

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.

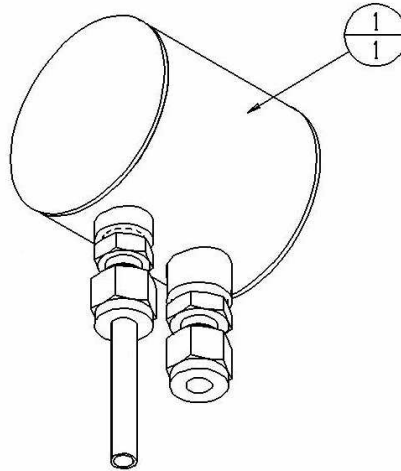
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DO NOT SCALE DRAWING - DIMENSIONS ARE IN INCHES															
UNLESS OTHERWISE SPECIFIED															
<p>BLACK OXIDE ALL STEEL DETAILS PER AMS 2485. ANODIZE ALL ALUMINUM DETAILS PER AMS2471 HARD ANODIZE PER AMS2468 COAT WITH RUST PREVENTIVE COMPOUND 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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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-G000043194-001-01

Figure 1 (Sheet 1 of 4)

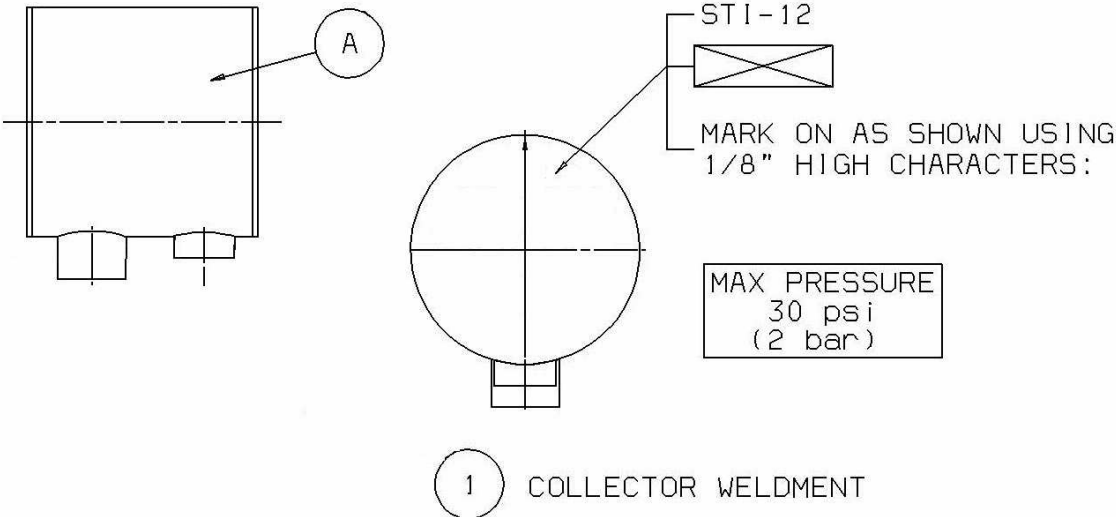
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DET.	REQ'D	DESCRIPTION	MATERIAL
A	1	TUBE (.050-.055" THK, 2"Ø ID)	AMS 5573 (AISI 316)

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Figure 1 (Sheet 2 of 4)

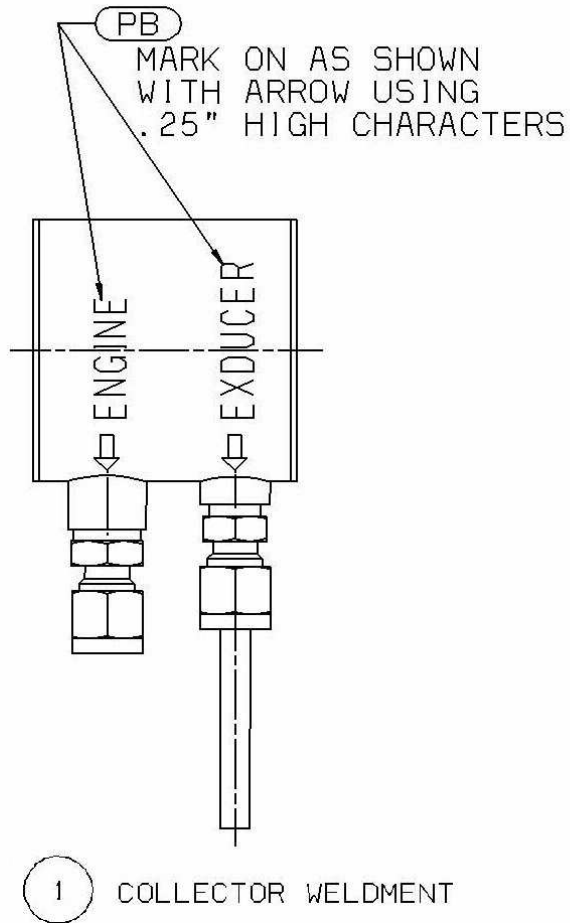
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NOTE:

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)

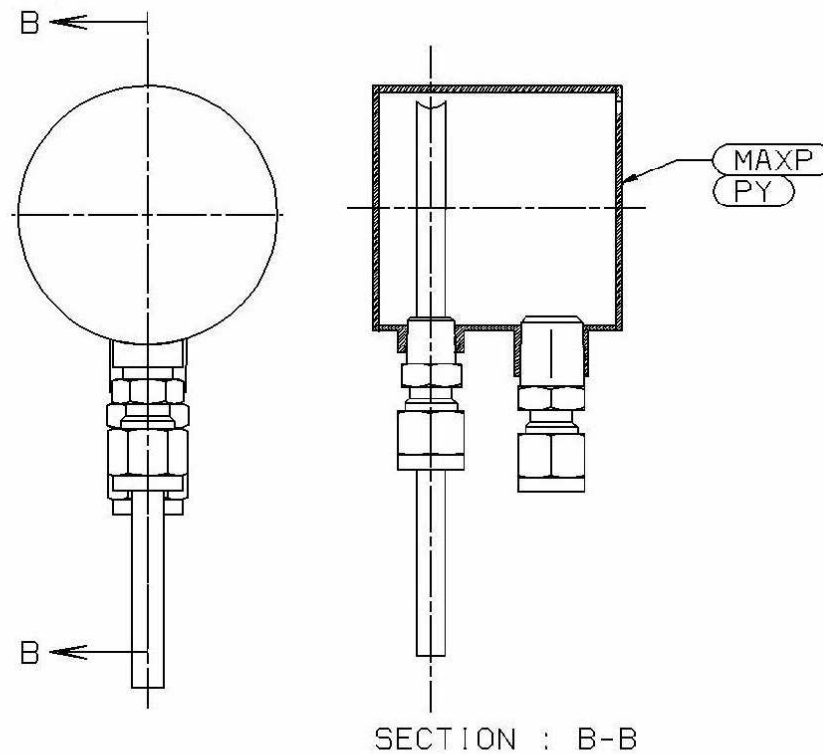
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1 COLLECTOR WELDMENT

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)

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