

PRATT & WHITNEY CANADA
TOOL SERVICE BULLETIN

NO: PT-977R1

Service Tool: PWC89843 Rev. B

Description: Cylinder-Hydraulic

Effectivity: PT6A-52, PT6A-60A, PT6A-60AG, PT6A-61, PT6A-66, PT6A-66B, PT6A-67B, PT6A-67P, 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.

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.

Issued: Aug 26/2020
Revised: May 26/2022

PWC89843
Page 1 of 10

PRATT & WHITNEY CANADA
TOOL SERVICE BULLETIN

NO: PT-977R1

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

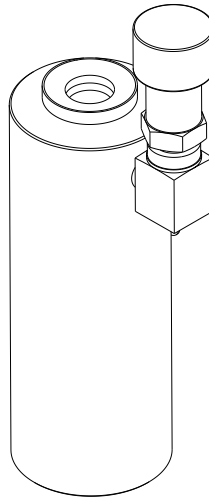
P&WC Proprietary Information. Subject to the restrictions on the first page.

Issued: Aug 26/2020
Revised: May 26/2022

PWC89843
Page 2 of 10

PRATT & WHITNEY CANADA TOOL SERVICE BULLETIN

NO: PT-977R1



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
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>														

ICN-00198-G000039213-001-01

Figure 1 (Sheet 1 of 8)

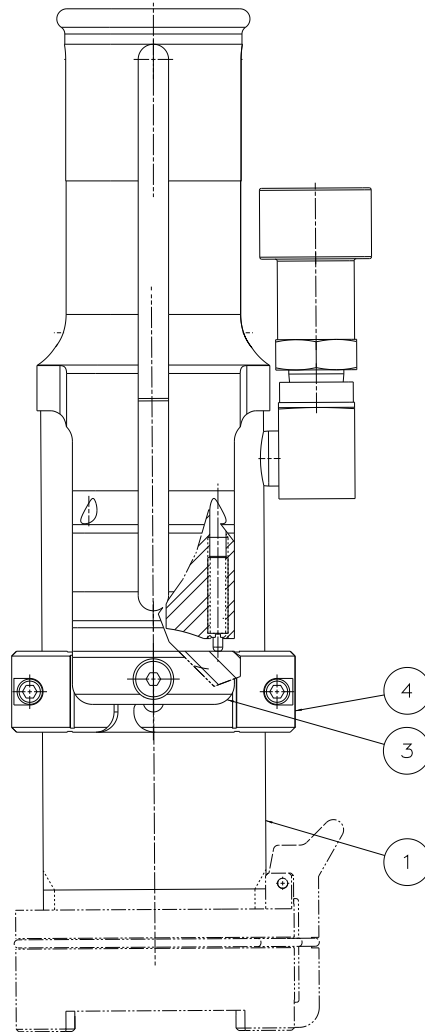
P&WC Proprietary Information. Subject to the restrictions on the first page.

Issued: Aug 26/2020
Revised: May 26/2022

PWC89843
Page 3 of 10

PRATT & WHITNEY CANADA TOOL SERVICE BULLETIN

NO: PT-977R1



ICN-00198-G000039214-001-01

Figure 1 (Sheet 2 of 8)

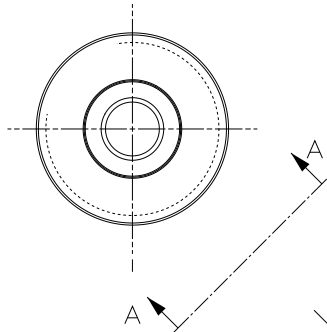
P&WC Proprietary Information. Subject to the restrictions on the first page.

Issued: Aug 26/2020
Revised: May 26/2022

PWC89843
Page 4 of 10

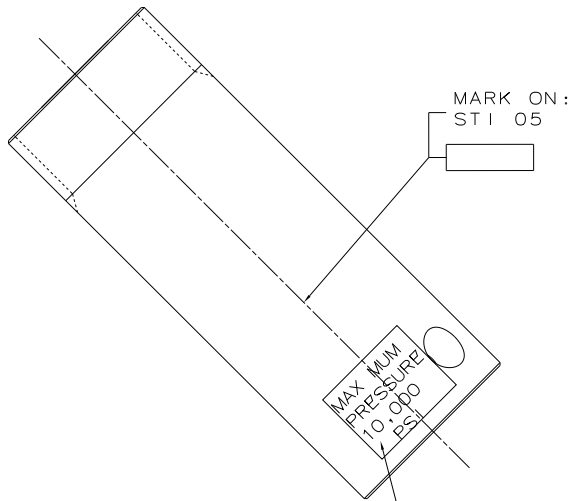
PRATT & WHITNEY CANADA
TOOL SERVICE BULLETIN

NO: PT-977R1



NOTE:

- 13. PAINT PER FED SPEC TT-E-489J
AND COLOR PER FED-STD-595C
(PW) WHITE (17925)



STAMP ON AS SHOWN (PW)
ABOVE PORT USING
.19 HIGH CHARACTERS
"MAX.PRESSURE 10,000 PSI"

VIEW A

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

ICN-00198-G000039216-001-01

Figure 1 (Sheet 3 of 8)

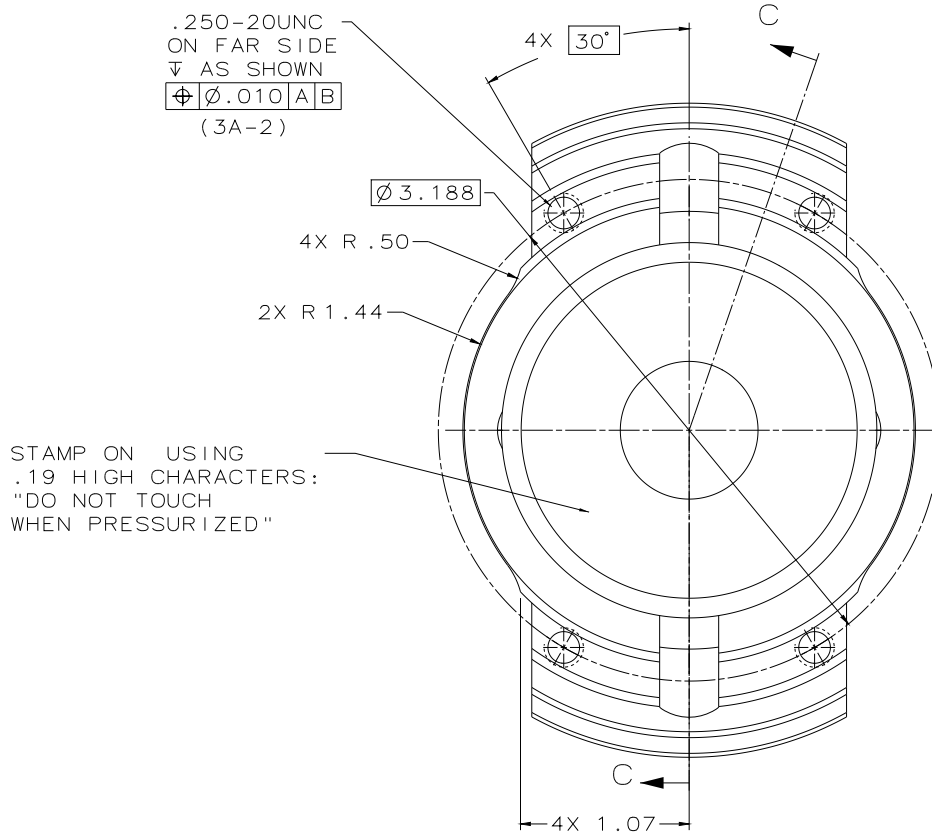
P&WC Proprietary Information. Subject to the restrictions on the first page.

Issued: Aug 26/2020
Revised: May 26/2022

PWC89843
Page 5 of 10

PRATT & WHITNEY CANADA TOOL SERVICE BULLETIN

NO: PT-977R1



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

ICN-00198-G000039217-001-01

Figure 1 (Sheet 4 of 8)

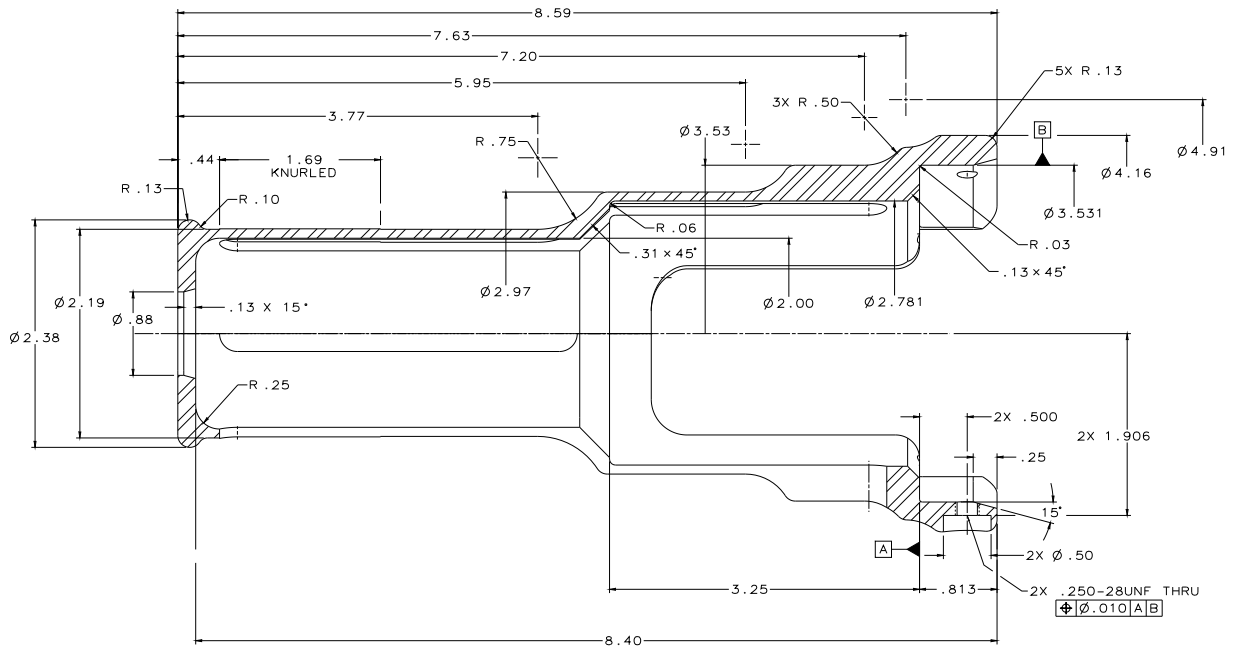
P&WC Proprietary Information. Subject to the restrictions on the first page.

Issued: Aug 26/2020
Revised: May 26/2022

PWC89843
Page 6 of 10

PRATT & WHITNEY CANADA TOOL SERVICE BULLETIN

NO: PT-977R1



SECT C-C

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

ICN-00198-G000039218-001-01

Figure 1 (Sheet 5 of 8)

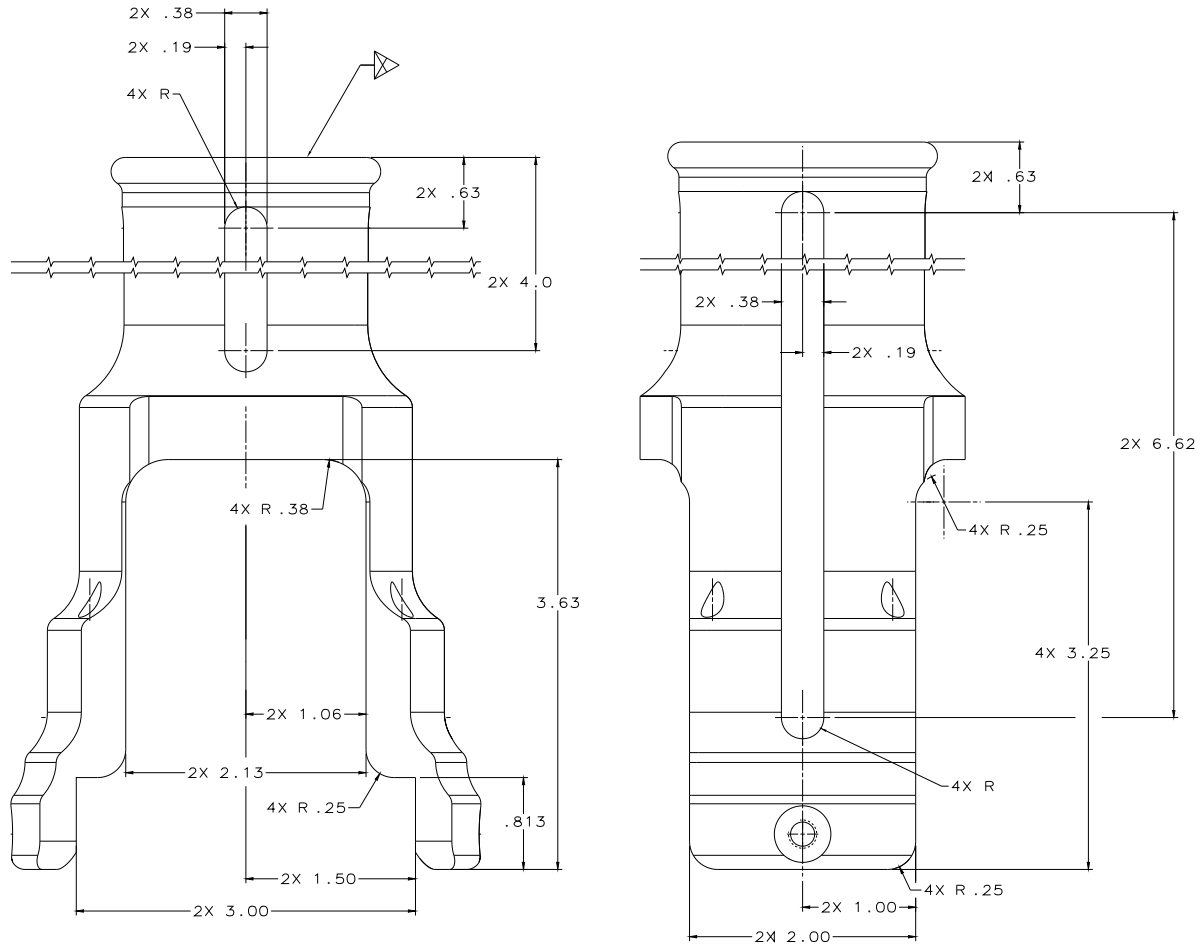
P&WC Proprietary Information. Subject to the restrictions on the first page.

Issued: Aug 26/2020
Revised: May 26/2022

PWC89843
Page 7 of 10

PRATT & WHITNEY CANADA TOOL SERVICE BULLETIN

NO: PT-977R1



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

ICN-00198-G000039219-001-01

Figure 1 (Sheet 6 of 8)

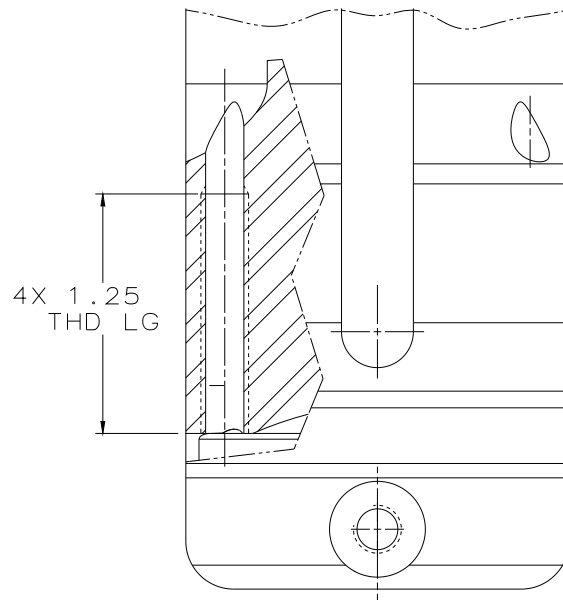
P&WC Proprietary Information. Subject to the restrictions on the first page.

Issued: Aug 26/2020
Revised: May 26/2022

PWC89843
Page 8 of 10

PRATT & WHITNEY CANADA
TOOL SERVICE BULLETIN

NO: PT-977R1



DUPLICATE VIEW

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

ICN-00198-G000039220-001-01

Figure 1 (Sheet 7 of 8)

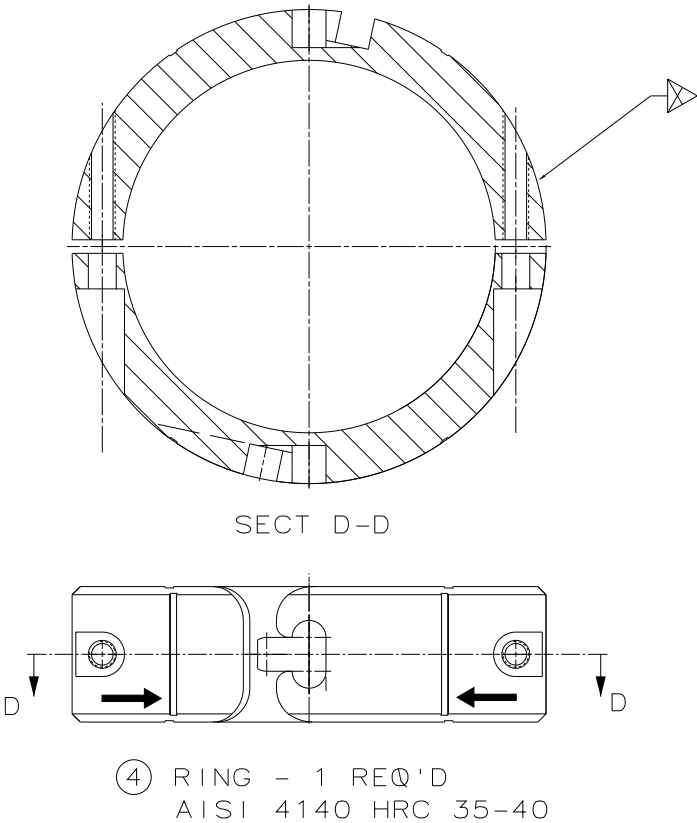
P&WC Proprietary Information. Subject to the restrictions on the first page.

Issued: Aug 26/2020
Revised: May 26/2022

PWC89843
Page 9 of 10

PRATT & WHITNEY CANADA TOOL SERVICE BULLETIN

NO: PT-977R1



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

ICN-00198-G000039221-001-01

Figure 1 (Sheet 8 of 8)

P&WC Proprietary Information. Subject to the restrictions on the first page.

Issued: Aug 26/2020
Revised: May 26/2022

PWC89843
Page 10 of 10