

PRATT & WHITNEY CANADA  
**SERVICE BULLETIN**

P&WC S.B. No. 28298R1

**BULLETIN INDEX LOCATOR**  
**72-41-00 / 73-11-40 / 73-11-60**

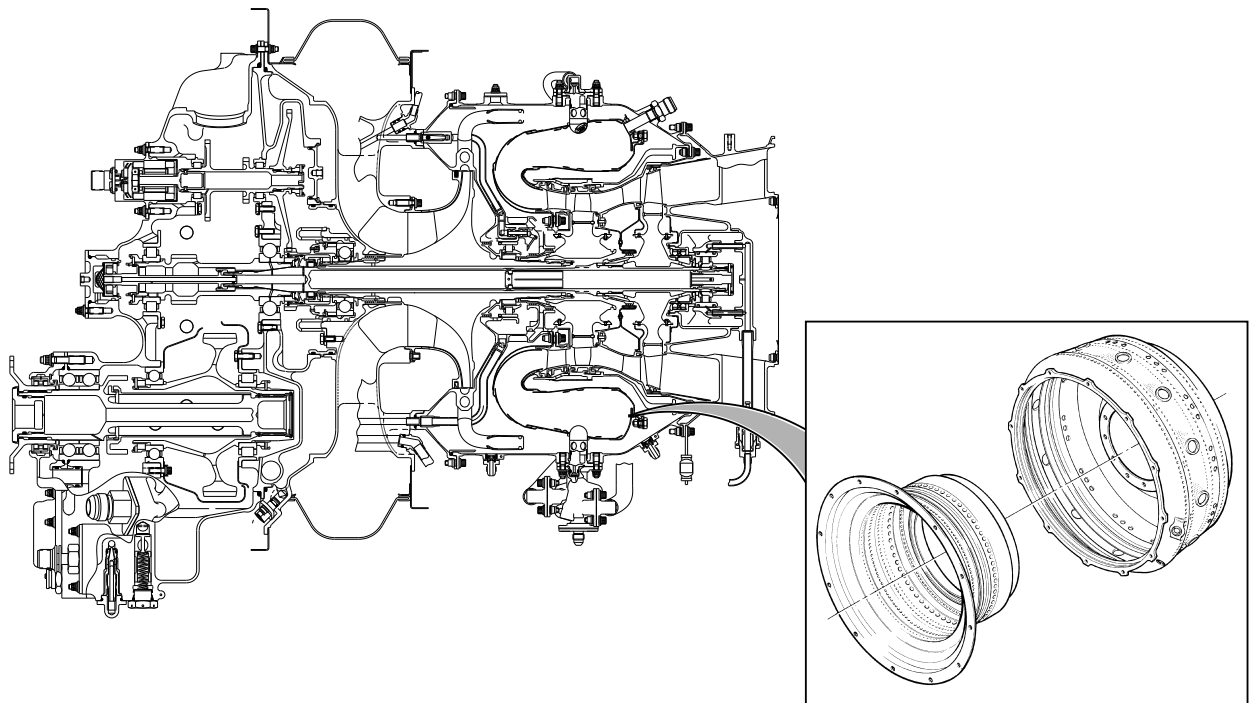
TURBOSHAFT ENGINE  
COMBUSTION CHAMBER LINER ASSEMBLY - REPLACEMENT OF

MODEL APPLICATION

PW206B, PW206C

Compliance: CATEGORY 5

Summary: Turbine components can be affected with the formation of carbon in the combustion system. Replace the two-piece combustion chamber liner with one which produces less carbon. This necessitates the incorporation of new fuel nozzles, fuel manifold, flow divider and associated hardware. The gas generator case is also replaced or modified to accommodate the new hardware.



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Cover Sheet

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14 February 2024

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REVISION TRANSMITTAL SHEET  
TURBOSHAFT ENGINE MODEL PW200

SUBJECT: Pratt & Whitney Canada Service Bulletin No. PW200-72-28298, Rev. No. 1, dated Feb 14/2024 (P&WC S.B. No. 28298R1) COMBUSTION CHAMBER LINER 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 Destroy the superseded copy.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:

- update the equivalent Supplier P/N in Para. 2.C., Material Information; and
- update pricing to current year.

NOTE: The format of this service bulletin is changed to a new standard. Only changes to the technical content have a black bar in the margin.

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: Dec 19/2007  
Revision No. 1: Feb 14/2024



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TURBOSHAFT ENGINE  
COMBUSTION CHAMBER LINER ASSEMBLY - REPLACEMENT OF

1. Planning Information

A. Effectivity

PW206B Engines.  
PW206C Engines.

NOTE: The above effectivity list does not identify engines that have been converted from one engine model to another via an engine conversion service bulletin. To clarify the effectivity of converted engines, refer to the original engine effectivity above. For the parts embodied during the engine conversion, refer to conversion service bulletin.

B. Concurrent Requirements

For PW206B engines, P&WC S.B. No. 28143 must be incorporated prior to or in conjunction with this service bulletin.

For PW206C engines, P&WC S.B. No. 28165 must be incorporated prior to or in conjunction with this service bulletin.

C. Reason

(1) Problem

Turbine components can be affected with the formation of carbon in the combustion system.

(2) Cause

The two piece combustion chamber liner may produce carbon build up.

(3) Solution

Replace the two-piece combustion chamber liner with one which produces less carbon. This necessitates the incorporation of new fuel nozzles, fuel manifold, flow divider and associated hardware. The gas generator case is also replaced or modified to accommodate the new hardware.

D. Description

Replace the two-piece combustion chamber liner, fuel nozzles, fuel manifold, flow divider and associated hardware and modify or replace the gas generator case to accommodate the new hardware.

E. Compliance

CATEGORY 5 - P&WC recommends to do this service bulletin when the engine is disassembled and access is available to the necessary subassembly (i.e. module, accessories, components, or build groups). Do all spare subassemblies.

■ P&WC No. E0694A, DCR29433

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TURBOSHAFT ENGINE  
COMBUSTION CHAMBER LINER ASSEMBLY - REPLACEMENT OF

1. Planning Information (Cont'd)

F. Approval

The technical content of this document is approved under the authority of the Transport Canada Civil Aviation (TCCA) Design Approval Organization No: DAO #93-Q-01.

G. Manpower

Once you have access to the part, an estimate of 1.5 man-hours is required to include this service bulletin at maintenance.

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

H. Weight and Balance

The engine weight will decrease by 0.3 pounds (0.14 kgs).

The effect of weight change on the center of gravity is negligible.

I. Electrical Load Data

Not changed.

J. Software Accomplishment Summary

Not changed.

K. References

Illustrated Parts Catalog P/N 3039734 (PW206B)  
Illustrated Parts Catalog P/N 3043324 (PW206C)  
Overhaul Manual P/N 3039733 (PW206B/206B2)  
Overhaul Manual P/N 3043323 (PW206C/207C)  
Maintenance Manual P/N 3039732 (PW206B/206B2)  
Maintenance Manual P/N 3043322 (PW206C/207C)  
CIR3040877  
P&WC S.B. No. 28085  
P&WC S.B. No. 28143  
P&WC S.B. No. 28165  
P&WC S.B. No. 28187  
P&WC S.B. No. 28202  
P&WC S.B. No. 28217

L. Publications Affected

Illustrated Parts Catalog P/N 3039734 (PW206B)

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1. Planning Information (Cont'd)

Illustrated Parts Catalog P/N 3043324 (PW206C)  
 Overhaul Manual P/N 3039733 (PW206B/206B2)  
 Overhaul Manual P/N 3043323 (PW206C/207C)  
 Maintenance Manual P/N 3039732 (PW206B/206B2)  
 Maintenance Manual P/N 3043322 (PW206C/207C)

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 \$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 Disposition</u>
<b>Hybrid Fuel Nozzle Installation, IPC 73-11-40</b>					
	Nozzle, Fuel, Hybrid Equivalent to Supplier P/N 70132	3044285-01	5		(A)(B)
3056042-02	Nozzle, Fuel, Hybrid Equivalent to Supplier P/N 135678		5	10125.00	(A)

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<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>
AS3209-010	Packing, Preformed	AS3209-012	5	1.23	(A)(C)
	Packing, Preformed	AS3209-014	5		(A)(C)
3056068-01	Gasket, Fuel Nozzle	3044897-02	5	31.01	(A)(C)
<b>Air Blast Fuel Nozzle Installation, IPC 73-11-40</b>					
	Nozzle, Fuel, Air Blast Equivalent to Supplier P/N 69332	3044180-01	7		(A)(B)
3056565-03	Nozzle, Fuel, Air Blast Equivalent to Supplier P/N 147624		7	7263.20	(A)
AS3209-012	Packing, Preformed	AS3209-010	7	1.67	(A)(C)
3056068-01	Gasket, Fuel Nozzle	3044897-02	7	31.01	(A)(C)
<b>Fuel Flow Divider Installation, IPC 73-11-60</b>					
	Flow Divider Assy Supplier (66503) P&WC P/N 3044134-02	8063-173	1		(A)(B)
8063-174	Flow Divider Assy Supplier (66503) P&WC P/N 3044134-03		1	30658.00	(A)
3056068-01	Gasket, Fuel Nozzle	3044897-02	1	31.01	(A)(C)
<b>Fuel Manifold Installation, IPC 73-11-40</b>					
	Manifold, Fuel Equivalent to Supplier P/N A7862-31	3044063-01	1		(A)(B)
3056066-01	Manifold, Fuel Equivalent to Supplier P/N A9478-3		1	33272.00	(A)
3056068-01	Gasket, Fuel Nozzle	3044897-02	11	31.01	(A)(C)
ST3030-09	Nut Option (IC)		5	6.32	(A)
ST3030-10	Nut Option (IC)		5	10.98	(A)
<b>Fuel Manifold Transfer Tube, IPC 73-11-40</b>					

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<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>
	Tube, Transfer, Oil, Two-Groove	3104225-01			(A)(B)
	Packing, Preformed	AS3209-010	2		(A)(C)
AS3209-010	Packing, Preformed		1	1.23	(A)
<b>Fuel Accumulator Installation, IPC 73-11-60</b>					
	Cover, Packing, 1-Groove, Two Holes	3044282-01	1		(A)(B)
	Gasket, Fuel Accumulator	3122999-01	1		(A)(C)
	Packing, Preformed	AS3209-010	1		(A)(C)
	Bolt, Mach, Dbl Hex	MS9208-08	2		(A)(B)
	Nut Option (IC)	ST3032-09	2		(A)(B)
<b>Fuel Manifold Installation, IPC 73-11-40 PW206B and PW206C Engines Pre-SB28217</b>					
	Bracket Assy	3044796-01	1		(A)(B)
	. Bracket, Angle	3044920-01	1		(A)(B)
	. Nut, Self Locking	ST3176-09	1		(A)(B)
	. Rivet, Solid, Ctsk, Flush	AN123470	2		(A)(C)
3056067-01	Bracket, Angle		1	399.20	(A)
ST3030-09	Nut Option (IC)		1	6.32	
<b>Fuel Tube Support Bracket PW206B and PW206C Engines Post-SB28217</b>					
3056067-01	Bracket, Angle	3055095-01	1	399.20	(A)(B)
<b>Combustion Chamber Liners and Compressor Turbine Stator Assembly Instructions, IPC 72-41-00</b>					
	Liner Assy, Combustion Chamber, Outer	3044926-01	1		(A)(B)
	. Boss, Igniter	3043737-01	2		(A)(B)
	. Bracket, Suspension Collar	3043738-01	2		(A)(B)

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<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>
	. Collar, Suspension	3043739-01	2		(A)(B)
	Liner Assy, Combustion Chamber, Inner	3044924-01	1		(A)(B)
	Bolt, Mach, Dbl, Hex	MS9696-06	12		(A)(B)
	Nut Option (IC)	ST3297-01	12		(A)(B)
3071989-01	Liner Assy, Combustion Chamber		1	Quote	(A)
3056148-01	. Ring, Cooling, Combustion Chamber Liner, Outer		1	Quote	(A)
3057188-01	. Ring, Cooling, Combustion Chamber Liner, Outer		1	Quote	(A)
3056146-01	. Spacer, Suspension Collar		2	Quote	(A)
3056145-01	. Bracket, Suspension Collar		2	Quote	(A)
3056147-01	. . Collar, Suspension Combustion Chamber Liner		2	Quote	(A)

### Modification of Gas Generator Case Assembly PW206B and PW206C Engines Pre-SB28085

01R3122337-01	Case Assy, Gas Generator	3122337-01	RWK		(A)(D)
	. Stud, Stepped	ST3264-033	16		(A)(C)
ST3264-033	. Stud, Stepped		2	112.50	(A)
	. Stud, Stepped	ST3264-047	10		(A)(C)
ST3648-12	. Stud, Key Locked		19	226.60	(A)
ST3755-14	. Stud, Key Locked		5	399.90	(A)

### Modification of Gas Generator Case Assembly PW206B and PW206C Engines Post-SB28085, Pre-SB28187, Pre-SB28202

01R3123032-01	Case Assy, Gas Generator	3123032-01	RWK		(A)(D)
	. Stud, Stepped	ST3264-033	14		(A)(C)
ST3264-033	. Stud, Stepped		2	112.50	(A)

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## TURBOSHAFT ENGINE COMBUSTION CHAMBER LINER 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>
	. Stud, Stepped	ST3264-026	2		(A)(C)
	. Stud, Stepped	ST3264-047	10		(A)(C)
ST3648-12	. Stud, Key Locked		19	226.60	(A)
ST3755-14	. Stud, Key Locked		5	399.90	(A)

### **Modification of Gas Generator Case Assembly PW206B and PW206C Engines Post-SB28187, Pre-SB28202**

01R3043675-01	Case Assy, Gas Generator	3043675-01	RWK		(A)(D)
	. Stud, Stepped	ST3264-033	26		(A)(C)
ST3264-033	. Stud, Stepped		2	112.50	(A)
ST3648-12	. Stud, Key Locked		19	226.60	(A)
ST3755-14	. Stud, Key Locked		5	399.90	(A)

### **Gas Generator Case Assembly PW206B and PW206C Engines Post-SB28202**

3056069-01	Case Assy, Gas Generator	3053077-01	1	52885.00	(A)(B)(E)
	. Stud, Key Locked	ST3648-12	24		(A)(C)
ST3648-12	. Stud, Key Locked		19	226.60	(A)
ST3755-14	. Stud, Key Locked		5	399.90	(A)

(A) RESTRICTED INTERCHANGEABILITY - (ATA 200 Explanation Code 07):  
All the old parts must be replaced by all the new parts as an assembly.

(B) Discard the part if it is unserviceable. Return a serviceable part to stock.

(C) Discard. Do not use again in any application.

(D) To get the new part it is necessary to make a modification to the old part.

(E) To get the new part it is possible to make a modification to the old part, or you can get the new part from any Pratt & Whitney Canada Distribution Center.

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D. Reidentified Parts

The following list of parts can be reworked:

<u>OLD P/N</u>	<u>NEW P/N</u>
3043675-01	01R3043675-01
3053077-01	3056069-01
3122337-01	01R3122337-01
3123032-01	01R3123032-01

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. OHM 72-01-00 ENGINE EXTERNALS (PW206B) - DISASSEMBLY-1.
- Ref. OHM 72-01-00 ENGINE EXTERNALS (PW206C) - DISASSEMBLY-1.
- Ref. OHM 72-03-00 TURBOMACHINERY - DISASSEMBLY.
- Ref. MM 72-00-30 HSI (PW206B (PRE-SB28187)) - HEAVY MAINTENANCE.
- Ref. MM 72-00-30 HSI (PW206C (PRE-SB28187)) - HEAVY MAINTENANCE.
- Ref. MM 72-00-31 HSI (PW206C (POST-SB28187), PW207C) - HEAVY MAINTENANCE.
- Ref. MM 72-00-31 HSI (PW206B (POST-SB28187), PW206B2 AND PW206B3) - HEAVY MAINTENANCE.
- Ref. MM 73-11-40 FUEL MANIFOLDS AND FUEL NOZZLES - MAINTENANCE PRACTICES.
- Ref. MM 73-11-60 FUEL FLOW DIVIDER - MAINTENANCE PRACTICES.

B. To modify gas generator case P/N 3043675-01, proceed as follows (Ref. Figure 1):

- (1) Remove studs at location A (5 places).
- (2) Drill and tap new threads at location A to dimensions shown.
- (3) Touch up reworked area as necessary per applicable Cleaning Inspection Repair (CIR) manual.

NOTE: Do not apply protective coating to threads.

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3. Accomplishment Instructions (Cont'd)

- (4) Install new studs P/N ST3755-14 at location A (5 places).
- (5) Remove studs at location B (19 places).
- (6) Install new studs ST3648-12 at location B (19 places).

**CAUTION:** MAKE SURE THAT THE REMAINING ELECTROLYTE (ETCH SOLUTION) IS FULLY NEUTRAL AFTER YOU WRITE ON THE PART. ELECTROLYTE CAN CAUSE CORROSION ON THE PART.

- (7) Put a line across the old part number. Use the electrolyte etch procedure, 0.002 in. (0.05 mm) deep maximum, and write the new part number in the same area.

NOTE: Protective coating is not permitted in area of part number.

C. To modify gas generator case P/N 3122337-01 or P/N 3123032-01, proceed as follows (Ref. Figure 2):

- (1) Remove studs at location A (5 places).
- (2) Remove studs at location B (7 places).
- (3) Drill and tap new threads at location A to dimensions shown.
- (4) Touch up reworked area as necessary per applicable Cleaning Inspection Repair (CIR) manual.

NOTE: Do not apply protective coating to threads.

- (5) Install new studs P/N ST3648-12 and P/N ST3755-14 as shown in Section C-C (Location A, 5 places).
- (6) Install new studs ST3648-12 as shown in Section F-F (Location B, 7 places).

**CAUTION:** MAKE SURE THAT THE REMAINING ELECTROLYTE (ETCH SOLUTION) IS FULLY NEUTRAL AFTER YOU WRITE ON THE PART. ELECTROLYTE CAN CAUSE CORROSION ON THE PART.

- (7) Put a line across the old part number. Use the electrolyte etch procedure, 0.002 in. (0.05 mm) deep maximum, and write the new part number in the same area.

NOTE: Protective coating is not permitted in area of part number.

D. To modify gas generator case P/N 3053077-01, proceed as follows (Ref. Figure 3):

- (1) Remove studs P/N ST3648-12 at location B (5 places).

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3. Accomplishment Instructions (Cont'd)

- (2) Drill and tap new threads at location B to dimensions shown.
- (3) Touch up reworked area as necessary per applicable Cleaning Inspection Repair (CIR) manual.

NOTE: Do not apply protective coating to threads.

- (4) Install new studs P/N ST3755-14 at location B (5 places).

**CAUTION:** MAKE SURE THAT THE REMAINING ELECTROLYTE (ETCH SOLUTION) IS FULLY NEUTRAL AFTER YOU WRITE ON THE PART. ELECTROLYTE CAN CAUSE CORROSION ON THE PART.

- (5) Put a line across the old part number. Use the electrolyte etch procedure, 0.002 in. (0.05 mm) deep maximum, and write the new part number in the same area.

NOTE: Protective coating is not permitted in area of part number.

E. 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. OHM 72-01-00 ENGINE EXTERNALS (PW206B) - ASSEMBLY-1.
- Ref. OHM 72-01-00 ENGINE EXTERNALS (PW206C) - ASSEMBLY-1.
- Ref. OHM 72-03-00 TURBOMACHINERY - ASSEMBLY-3 (For PW206B).
- Ref. OHM 72-03-00 TURBOMACHINERY SECTION - ASSEMBLY-3 (For PW206C).
- Ref. MM 72-00-30 HSI (PW206B (PRE-SB28187)) - HEAVY MAINTENANCE.
- Ref. MM 72-00-30 HSI (PW206C (PRE-SB28187)) - HEAVY MAINTENANCE.
- Ref. MM 72-00-31 HSI (PW206C (POST-SB28187), PW207C) - HEAVY MAINTENANCE.
- Ref. MM 72-00-31 HSI (PW206B (POST-SB28187), PW206B2 AND PW206B3) - HEAVY MAINTENANCE.
- Ref. MM 73-11-40 FUEL MANIFOLDS AND FUEL NOZZLES - MAINTENANCE PRACTICES.
- Ref. MM 73-11-60 FUEL FLOW DIVIDER - MAINTENANCE PRACTICES.

F. Write accomplishment of P&WC S.B. No. 28298 in the engine module log book.

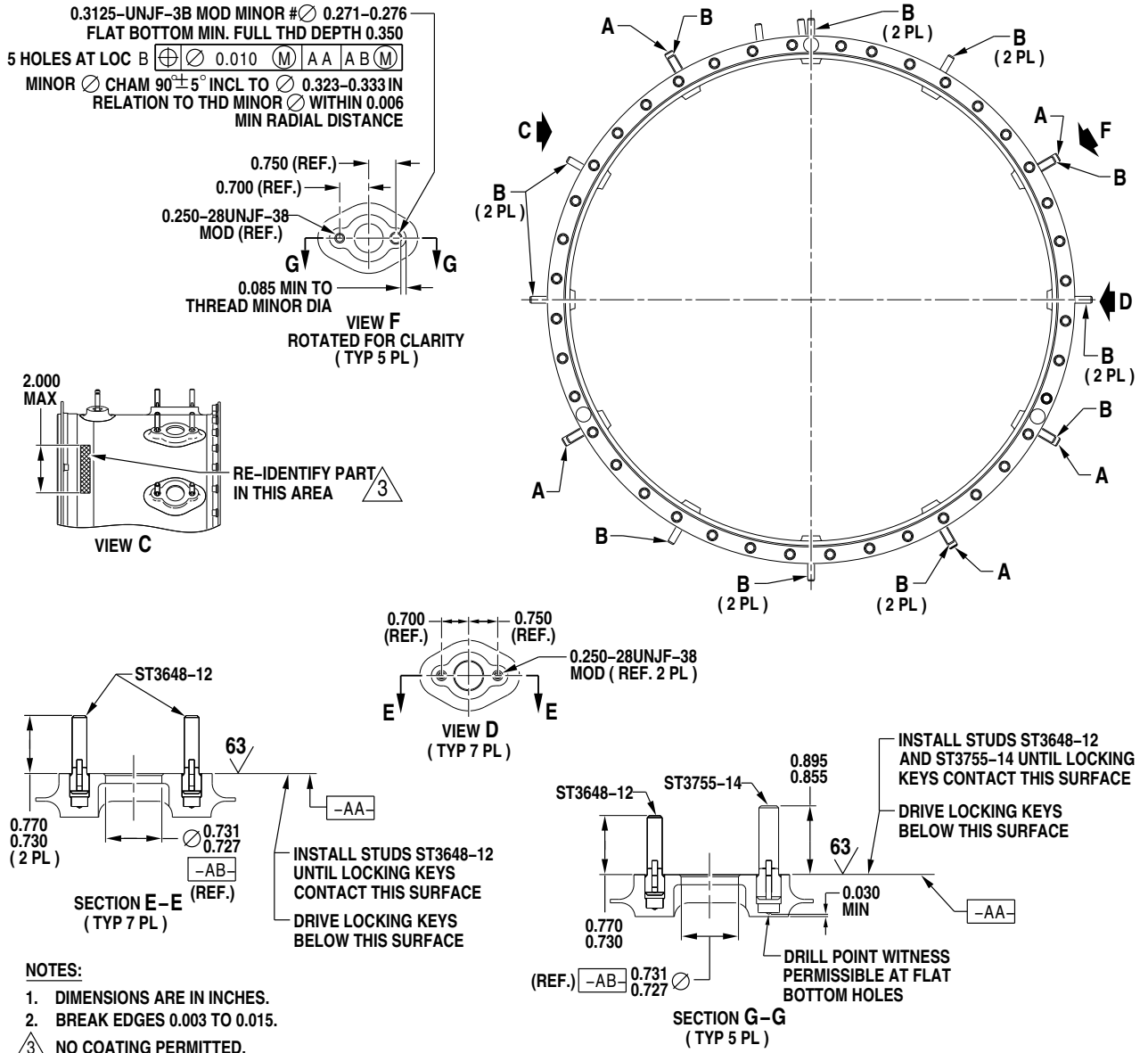
4. Appendix

A. Refer to Figure 4 for the progression of the Combustion Chamber Liner.

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## TURBOSHAFT ENGINE COMBUSTION CHAMBER LINER ASSEMBLY - REPLACEMENT OF



C128664

Modification of Gas Generator Case P/N 3043675-01  
 Figure 1

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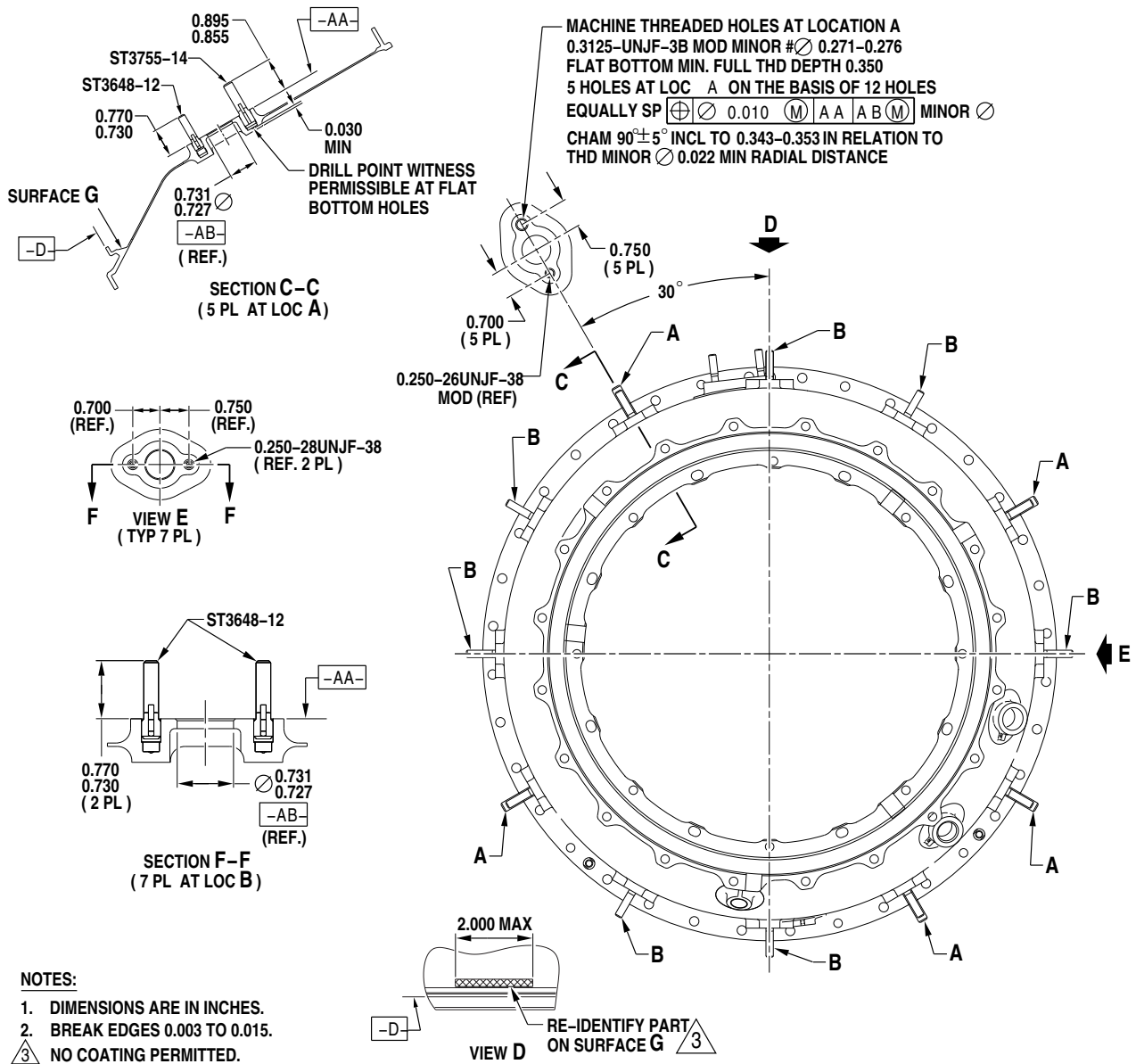
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## TURBOSHAFT ENGINE COMBUSTION CHAMBER LINER ASSEMBLY - REPLACEMENT OF



C128666

Modification of Gas Generator Case P/N 3122337-01 and P/N 3123032-01  
 Figure 2

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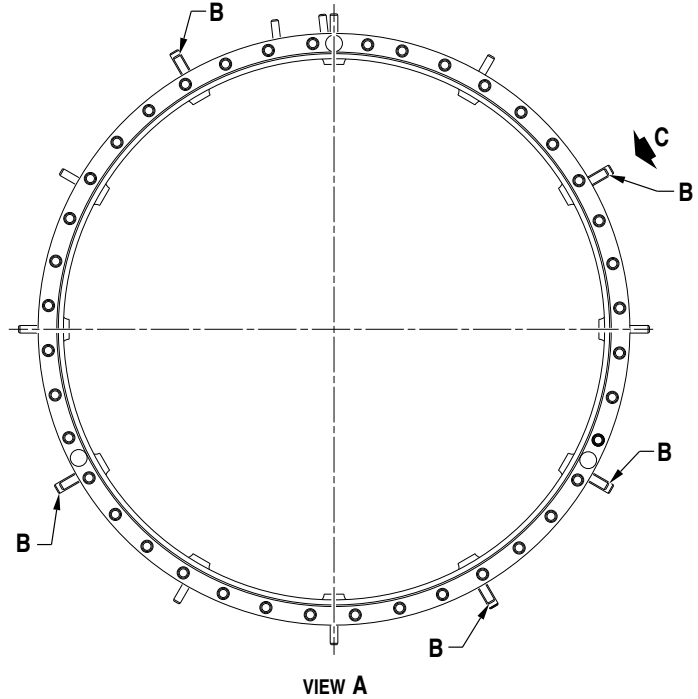
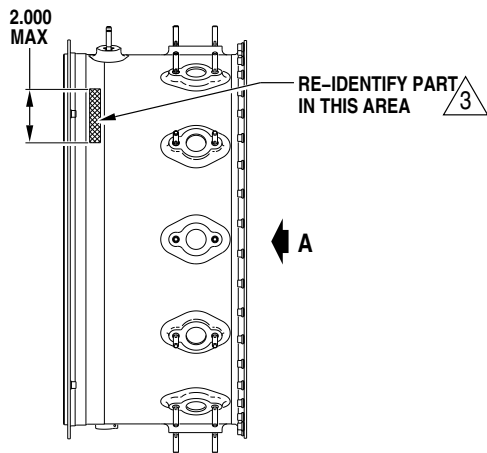
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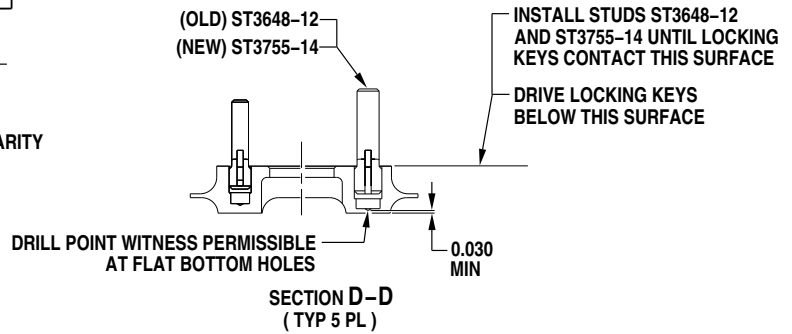
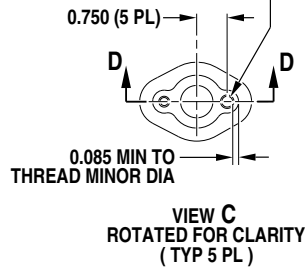
# PRATT & WHITNEY CANADA SERVICE BULLETIN

P&WC S.B. No. 28298R1

## TURBOSHAFT ENGINE COMBUSTION CHAMBER LINER ASSEMBLY - REPLACEMENT OF



0.3125-UNJF-3B MOD MINOR #  $\varnothing$  0.271-0.276 MOD  
FLAT BOTTOM MIN FULL THD DEPTH 0.350  
5 HOLES AT LOC B  $\varnothing$  0.010 (M) MINOR  $\varnothing$   
CHAM  $90^{\circ} \pm 5^{\circ}$  INCL TO  $\varnothing$  0.323-0.333 IN  
RELATION TO THD MINOR  $\varnothing$  WITHIN 0.006  
MIN RADIAL DISTANCE



**NOTES:**

1. DIMENSIONS ARE IN INCHES.
2. BREAK EDGES 0.003 TO 0.015.
3. NO COATING PERMITTED.

C129060

Modification of Gas Generator Case P/N 3053077-01  
Figure 3

Dec 19/2007  
Revision No. 1: Feb 14/2024

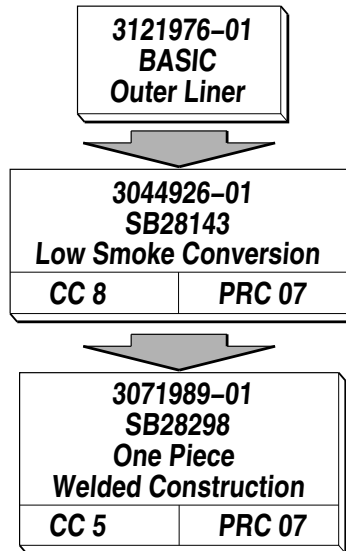
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PRATT & WHITNEY CANADA  
**SERVICE BULLETIN**

P&WC S.B. No. 28298R1

TURBOSHAFT ENGINE  
COMBUSTION CHAMBER LINER ASSEMBLY - REPLACEMENT OF



C130644

Progression of the Combustion Chamber Liner  
Figure 4

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