

PRATT & WHITNEY CANADA  
**SERVICE BULLETIN**

P&WC S.B. No. 28404R1

**BULLETIN INDEX LOCATOR**  
**72-51-04**

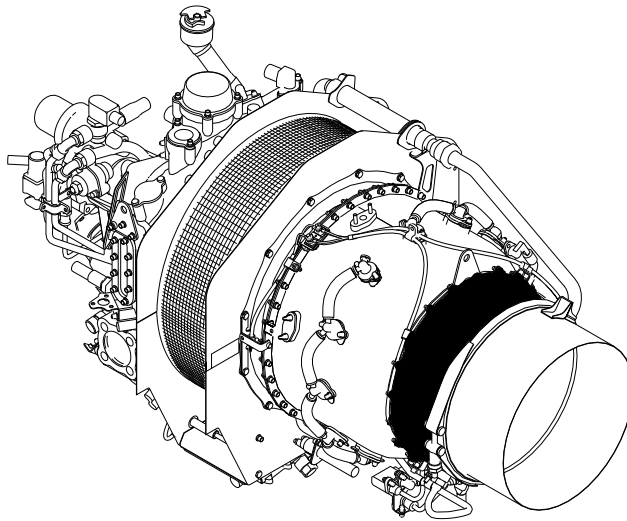
TURBOSHAFT ENGINE  
NOZZLE-ASSEMBLY TURBINE EXHAUST - REPLACEMENT OF

MODEL APPLICATION

PW206A, PW206B, PW206B2, PW206B3, PW206C, PW206E, PW207C, PW207D, PW207D1,  
PW207D2, PW207E, PW207K

Compliance: CATEGORY 7

Summary: Brazing gaps between No. 5 cover bearing housing and oil tubes are not in line with the engineering specification. Replace No. 5 cover bearing housing with a new one that has increased holes diameter to meet brazing specification requirements.



Mar 11/2023  
Revision No. 1: Mar 29/2023

**PW200-72-28404**  
Cover Sheet

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**Pratt & Whitney Canada**

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Mar 29/2023

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REVISION TRANSMITTAL SHEET  
TURBOSHAFT ENGINE MODEL PW200

SUBJECT: Pratt & Whitney Canada Service Bulletin No. PW200-72-28404, Rev. No. 1 dated Mar 29/2023 (P&WC S.B. No. 28404R1) NOZZLE-ASSEMBLY TURBINE EXHAUST - 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 Destroy the superseded copy.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 revision is issued to:

- correct the Build Spec (BS) for the PW206B3 to read BS1313 in lieu of BS1028 and BS1170.

EFFECT OF REVISION ON PRIOR ACCOMPLISHMENT:

None.

REVISION HISTORY:

Original Issue: Mar 11/2023

Revision No. 1: Mar 29/2023



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TURBOSHAFT ENGINE  
NOZZLE-ASSEMBLY TURBINE EXHAUST - REPLACEMENT OF

1. Planning Information

A. Effectivity

PW206A (BS752) Engines.

PW206B (BS778) Engines.

PW206B2 (BS1028, BS1170) Engines which are before and include Serial No. PCE-BJ1487.

PW206B3 (BS1313) Engines which are before and include Serial No. PCE-BR0227.

PW206C (BS847, BS1164, BS1296, BS1297) Engines which are before and include Serial No. PCE-BC1019, and Serial Numbers 208001 to 208999.

PW206E (BS934) Engines which are before and include Serial No. PCE-BE0052.

PW207C (BS1068, BS1166, BS1299, BS1300) Engines which are before and include Serial No. PCE-BH1095.

PW207D (BS993, BS1167) Engines which are before and include Serial No. PCE-BF0215.

PW207D1 (BS1215) Engines which are before and include Serial No. PCE-BL1033.

PW207D2 (BS1247, BS1281) Engines which are before and include Serial No. PCE-BN0030.

PW207E (BS1035, BS1168) Engines which are before and include Serial No. PCE-BG0193.

PW207K (BS1031, BS1169, BS1301, BS1302) Engines which are before and include Serial No. PCE-BK0386.

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

None.

C. Reason

(1) Problem

Brazing clearances between No. 5 cover bearing housing and oil tubes are not optimal.

(2) Cause

Brazing clearances are not in line with engineering specification.

(3) Solution

Replace No. 5 cover bearing housing with a new one that has increased holes diameter to meet brazing specification requirements.

P&WC No. CO-0012335, EC-0079757

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TURBOSHAFT ENGINE  
NOZZLE-ASSEMBLY TURBINE EXHAUST - REPLACEMENT OF

1. Planning Information (Cont'd)

D. Description

Replace the Turbine Exhaust Nozzle-Assembly 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

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

No more man-hours is required to include this service bulletin at Heavy Maintenance.

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

H. Weight and Balance

None.

I. Electrical Load Data

Not applicable.

J. Software Accomplishment Summary

Not applicable.

K. References

Illustrated Parts Catalog P/N [3038326](#) (PW206A/206E)

Illustrated Parts Catalog P/N [3049725](#) (PW207E)

Illustrated Parts Catalog P/N [3039734](#) (PW206B)

Illustrated Parts Catalog P/N [3054928](#) (PW206B2/206B3)

Illustrated Parts Catalog P/N [3043324](#) (PW206C)

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## TURBOSHAFT ENGINE NOZZLE-ASSEMBLY TURBINE EXHAUST - REPLACEMENT OF

### 1. Planning Information (Cont'd)

- Illustrated Parts Catalog P/N [3054927](#) (PW207C)
- Illustrated Parts Catalog P/N [3049724](#) (PW207D)
- Illustrated Parts Catalog P/N [3071604](#) (PW207D1/207D2)
- Illustrated Parts Catalog P/N [3053374](#) (PW207K)
- Maintenance Manual P/N [3038324](#) (PW206A/206E/207E)
- Maintenance Manual P/N [3039732](#) (PW206B/206B2/206B3)
- Maintenance Manual P/N [3043322](#) (PW206C/207C)
- Maintenance Manual P/N [3043612](#) (PW207D)
- Maintenance Manual P/N [3071602](#) (PW207D1/207D2)
- Maintenance Manual P/N [3053372](#) (PW207K)
- Overhaul Manual P/N [3038325](#) (PW206A/206E/207E)
- Overhaul Manual P/N [3039733](#) (PW206B/206B2/206B3)
- Overhaul Manual P/N [3043323](#) (PW206C/207C)
- Overhaul Manual P/N [3043613](#) (PW207D)
- Overhaul Manual P/N [3071603](#) (PW207D1/207D2)
- Overhaul Manual P/N [3053373](#) (PW207K)

### L. Publications Affected

- Illustrated Parts Catalog P/N [3038326](#) (PW206A/206E)
- Illustrated Parts Catalog P/N [3049725](#) (PW207E)
- Illustrated Parts Catalog P/N [3039734](#) (PW206B)
- Illustrated Parts Catalog P/N [3054928](#) (PW206B2/206B3)
- Illustrated Parts Catalog P/N [3043324](#) (PW206C)
- Illustrated Parts Catalog P/N [3054927](#) (PW207C)

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## TURBOSHAFT ENGINE NOZZLE-ASSEMBLY TURBINE EXHAUST - REPLACEMENT OF

1. Planning Information (Cont'd)

Illustrated Parts Catalog P/N [3049724](#) (PW207D)

Illustrated Parts Catalog P/N [3071604](#) (PW207D1/207D2)

Illustrated Parts Catalog P/N [3077164](#) (PW207D2M)

Illustrated Parts Catalog P/N [3053374](#) (PW207K)

Cleaning Inspection Repair Manual (CIR) P/N [3040877](#)

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, 2023).

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, 2023)</u>	<u>Instructions Dispositions</u>
<a href="#">3137075</a>	Nozzle Assembly, Turbine Exhaust	3077647-01	1	Quote	(A)(B)

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

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

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## TURBOSHAFT ENGINE NOZZLE-ASSEMBLY TURBINE EXHAUST - REPLACEMENT OF

### 2. Material Information (Cont'd)

#### 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:

**For Engines PW206A, PW206E:**

- Ref. MM 72-00-30 HSI (PW206A/PW206E) - HEAVY MAINTENANCE.
- Ref. OHM 72-51-04 EXHAUST SECTION - DISASSEMBLY.

**For Engines PW206B:**

- Ref. MM 72-00-30 HSI (PW206B (PRE-SB28187)) - HEAVY MAINTENANCE.
- Ref. OHM 72-51-04 EXHAUST SECTION - DISASSEMBLY.

**For Engines PW206B2, PW206B3:**

- Ref. MM 72-00-31 HSI (PW206B (Post-SB28187), PW206B2 AND PW206B3)- HEAVY MAINTENANCE.
- Ref. OHM 72-51-04 EXHAUST SECTION - DISASSEMBLY.

**For Engines PW206C, PW207C:**

- Ref. MM 72-00-30 HSI (PW206C (PRE-SB28187)) - HEAVY MAINTENANCE.
- Ref. MM 72-00-31 HSI (PW206C (Post-SB28187), PW207C) - HEAVY MAINTENANCE.
- Ref. OHM 72-51-04 EXHAUST SECTION - DISASSEMBLY.

**For Engines PW207D, PW207D1, PW207D2, PW207K:**

- Ref. MM 72-00-30 HSI - HEAVY MAINTENANCE.
- Ref. OHM 72-51-04 EXHAUST SECTION - DISASSEMBLY.

**For Engines PW207E:**

- Ref. MM 72-00-31 HSI (PW207E) - HEAVY MAINTENANCE.
- Ref. OHM 72-51-04 EXHAUST SECTION - 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:

**For Engines PW206A, PW206E:**

- Ref. MM 72-00-30 HSI (PW206A/PW206E) - HEAVY MAINTENANCE.
- Ref. OHM 72-51-04 EXHAUST SECTION - SUBASSEMBLY.

**For Engines PW206B:**

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## TURBOSHAFT ENGINE NOZZLE-ASSEMBLY TURBINE EXHAUST - REPLACEMENT OF

### 3. Accomplishment Instructions (Cont'd)

- Ref. MM 72-00-30 HSI (PW206B (PRE-SB28187)) - HEAVY MAINTENANCE.
- Ref. OHM 72-51-04 EXHAUST SECTION - SUBASSEMBLY.
- For Engines PW206B2, PW206B3:**
- Ref. MM 72-00-31 HSI (PW206B (Post-SB28187), PW206B2 AND PW206B3)- HEAVY MAINTENANCE.
- Ref. OHM 72-51-04 EXHAUST SECTION - SUBASSEMBLY.
- For Engines PW206C, PW207C:**
- Ref. MM 72-00-30 HSI (PW206C (PRE-SB28187)) - HEAVY MAINTENANCE.
- Ref. MM 72-00-31 HSI (PW206C (Post-SB28187), PW207C) - HEAVY MAINTENANCE.
- Ref. OHM 72-51-04 EXHAUST SECTION - SUBASSEMBLY.
- For Engines PW207D, PW207D1, PW207D2, PW207K:**
- Ref. MM 72-00-30 HSI - HEAVY MAINTENANCE.
- Ref. OHM 72-51-04 EXHAUST SECTION - SUBASSEMBLY.
- For Engines PW207E:**
- Ref. MM 72-00-31 HSI (PW207E) - HEAVY MAINTENANCE.
- Ref. OHM 72-51-04 EXHAUST SECTION - SUBASSEMBLY.

C. Write the accomplishment of P&WC SB28404 in the engine module log book.

### 4. Appendix

Refer to Table 1 Sheet 1and Figure 1 for Fits and Clearances.

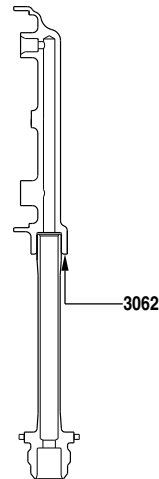
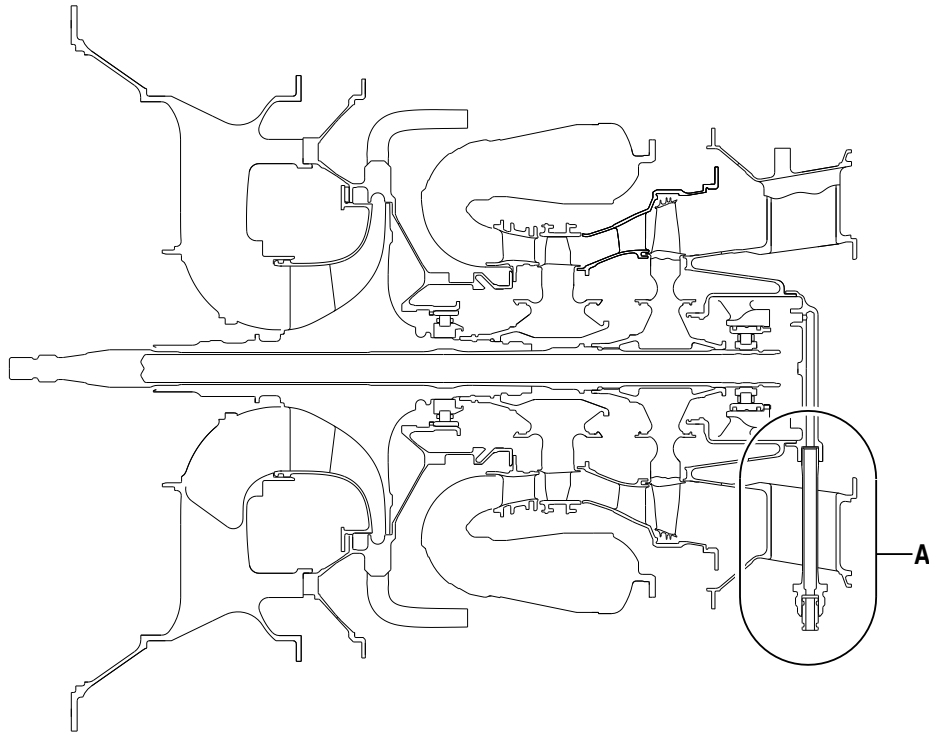
TABLE 1, Fits and Clearances

REF. NO.	IFR	Name	Dim. for Ref. inches (mm)		Limits inches (mm)		Replace
			Min.	Max.	Min.	Max	
<b>PRE-SB</b>		Tube Oil No. 5 Brg.	0.4260 (10.820)	0.4275 (10.859)	0.0005 (0.013)	0.0040 (0.102)	
		Cover No. 5 Brg. Hsg.	0.4280 (10.871)	0.4300 (10.922)			
<b>POST-SB</b>		Tube Oil No. 5 Brg.	0.4260 (10.820)	0.4275 (10.859)	0.0025 (0.064)	0.0060 (0.152)	
		Cover No. 5 Brg. Hsg.	0.4300 (10.922)	0.4320 (10.973)			

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TURBOSHAFT ENGINE  
NOZZLE-ASSEMBLY TURBINE EXHAUST - REPLACEMENT OF



**VIEW A**

ICN-00198-G000125481-001-01

Fits and Clearances  
Figure 1

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