

PRATT & WHITNEY CANADA
TOOL SERVICE BULLETIN

NO: PT-986

Service Tool: PWC50692 Rev. A

Description: Clamp - First Stage Carrier

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

Subject: Tool Modification

Reason:

Problem: Potential FOD caused by detail No. 2 and No. 5.

Cause: Material used is very fragile.

Solution: Modify in accordance with revision A.

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- Instruction:**
1. Detail No. 2, material is modified to 8612K55 from McMaster-Carr (Ref. Fig. 1 Sheet 1).
 2. Detail No. 5, material is modified to 8612K55 from McMaster-Carr (Ref. Fig. 1 Sheet 1).
 3. Bond detail No. 2 to detail No. 1 using loctite 401 instead of black Max. (Ref. Fig. 1 Sheet 1).
 4. Bond detail No. 5 to detail No. 3 using loctite 401 instead of black Max. (Ref. Fig. 1 Sheet 1).

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

5. Use the vibration peening procedure and write change letter "A" 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.

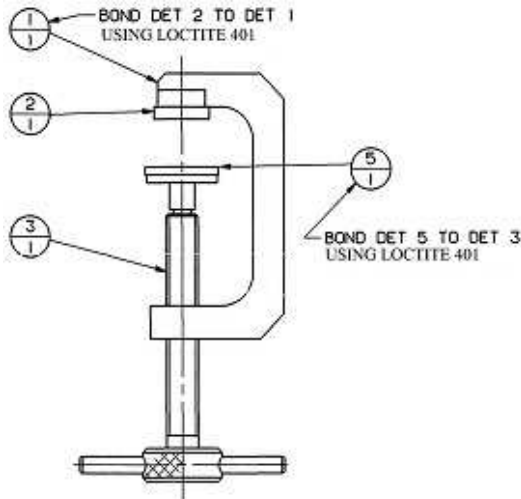
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DO NOT SCALE DRAWING - DIMENSIONS ARE IN INCHES															
UNLESS OTHERWISE SPECIFIED															
<p>BLACK OXIDE ALL STEEL DETAILS PER AMS 2485. ANODIZE ALL ALUMINUM DETAILS PER AMS2471 HARD ANODIZE PER AMS2468 COAT WITH RUST PREVENTIVE COMPOUND 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 style="width: 50%;">CONCENTRICITY WITHIN</td> <td style="width: 50%;">.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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MACHINE FINISHED SURFACE ROUGHNESS	125 AA														
<p>DIMENSION TOLERANCES</p> <p>.X = ± .030 .XX = ± .015 .XXX = ± .005</p>	<p>THIRD ANGLE PROJECTION</p>														

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Figure 1 (Sheet 1 of 2)

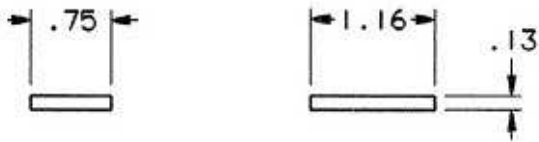
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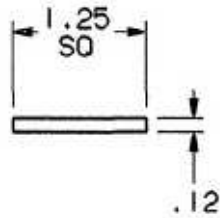
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② PAD - 1 REQ'D



⑤ PAD - 1 REQ'D

5	PAD	1	8612K55	3A054(MCMaster)
2	PAD	1	8612K55	3A054(MCMaster)
ITEM NO.	NOMENCLATURE OR DESCRIPTION	QTY REQ'D	PART NO. OR IDENTIFYING NO.	MATERIAL OR CAGE NUMBER

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Figure 1 (Sheet 2 of 2)

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