

PRATT & WHITNEY CANADA
TOOL SERVICE BULLETIN

NO: PT-977

Service Tool: PWC89843 Rev. B

Description: Cylinder-Hydraulic

Effectivity: PT6A-52, PT6A-60, PT6A-66, PT6A-67B, PT6A-68D, PT6B-37A,
PT6B-67A, PT6C-67A, PT6C-67C, PT6C-67D, PT6C-67E, PT6T-9

Subject: Tool Modification

Reason:

Problem: Potential EH&S issue with detail No. 3.

Cause: Detail prone to cracking.

Solution: Modify in accordance with revision B.

Instruction: 1. On detail No. 1, add identification and stamp (Ref. Fig. 1 Sheet 3).

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2. Make new detail No. 3 (Ref. Fig. 1 Sheet 4, 5, 6 and 7).
3. On detail No. 4, add identification (Ref. Fig. 1 Sheet 8).

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

4. Use the vibration peening procedure and write change letter "B" after the part number.

Compliance: Required

Tool Usage: Overhaul, Heavy Maintenance

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

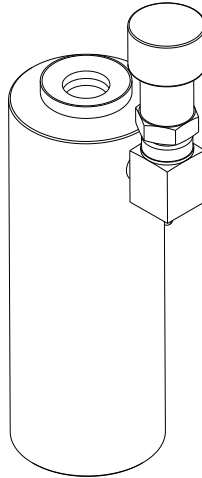
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DO NOT SCALE DRAWING - DIMENSIONS ARE IN INCHES															
UNLESS OTHERWISE SPECIFIED															
<p>BLACK OXIDE ALL STEEL DETAILS PER AMS 2485. ANODIZE ALL ALUMINUM DETAILS PER AMS2471 HARD ANODIZE PER AMS2468 COAT WITH RUST PREVENTIVE COMPOUND FOR SHIPMENT AND STORAGE ONLY</p> <p>PERMANENTLY ENGRAVE ON PART NUMBER AND LATEST CHANGE LETTER PER MIL SPEC 130 </p> <p>PERMANENTLY ENGRAVE ON PART NUMBER AND DETAIL NUMBER ON ALL LOOSE DETAILS PER MIL SPEC 130 </p> <p>PERMANENTLY ENGRAVE ON ASSEMBLY ACTUAL WEIGHT IN POUNDS EXCEEDING 15 LBS</p> <p>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
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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>														

ICN-00198-G000039213-001-01

Figure 1 (Sheet 1 of 8)

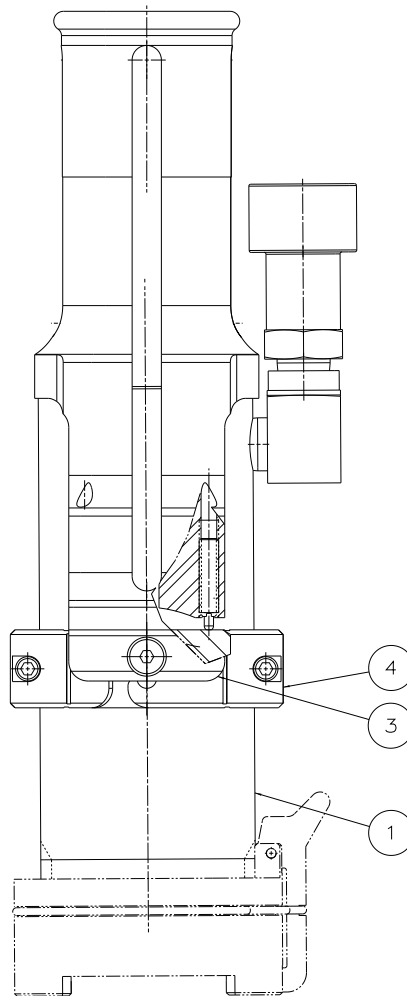
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Figure 1 (Sheet 2 of 8)

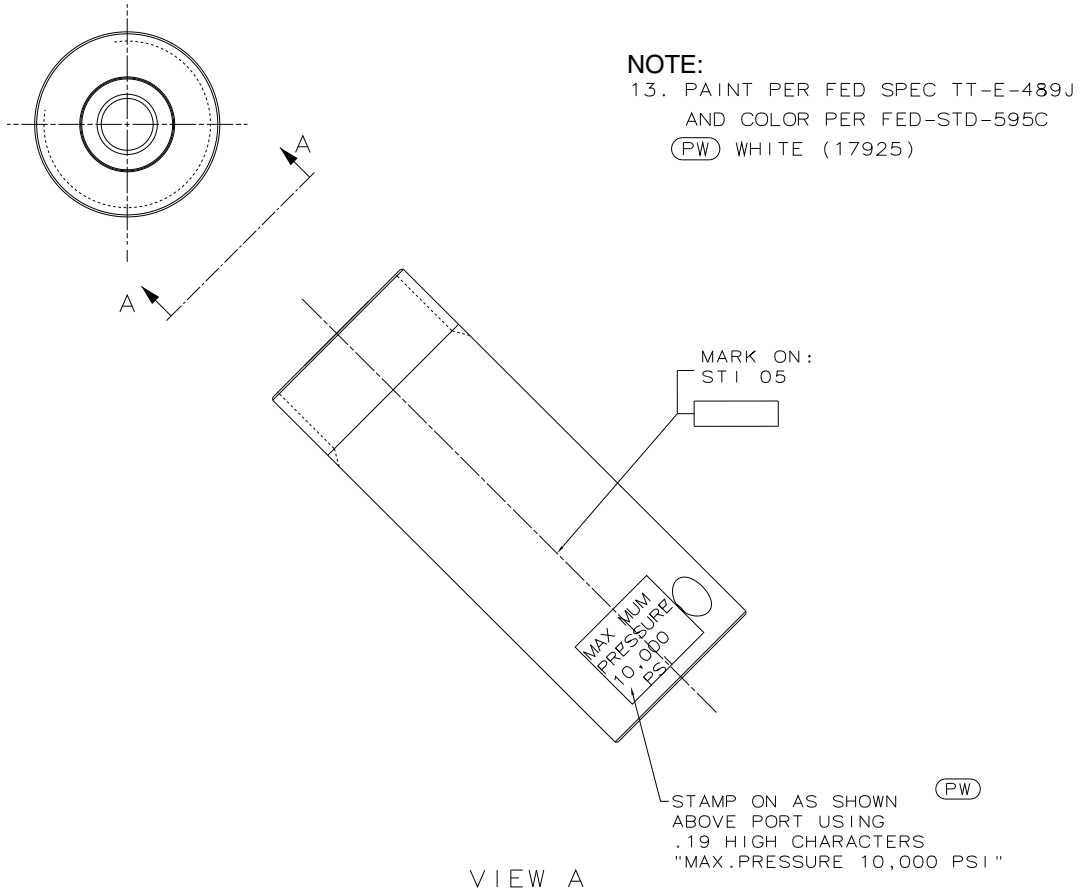
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- ① HYDRAULIC CYLINDER - 1 REQ'D
STOCK NO - RCH-123
ALTER AS SHOWN

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Figure 1 (Sheet 3 of 8)

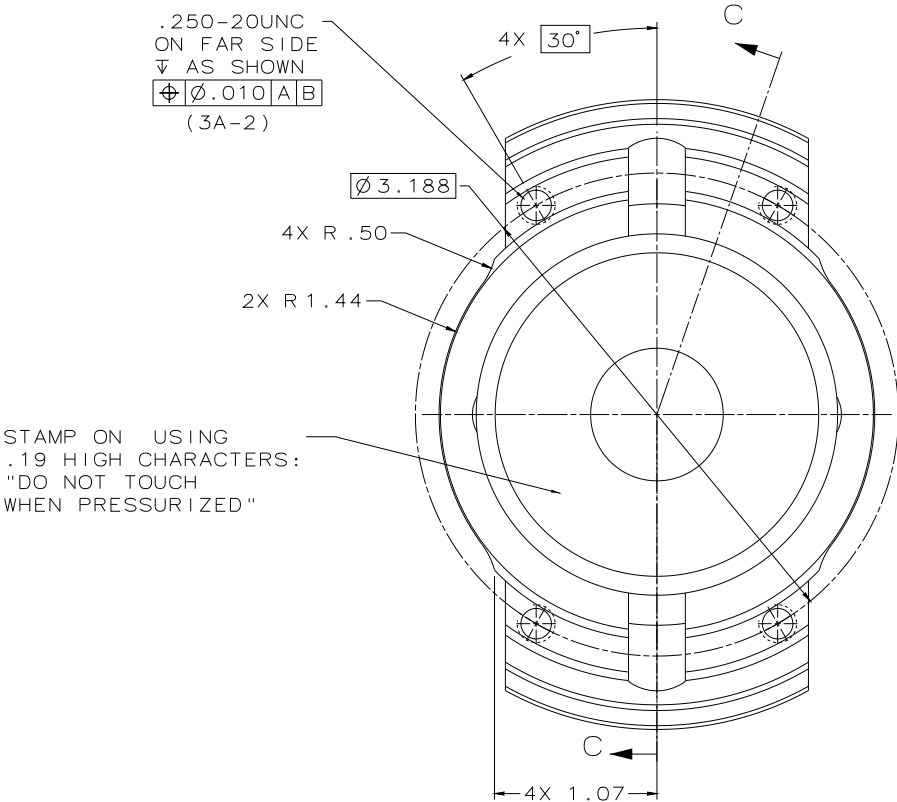
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③ CONTAINMENT - 1 REQ'D
AL6061-T6
RED ANODIZE

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Figure 1 (Sheet 4 of 8)

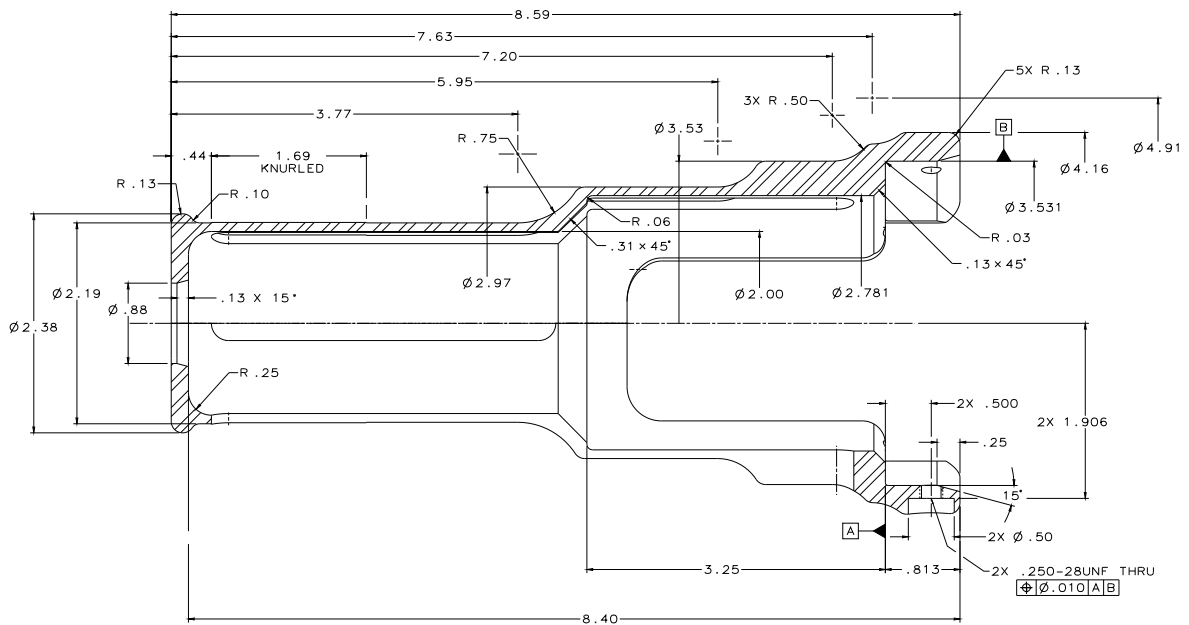
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SECT C-C

③ CONTAINMENT - 1 REQ'D
AL6061-T6
RED ANODIZE

ICN-00198-G000039218-001-01

Figure 1 (Sheet 5 of 8)

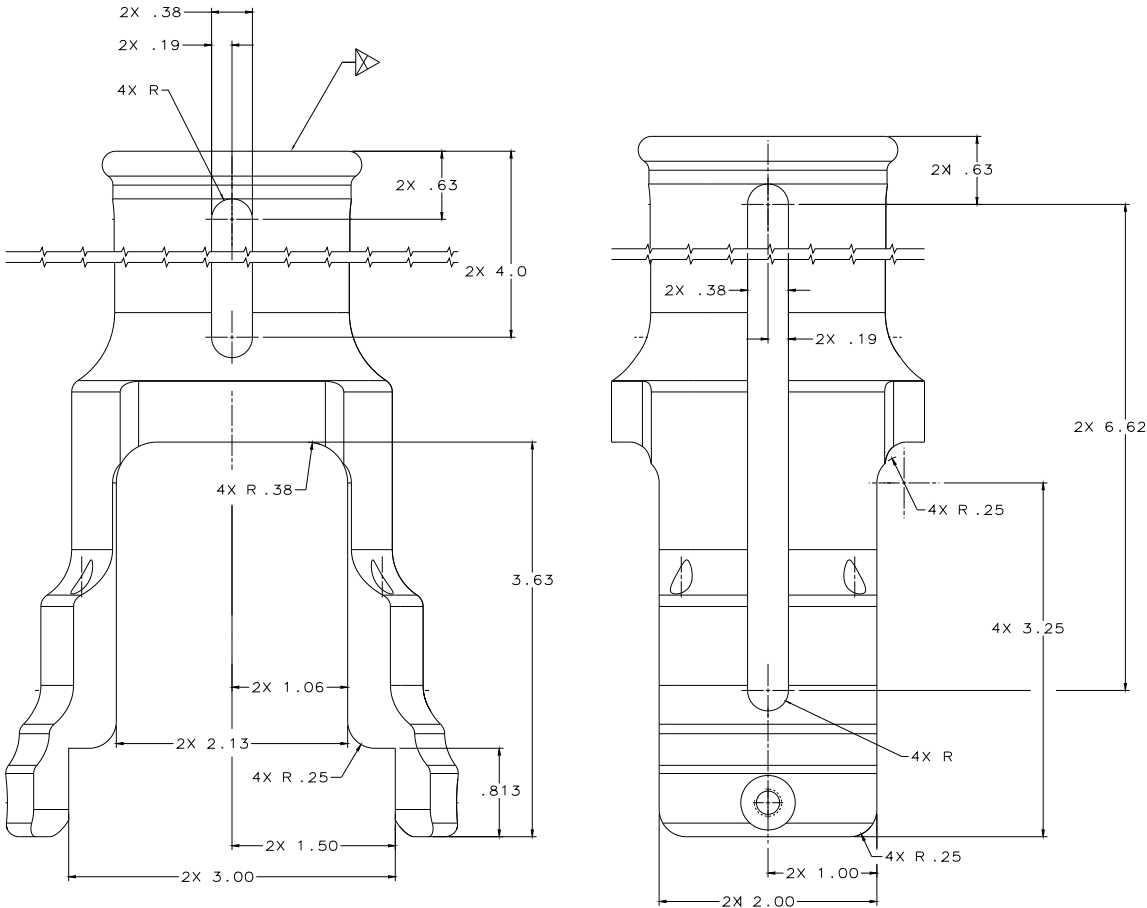
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③ CONTAINMENT - 1 REQ'D
AL6061-T6
RED ANODIZE

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Figure 1 (Sheet 6 of 8)

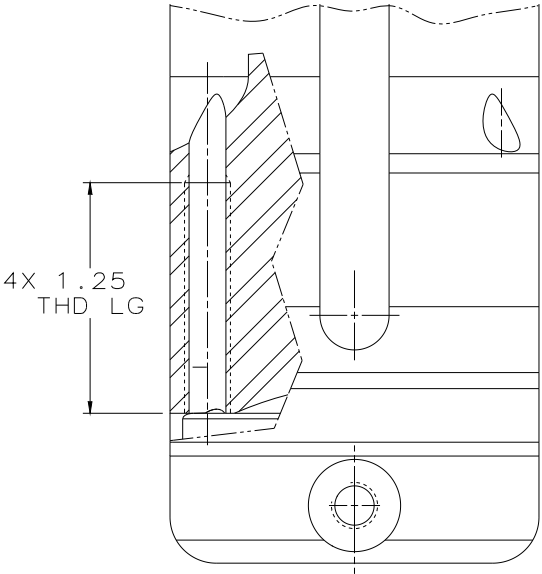
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DUPLICATE VIEW

- ③ CONTAINMENT - 1 REQ'D
AL6061-T6
RED ANODIZE

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Figure 1 (Sheet 7 of 8)

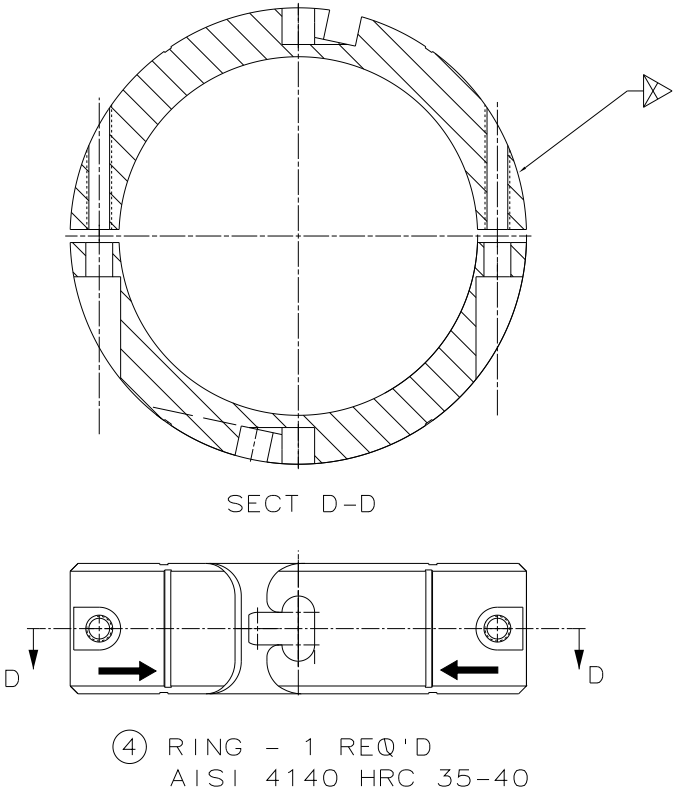
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4	1	RING	AISI 4140 HRC 35-40	—	—
3	1	CONTAINMENT	AL6061-T6	—	—
1	1	HYDRAULIC CYLINDER	—	RCH-123	26952(ENERPAC)
NO	QTY	PART	MATERIAL	STOCK NO	CAGE NUMBER

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Figure 1 (Sheet 8 of 8)

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