO. PCE-PK0971

ENGINE MODEL PT6A-60A

BUILD SPEC 1024

## SERVICE BULLETINS

13006	13008	13009	13010	13011	13015	13018	13019	13021
13023	13025	13026	13028	13031	13032	13034	13038	13043
13046	13047	13048	13050	13052	13053	13055	13058	13059
13062	13065	13066	13067	13068	13069	13071	13072	13080
13082	13086	13089	13093	13096	13105	13108	13109	13115
13116	13121	13124	13126	13128	13129	13130	13131	13134
13135	13136	13141	13144	13148	13152	13155	13159	13161
13163	13172	13173	13174	13175	13177	13179	13181	13188
13189	13190	13191	13192	13193	13197	13201	13205	13206
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13249	13252	13255	13256	13258	13263	13266	13267	13268
13270	13274	13275	13277	13280	13282	13287	13290	13293
13297	13301	13302	13312	13313	13319	13321	13323	13337
13338	13346	13352	13354	13355	13356	13357	13359	13360
13365	13369	13371	13379	13385	13386	13392	13399	13400
13401	13405	13414	13416	13422	13423	13425	13426	

APPROVED BY :

*B. Hungerford*T.C. 4-58  
NO. 031

B. HUNGERFORD

DATE : 2008.04.22

PRATT & WHITNEY CANADA

ENGINE BUILD RECORD STATUS

THE FOLLOWING SERVICE BULLETINS ARE BASIC TO :

ENGINE SERIAL NO. PCE-PK1183

ENGINE MODEL PT6A-60A

BUILD SPEC 1024

SERVICE BULLETINS

13006	13008	13009	13010	13011	13015	13018	13019	13021
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13046	13047	13048	13050	13052	13053	13055	13058	13059
13062	13065	13066	13067	13068	13069	13071	13072	13080
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13249	13252	13255	13256	13258	13263	13266	13267	13268
13270	13274	13275	13277	13280	13282	13287	13290	13293
13297	13301	13302	13312	13313	13319	13321	13323	13337
13338	13346	13352	13354	13355	13356	13357	13359	13360
13365	13369	13371	13379	13385	13386	13392	13399	13400
13401	13405	13414	13416	13422	13423	13425	13426	13431



APPROVED BY:

*[Signature]*  
**K. PIVIDOR**

DATE: 2009.08.28

## PRATT &amp; WHITNEY CANADA

## ENGINE BUILD RECORD STATUS

THE FOLLOWING SERVICE BULLETINS ARE BASIC TO :

ENGINE SERIAL NO. PCE-PK0970

ENGINE MODEL PT6A-60A

BUILD SPEC 1024

## SERVICE BULLETINS

13006	13008	13009	13010	13011	13015	13018	13019	13021
13023	13025	13026	13028	13031	13032	13034	13038	13043
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13249	13252	13255	13256	13258	13263	13266	13267	13268
13270	13274	13275	13277	13280	13282	13287	13290	13293
13297	13301	13302	13312	13313	13319	13321	13323	13337
13338	13346	13352	13354	13355	13356	13357	13359	13360
13365	13369	13371	13379	13385	13386	13392	13399	13400
13401	13405	13414	13416	13422	13423	13425	13426	

T.C. 4-88  
NO. 024

APPROVED BY :


**K. PIVDOR**

DATE : 2008.04.22



PRATT & WHITNEY CANADA

ENGINE BUILD RECORD STATUS

THE FOLLOWING SERVICE BULLETINS ARE BASIC TO :

ENGINE SERIAL NO. PCE-PK0984

ENGINE MODEL PT6A-60A

BUILD SPEC 1024

SERVICE BULLETINS

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13297	13301	13302	13312	13313	13319	13321	13323	13337
13338	13346	13352	13354	13355	13356	13357	13359	13360
13365	13369	13371	13379	13385	13386	13392	13399	13400
13401	13405	13414	13416	13422	13423	13425	13426	

APPROVED BY :  M. VANMAANEN  T.C. 4-58 NO. 039

DATE : 2008.05.26

PRATT & WHITNEY CANADA

ENGINE BUILD RECORD STATUS

THE FOLLOWING SERVICE BULLETINS ARE BASIC TO :

ENGINE SERIAL NO. PCE-PK0998

ENGINE MODEL PT6A-60A

BUILD SPEC 1024

SERVICE BULLETINS

13006	13008	13009	13010	13011	13015	13018	13019	13021
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13163	13172	13173	13174	13175	13177	13179	13181	13188
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13249	13252	13255	13256	13258	13263	13266	13267	13268
13270	13274	13275	13277	13280	13282	13287	13290	13293
13297	13301	13302	13312	13313	13319	13321	13323	13337
13338	13346	13352	13354	13355	13356	13357	13359	13360
13365	13369	13371	13379	13385	13386	13392	13399	13400
13401	13405	13414	13416	13422	13423	13425	13426	

APPROVED BY :  **K. PIVDOR**

DATE : 2008.06.25

PRATT & WHITNEY CANADA

ENGINE BUILD RECORD STATUS

THE FOLLOWING SERVICE BULLETINS ARE BASIC TO :

ENGINE SERIAL NO. **PCE-PK0985**

ENGINE MODEL PT6A-60A

BUILD SPEC 1024

SERVICE BULLETINS

13006	13008	13009	13010	13011	13015	13018	13019	13021
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13046	13047	13048	13050	13052	13053	13055	13058	13059
13062	13065	13066	13067	13068	13069	13071	13072	13080
13082	13086	13089	<b>13093</b>	13096	13105	13108	13109	13115
13116	13121	13124	13126	13128	13129	13130	13131	13134
13135	13136	13141	13144	13148	13152	13155	13159	13161
13163	13172	13173	13174	13175	13177	13179	13181	13188
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13297	13301	13302	13312	13313	13319	13321	13323	13337
13338	13346	13352	13354	13355	13356	13357	13359	13360
13365	13369	13371	13379	13385	13386	13392	13399	13400
13401	13405	13414	13416	13422	13423	13425	13426	



APPROVED BY :  **K. PIVDOR**

DATE : 2008.05.27

PRATT & WHITNEY CANADA

ENGINE BUILD RECORD STATUS

THE FOLLOWING SERVICE BULLETINS ARE BASIC TO :

ENGINE SERIAL NO. PCE-PK1184

ENGINE MODEL PT6A-60A

BUILD SPEC 1024

SERVICE BULLETINS

13006	13008	13009	13010	13011	13015	13018	13019	13021
13023	13025	13026	13028	13031	13032	13034	13038	13043
13046	13047	13048	13050	13052	13053	13055	13058	13059
13062	13065	13066	13067	13068	13069	13071	13072	13080
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13249	13252	13255	13256	13258	13263	13266	13267	13268
13270	13274	13275	13277	13280	13282	13287	13290	13293
13297	13301	13302	13312	13313	13319	13321	13323	13337
13338	13346	13352	13354	13355	13356	13357	13359	13360
13365	13369	13371	13379	13385	13386	13392	13399	13400
13401	13405	13414	13416	13422	13423	13425	13426	13431



APPROVED BY:

*[Signature]*  
K. PIVDOR

DATE: 2009.08.28

PRATT & WHITNEY CANADA

ENGINE BUILD RECORD STATUS

THE FOLLOWING SERVICE BULLETINS ARE BASIC TO :

ENGINE SERIAL NO. PCE-PK1187

ENGINE MODEL PT6A-60A

BUILD SPEC 1025

SERVICE BULLETINS

13006	13008	13009	13010	13011	13015	13018	13019	13021
13023	13025	13026	13028	13031	13032	13034	13038	13043
13046	13047	13048	13050	13052	13053	13055	13058	13059
13062	13065	13066	13067	13068	13069	13071	13072	13080
13082	13086	13089	13093	13096	13105	13108	13109	13115
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13163	13172	13173	13174	13175	13177	13179	13181	13188
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13227	13228	13232	13234	13235	13240	13241	13242	13243
13249	13252	13255	13256	13258	13263	13266	13267	13268
13270	13274	13275	13277	13280	13282	13287	13290	13293
13297	13301	13302	13312	13313	13319	13321	13323	13337
13338	13346	13352	13354	13355	13356	13357	13359	13360
13365	13369	13371	13379	13385	13386	13392	13399	13400
13401	13405	13414	13416	13422	13423	13425	13426	13431

R. WEISTRA

APPROVED BY: *[Signature]*



DATE: 2009.08.31

PRATT & WHITNEY CANADA

ENGINE BUILD RECORD STATUS

THE FOLLOWING SERVICE BULLETINS ARE BASIC TO :

ENGINE SERIAL NO. PCE-PK1188

ENGINE MODEL PT6A-60A

BUILD SPEC 1025

SERVICE BULLETINS

13006	13008	13009	13010	13011	13015	13018	13019	13021
13023	13025	13026	13028	13031	13032	13034	13038	13043
13046	13047	13048	13050	13052	13053	13055	13058	13059
13062	13065	13066	13067	13068	13069	13071	13072	13080
13082	13086	13089	13093	13096	13105	13108	13109	13115
13116	13121	13124	13126	13128	13129	13130	13131	13134
13135	13136	13141	13144	13148	13152	13155	13159	13161
13163	13172	13173	13174	13175	13177	13179	13181	13188
13189	13190	13191	13192	13193	13197	13201	13205	13206
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13227	13228	13232	13234	13235	13240	13241	13242	13243
13249	13252	13255	13256	13258	13263	13266	13267	13268
13270	13274	13275	13277	13280	13282	13287	13290	13293
13297	13301	13302	13312	13313	13319	13321	13323	13337
13338	13346	13352	13354	13355	13356	13357	13359	13360
13365	13369	13371	13379	13385	13386	13392	13399	13400
13401	13405	13414	13416	13422	13423	13425	13426	13431

R. WEISTRA

APPROVED BY:

*Robert Weistra*



DATE: 2009.09.01