PRATT & WHITNEY CANADA

TOOL SERVICE BULLETIN

NO: PT-984

Service Tool: PWC50572 Rev. B

Description: Collector Assembly, Gearbox Static Pressure

Effectivity: PT6A-11, PT6B-37A, PT6C-67C, PT6C-67E

Subject: Tool Modification

Reason:

Problem: Port location is not clear.

Cause: No markings on tool for clarity.

Solution: Modify in accordance with revision B.

Instruction:

1. In detail No. 1A, mark on and arrow added and PB as per note 9 (Ref. Fig. 1 Sheet 3).

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2. In detail No. 1A, MAXP mark on added as per note 7 and PY as per note 9 (Ref. Fig. 1 Sheet 4).

3. Tool STI number is modified from STI-01 to STI-12 (Ref. Fig. 1 Sheet 2).

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

Tool Disposition: Tool PWC50572 can be reworked per the accomplished instructions or you can send tool to an accredited tool supplier for modifications.

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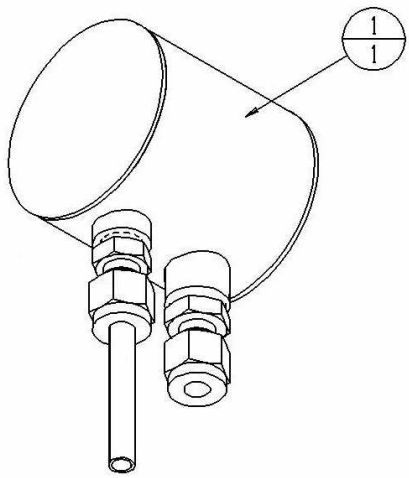

DO NOT SCALE DRAWING - DIMENSIONS ARE IN INCHES

UNLESS OTHERWISE SPECIFIED

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

PERMAMENTLY 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 RELEIVED PRIOR TO FINAL MACHINING

DRAWING INTERPRETATION ASME Y14.5M

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 INTERFERANCE, PER INCHE OF DIA.
P.F.(PRESS FIT)NO PLAY, WITH .001 TO .0025 INTERFERANCE, PER INCHE OF DIA.

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

DIMENSION TOLERANCES

.X = ±.030

.XX = ±.015

.XXX = ±.005

THIRD ANGLE PROJECTION

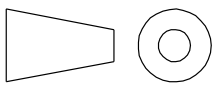

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Figure 1 (Sheet 1 of 4)

TOOL SERVICE BULLETIN

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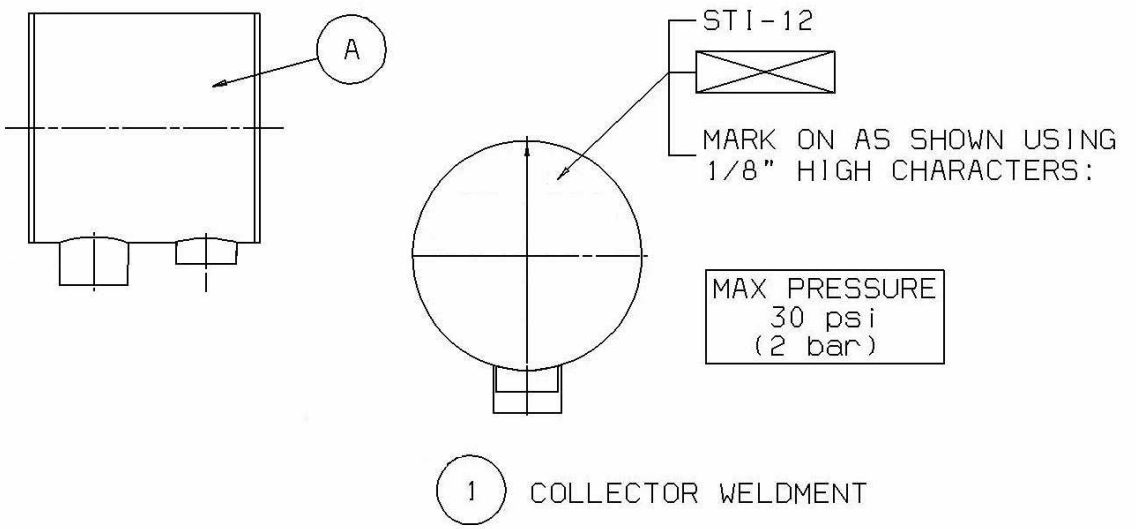

DET.	REQ'D	DESCRIPTION	MATERIAL
A	1	TUBE (.050-055" THK, 2"Ø ID)	AMS 5573 (AISI 316)

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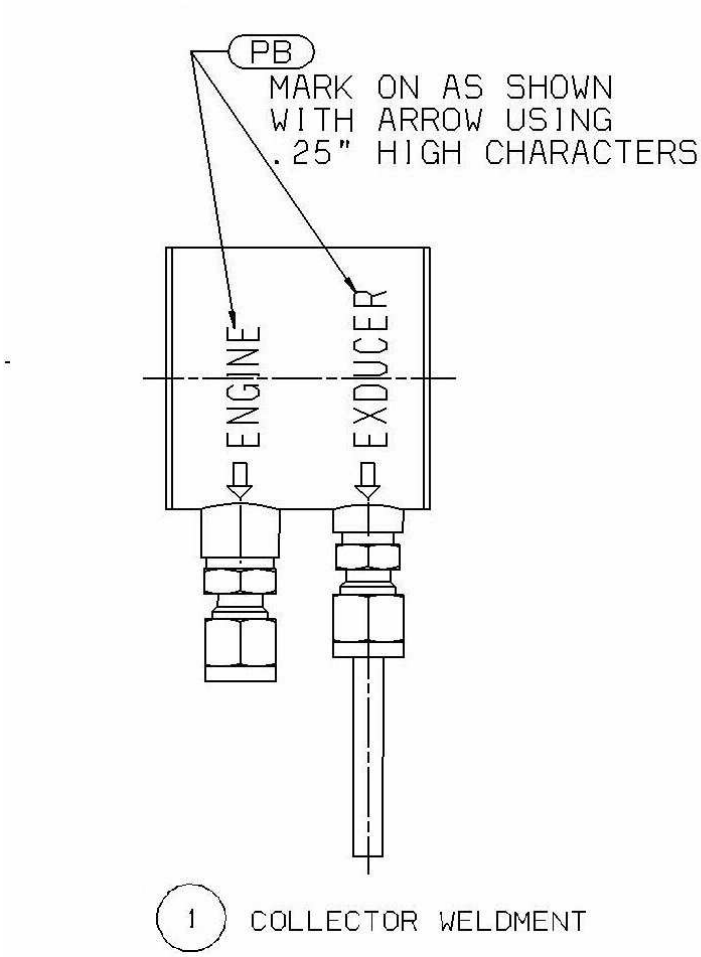
Figure 1 (Sheet 2 of 4)



NOTE:

9. PAINT PER FED SPEC TT-E-489J AND COLOR PER FED-STD-595C

(PY) YELLOW (13538)
(PB) BLACK (17038)

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Figure 1 (Sheet 3 of 4)

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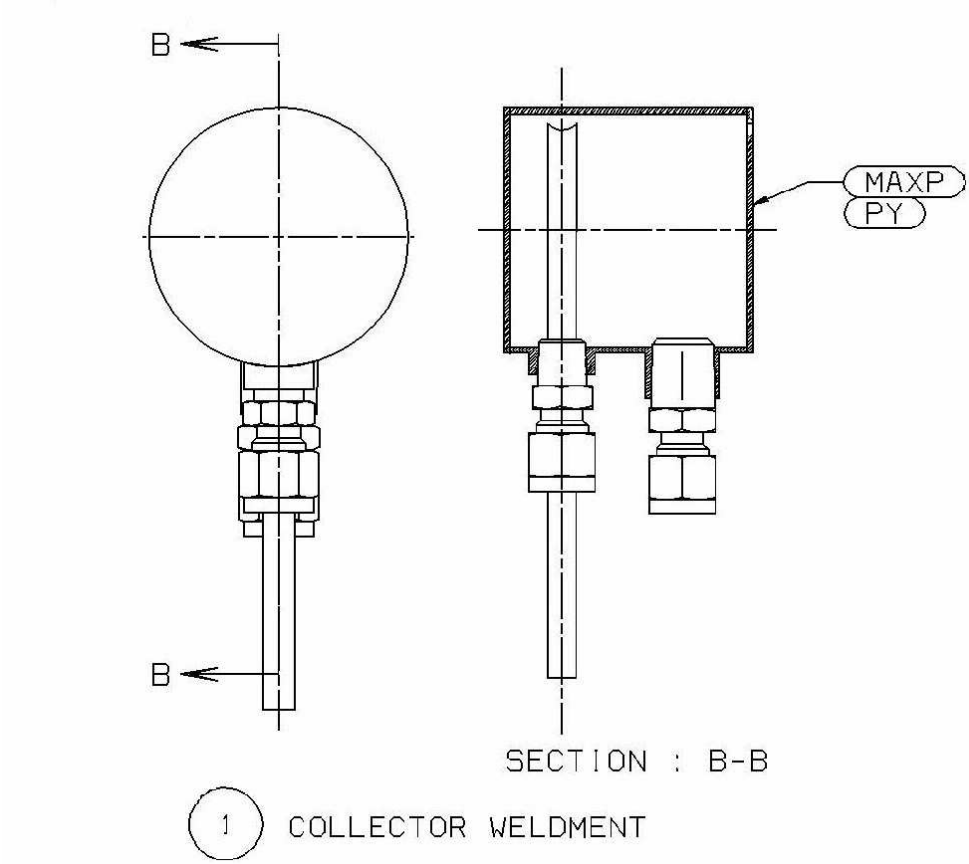

NOTES:

7. (MAXP) MARK ON: "MAX PRESSURE= 30 PSI (2 bar) ENGRAVE .12 HIGH CHARACTERS

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

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Figure 1 (Sheet 4 of 4)