

PRATT & WHITNEY CANADA  
**TOOL SERVICE BULLETIN**

NO: PT-939

**Service Tool:** PWC32047 Rev. C

**Description:** Puller

**Effectivity:** PT6A-45A, PT6A-45B, PT6A-45R, PT6A-50, PT6A-52, PT6A-60A, PT6A-60AG, PT6A-61, PT6A-62, PT6A-64, PT6A-65AG, PT6A-65AR, PT6A-65B, PT6A-65R, PT6A-66A, PT6A-66, PT6A-66B, PT6A-67B, PT6A-67D, PT6A-67P, PT6A-67, PT6A-67A, PT6A-67AF, PT6A-67AG, PT6A-67R, PT6A-67T

**Subject:** Tool Modification

**Reason:**

**Problem:** Will not fit on new engine part.

**Cause:** Engineering change (new engine hardware) Ref. SB No. 14377.

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

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**Instruction:** 1. Modify the diameter from 3.275 +/-0.002 to 3.310 and incorporate related dimensions in detail No. 2 (Ref. Fig. 1).

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

2. Use the vibration peening procedure and write change letter "C" after the part number.

**Compliance:** Required

**Tool Usage:** Overhaul

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

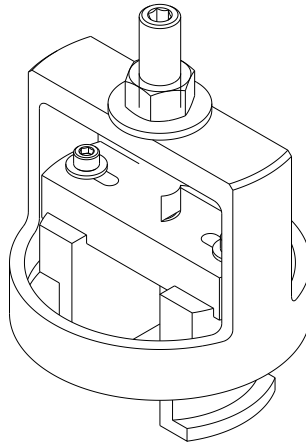
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# PRATT & WHITNEY CANADA TOOL SERVICE BULLETIN

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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 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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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>														

ICN-00198-G000019976-001-01

Figure 1 (Sheet 1 of 3)

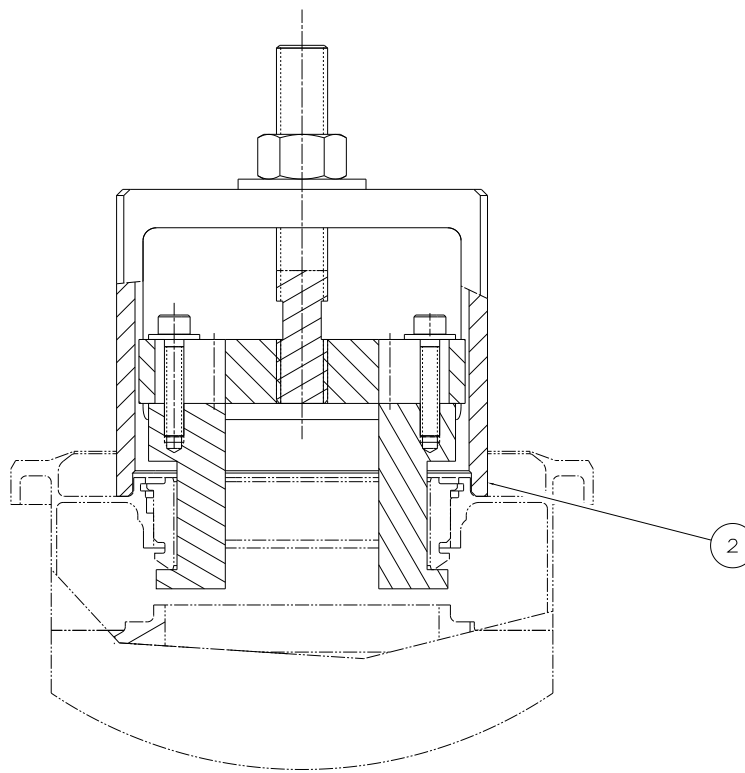
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Figure 1 (Sheet 2 of 3)

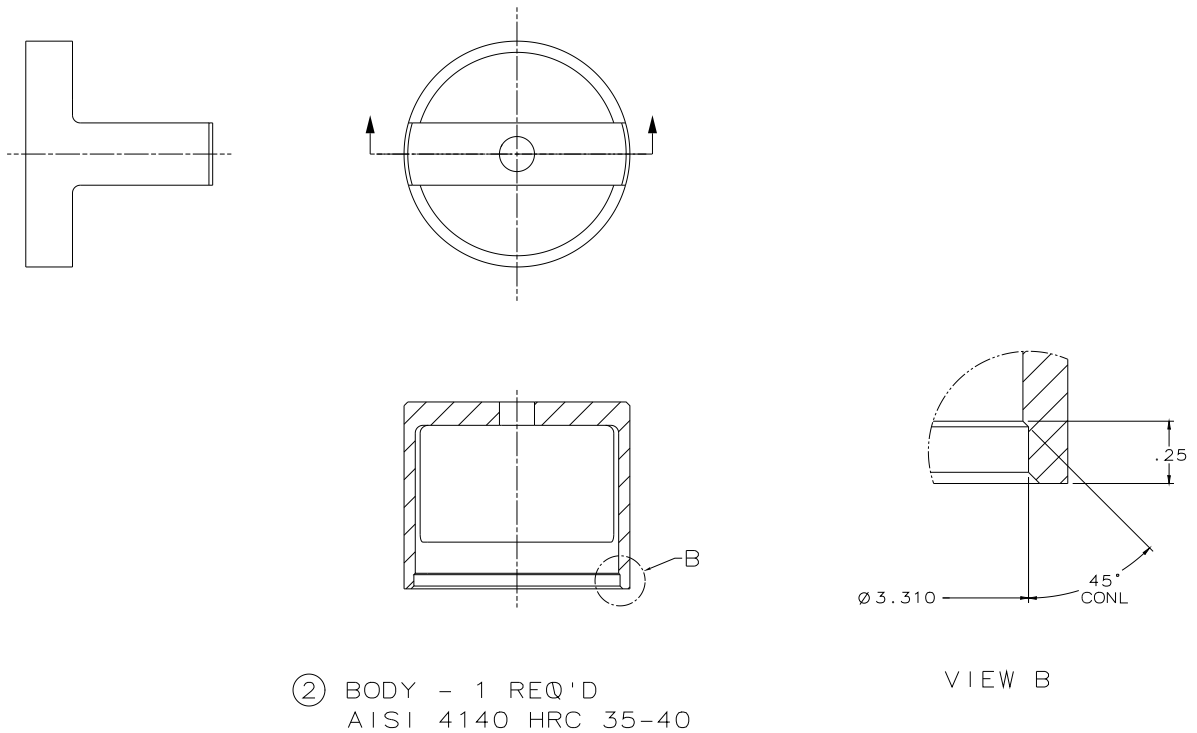
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# PRATT & WHITNEY CANADA TOOL SERVICE BULLETIN

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2	1	BODY	AISI 4140 HRC 35-40	-	-	-
NO	QTY	PART	MATERIAL	STOCK NO	CAGE NUMBER	ALTER

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Figure 1 (Sheet 3 of 3)

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