

PRATT & WHITNEY CANADA  
**TOOL SERVICE BULLETIN**

NO: PT-935R1

**Service Tool:** PWC50608 Rev. H

**Description:** Ring - Housing Impeller

**Effectivity:** PT6A-11, PT6A-11AG, PT6A-15AG, PT6A-21, PT6A-25, PT6A-25A, PT6A-25C, PT6A-27, PT6A-28, PT6A-34, PT6A-34B, PT6A-34AG, 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-62, PT6A-65B, PT6A-65R, PT6A-65AG, PT6A-65AR, PT6A-110, PT6A-112, PT6A-114, PT6A-114A, PT6A-116, PT6A-121, PT6A-135, PT6A-135A, PT6A-140, PT6A-140A, PT6A-140AG, PT6B-36, PT6B-36A, PT6B-36B, PT6B-37A, PT6T-3, PT6T-3B, PT6T-3D, PT6T-3BE, PT6T-3BF, PT6T-3BG, PT6T-3DE, PT6T-3DF, PT6T-6, PT6T-6B, PT6T-9, ST6T-76

**Subject:** Tool Modification

**Reason:**

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**Problem:** No MAX load marked on tool and interference with 3rd stage stator.

**Cause:** Tool used with a press and design optimization.

**Solution:** Modify in accordance with revision H.

- Instruction:**
1. This TSB incorporates revisions changes “F”, “G” and “H”.
  2. In detail No. 3, 3X 0.75 flats and related dimensions added (Ref. Fig. 7).
  3. In detail No. 2, MAXL mark on as per Note 2.1 and PY as per Note 1.2 added (Ref. Fig. 6).
  4. In detail No. 4, MAXL mark on as per Note 2.1 and PY as per Note 1.2 added (Ref. Fig. 8).
  5. Tool is now categorized as STI-09 and re-identify.
  6. In detail No. 1, modify the dimension from 0.70 in. to 0.60 in. (Ref. Fig. 5).
  7. In detail No. 1, modify the dimension from 0.19 in. to 0.188 in. (Ref. Fig. 5).
  8. In detail No. 6, modify the diameter from 0.63 in. to 0.68 in. and related dimensions added (Ref. Fig. 9).
  9. In detail No. 6, modify the diameter from 0.188 in. to 2 x 0.156 in. and related dimensions added (Ref. Fig. 9).

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

10. Use the vibration peening procedure and write change letter “H” after the part number.

**Compliance:** Required

**Tool Usage:** Overhaul

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**Tool Disposition:** Rework the tool per the accomplishment instructions or send tool to a Pratt & Whitney Canada accredited suppliers.

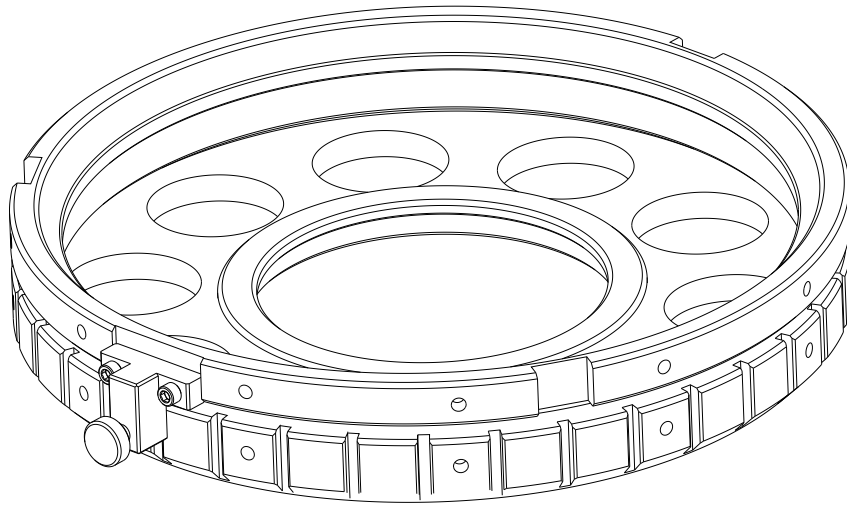
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6	1	HOLDER 1	AISI 4140 HRC 26-32	—	—	—
4	1	BODY 2	AISI 4140 HRC 26-32	—	—	—
3	1	RING 2	AISI 4140 HRC 26-32	—	—	—
2	1	BODY	AISI 4140 HRC 26-32	—	—	—
1	1	RING	AISI 4140 HRC 26-32	—	—	—
NO	QTY	PART	MATERIAL	STOCK NO	CAGE NUMBER	ALTER

ICN-00198-G000046034-001-01

Figure 1

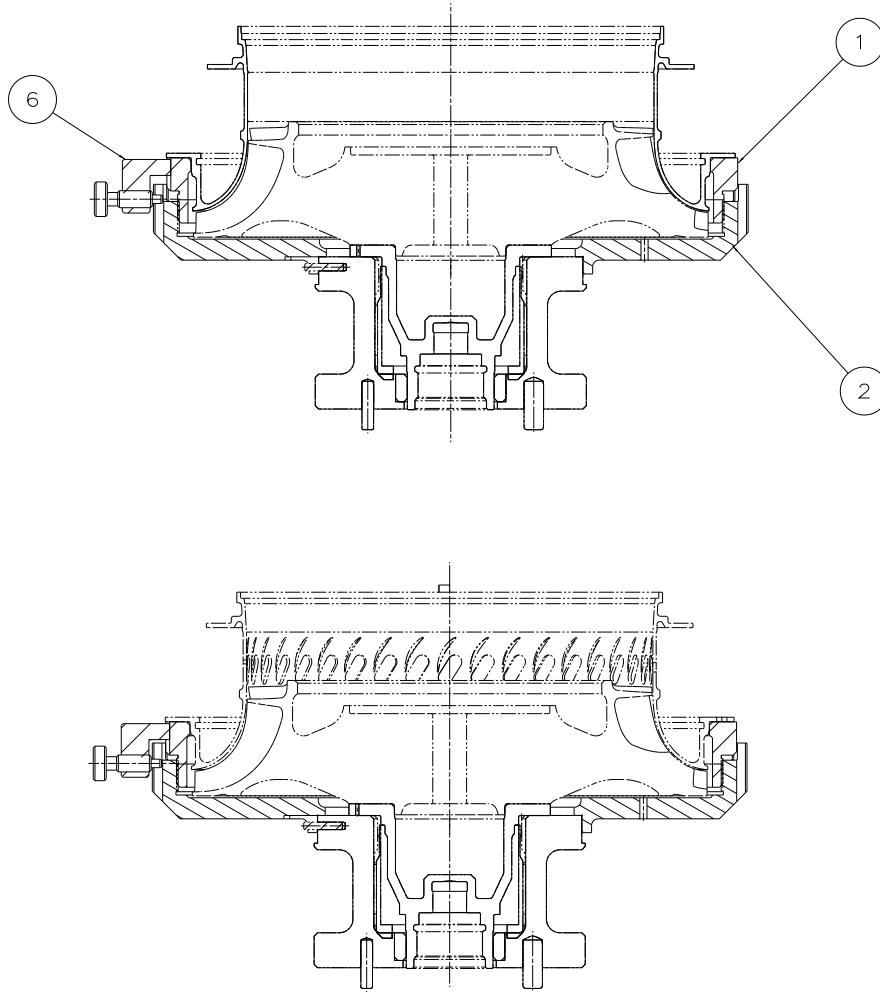
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Figure 2

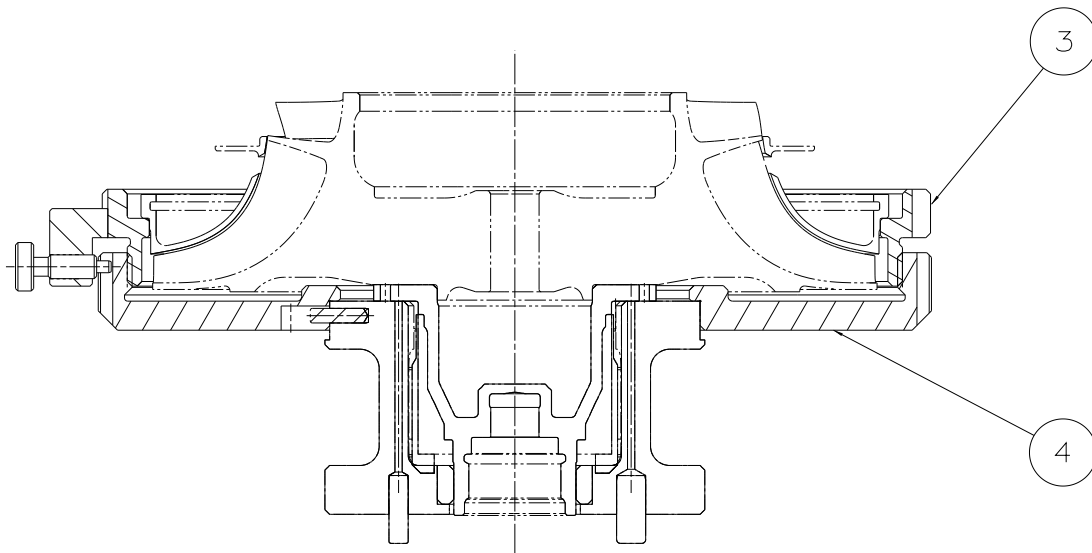
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Figure 3

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**NOTES:**

1 - ASSEMBLY & TEST TOOLING

1.2 PAINT PER FED SPEC TT-E-489J  
AND COLOR PER FED-STD-595C  
(PY) YELLOW (13538)

MAXIMUM LOAD  
3000 LB  
(1360 kg)

2 - MARK ON TOOL

2.1 (MAXL) MARK ON: "MAX LOAD = 3000 LB  
(1360 kg)" ENGRAVE .25 HIGH CHARACTERS

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 style="width: 80%;">CONCENTRICITY WITHIN</td> <td style="text-align: right;">.015 FIR</td> </tr> <tr> <td>SYMMETRY WITHIN</td> <td style="text-align: right;">.015 FIR</td> </tr> <tr> <td>PERPENDICULARITY</td> <td style="text-align: right;">.015</td> </tr> <tr> <td>BREAK SHARP EDGES</td> <td style="text-align: right;">.015 MIN</td> </tr> <tr> <td>CORNER FILLET RADIUS</td> <td style="text-align: right;">.015 MAX</td> </tr> <tr> <td>ANGLES</td> <td style="text-align: right;">± 2°</td> </tr> <tr> <td>MACHINE FINISHED SURFACE ROUGHNESS</td> <td style="text-align: right;">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
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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 4

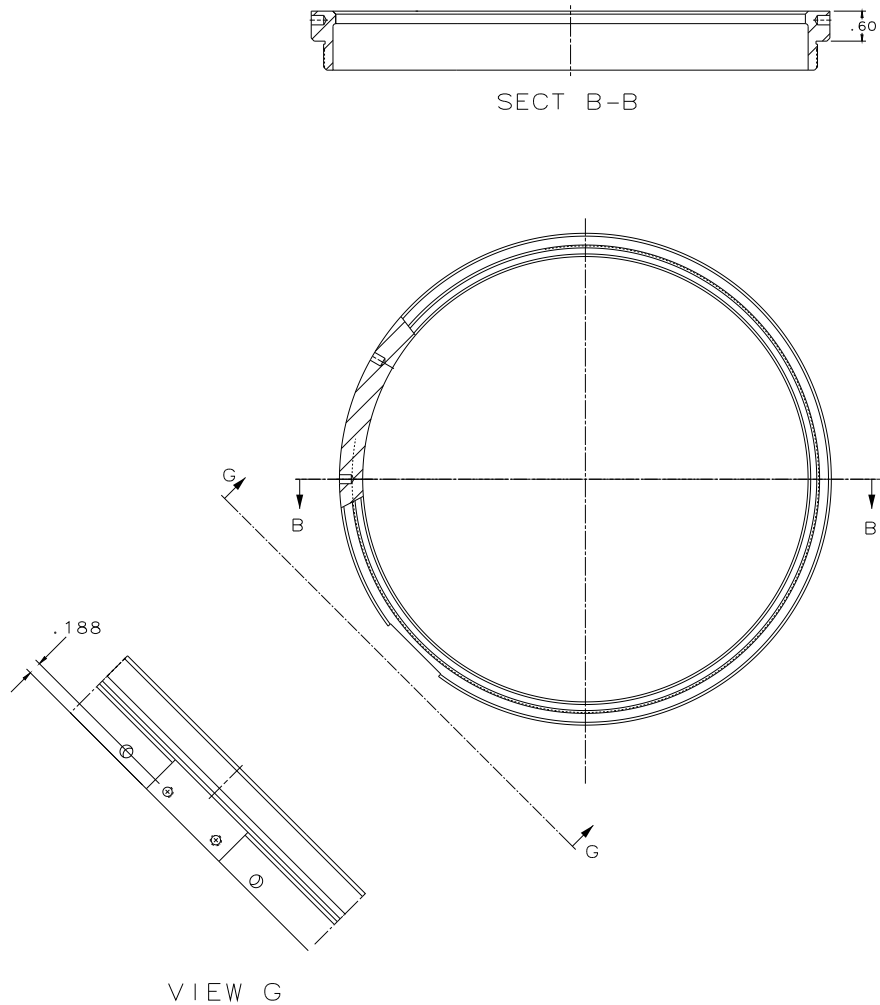
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① RING - 1 REQ'D  
AISI 4140 HRC 26-32

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Figure 5

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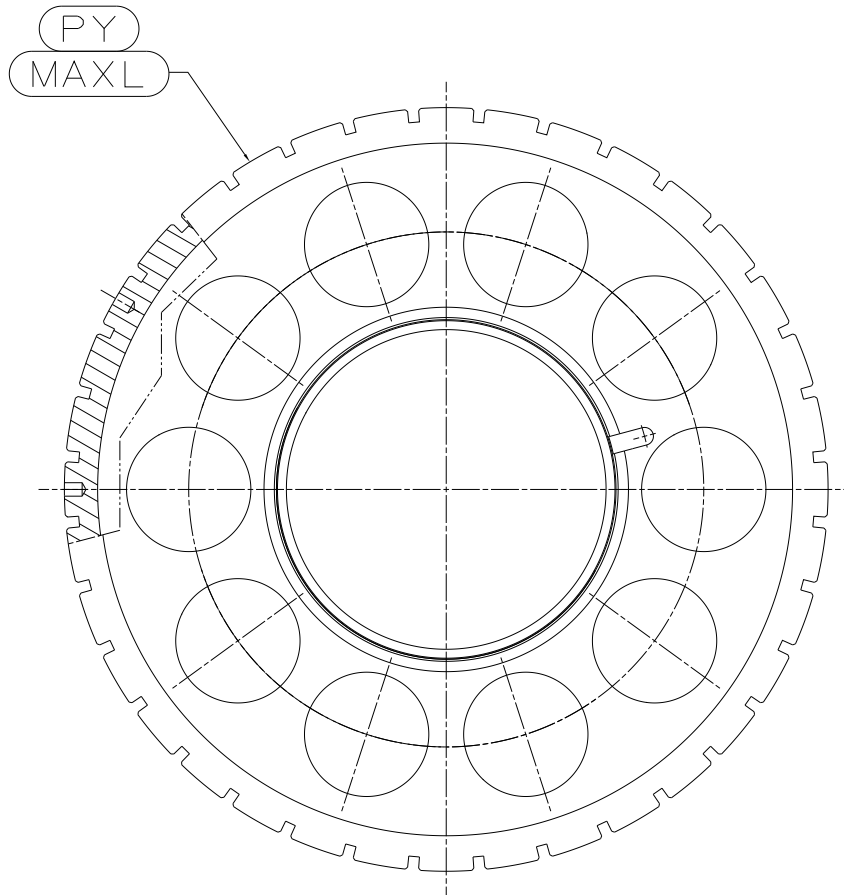
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② BODY - 1 REQ'D  
AISI 4140 HRC 26-32

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Figure 6

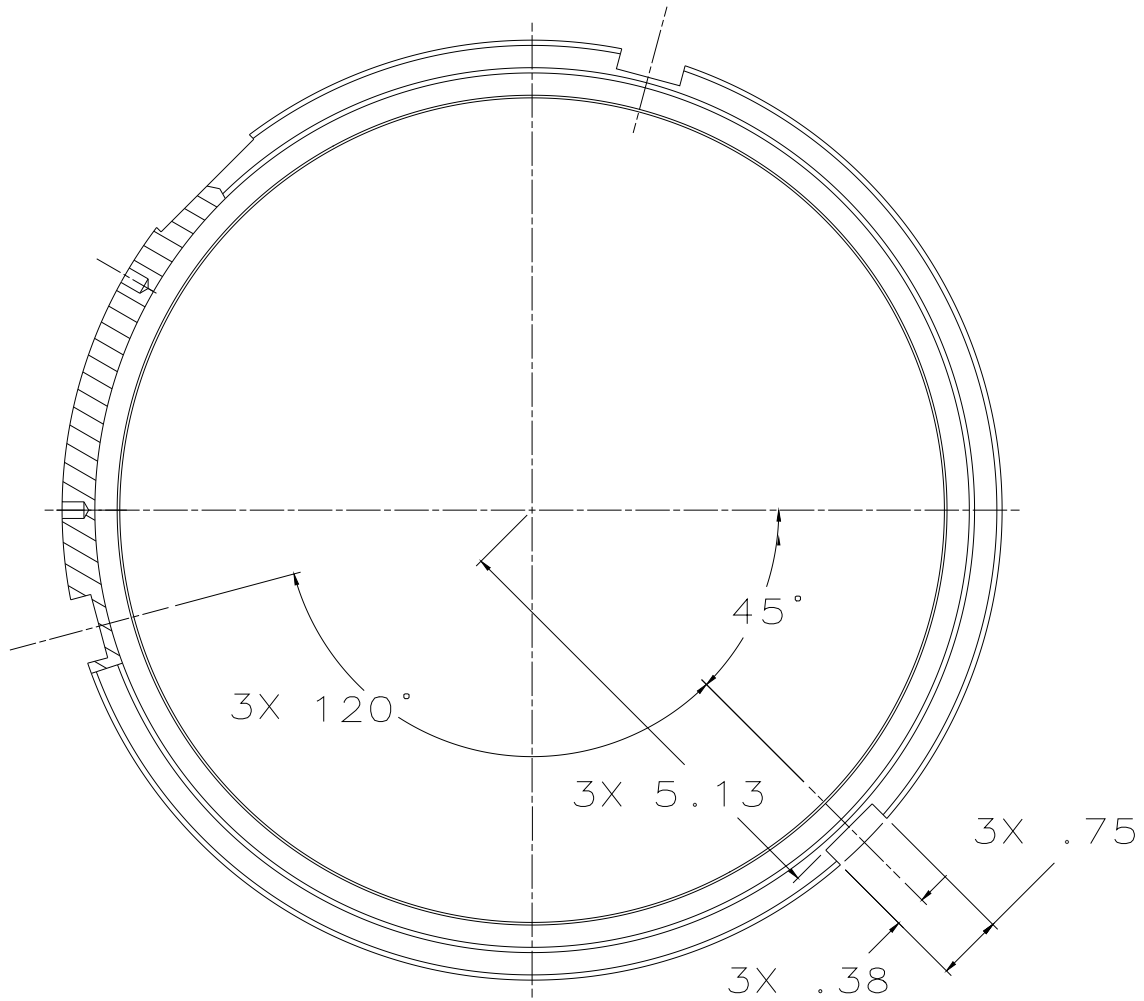
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③ RING 2 - 1 REQ'D  
AISI 4140 HRC 26-32

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Figure 7

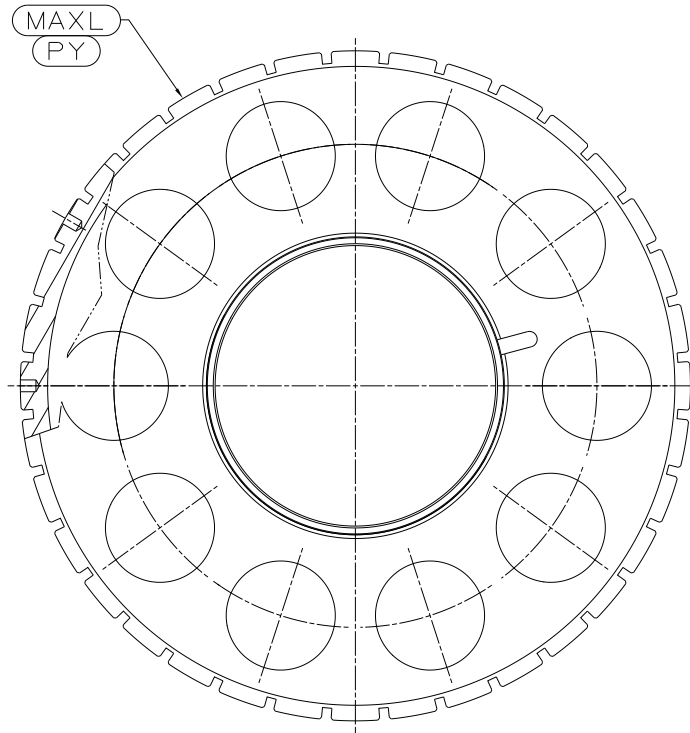
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④ BODY 2 - 1 REQ'D  
AISI 4140 HRC 26-32

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Figure 8

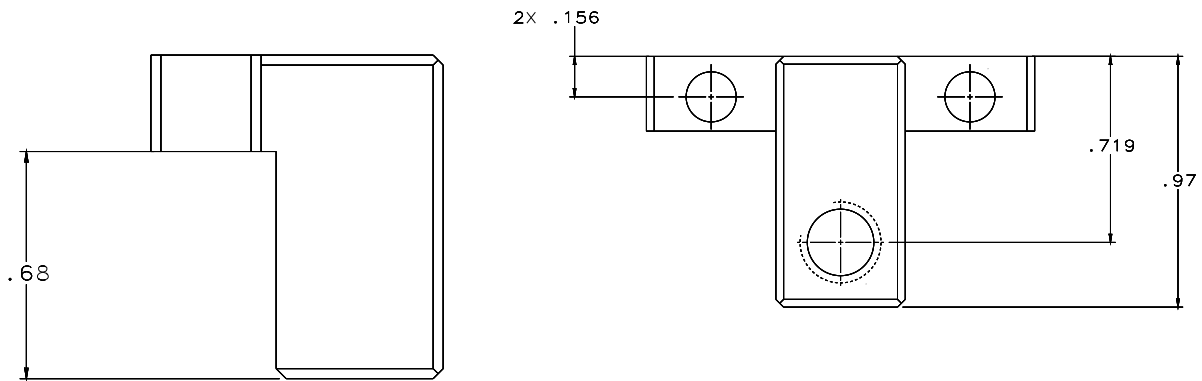
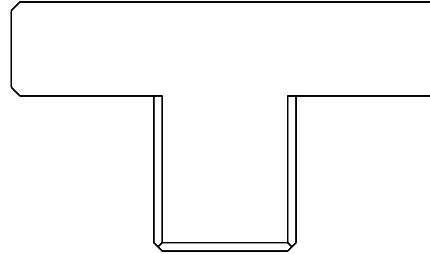
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⑥ HOLDER 1 - 1 REQ'D  
AISI 4140 HRC 26-32

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Figure 9

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