

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 13519

BULLETIN INDEX LOCATOR
75-30-00

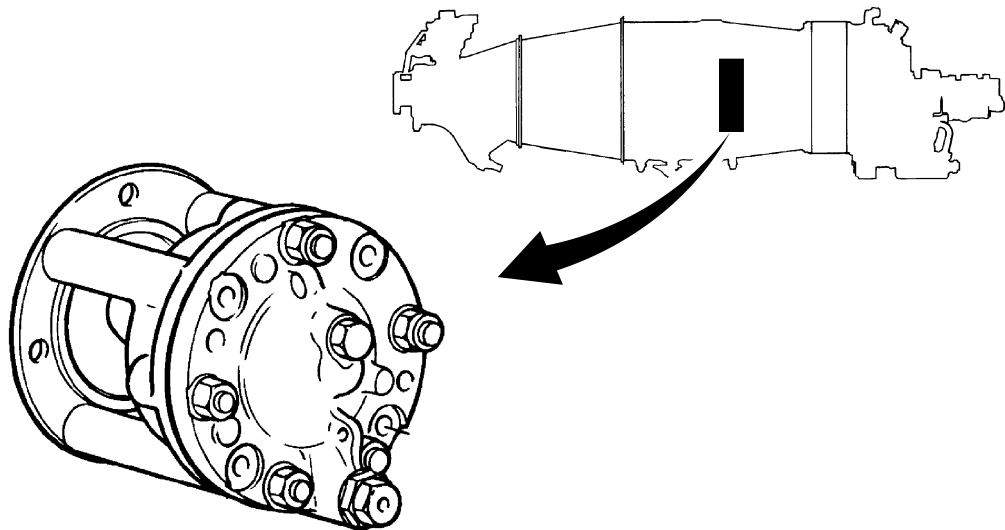
TURBOPROP ENGINE
COMPRESSOR BLEED VALVE - REPLACEMENT OF

MODEL APPLICATION

PT6A-52, PT6A-60A, PT6A-60AG, PT6A-61, PT6A-62

Compliance: CATEGORY 7

Summary: The compressor bleed valve assembly can be improved. Replace the bleed valve assembly with one that has the housing and cover manufactured by a fully machined process. The opportunity is taken to replace various cadmium plated hardware with ones made from a different material.



Jun 01/2021

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Cover Sheet

24-Hour Global Service

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TURBOPROP ENGINE
COMPRESSOR BLEED VALVE - REPLACEMENT OF

1. Planning Information

A. Effectivity

PT6A-52 BS1228, BS1269, BS1270, BS1358, BS1435 Engines which are before and include Serial No. PCE-RX1156.

PT6A-60A BS613, BS662, BS1024, BS1025, BS1271, BS1272 Engines which are before and include Serial No. PCE-PK2698 and PCE-95006 thru PCE-95828.

PT6A-60AG BS919, BS976, BS1048, BS1049, BS1210, BS1212 Engines which are before and include Serial No. PCE-RG0219.

PT6A-61 BS618, BS1236, BS1275 Engines which are before and include Serial No. PCE-HA0305 and Serial No. which include PCE-99001 thru PCE-99142.

PT6A-62 BS641, BS741, BS833, BS855, BS917, BS938, BS960, BS981, BS982, BS1044, BS1110, BS1173, BS1190, BS1320 Engines.

B. Concurrent Requirements

None.

C. Reason

(1) Problem

The compressor bleed valve assembly can be improved.

(2) Cause

The bleed valve housing and cover casting process is not optimal.

(3) Solution

Replace the bleed valve assembly with one that has the housing and cover manufactured by a fully machined process. Also the opportunity is taken to replace various cadmium plated hardware with ones made from a different material

D. Description

Replace the BOV with a new one.

E. Compliance

CATEGORY 7 - You can do this service bulletin when the supply of superseded parts is fully used.

F. Approval

D.O.T./D.A.A . Approved.

P&WC No. CO-0009357

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COMPRESSOR BLEED VALVE - REPLACEMENT OF

1. Planning Information (Cont'd)

G. Manpower

Not applicable.

H. Weight and Balance

None.

I. Electrical Load Data

Not applicable.

J. Software Accomplishment Summary

Not applicable.

K. References

Illustrated Parts Catalog P/N [3072864](#) (PT6A-52)

Illustrated Parts Catalog P/N [3034344](#) (PT6A-60A/60AG/61)

Illustrated Parts Catalog P/N [3034544](#) (PT6A-62)

Maintenance Manual P/N [3072862](#) (PT6A-52)

Maintenance Manual P/N [3034342](#) (PT6A-60A/60AG/61)

Maintenance Manual P/N [3034542](#) (PT6A-62)

Overhaul Manual P/N [3072863](#) (PT6A-52)

Overhaul Manual P/N [3034343](#) (PT6A-60A/60AG/61)

Overhaul Manual P/N [3034543](#) (PT6A-62)

L. Publications Affected

Illustrated Parts Catalog P/N [3072864](#) (PT6A-52)

Illustrated Parts Catalog P/N [3034344](#) (PT6A-60A/60AG/61)

Illustrated Parts Catalog P/N [3034544](#) (PT6A-62)

Maintenance Manual P/N [3072862](#) (PT6A-52)

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1. Planning Information (Cont'd)

Maintenance Manual P/N [3034342](#) (PT6A-60A/60AG/61)

Maintenance Manual P/N [3034542](#) (PT6A-62)

Overhaul Manual P/N [3072863](#) (PT6A-52)

Overhaul Manual P/N [3034343](#) (PT6A-60A/60AG/61)

Overhaul Manual P/N [3034543](#) (PT6A-62)

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 - Price 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 Quote (US, 2021).

The new parts are available.

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 Dispositions</u>
PT6A-62(BS641, BS741, BS833, BS855, BS917, BS938, BS960, BS981, BS982, BS1173, BS1190, BS1320:)					
3133925	Valve Assembly, Compressor Bleed	3072715-01	1		(A)(C)

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2. Material Information (Cont'd)

<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 Dispositions</u>
3133906	.Housing Assembly, Compressor Bleed Valve	3056987-01	1		(B)
3133860	..Housing, Compressor Bleed Valve	3056707-01	1	NP	
ST3174-021	..Stud, Stepped,.250- 20X.190-32X1.125	AN154732	5		(B)
MS9816-05	.Bolt, Mach, DR HEX	MS9529-05	3		(B)
3133916	.Cover Assembly, Compressor Bleed Valve	3070261-01	1		(B)
3133915	..Cover, Compressor Bleed Valve	3070260-01	1	NP	
MS9321-09	.Washer, Flat	MS9320-09	5		(B)
ST3032-09	.Nut Option (IC)	3012675	5		(B)
AS3510-0218K	.Wire-Safety,.025 DIA	MS9226-03	999		(A)
PT6A-52(BS1228, BS1269, BS1270, BS1358, BS1435), PT6A-60A(BS1024, BS1025, BS1271, BS1272, BS613, BS662), PT6A-60AG(BS1048, BS1049, BS1210, BS1212, BS919, BS976), PT6A-61(BS1236, BS1275, BS618)					
3136457	Valve Assembly, Compressor Bleed	3136046	1		(A)(C)
3133902	.Housing Assembly, Compressor Bleed Valve	3102073-04	1		(B)
3133857	..Housing, Compressor Bleed Valve	3103172-01	1	NP	
ST3174-021	..Stud, Stepped,.250- 20X.190-32X1.125	AN154732	5		(B)
MS9816-05	.Bolt, Mach, DR HEX	MS9529-05	3		(B)
3133908	.Cover Assembly, Compressor Bleed Valve	3102070-02	1		(B)
3133907	..Cover, Compressor Bleed Valve	3102069-01	1	NP	

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2. Material Information (Cont'd)

<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 Dispositions</u>
MS9321-09	.Washer, Flat	MS9320-09	5		(B)
ST3081-10	.Nut Option (IC)	3012675	5		(B)
AS3510-0218K	.WIRE-SAFETY,.025 DIA	MS9226-03	999		(A)

(A) TWO WAY INTERCHANGEABLE - (ATA 200 Explanation Code 02): The old or the new part can replace the old or the new part.

(B) NOT INTERCHANGEABLE - (ATA 200 Explanation Code 03): The old part must replace the old part; the new part must replace new part.

(C) Discard the old part if it is unserviceable.

D. Reidentified Parts

None.

E. Tooling - Price and Availability

Not Applicable.

3. Accomplishment Instructions

A. Remove the parts in the Old P/N list in Para. 2.C., Material Information, in accordance with the maintenance or overhaul manual instructions as follows:

Ref. MM 75-30-00 COMPRESSOR BLEED VALVE - MAINTENANCE PRACTICES.

Ref. OHM 75-30-00 COMPRESSOR BLEED VALVE - DISASSEMBLY.

B. Install the parts in the New P/N list in Para. 2.C., Material Information, in accordance with the maintenance or overhaul manual instructions as follows:

Ref. MM 75-30-00 COMPRESSOR BLEED VALVE - MAINTENANCE PRACTICES.

Ref. OHM 75-30-00 COMPRESSOR BLEED VALVE - ASSEMBLY.

C. Write the accomplishment of P&WC SBNo. 13519 in the engine module log book.

4. Appendix

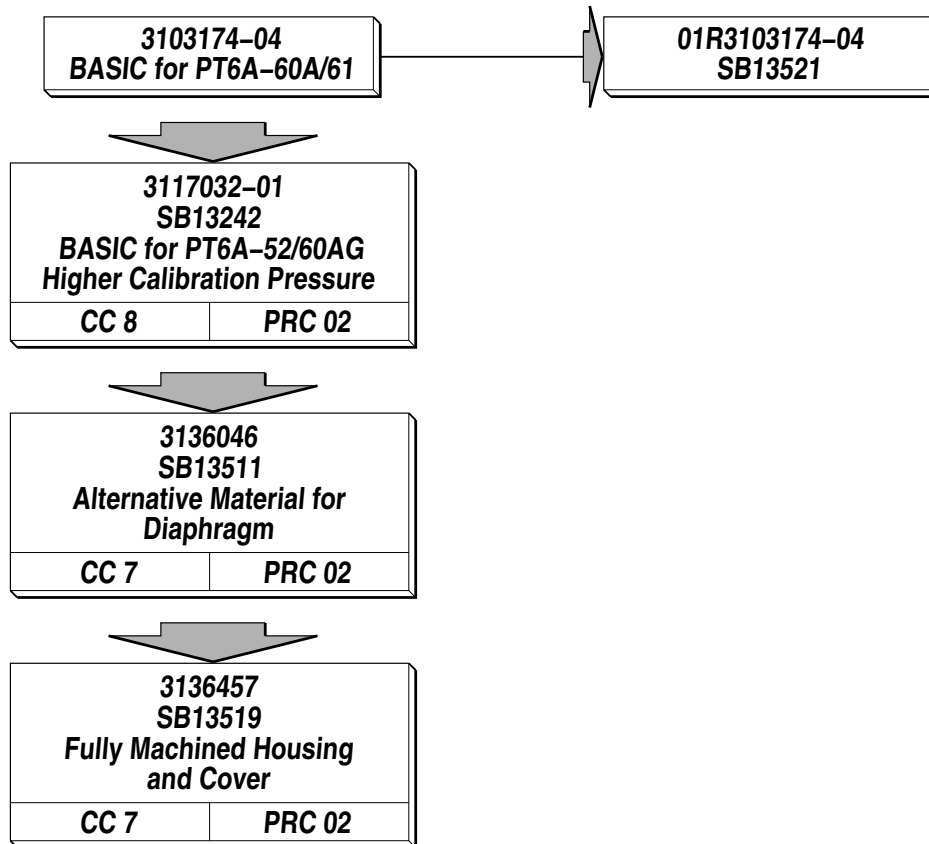
Refer to Figure 1 for parts progression.

Refer to Figure for the F&C.

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ICN-00198-G000045201-001-01

Compressor Bleed Valve - Parts Progression
Figure 1 (Sheet 1 of 2)

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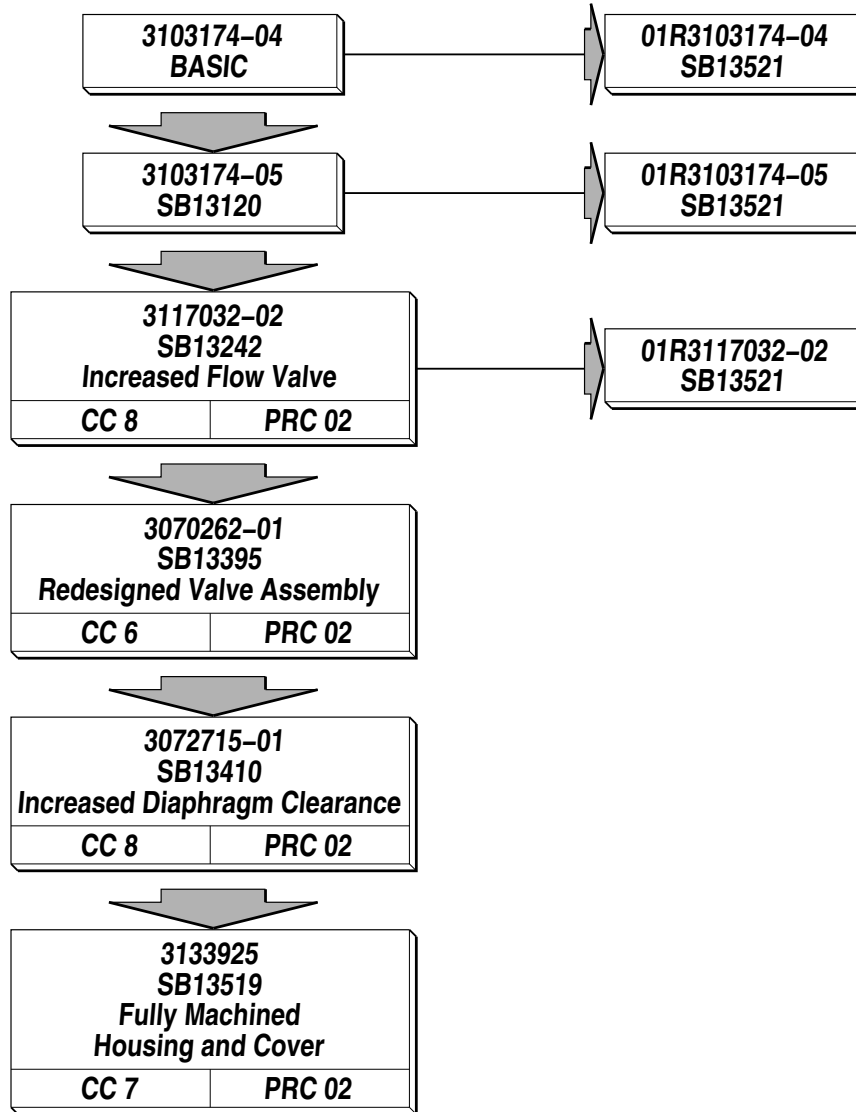
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TURBOPROP ENGINE COMPRESSOR BLEED VALVE - REPLACEMENT OF



PT6A-62

ICN-00198-G000045214-001-01

Compressor Bleed Valve - Parts Progression
Figure 1 (Sheet 2)

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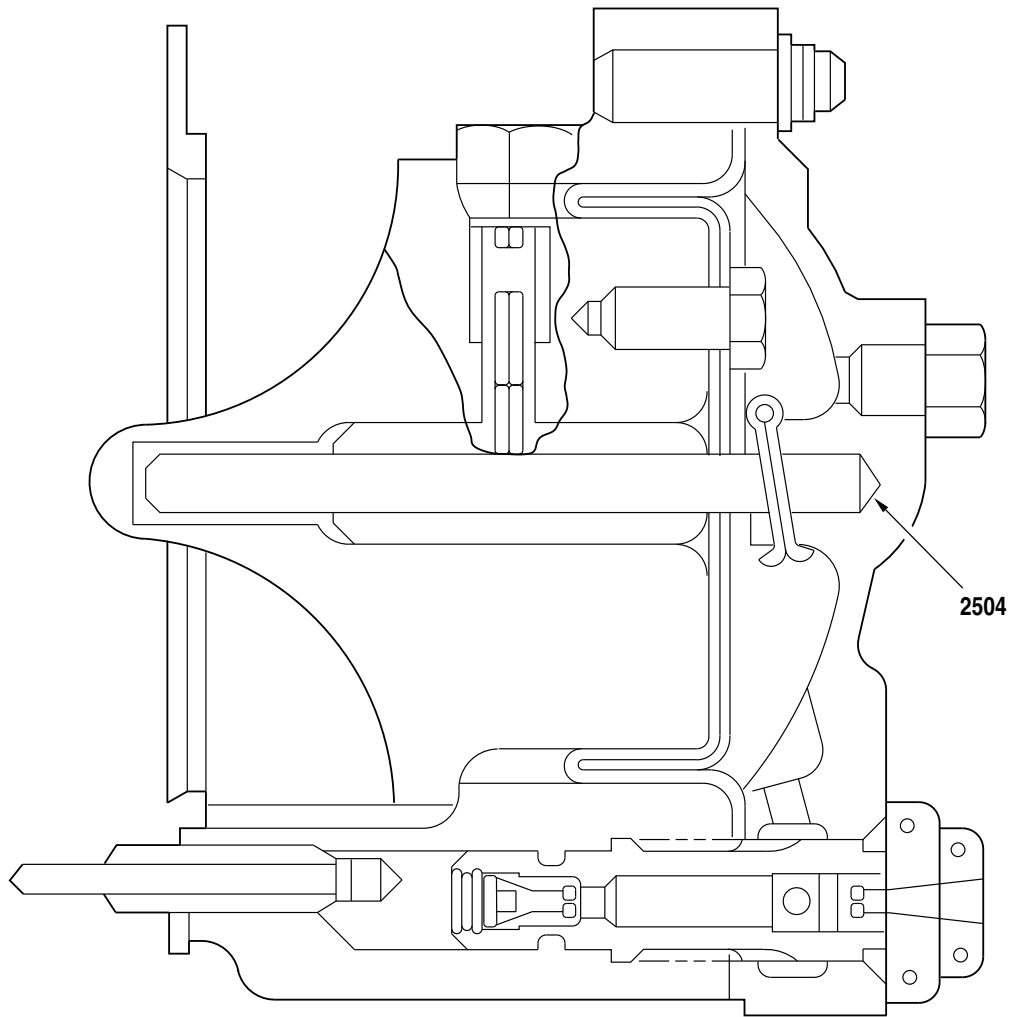
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COMPRESSOR BLEED VALVE - REPLACEMENT OF



ICN-00198-G000045221-001-01

Fits and Clearances
Figure 2

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4. Appendix (Cont'd)

TABLE 1, Fits and Clearances

REF. NO.	IFR	Name	Dim. for Ref. inches (mm)		Limits inches (mm)		Replace
			Min.	Max.	Min.	Max	
PRE-SB 2504		Cover - Compressor Bleed Valve Shaft	0.2340 (5.944)	0.2350 (5.969)	0.0015T (0.038)T	0.0000 (0.000)	
		Shaft - Guide Pin, Bleed Valve Piston	0.2350 (5.969)	0.2355 (5.982)			
POST-SB 2504		Cover - Compressor Bleed Valve Shaft	0.2340 (5.944)	0.2345 (5.956)	0.0005T (0.013)T	0.0015T (0.038)T	
		Shaft - Guide Pin, Bleed Valve Piston	0.2350 (5.969)	0.2355 (5.982)			