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S.I.L. NO.
GEN-020R8

SERVICE INFORMATION LETTER

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Subject: Vane Rings airflow rig correlation and calibration with P&WC

Applicability: P&WC approved Designated Overhaul Facilities and Repair Suppliers

NOTE: This revision is issued to update pricing information.

1.0 General

Pratt & Whitney Canada Corp. is pleased to offer airflow master calibration services to P&WC approved Designated Overhaul Facilities and Repair Suppliers. The calibration service ensures that an accurate airflow measurement system is used to repair vane rings with traceability for P&WC customers.

Vane rings are classified into airflow tables. Each airflow table needs to be established on an airflow rig using master parts that have been calibrated. This activity correlates the new rig values back to the P&WC Master Rig, providing equivalent test results. A minimum of 3 masters covering the entire range of EFA (effective flow area) are required for correlation of an airflow table. These 3 masters should be the property of the customers. One working master is used to confirm the operation of the rig before flow measurement. To obtain information related to the airflow tables, please refer technical questions to the contact person in Section 3.0.

Vane rings and vane segments with internal airfoil cooling passages are required to have those passages tested to ensure proper cooling air. A mass flow test is used. This test is typically performed after the airfoil has been adjusted (airfoil tweak) for EFA changes. Mass flow test masters can be used to ensure proper test values on a test machine.

2.0 Service Charges

Depending on the level of service required, you will find below the description and pricing related to each option:
2.0.1- Airflow EFA master calibration at P&WC or 2.0.2- Internal cooling mass flow masters calibration at P&WC.

This Service Information Letter is valid until superseded or cancelled by revision.

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QUEBEC, CANADA J4G 1A1
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2.0.1 Airflow masters

Airflow calibration (EFA) of masters at P&WC:

Per Table = \$5,322 US (Flat rate for up to 3 vane rings or vane segments)
\$1,775 US for each supplementary master

2.0.2 Mass flow masters

Mass flow calibration of internal air cooling passages on master parts at P&WC:

Per Part = \$1,775 US Flat rate per vane ring or vane segment, all mass flow conditions.

For scheduling purposes, typical turn time for calibration is 15 days from receipt.

Note that the prices above are subject to annual price escalation as required.

3.0 Contact

For more information, please refer to the contacts below:

Oku Okeke
Customer Service & Quality Manager
P&WC Component Repairs – Wichita Falls
1-940-761-9248
[Email: Oku.Okeke@prattwhitney.com](mailto:Oku.Okeke@prattwhitney.com)

Jason Williford
Airflow Engineer
P&WC Component Repairs – Wichita Falls
1-940-761-9213
[Email: Jason.Williford@prattwhitney.com](mailto:Jason.Williford@prattwhitney.com)

Respectfully,



Anthony Louis
Engineering Manager
P&WC Component Repairs - Wichita Falls
1-940-761-9253
[Email: Anthony.Louis@prattwhitney.com](mailto:Anthony.Louis@prattwhitney.com)

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