

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 41122

BULLETIN INDEX LOCATOR
72-30-00

TURBOSHAFT ENGINE
INCREASED NUMBER OF COMPRESSOR ROTOR BALANCING RIVETS AND WEIGHT

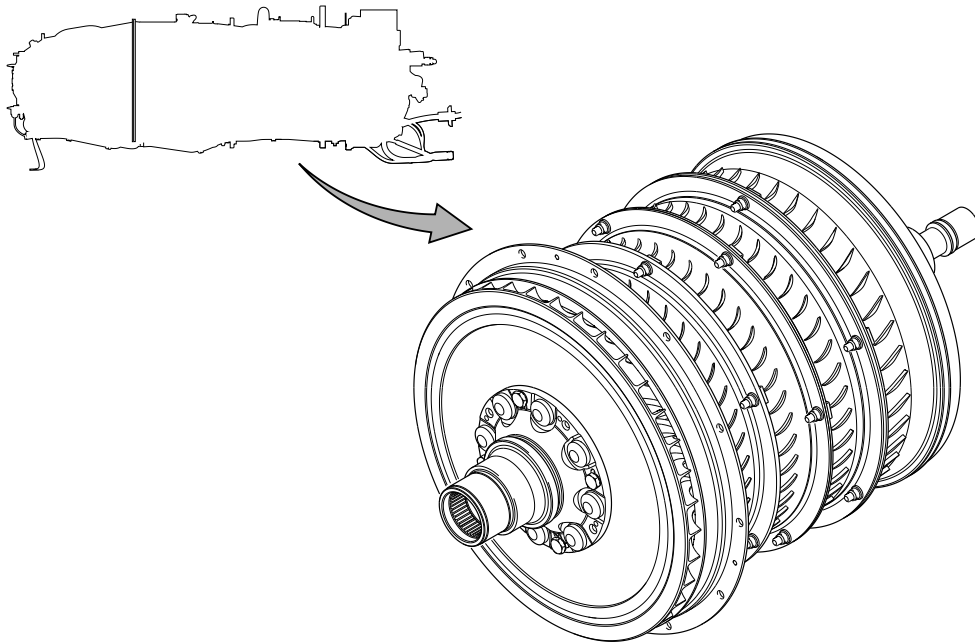
MODEL APPLICATION

PT6C-67C, PT6C-67C1

Compliance: CATEGORY 5

Summary: The larger balancing counterweight and rivet combination of the compressor rotor balancing assembly may disengage and damage the first stage rotor. To optimize the balancing process and prevent damage to the first stage rotor, modify the compressor rotor balancing assembly to:

- remove the larger balancing counterweight and rivet combination,
- increase the quantity of the smaller balancing counterweight and rivet combination.



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Cover Sheet

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1. Planning Information

A. Effectivity

PT6C-67C (BS963, BS1019) Engines which are before and include Serial No. PCE-KB2692.
PT6C-67C1 (BS1447, BS1448) 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

None.

C. Reason

(1) Problem

The larger balancing counterweight and rivet combination of the compressor rotor balancing assembly may disengage and damage the first stage rotor.

(2) Cause

The balancing of the compressor rotor assembly is not optimal.

(3) Solution

To optimize the balancing process and prevent damage to the first stage rotor, modify the compressor rotor balancing assembly to:

- remove the larger balancing counterweight and rivet combination,
- increase the quantity of the smaller balancing counterweight and rivet combination.

D. Description

Replace the weights and rivets as required.

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.

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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

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 [3045334](#) (PT6C-67C/C1)

Overhaul Manual P/N [3045333](#) (PT6C-67C/C1)

L. Publications Affected

Illustrated Parts Catalog P/N [3045334](#) (PT6C-67C/C1)

Overhaul Manual P/N [3045333](#) (PT6C-67C/C1)

M. Interchangeability and Intermixability of Parts

Interchangeability - Refer to Para. 2.C.

Intermixability - Not changed.

2. Material Information

A. Industry Support Information

Not applicable.

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2. Material Information (Cont'd)

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 TBA (US, 2022).

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, 2022)</u>	<u>Instructions Dispositions</u>
	Rivet, Tubular, Countersunk	3102267-01	1		(A)
	Counterweight, Low Pressure Impeller	3032255	1		(A)
	Weight, Balance, Compressor	3036722	4		(A)(B)
3036722CL	Weight, Balance, Compressor		6	261.30	(B)(C)
3036722CL1	Weight, Balance, Compressor, 0.018 OZ (0.51 g)		A/R		
3036722CL2	Weight, Balance, Compressor, 0.036 OZ (1.02 g)		A/R		
	Rivet, Tubular, Ctsk	3102267-03	4		(A)(B)
3102267-03	Rivet, Tubular, Ctsk		6		(B)(C)

(A) Discard.

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

(C) Use zero to six Max as required for balancing.

D. Reidentified Parts

None.

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2. Material Information (Cont'd)

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 overhaul manual instructions as follows:

Ref. OHM 72-34-01.

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

Ref. OHM 72-34-01.

C. Write the accomplishment of P&WC S.B. No. SB41122 in the applicable engine module log book.

4. Appendix

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

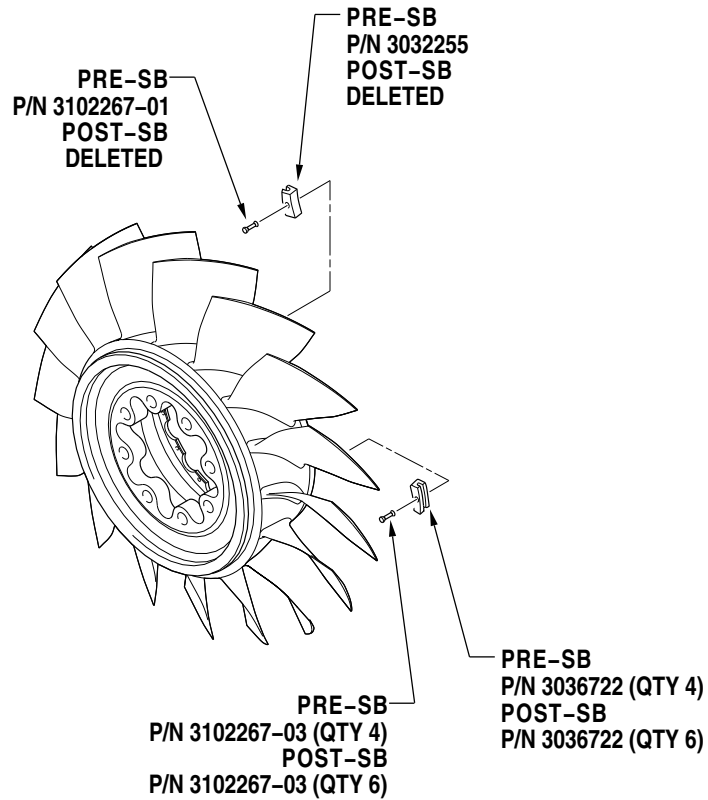
TABLE 1, Special Assembly Requirements

REF. NO.	Name	Limits		Replace
		Min.	Max	
914	For balancing purpose: Use MAX 6 weights (P/N 3036722 CLASS 1 or 2) or MAX 6 rivets (P/N AN123152) or a combination of either P/N but not exceeding MAX 6 total do not use any other class.			

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Rivets and Weight - Installation of
Figure 1

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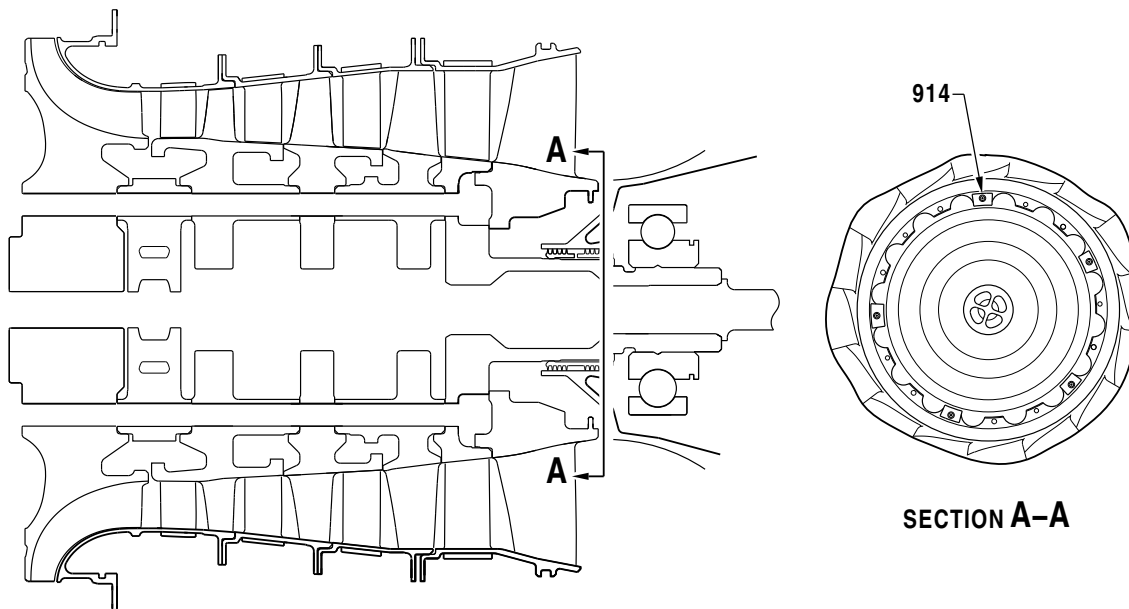
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Fit 914
Figure 2

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