

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 13240R2

BULLETIN INDEX LOCATOR

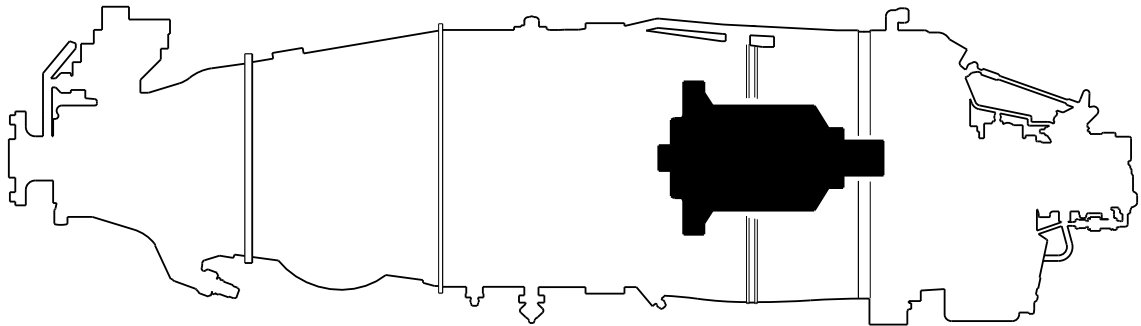
TURBOPROP ENGINE
COMPRESSOR ROTOR ASSEMBLY - REPLACEMENT OF

MODEL APPLICATION

PT6A-60A, PT6A-61, PT6A-62

Compliance: CATEGORY 8

Summary: It is sometimes necessary to rebuild the engine after test in order to meet the performance acceptance limits due to vibrations in the compressor. The compressor efficiency is improved with a new (rear) compressor rotor assembly which has reduced dimensional tolerances for the rotor blade angle and hub and blade tip profiles.



Jan 25/1994
Revision No. 2: May 25/2021

PT6A-72-13240
Cover Sheet

24-Hour Global Service CFIRST CENTRE Toll free where available (SIL GEN-027)	USA & CANADA..... 1-800-268-8000 International (IAC*)+8000-268-8000 * International Access Code	Other 1-450-647-8000 Fax 1-450-647-2888 Web Site www.pwc.ca
---	---	---

WARNING - PROPRIETARY RIGHTS & EXPORT CONTROLS NOTICE

This bulletin contains proprietary information of Pratt & Whitney Canada Corp. ("P&WC"), which P&WC provides in confidence and solely for the purposes of supporting engine certification and providing applicable information regarding the proper use, maintenance, inspection, repair, servicing and parts application of P&WC products and services, as directed therein. Neither this bulletin nor any information in it may be disclosed to others, or used for any other purpose, including, without limitation, to design, create, develop, reproduce, manufacture or derive any design, part, product, material, process, modification, configuration change or repair, or obtain FAA or other government approval to do so. Possession and use of this bulletin is also subject to the restrictions set out in P&WC's Technical Data Agreement (a copy of which may be obtained by contacting P&WC Technical Publications). The contents of this bulletin may be subject to export control laws. Unauthorized export or re-export of the bulletin, or parts thereof, is prohibited. By accepting and possessing this bulletin, you agree to be bound by the foregoing terms.

If a Government agency or department intends to disclose any information, written notice should be given to:

VP - Legal Services, Pratt & Whitney Canada Corp., 1000 Marie-Victorin (01BE5), Longueuil, Quebec J4G 1A1.

Pratt & Whitney Canada Corp.
1000, Marie-Victorin
Longueuil, Québec, Canada J4G 1A1
Tél. 450-677-9411



Pratt & Whitney Canada

A United Technologies Company

25 May 2021

P&WC S.B. No. 13240R2

REVISION TRANSMITTAL SHEET
TURBOPROP ENGINE MODEL PT6A

SUBJECT: Pratt & Whitney Canada Service Bulletin No. PT6A-72-13240, Rev. No. 2, dated May 25/2021 (P&WC S.B. No. 13240R2) COMPRESSOR ROTOR ASSEMBLY - REPLACEMENT OF

Replace your existing copy of this service bulletin with the attached revised bulletin. Destroy the superseded copy.

Please retain this Revision Transmittal Sheet with the revised bulletin.

SUMMARY: This service bulletin is revised to correct the Fits and Clearance limits value in para.4.B., Appendix and update pricing to current year.

EFFECT OF REVISION ON PRIOR ACCOMPLISHMENT:

None.

NOTE: A black bar in the left margin indicates a change in that line of text or figure.

REVISION HISTORY:

Original Issue: Jan 25/1994
Revision No. 1: Jan 22/1999
Revision No. 2: May 25/2021

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 13240R2

TURBOPROP ENGINE
COMPRESSOR ROTOR ASSEMBLY - REPLACEMENT OF

1. Planning Information

A. Effectivity

PT6A-60A Engines which are before and include Serial No. PCE-95769
PT6A-61 Engines Serial No. PCE-99001 thru PCE-99142
PT6A-62 Engines which are before and include Serial No. PCE-103220.

B. Concurrent Requirements

None.

C. Reason

(1) Problem

It is sometimes necessary to rebuild the engine after test in order to meet the performance acceptance limits.

(2) Cause

The compressor efficiency varies because the dimensional tolerances on the rotor blade angle and the hub and blade tip profiles.

(3) Solution

To obtain improved and consistent compressor efficiency, replace the (rear) compressor rotor assembly with a new one which has reduced dimensional tolerances for the rotor blade and the hub and blade tip profiles.

D. Description

The compressor rotor assembly is replaced with a similar rotor assembly with reduced dimensional tolerances.

E. Compliance

CATEGORY 8 - This service bulletin is optional and can be done at the discretion of the operator.

F. Approval

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

G. Manpower

No more man-hours are necessary to include this service bulletin at overhaul.

H. Weight and Balance

None.

P&WC No. 96181

Jan 25/1994

Revision No. 2: May 25/2021

P&WC Proprietary Information. Subject to the restrictions on the back of the locator

© 1994 Pratt & Whitney Canada Corp.
PRINTED IN CANADA

PT6A-72-13240

Page 1 of 7

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 13240R2

TURBOPROP ENGINE
COMPRESSOR ROTOR ASSEMBLY - REPLACEMENT OF

1. Planning Information (Cont'd)

I. Electrical Load Data

Not changed.

J. Software Accomplishment Summary

Not applicable.

K. References

Applicable PT6A Technical Manuals

L. Publications Affected

Applicable PT6A Technical Manuals

M. Interchangeability and Intermixability of Parts

Interchangeability - Refer to Para. 2.C.

Intermixability - Not changed.

2. Material Information

A. Industry Support Information

Not applicable.

B. Material - Cost and Availability

You can get the procurable parts listed in Para. 2.C. from any Pratt & Whitney Canada Parts Distribution Center.

The estimated total cost of new parts needed to replace old parts is \$ 86,713.00 (US, 2021).

The new parts are available.

PRATT & WHITNEY CANADA SERVICE BULLETIN

P&WC S.B. No. 13240R2

TURBOPROP ENGINE COMPRESSOR ROTOR ASSEMBLY - REPLACEMENT OF

2. Material Information (Cont'd)

C. Material Necessary for Each Engine

The quantity of materials listed in this section is on a per Engine basis.

<u>New P/N</u>	<u>Keyword</u>	<u>Old P/N</u>	<u>Qty</u>	<u>Est. Unit List Price (\$US, 2021)</u>	<u>Instructions Disposition</u>
For PT6A-60A and -61 Engines:					
3106896-01	Rotor Balancing Assembly, Compressor	3106896-01	Ref		
	OR				
3119225-01	Rotor Balancing Assembly, Compressor	3119225-01	Ref		
3119074-01	. Rotor Assembly, Compressor		1	86,713.00	(A)
3041271	. . Rotor, Compressor, Rear		NP		
	. Rotor Assembly, Compressor	3115821-01	1		(A)(B)
	. . Rotor, Interchangeability Control (IC)	3038759	1		
	. . . Rotor, Compressor, Rear	3041401	1		
	. . . Rotor, Compressor, Rear	3041301	1		
For PT6A-62 Engines:					
3106860-01	Rotor Balancing Assembly, Compressor	3106860-01	Ref		
	OR				
3119224-01	Rotor Balancing Assembly, Compressor	3119224-01	Ref		
3119074-01	. Rotor Assembly, Compressor	3117821-01	1	86,713.00	(A)(B)
3041271	. . Rotor, Compressor, Rear	3041401	NP		

Jan 25/1994

Revision No. 2: May 25/2021

P&WC Proprietary Information. Subject to the restrictions on the back of the locator

PT6A-72-13240
Page 3 of 7

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 13240R2

TURBOPROP ENGINE
COMPRESSOR ROTOR ASSEMBLY - REPLACEMENT OF

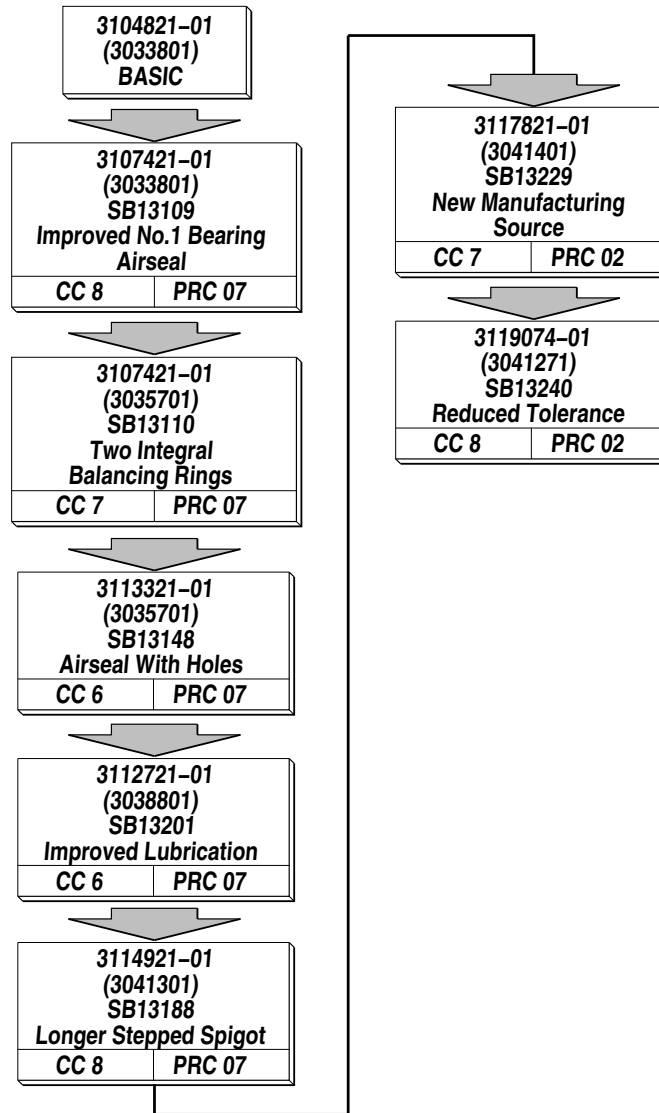
<u>New P/N</u>	<u>Keyword</u>	<u>Old P/N</u>	<u>Qty</u>	<u>Est. Unit List Price (\$US, 2021)</u>	<u>Instructions Disposition</u>
(A)	TWO WAY INTERCHANGEABLE - (ATA 200 Explanation Code 02): The old or the new part can replace the old or the new part.				
(B)	Retain the old part for future modification. Modification instructions will be included in a revision to this service bulletin.				
D.	<u>Reidentified Parts</u> None.				
E.	<u>Tooling - Price and Availability</u> Not applicable.				
3.	<u>Accomplishment Instructions</u> A. Remove the parts listed under old P/N in Para. 2.C., Material Information, per the applicable overhaul manual instructions. B. Install the parts listed under New P/N in Para. 2.C., Material Information, per the applicable overhaul manual instructions (Ref. Table 1). C. Write accomplishment of P&WC S.B. No. 13240 in the applicable engine module log book.				
4.	<u>Appendix</u> A. Refer to Figure 1 for the progression of the part. B. Changes to the Fits and Clearances also are in the Appendix				

PRATT & WHITNEY CANADA SERVICE BULLETIN

P&WC S.B. No. 13240R2

TURBOPROP ENGINE COMPRESSOR ROTOR ASSEMBLY - REPLACEMENT OF

PT6A-62 ENGINES



C66378

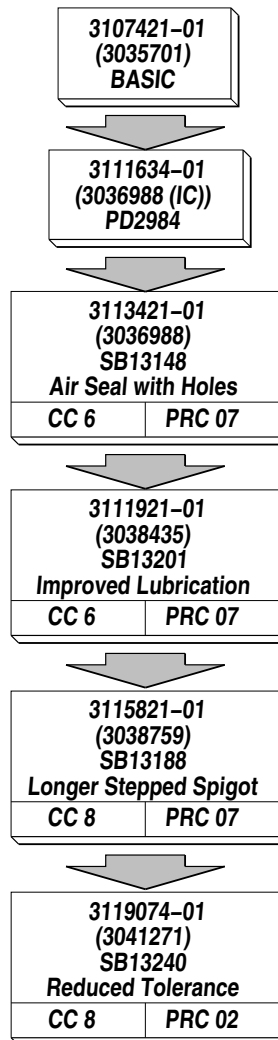
Compressor Rotor Assembly (Rotor) Part Progression
Figure 1 (Sheet 1 of 2)

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 13240R2

TURBOPROP ENGINE
COMPRESSOR ROTOR ASSEMBLY - REPLACEMENT OF

PT6A-60A/-61 ENGINES



C66399

Compressor Rotor Assembly (Rotor) Part Progression
Figure 1 (Sheet 2)

Jan 25/1994
Revision No. 2: May 25/2021

P&WC Proprietary Information. Subject to the restrictions on the back of the locator

PT6A-72-13240
Page 6 of 7

PRATT & WHITNEY CANADA SERVICE BULLETIN

P&WC S.B. No. 13240R2

TURBOPROP ENGINE COMPRESSOR ROTOR ASSEMBLY - REPLACEMENT OF

4. Appendix (Cont'd)

TABLE 1, Compressor 1 st Stage

REF. NO.	IFR	Name	Dim. for Ref. inches (mm)		Limits inches (mm)		Replace
			Min.	Max.	Min.	Max.	
319		Blade, Compressor 1st Stage (By selection)			0.0110 (0.279)	0.0190 (0.483)	
<u>NOTE:</u> (Radial Tip Clearance)							