

PRATT & WHITNEY CANADA
TOOL SERVICE BULLETIN

NO: PT-989

Service Tool: PWC70014 Rev. F

Description: Puller - No. 5 Bearing

Effectivity: PT6A-45A, PT6A-45B, PT6A-45R, PT6A-60A, PT6A-60AG, PT6A-61, PT6A-65AG, PT6A-65AR, PT6A-65B, PT6A-65R, PT6A-65SC, PT6A-67, PT6A-67A, PT6A-67AF, PT6A-67AG, PT6A-67B, PT6A-67D, PT6A-67P, PT6A-67R, PT6A-67T, PT6E-67XP

Subject: Tool obsolete

Reason:

Problem: Tool can damage engine hardware.

Cause: Tool PWC70014 detail No. 10 legs can cause damage when overextended.

Solution: Obsolete, replaced by PWC77665.

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- Instruction:**
1. Tool PWC70014 can be modified to create PWC77665 .
 2. In detail No. 1, modify the diameter from 0.71 in. to 0.68 in. (Ref. Fig. 4).
 3. In detail No. 1, modify the radius from 0.03 in. to 0.06 in. (Ref. Fig. 4).
 4. In detail No. 1, angle 15° added (Ref. Fig. 4).

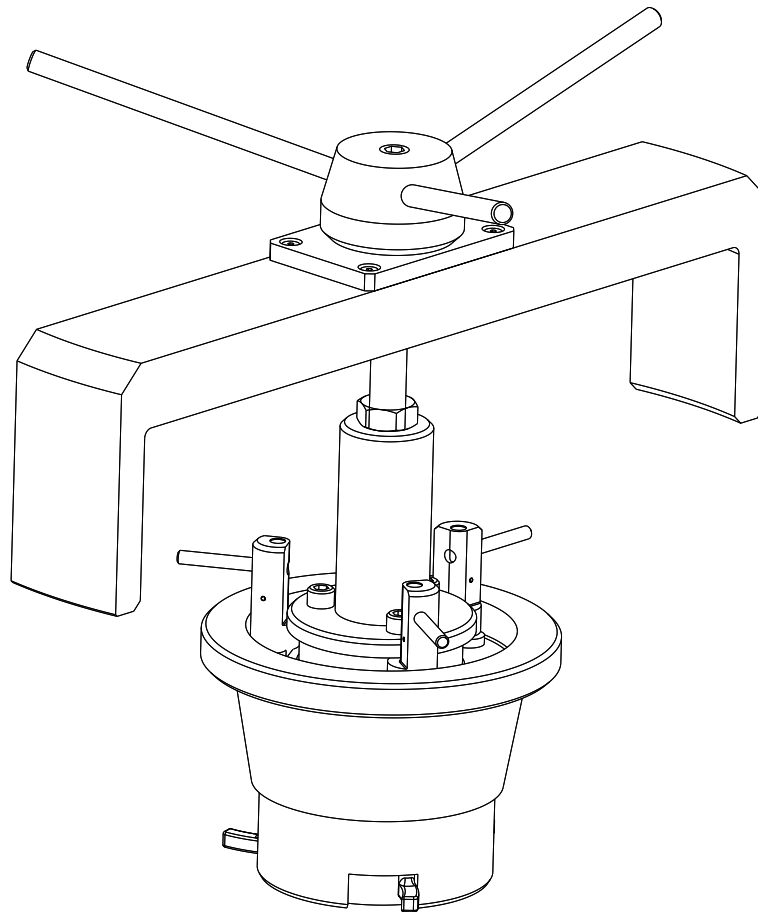
Compliance: Required

Tool Usage: Overhaul

Tool Disposition: Modify tool PWC70014 to create tool PWC77665. Tool PWC77665 can be obtained from an accredited tool supplier if required.

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1	3	LEG	AISI 4140 HRC 35-40	-	-
NO	QTY	PART	MATERIAL	STOCK NO	CAGE NUMBER

ICN-00198-G000098329-001-01

Figure 1

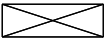

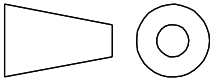
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DO NOT SCALE DRAWING - DIMENSIONS ARE IN INCHES															
UNLESS OTHERWISE SPECIFIED															
<p>BLACK OXIDE ALL STEEL DETAILS PER AMS 2485. ANODIZE ALL ALUMINUM DETAILS PER AMS2471 HARD ANODIZE PER AMS2468 COAT WITH RUST PREVENTIVE COMPOUND 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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<p>DIMENSION TOLERANCES</p> <p>.X = ± .030 .XX = ± .015 .XXX = ± .005</p>	<p>THIRD ANGLE PROJECTION</p> 														

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Figure 2

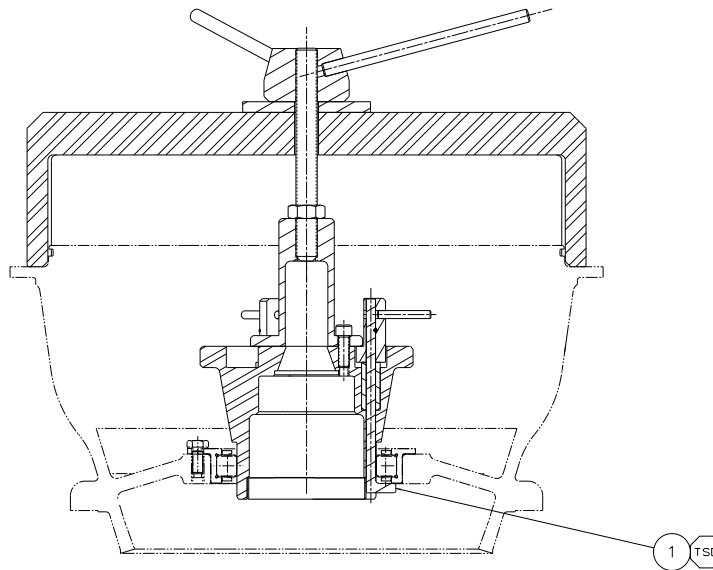
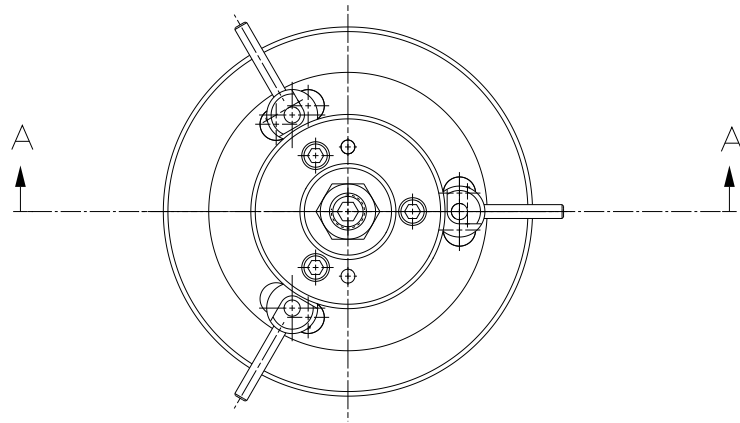
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SECT A-A

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Figure 3

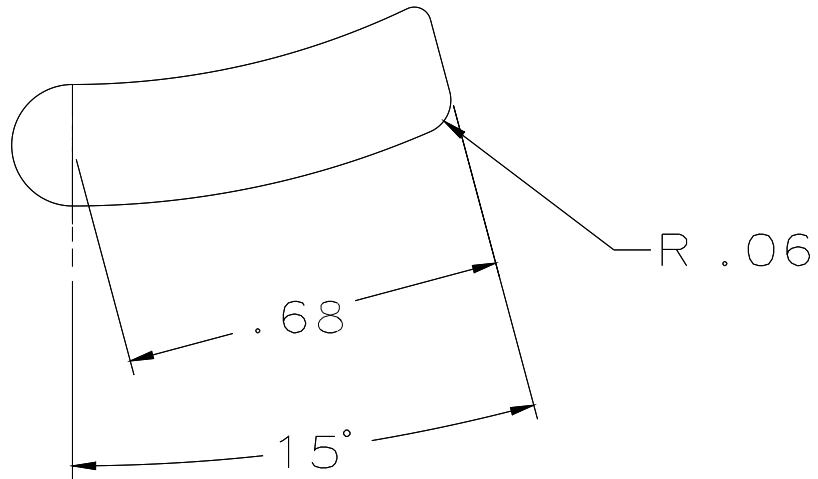
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LEG - 3 REQ'D
AISI 4140 HRC 35-40

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Figure 4

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