

PRATT & WHITNEY CANADA  
**TOOL SERVICE BULLETIN**

NO: PT-708R2

**Service Tool:** PWC32380 Rev. G

**Description:** Radius Gauge

**Effectivity:** PT6A-11, PT6A-11AG, PT6A-15AG, PT6A-21, PT6A-27, PT6A-28, PT6A-25, PT6A-25A, PT6A-25C, PT6A-34, PT6A-34AG, PT6A-34B, PT6A-35, PT6A-36, PT6A-38, PT6A-41, PT6A-42, PT6A-42A, PT6A-45A, PT6A-45B, PT6A-45R, PT6A-50, PT6A-52, PT6A-60A, PT6A-60AG, PT6A-61, PT6A-62, PT6A-64, PT6A-65B, PT6A-65R, PT6A-65AG, PT6A-65AR, PT6A-66, PT6A-66B, PT6A-66A, PT6A-66D, PT6A-67, PT6A-67A, PT6A-67AF, PT6A-67AG, PT6A-67B, PT6A-67D, PT6A-67F, PT6A-67P, PT6A-67R, PT6A-67RM, PT6A-67T, PT6A-68, PT6A-68B, PT6A-68C, PT6A-68D, PT6A-68T, PT6A-110, PT6A-112, PT6A-114, PT6A-114A, PT6A-116, PT6A-121, PT6A-135, PT6A-135A, PT6A-140, PT6A-140A, PT6A-140AG, PT6B-36A, PT6B-37A, PT6B-67A, PT6C-67C, PT6C-67C1, PT6C-67D, PT6C-67E, PT6E-67XP, PT6T-3, PT6T-3B, PT6T-3BE, PT6T-3BF, PT6T-3BG, PT6T-3D, PT6T-3DE, PT6T-3DF, PT6T-6, PT6T-6B, PT6T-9, ST6T-76

**Subject:** Tool Modification

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**Reason:**

**Problem:** Does not meet current design standards.

**Cause:** Design and process improvement.

**Solution:** Obsolete, replaced by PWC71568.

**Instruction:**

1. Existing PWC32380 may be modified and re-identified as PWC71568 if the following modifications are applied. as shown (Ref. Fig. 1).
2. Keep details No.3, No.4, No.8, No.12 & No.14 of PWC32380 identical to details No.18, No.1, No.3, No.5 & No.6 of PWC71568 respectively.
3. Discard details No.1, No.2, No.5, No.6, No.7, No.9, No.10, & No.16 of PWC32380.
4. Modify detail No.15 of PWC32380 as per detail No.2 of PWC71568.
5. Incorporate PWC71568 details No.4, No.9, No.10, No.11, No.12, No.13, No.14, No.15, No.16, & No.17.

**Compliance:** Optional

**Tool Usage:** Overhaul, Heavy Maintenance

**Tool Disposition:** Rework the tool per the accomplishment instructions or you can order a new tool from Pratt & Whitney Canada accredited suppliers.

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TSB Revision Notes			
TSB	DATE	Tool Rev No.	CHANGES
PT-708	10/2023	2	Effectivity Revised to Include PT6A-66B, PT6A-67P, PT6A-68B, PT6A-68C, PT6A-68D PT6A-68T, PT6A-140, PT6E-67XP.

ICN-00198-G000134602-001-01

Figure 1 (Sheet 1 of 11)

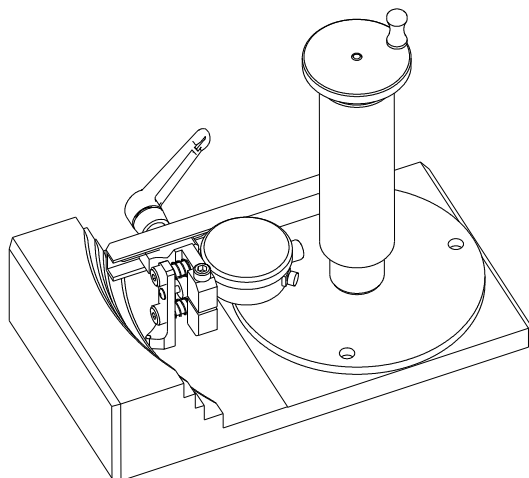
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DO NOT SCALE DRAWING - DIMENSIONS ARE IN INCHES															
UNLESS OTHERWISE SPECIFIED															
<p>BLACK OXIDE ALL STEEL DETAILS PER AMS 2485. ANODIZE ALL ALUMINUM DETAILS PER AMS2471 HARD ANODIZE PER AMS2468 COAT WITH RUST PREVENTIVE COMPOUND FOR SHIPMENT AND STORAGE ONLY PERMANENTLY ENGRAVE ON PART NUMBER AND LATEST CHANGE LETTER PER MIL SPEC 130   PERMANENTLY ENGRAVE ON PART NUMBER AND DETAIL NUMBER ON ALL LOOSE DETAILS PER MIL SPEC 130   PERMANENTLY ENGRAVE ON ASSEMBLY ACTUAL WEIGHT IN POUNDS EXCEEDING 15 LBS WELDED ASSEMBLIES MUST BE STRESS RELIEVED PRIOR TO FINAL MACHINING DRAWING INTERPRETATION ASME Y14.5M</p>	<p>L.F. (LOOSE FIT) .001 TO .005 PLAY, WITH FREE MOVEMENT. S.F. (SLIDE FIT) LESS THAN .0005 PLAY, WITH FREE MOVEMENT. G.F. (GAUGE FIT) LESS THAN .0001 PLAY, FROM FREE MOVEMENT TO 5 LBS MAX. RESISTANCE MOVEMENT. L.P.F. (LIGHT PRESS FIT) NO PLAY, WITH .0001 TO .0005 INTERFERENCE, PER INCH OF DIA. P.F. (PRESS FIT) NO PLAY, WITH .001 TO .0025 INTERFERENCE, PER INCH OF DIA.</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td>CONCENTRICITY WITHIN</td> <td>.015 FIR</td> </tr> <tr> <td>SYMMETRY WITHIN</td> <td>.015 FIR</td> </tr> <tr> <td>PERPENDICULARITY</td> <td>.015</td> </tr> <tr> <td>BREAK SHARP EDGES</td> <td>.015 MIN</td> </tr> <tr> <td>CORNER FILLET RADIUS</td> <td>.015 MAX</td> </tr> <tr> <td>ANGLES</td> <td>± 2°</td> </tr> <tr> <td>MACHINE FINISHED SURFACE ROUGHNESS</td> <td>125 AA</td> </tr> </table>	CONCENTRICITY WITHIN	.015 FIR	SYMMETRY WITHIN	.015 FIR	PERPENDICULARITY	.015	BREAK SHARP EDGES	.015 MIN	CORNER FILLET RADIUS	.015 MAX	ANGLES	± 2°	MACHINE FINISHED SURFACE ROUGHNESS	125 AA
CONCENTRICITY WITHIN	.015 FIR														
SYMMETRY WITHIN	.015 FIR														
PERPENDICULARITY	.015														
BREAK SHARP EDGES	.015 MIN														
CORNER FILLET RADIUS	.015 MAX														
ANGLES	± 2°														
MACHINE FINISHED SURFACE ROUGHNESS	125 AA														
<p>DIMENSION TOLERANCES</p> <p>. X = ± .030 . XX = ± .015 . XXX = ± .005</p>	<p>THIRD ANGLE PROJECTION</p>														

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Figure 1 (Sheet 2 of 11)

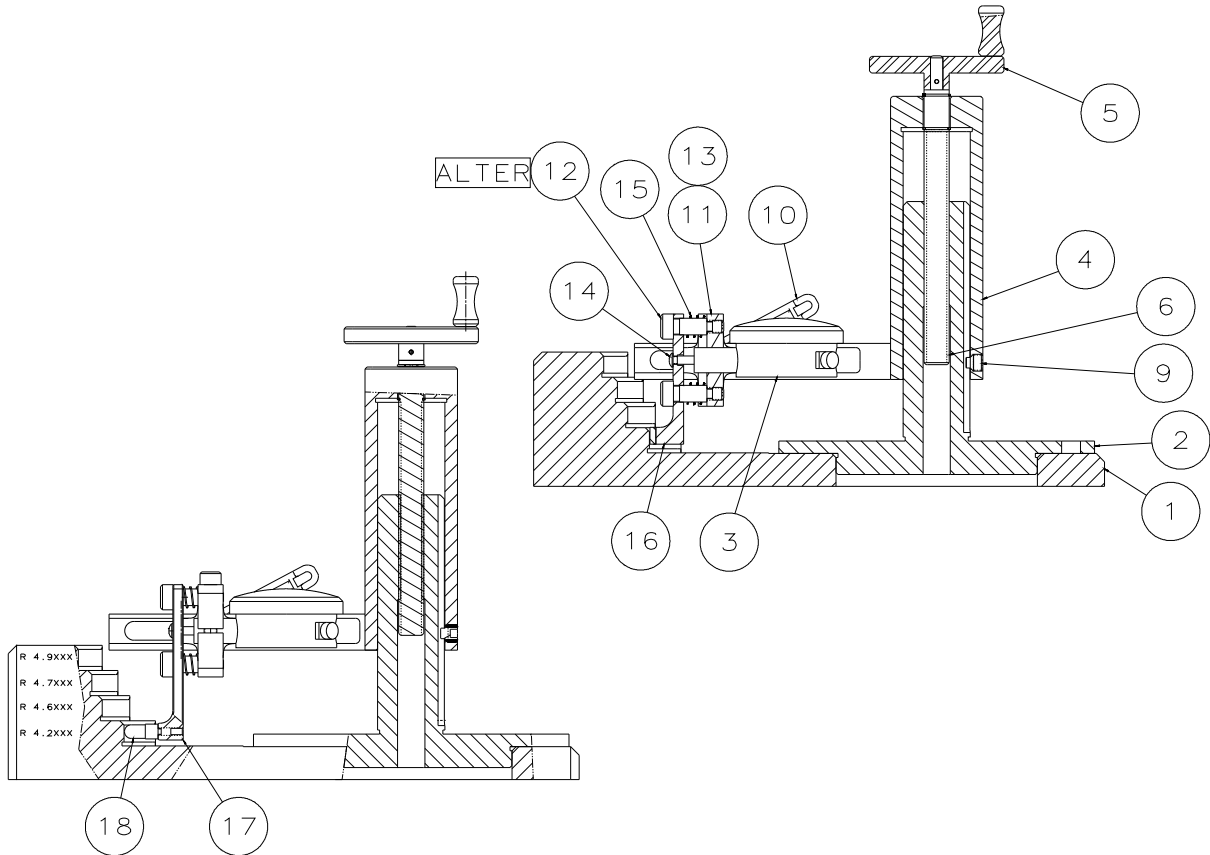
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18	1	CONTACT POINT	SAE GRADE 5	PT06677	57163 (STARRETT)
15	4	SPRING	STEEL	LC 016DE 03M	84830 (LEE SPRING)
14	2	BHSCS No4-48UNF x .38	STEEL		
13	2	SHCS No10-32UNF x 1.25	STEEL		
12	4	SHLD SCREW .250 DIA x .5 LG	STEEL	91259A537	3A054 (McMASTER)
11	2	INDICATOR BLOCK	AISI 4140 HRC 35-40		
10	1	ADJUSTABLE HANDLE		CL-408-AHP-1	99862 (CARRLANE)
9	1	SSS EXTEND PNT .250-20UNC X .25	STEEL	95289A314	3A054 (McMASTER)
3	2	DIAL IND PWC32602-0009	STEEL	B8I	21938 (Federal)
NO	QTY	PART	MATERIAL	STOCK NO	CAGE NUMBER

C180691

Figure 1 (Sheet 3 of 11)

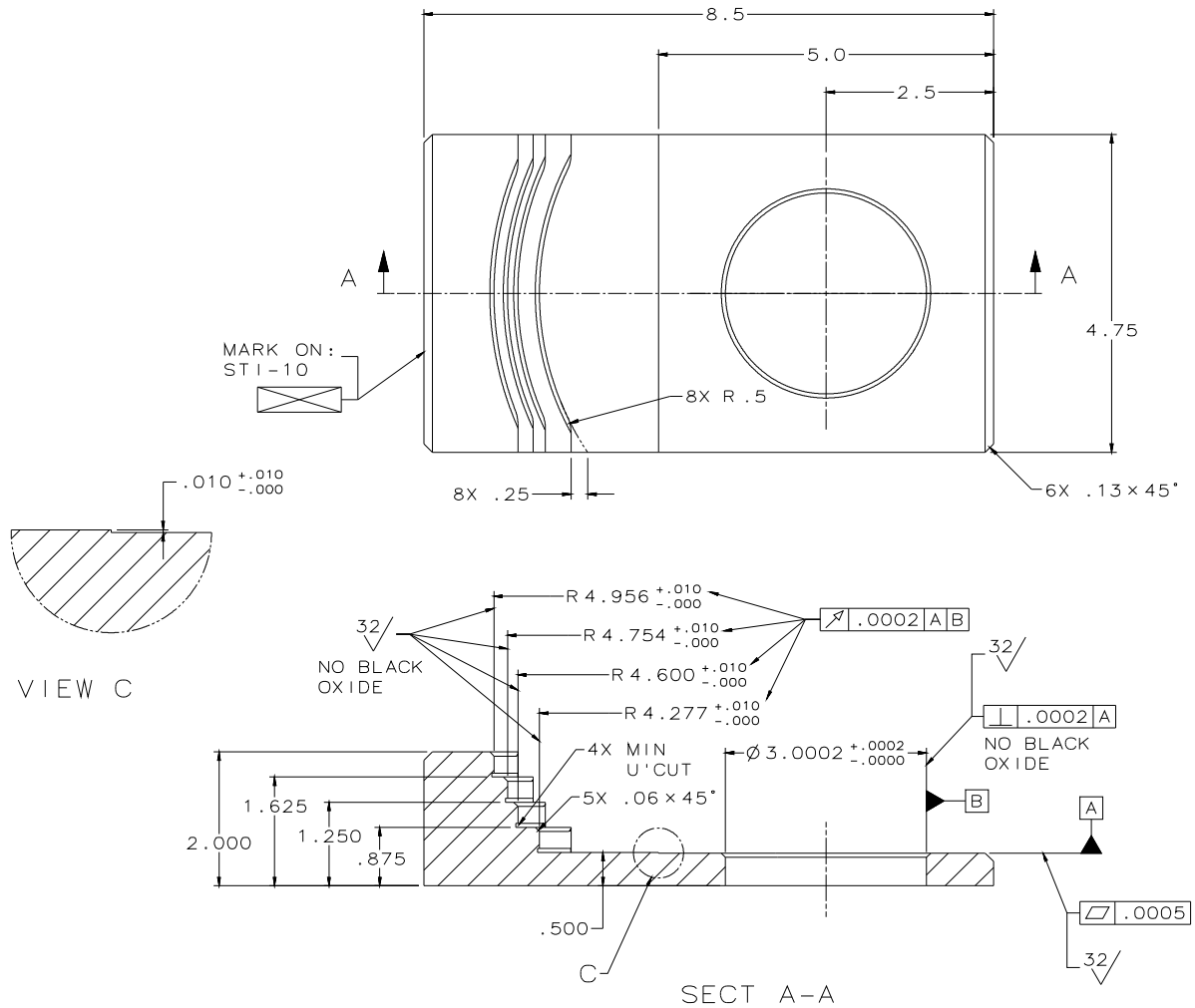
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① MASTER BASE - 1 REQ'D  
AISI 4140 HRC 35-40

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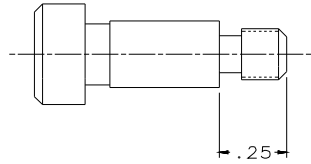




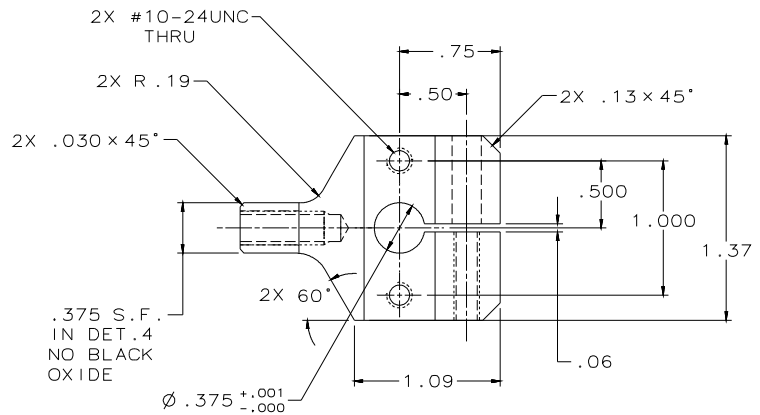
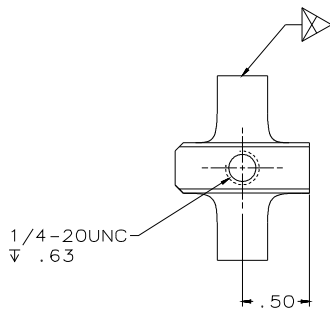
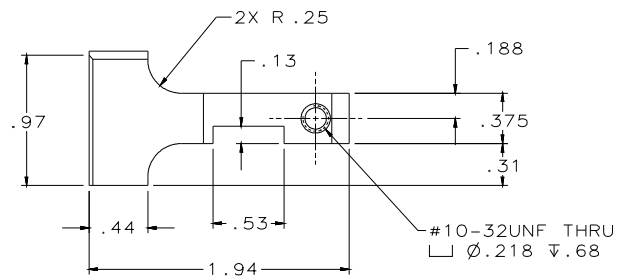


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- ⑫ SHLD SCREW .250 DIA x .5 LG - 4 REQ'D  
 STEEL  
 STOCK NO - 91259A537  
 ALTER AS SHOWN



- ⑪ INDICATOR BLOCK - 2 REQ'D  
 AISI 4140 HRC 35-40

C180695

Figure 1 (Sheet 7 of 11)

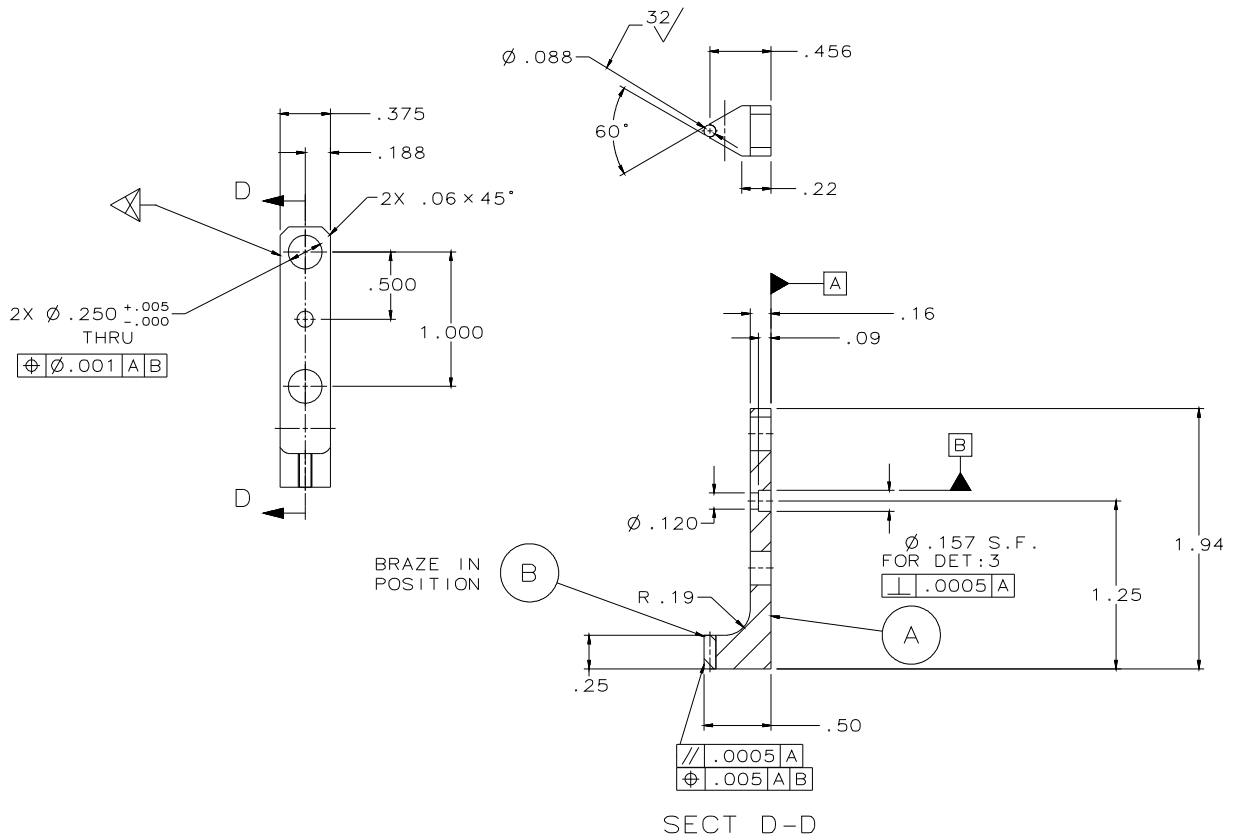
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(16) CONTACT BLOCK ASSY - 1 REQ'D

LTR	QTY	PART	MATERIAL
A	1	CONTACT BLOCK	AISI 4140 HRC 35-40
B	1	CARBIDE TIP	

C180696

Figure 1 (Sheet 8 of 11)

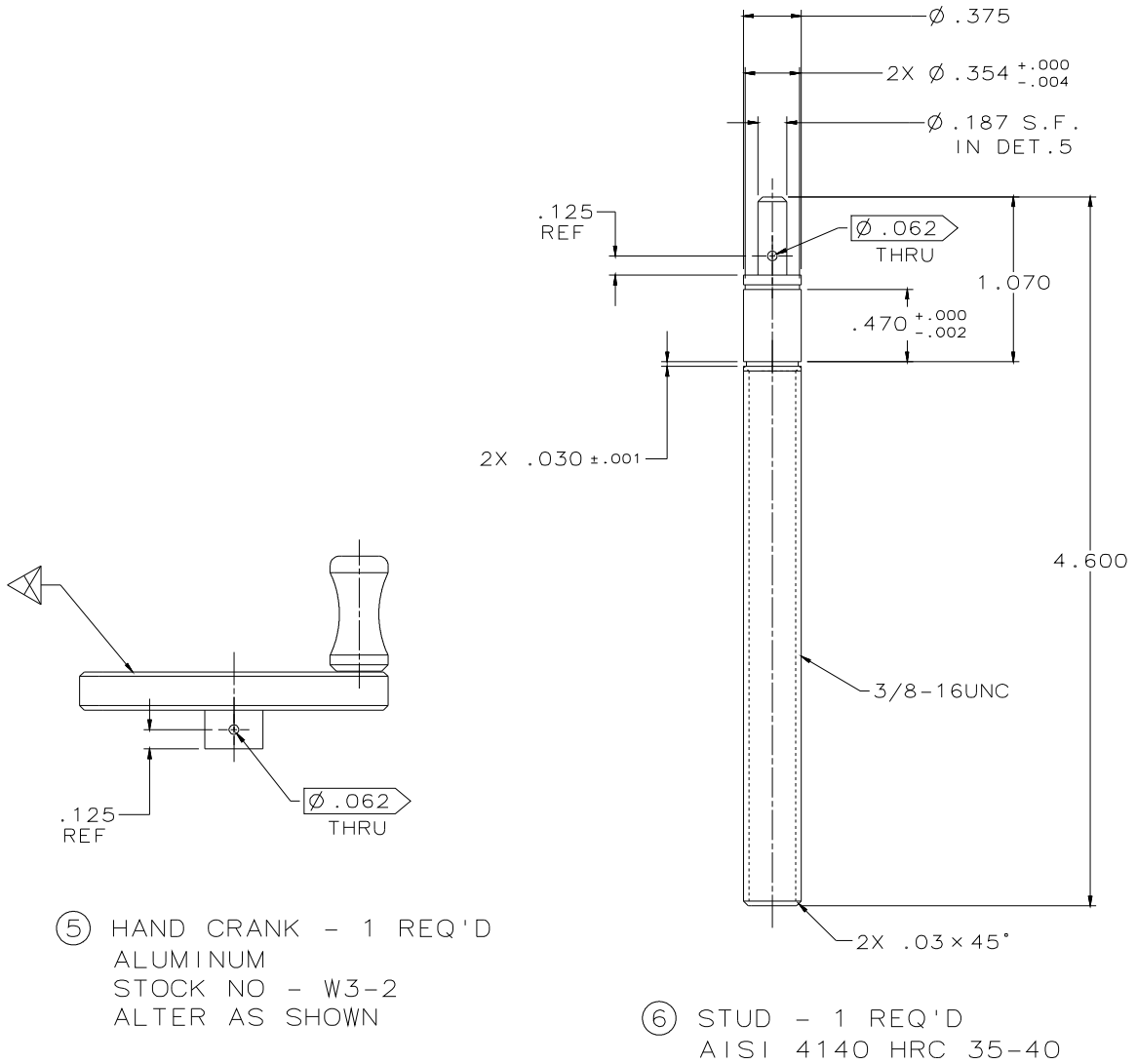
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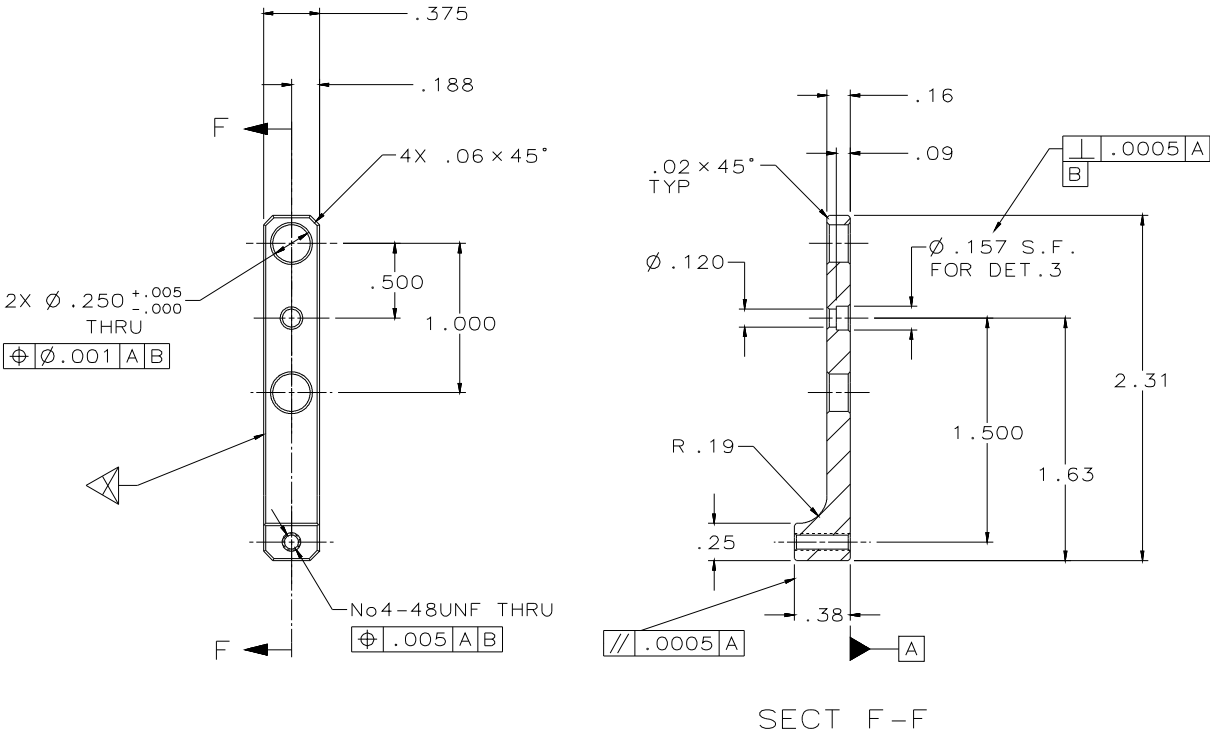
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(17) LONG CONTACT BLOCK - 1 REQ'D  
 AISI 4140 HRC 35-40

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1	16	DOWEL PIN NOM $\varnothing$ .187 X .875 LG	60380	STL
1	10	SDC SET SCREW		SEE DETAIL
1	9	SLEEVE ASSY		SEE DETAIL
1	7	SOC HD CAP SCREW .190-32UNF X .625 LG		STL
1	6	TIP		
1	5	SOC HD CAP SCREW .112-48UNF X .500 LG		STL
1	2	CONTACT POINT 6677A	57163	
1	1	CONTACT POINT 6677B	57163	
REQ'D	DET NO.	DESCRIPTION	CAGE NO.	MATL. SPEC.

C180988

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