

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 41079

BULLETIN INDEX LOCATOR
72-30-04

TURBOSHAFT ENGINE
X-RAY INSPECTION OF THE NO. 2 BEARING OIL-PRESSURE-TUBE BOSS OF THE GAS
GENERATOR CASE

MODEL APPLICATION

PT6C-67C

Compliance: CATEGORY 6

Summary: X-ray inspection after an in-process weld repair under the No. 2 bearing oil pressure tube boss was not performed during part manufacturing. Do a one-time x-ray inspection of the No. 2 bearing oil pressure tube boss weld area at first overhaul.

Oct 15/2013

PT6C-72-41079
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.

Export Control Classification		
*Data is subject to the jurisdiction of the Export and Import Controls Bureau of the Department of Foreign Affairs and International Trade of Canada, Department of Commerce of the United States and/or Department of State of the United States. ** Data is not subject to the jurisdiction of the Department of Commerce of the United States or Department of State of the United States but would become subject if exposed to any US involvement.	Regulation	Classification Number
	Canadian ECL(s)*	
	ECCN(s)*	
	P-ECCN(s)**	9E991
	USML (ITAR)*	
	P-USML**	

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 41079

TURBOSHAFT ENGINE
X-RAY INSPECTION OF THE NO. 2 BEARING OIL-PRESSURE-TUBE BOSS OF THE GAS
GENERATOR CASE

1. Planning Information

A. Effectivity

PT6C-67C Engine Serial No. PCE-KB0849, KB0851, KB0855, KB0866.

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

X-ray inspection after an in-process weld repair under the No. 2 bearing oil pressure tube boss was not performed during part manufacturing.

(2) Cause

Post-repair inspection was not performed.

(3) Solution

Do a one-time x-ray inspection of the No. 2 bearing oil pressure tube boss weld area at first overhaul.

D. Description

Do a one time inspection of the No. 2 Bearing oil-pressure-tube boss weld area.

E. Compliance

CATEGORY 6 - P&WC recommends to do this service bulletin when the subassembly (i.e. module, accessories, components, or build groups) is disassembled and access is available to the necessary part. Do all spare subassemblies.

F. Approval

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

G. Manpower

Estimate of 1.0 man-hours required to include this service bulletin at overhaul.

P&WC No. DCR17772

Oct 15/2013

P&WC Proprietary Information. Subject to the restrictions on the back of the locator
The export control classification with respect to this document is contained on the back of the locator.

© 2013 Pratt & Whitney Canada Corp.
PRINTED IN CANADA

PT6C-72-41079
Page 1 of 6

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 41079

TURBOSHAFT ENGINE
X-RAY INSPECTION OF THE NO. 2 BEARING OIL-PRESSURE-TUBE BOSS OF THE GAS
GENERATOR CASE

1. Planning Information (Cont'd)

H. Weight and Balance

None.

I. Electrical Load Data

Not changed.

J. Software Accomplishment Summary

Not applicable.

K. References

Overhaul Manual P/N 3045333 (PT6C-67C)

L. Publications Affected

None.

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

Not applicable.

C. Material Necessary for Each Engine

Not applicable.

D. Reidentified Parts

None.

E. Tooling - Price and Availability

Not applicable.

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 41079

TURBOSHAFT ENGINE
X-RAY INSPECTION OF THE NO. 2 BEARING OIL-PRESSURE-TUBE BOSS OF THE GAS
GENERATOR CASE

3. Accomplishment Instructions

- A. Disassemble the gas generator case, per the overhaul manual instructions.
- B. Do an X-ray inspection of the weld of the GGC no. 2 bearing oil-pressure-tube boss (identified on figure 1) as follows:

NOTE: Inspection must be performed by a NDT technician with CXRM Level II or Level III certification to perform the X-ray inspection to the latest revision of CNDTQ (or an equivalent internationally-recognized certification). The X-ray inspection is to be performed in accordance with CXRM-1 to CXRS - E.5 Class A and CXRM-Master requirements. CXRS -E.5 Class A documentation allows some cracks. When doing this inspection, no detectable cracks are acceptable.

- (1) In a dark room, cut a X-ray film to fit around the no. 2 bearing oil tube located on the internal diameter of the GGC. Use black tape to close the contour of the cut on the X-ray film to avoid light exposure on the X-ray film.
- (2) Secure the X-ray film to the internal diameter of the no. 2 bearing boss with tape.
- (3) Perform the X-ray inspection of the No. 2 bearing boss weld and check for exhibition of cracks, gas holes, welding discontinuities and lack of fusion.

NOTE: The use of lead backing to reduce the back scatter may be required.

- (4) If the inspection of the weld reveals a defect, send the part for a repair.
- (5) If the part is free of defects, re-identify the GGC with "SB 41079" as follows:
 - (a) Locate the part number on the gas generator case.

NOTE: The part number should be at the 12 o'clock position on the band adjacent to the fuel nozzle bosses.

WARNING: USE EYE PROTECTION WHEN YOU WRITE WITH THE VIBRATION PEENING PROCEDURE

CAUTION: MAKE SURE TO REIDENTIFY PRIOR TO COATING RESTORATION

- (b) Use the vibration peening procedure, 0.003 to 0.006 in (0.08-0.015 mm) deep, and write "SB 41079" close to the part number (Ref. Fig. 3).

- C. Reassemble the gas generator case per the overhaul manual instructions.
- D. Write accomplishment of P&WC S.B. No. 41079 in the engine module log book.

4. Appendix

Not applicable.

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 41079

TURBOSHAFT ENGINE
X-RAY INSPECTION OF THE NO. 2 BEARING OIL-PRESSURE-TUBE BOSS OF THE GAS
GENERATOR CASE



C212426

No. 2 Bearing Oil Pressure Tube Boss Area - Inspection
Figure 1

Oct 15/2013

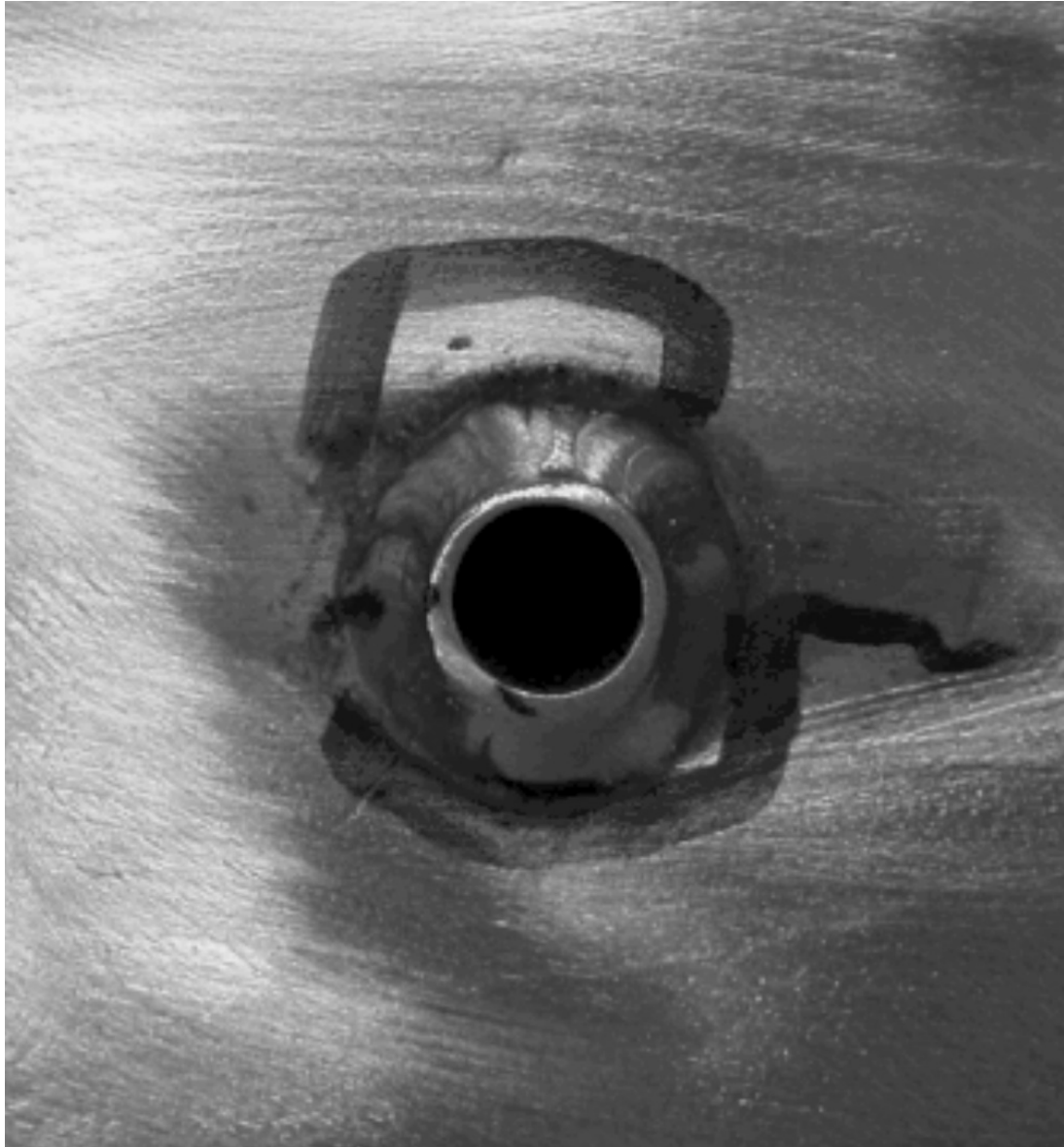
P&WC Proprietary Information. Subject to the restrictions on the back of the locator
The export control classification with respect to this document is contained on the back of the locator.

PT6C-72-41079
Page 4 of 6

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 41079

TURBOSHAFT ENGINE
X-RAY INSPECTION OF THE NO. 2 BEARING OIL-PRESSURE-TUBE BOSS OF THE GAS
GENERATOR CASE



C181352

No. 2 Bearing Oil Pressure Tube Boss Area - Inspection (Tube Removed For Clarity)
Figure 2

Oct 15/2013

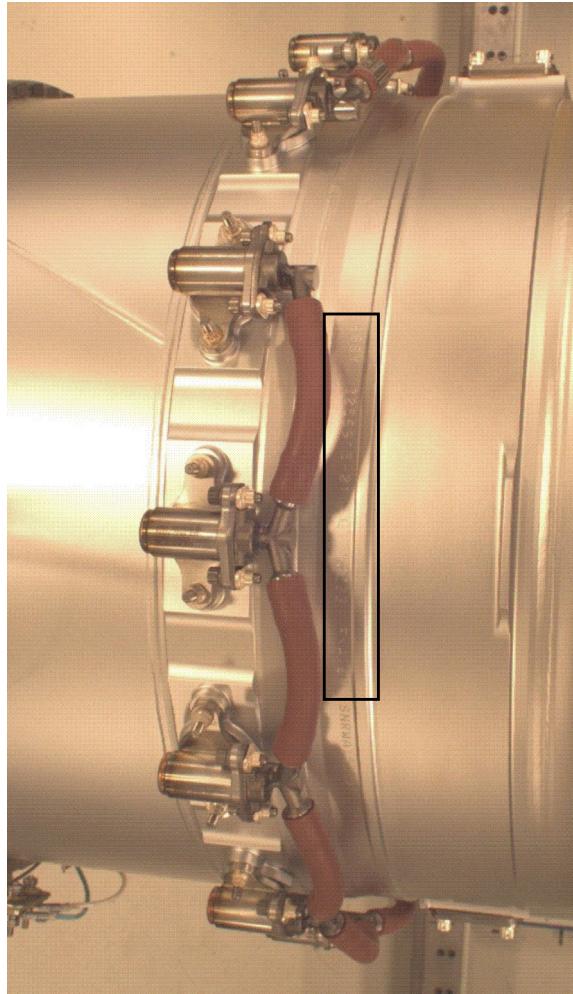
P&WC Proprietary Information. Subject to the restrictions on the back of the locator
The export control classification with respect to this document is contained on the back of the locator.

PT6C-72-41079
Page 5 of 6

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 41079

TURBOSHAFT ENGINE
X-RAY INSPECTION OF THE NO. 2 BEARING OIL-PRESSURE-TUBE BOSS OF THE GAS
GENERATOR CASE



C212427

GGC - Reidentification
Figure 3

Oct 15/2013

P&WC Proprietary Information. Subject to the restrictions on the back of the locator
The export control classification with respect to this document is contained on the back of the locator.

PT6C-72-41079
Page 6 of 6