

SERVICE LETTER

**SUBJECT: PRATT & WHITNEY CANADA SERVICE BULLETIN NO: 14251R1 (02-12-96)
TURBOPROP ENGINE - BLEED OFF VALVE (BOV) COVER, INSPECTION AND/OR
REPLACEMENT.**

All Operators:

Date: 04 December 1996

The attention of all PC-12 operators is drawn to the subject Service Bulletin which explains that there have been occurrences of BOV malfunction. Any PC-12 that has an engine BOV which bears the Supplier's Code No. 8070, or have changed a BOV after January 1995, should pay special attention to the P&WC Service Bulletin No. 14251R1.

The P&WC Service Bulletin explains that BOV's which bear the Supplier's Code No. 8070, must be inspected and the BOV cover assembly replaced if any wear indications are found on the cotter pin; or any movement is found in the guide shaft pin.

Refer to the attached Appendixes:

APPENDIX A - Pratt & Whitney Canada - Service Information Letter No: PT6A-031.

APPENDIX B - Pratt & Whitney Canada - Service Bulletin No: 14251R1.

APPENDIX C - Pratt & Whitney Canada - Commercial Support Program Notification No: A 96036.

NOTE: Operators are also advised that any BOV's held in stock should also be inspected.

Any specific queries, concerning this subject, should be addressed in the first instance directly to the Vendor.

Should any difficulty be encountered, enquiries should be made to your Authorized PC-12 Service Center or to the following address:

PILATUS AIRCRAFT LTD.
CUSTOMER LIAISON MANAGER,
CH-6370 STANS,
SWITZERLAND.

Tel: + 41 41 619 6233
Fax: + 41 41 610 3351

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APPENDIX A

Pratt & Whitney Canada - Service Information Letter No: PT6A-031
(2 Pages)

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Pratt & Whitney Canada
A United Technologies Company

S.I.L. NO PT6A-031

SERVICE INFORMATION LETTER

Subject **SB1538/SB3344/SB4204/SB12134/SB13287/SB14251**
One Time Inspection of Compressor Bleed Valve

Applicability **ALL PT6A Engine Models**

There have been two recent in-flight occurrences of malfunction of compressor bleed valves in new PT6A-25C series engines resulting in engine power reduction.

Investigation of the two bleed valves revealed a broken cotter pin, the pieces of which interfered with movement of the bleed valve piston. The illustration on page two shows the location of the cotter pin. The cause of cotter pin breakage has been identified as stress loading from the piston guide rod, which was found to be installed improperly in the two cases mentioned above. The guide rod was found to be loose, a deviation from the engineering drawing requirements. See the page two illustration for detail.

Further investigation with the bleed valve supplier has identified that the two cases above were from a recent batch of bleed valves produced since January 1995, that are now suspected to have some loose guide rods. The bleed valves are common to all PT6A engine models.

P&WC will issue the above referenced Service Bulletins (November 1996) that recommend a one time inspection of all bleed valves installed on engines within a serial number range. All spare bleed valve assemblies should also be inspected. In addition to providing instructions for the inspection, the Service Bulletins will refer to Commercial Support Program Notification No. A96036 which will provide for labour allowance, free issue of consumables and a replacement bleed valve cover if required.

Yours truly,

PRATT & WHITNEY CANADA INC.

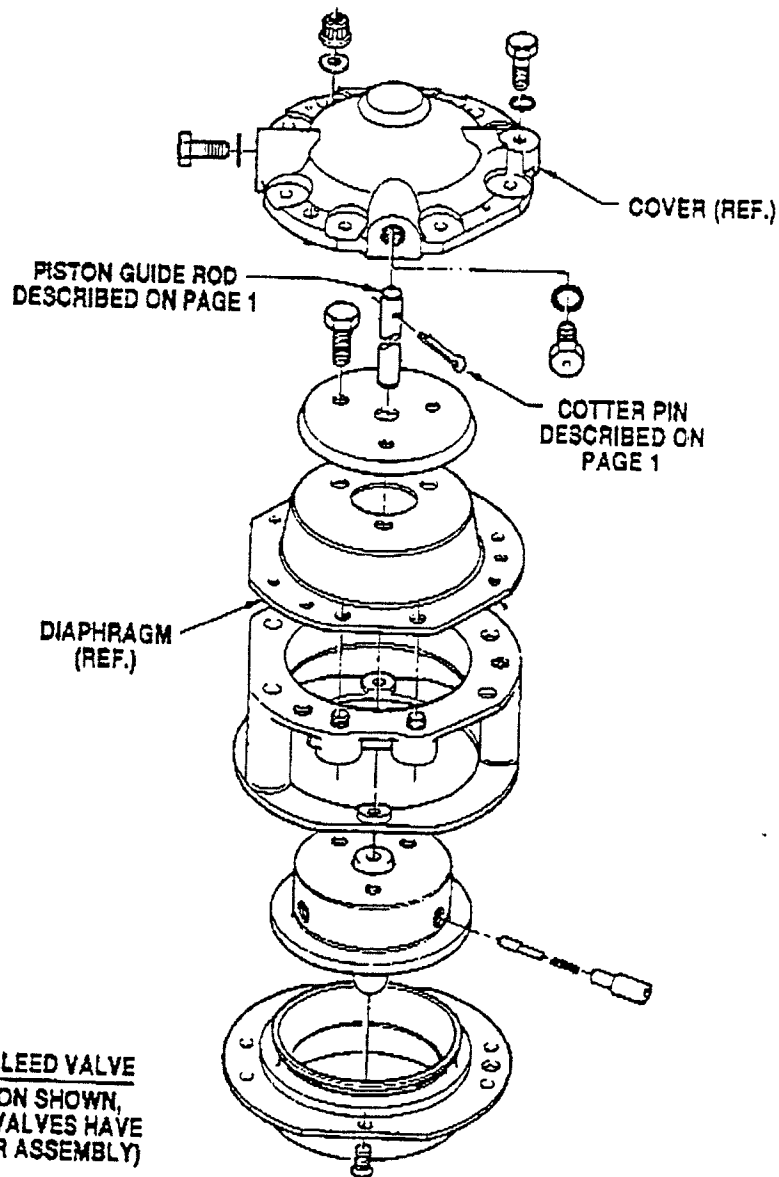
Vince Mastrocola,
Manager, PT6A Technical Support,
Programs & Reliability

This Service Information Letter is valid for one year from date of re-issue.

Issued: 27 Nov. 1996

1000, Marie-Victorin, Longueuil, Québec
Canada J4G 1A1

PRINTED IN CANADA



COMPRESSOR BLEED VALVE
(LATEST VERSION SHOWN,
EARLIER BLEED VALVES HAVE
THE SAME COVER ASSEMBLY)

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APPENDIX B

Pratt & Whitney Canada - Service Bulletin No: 14251R1 (Dec 02/96)
(11 Pages)

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PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 14251R1

BULLETIN INDEX LOCATOR
75-30-00

TURBOPROP ENGINE
BLEED OFF VALVE (BOV) COVER - INSPECTION/REPLACEMENT OF

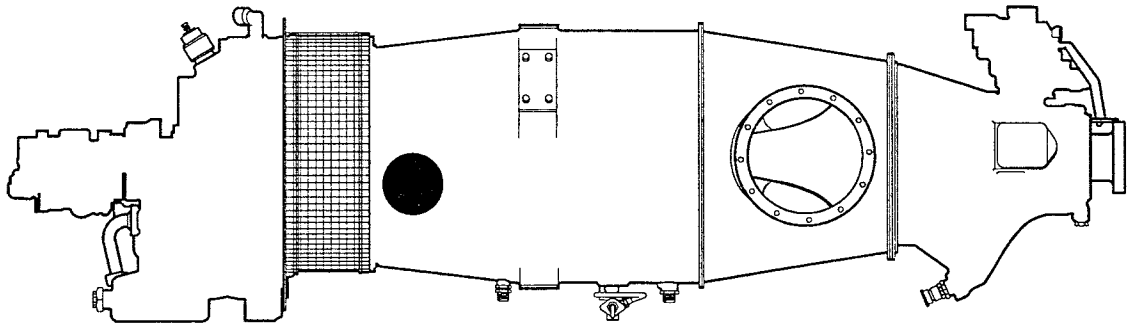
MODEL APPLICATION

PT6A-64, PT6A-66, PT6A-67, PT6A-67A, PT6A-67AF, PT6A-67AG, PT6A-67B, PT6A-67D and
PT6A-67R

Commercial Support Program No: A96036

Compliance: CATEGORY 3

Summary: There have been occurrences of BOV malfunction (Ref. Supplier's Code 8070). This service bulletin specifies an inspection or a replacement of the BOV cover assembly on affected engines. A Commercial Support Program Notification No. A96036, has been defined to assist in procuring this part.





Pratt & Whitney Canada Inc.

1000, Marie-Victorin
Longueuil, Québec
Canada J4G 1A1
Tél. 514/677-9411
Fax 514/647-3620

02 December 1996

P&WC S.B. No. 14251R1

REVISION TRANSMITTAL SHEET
TURBOPROP ENGINE MODEL PT6A

SUBJECT: Pratt & Whitney Canada Service Bulletin No. PT6A-72-14251, Rev. No. 1, dated Dec 02/96 (P&WC S.B. No. 14251R1) BLEED OFF VALVE (BOV) COVER - INSPECTION/REPLACEMENT OF

Replace your existing copy of this service bulletin with the attached revised bulletin. Destroy the superseded copy.

Please retain this Revision Transmittal Sheet with the revised bulletin.

SUMMARY: 1. Para. 1. A., Effectivity, revised to add models, PT6A-66, PT6A-67A
2. Para. 3., Accomplishment Instructions revised and resequenced.

EFFECT OF REVISION ON PRIOR ACCOMPLISHMENT: None.

NOTE: A black bar in the left margin indicates a change in that line of text or figure.

REVISION HISTORY:

Original Issue: Nov 28/96
Revision No. 1: Dec 02/96

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 14251R1

TURBOPROP ENGINE
BLEED OFF VALVE (BOV) COVER - INSPECTION/REPLACEMENT OF

1. Planning Information

A. Effectivity

PT6A-64 Engines which are between and include Serial No.PCE-111104 and PCE-111114
PT6A-64 Engines which are before and include Serial No. PCE-PM0005
PT6A-66 Engines, refer to Note 1.
PT6A-67 Engines Serial No. PCE-105191 and PCE-105192
PT6A-67A Engines, refer to Note 1.
PT6A-67B Engines which are between and include Serial No.PCE-110024 and PCE-110050
PT6A-67B Engines which are before and include Serial No. PCE-PR0027
PT6A-67D Engines which are between and include Serial No. PCE-114321 and PCE-114482
PT6A-67D Engines which are before and include Serial No. PCE-PS0112 but not including PCE-PS0096
PT6A-67R Engines which are between and include Serial No. 106217 and PCE-106224 and all engines converted to Engine Model PT6A-67R (Ref. P&WC engine conversion SB14221)
PT6A-67R Engines which are before and include Serial No. PCE-PY0002 and all engines converted to Engine Model PT6A-67R (Ref. P&WC engine conversion SB14221)
PT6A-67AF Engines Serial No. PCE-107025 and PCE-107026
PT6A-67AF Engine Serial No. PCE-PX0001
All PT6A-67AG Engines converted to Engine Model PT6A-67AG (Ref. P&WC engine conversion SB14192)

NOTE: 1. This service bulletin applies to all BOV's (Supplier's Code No. 8070) and to all installed BOV's on engines not identified in the above list, and including all spare BOV's with that code number. This code number is found on the compressor bleed valve cover assembly P/N 3118422-01.

NOTE: 2. The serial numbers of the affected BOV's are listed in Table 1. BOV's that have been reidentified to RE71 have been inspected and no further action is necessary.

NOTE: 3. If there is a conflict between engine serial numbers and the serial numbers of the affected BOV's the serial numbers of the BOV's take precedence.

B. Concurrent Requirements

None.

C. Reason

(1) Problem

Malfunction of BOV (Ref. Supplier's Code No. 8070).

P&WC No. R6071B

Nov 28/96
Revision No. 1: Dec 02/96

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PT6A-72-14251
Page 1 of 9

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 14251R1

TURBOPROP ENGINE
BLEED OFF VALVE (BOV) COVER - INSPECTION/REPLACEMENT OF

1. Planning Information (Cont'd)

(2) Cause

Possible movements of guide shaft pin can result in wear indications or fracture of the cotter pin.

(3) Solution

Perform an inspection on the cotter pin and check for any movement of BOV guide shaft pin. Replace the BOV cover assembly if any wear indications are found on the cotter pin or any movement of the guide shaft pin is apparent.

D. Description

For the BOV with the supplier's code No. 8070, inspect and or replace the BOV cover assembly if any wear indications are found on the cotter pin or any movement in the guide shaft pin is apparent.

NOTE: A Commercial Support Program Notification No. A96036, has been defined to assist in procuring this part.

E. Compliance

CATEGORY 3 - Do within the next 100 flight hours.

NOTE: Do all spare subassemblies.

F. Approval

D.O.T./D.A.A. approved.

G. Manpower

Once you have access to the part, an estimate of 1.0 man-hours is required to include this service bulletin at maintenance.

No more man-hours are necessary to include this service bulletin at overhaul.

H. Weight and Balance

None.

I. Electrical Load Data

Not changed.

J. Software Accomplishment Summary

Not applicable.

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 14251R1

TURBOPROP ENGINE
BLEED OFF VALVE (BOV) COVER - INSPECTION/REPLACEMENT OF

1. Planning Information (Cont'd)

K. References

Applicable PT6A Technical Manuals
Commercial Support Program Notification No. A96036
P&WC S.B. No. 14221 and 14192

L. Publications Affected

Applicable PT6A Technical Manuals

M. Interchangeability and Intermixability of Parts

Not changed.

2. Material Information

A. Material - Cost and Availability

You can get the procurable parts listed in Para. 2.C. from any Pratt & Whitney Canada Parts Distribution Center.

B. Industry Support Information

A Commercial Support Program Notification No. A96036, will be available to support these parts.

C. Material Necessary for Each Engine

The quantity of materials listed in this section is on a per engine basis.

<u>New P/N</u>	<u>Keyword</u>	<u>Old P/N</u>	<u>Qty</u>	<u>Est. Unit List Price (\$US,1996)</u>	<u>Instructions Disposition</u>
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Refer to Para. 3, Accomplishment Instructions for details of any parts and consumable materials required, depending on the results of the inspection.

D. Reidentified Parts

None.

E. Tooling - Price and Availability

Not applicable.

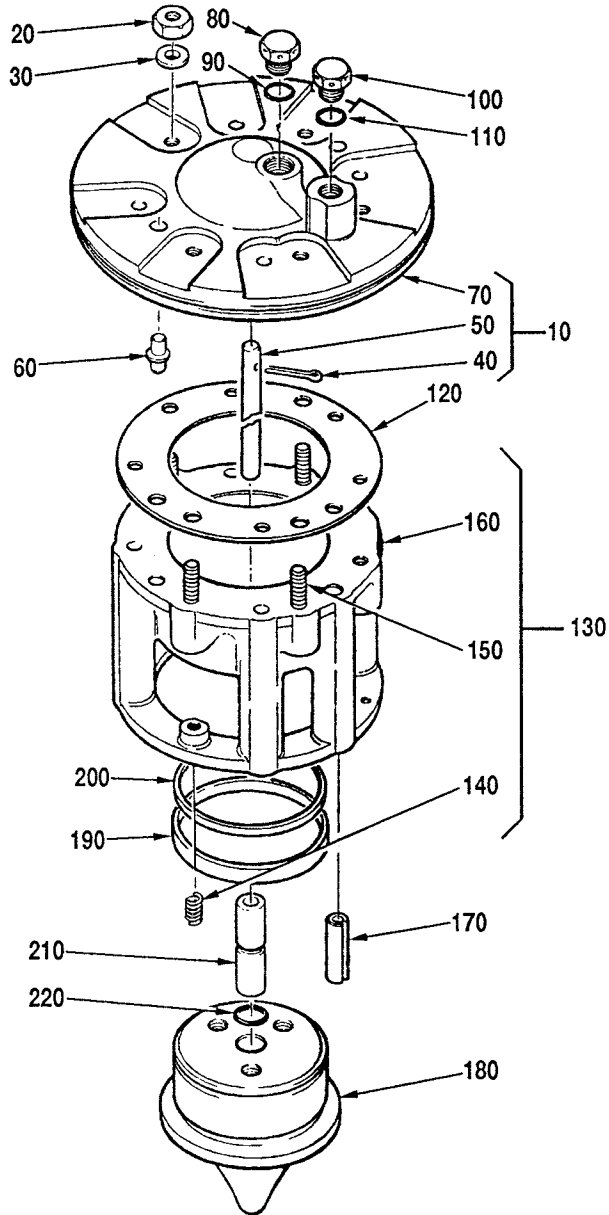
3. Accomplishment Instructions

A. Refer to the maintenance manual and to Figure 1, for removal and installation instructions:

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 14251R1

TURBOPROP ENGINE
BLEED OFF VALVE (BOV) COVER - INSPECTION/REPLACEMENT OF



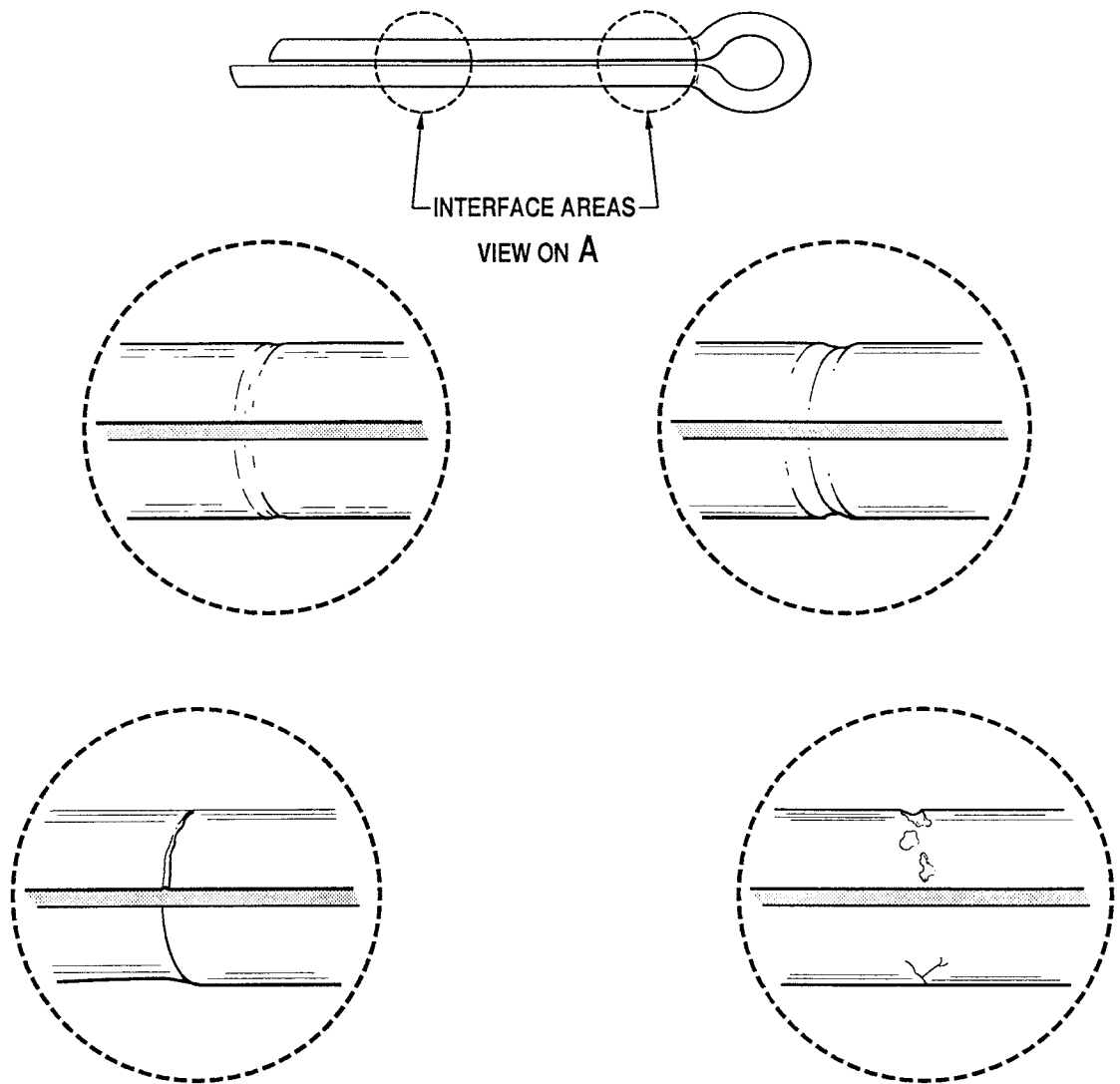
C36229

Compressor Bleed Valve Cover Inspection and Replacement Area
Figure 1 (Sheet 1 of 2)

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SERVICE BULLETIN

P&WC S.B. No. 14251R1

TURBOPROP ENGINE
BLEED OFF VALVE (BOV) COVER - INSPECTION/REPLACEMENT OF



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Compressor Bleed Valve Cover Inspection and Replacement Area
Figure 1 (Sheet 2)

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 14251R1

TURBOPROP ENGINE
BLEED OFF VALVE (BOV) COVER - INSPECTION/REPLACEMENT OF

3. Accomplishment Instructions (Cont'd)

(1) For BOV with Supplier's Code No. 8070.

TABLE 1, Affected BOV Serial Numbers

19A757	To	19A949
19A962	To	20A011
20A114	To	20A286
20A295	To	20A375
20A409	To	20A587
20A590	To	20A717
20A818	To	21A179
21A180	To	21A189
21A210	To	21A232
21A233	To	21A287
21A388	To	22A351
22A406	To	22A411
22A512	To	23A156
23A357	To	23A389
23A444	To	23A604
23A665	To	23A761
23A762	To	23A855
23A956	To	24A135
24A336	To	24A831

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 14251R1

TURBOPROP ENGINE
BLEED OFF VALVE (BOV) COVER - INSPECTION/REPLACEMENT OF

3. Accomplishment Instructions (Cont'd)

NOTE: 1. This supplier's code number is found in the area of the compressor bleed valve cover assembly P/N 3118422-01 (Ref. 10).

NOTE: 2. The serial numbers of the affected BOV's are listed in Table 1. BOV's that have been reidentified to RE71 have been inspected and no further action is necessary.

NOTE: 3. If you have identified a BOV in the above list please contact your local P&WC Field Support representative or the P&WC Help Desk at 1-800-268-8000 (North America) or 1-500-647-8000 (International).

NOTE: 4. If there is a conflict between engine serial numbers and the serial numbers of the affected BOV's the serial numbers of the BOV's take precedence.

(a) Remove compressor BOV from the engine.

NOTE: Handle the BOV with care to prevent the piston from falling out of the compressor bleed valve housing assembly (Ref. 130).

(b) Remove compressor bleed valve cover assembly by removing five nuts P/N 3012675 (Ref. 20), washers P/N MS9320-09 (Ref. 30).

(c) Separate compressor bleed valve cover assembly P/N 3118422-01 (Ref. 10) from compressor bleed valve housing assembly (Ref. 130).

(d) Remove and discard gasket (Ref.120).

(2) Perform an inspection on the compressor bleed valve cover assembly:

(a) Verify the integrity of the cotter pin P/N MS9245-30 (Ref. 40).

(b) Remove the cotter pin P/N MS9245-30 (Ref. 40).

(c) Inspect middle section of the cotter pin for marks, dents, grooves or any evidence of pitting, pinching or any wear (Ref. View A).

(d) Special attention should be placed on the interface areas between the guide shaft pin and the cover bore where the cotter pin may be subjected to shear stress as defined in Figure 1.

NOTE: Discard the cotter pin.

(e) Any defect found on the cotter pin is a true indication of movement of the guide shaft pin in the bore while valve is in operation.

NOTE: If this condition is found, a new compressor bleed valve cover assembly must be installed (Ref. Para. 3.A.3).

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 14251R1

TURBOPROP ENGINE
BLEED OFF VALVE (BOV) COVER - INSPECTION/REPLACEMENT OF

3. Accomplishment Instructions (Cont'd)

- (f) Firmly hold the valve cover assembly with one hand and using the other hand apply radial and axial force from guide shaft pin end, to check for movement of the shaft in the cover bore.

NOTE: If movement is found, a new compressor bleed valve cover assembly must be installed (Ref. Para. 3.A.3).

- (g) Install a new cotter pin P/N MS9245-30 (Ref. 40), and assemble compressor bleed valve cover assembly to bleed valve housing assembly (Ref. Para. 3.A.4).

(3) Installation of a new compressor bleed valve cover assembly.

- (a) Disassemble unserviceable compressor bleed valve cover assembly:

- 1 Remove plug (Ref. 80) from cover (Ref. 10) and discard preformed packing (Ref. 90).
- 2 Remove plug (Ref. 100) from cover (Ref. 10) and discard preformed packing (Ref. 110).

- (b) Assemble and install plugs on compressor bleed valve cover assembly:

- 1 Install new preformed packing (Ref. 110) on plug (Ref. 100) and install in cover (Ref. 10). Torque 15 to 20 lb.in. and lockwire.
- 2 Install new preformed packing (Ref. 90) on plug (Ref. 80) and install in cover (Ref. 10). Torque 35 to 40 lb.in. and lockwire.

(4) Assemble and install compressor bleed valve cover assembly on housing assembly:

- (a) Using a cleaning solvent and a soft cloth remove any residue of previous sealing compound or gasket material from BOV housing assembly. Extra care must be taken to prevent damage to the mating surface of the housing.
- (b) Lightly smear gasket face of housing with sealing compound (PWC09-003C) and install new gasket (Ref. 120).
- (c) Lightly smear mating face of cover (Ref. 10) with sealing compound (PWC09-003C) and position cover over studs on housing (Ref. 130) to allow shoulder pins (Ref. 40) to align. Make sure that the gasket is properly seated between the housing and cover.
- (d) Install five washers (Ref. 30) and nuts (Ref. 20) on the housing studs. Torque nuts 16 to 20 lb.in., plus torque required to turn nuts on studs.

PRATT & WHITNEY CANADA
SERVICE BULLETIN

P&WC S.B. No. 14251R1

TURBOPROP ENGINE
BLEED OFF VALVE (BOV) COVER - INSPECTION/REPLACEMENT OF

3. Accomplishment Instructions (Cont'd)

(5) Adjustment/Test

(a) Procedure:

- 1 There are no adjustments or test procedures pertaining to the compressor bleed valve. Refer to maintenance manual chapter 72-00-00, (Ref. Fault Isolation) if bleed valve malfunction is suspected.

- (6) Identify serviceable compressor bleed valve assembly with "RE71" adjacent to the part number using the vibropeen method of marking.

NOTE: If a new compressor bleed valve cover assembly is used, transfer all necessary identification part numbers (including serial and class number) from the old cover assembly to the new cover assembly.

- (7) Install serviceable compressor bleed valve assembly in accordance with the maintenance manual.

- (8) Write "P&WC S.B. No. 14251R1 incorporated" in the engine log book.

4. Appendix

Not applicable.

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APPENDIX C

Pratt & Whitney Canada - Commercial Support Program Notification No: A 96036
(5 Pages)

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COMMERCIAL SUPPORT PROGRAM NOTIFICATION

SPECIAL PROGRAM ALLOWANCE

PROGRAM NAME:

Inspection/Replacement of Bleed Off Valve (BOV) Cover

APPLICABILITY:

PT6A-10 engines refer to Notes 1 and 2 below.

PT6A-11 engines refer to Notes 1 and 2 below.

PT6A-11AG engines refer to Notes 1 and 2 below.

PT6A-15AG engines which are between and include serial number PCE-14262 and PCE-14286.

PT6A-15AG engines which are before and include serial number PCE-PD0020.

PT6A-21 engines which are between and include serial number PCE-25845 and PCE-25931.

PT6A-21 engines which are before and include serial number PCE-PE0051.

PT6A-25 engines refer to Notes 1 and 2 below.

PT6A-25A engines refer to Notes 1 and 2 below.

PT6A-25C engines which are between and include serial number PCE-26372 and PCE-26440.

PT6A-25C engines which are before and include serial number PCE-PF0029 but not including PCE-PF0013, PCE-PF0015, PCE-PF0017 and PCE-PF0028.

PT6A-27 engines which are between and include serial number PCE-42767 and PCE-42771 and all engines converted to engine model PT6A-27 (Ref. P&WC engine conversion SB1214).

PT6A-27 engines which are before and include serial number PCE-PG0008 and all engines converted to engine model PT6A-27 (Ref. P&WC engine conversion SB1214).

PT6A-28 engines refer to Notes 1 and 2 below.

PT6A-34 engines which are before and include serial number PCE-RB0004

PT6A-34AG engines which are between and include serial no. PCE-57494 and PCE-57528 and. all engines converted to engine model PT6A-34AG (Ref. P&WC engine conversion SB1252)

PT6A-34AG engines which are before and include serial number PCE-PH0036 but not including PCE-PH0033 and PCE-PH0035 and. all engines converted to engine model PT6A-34AG (Ref. P&WC engine conversion SB1252).

PT6A-34B engines refer to Notes 1 and 2 below.

PT6A-38 engines refer to Notes 1 and 2 below.

PT6A-40 engines refer to Notes 1 and 2 below.

PT6A-41 engine serial number PCE-85462 and all engines converted to engine model PT6A-41 (Ref. P&WC engine conversion SB3273).

PT6A-41 engine serial number PCE-RC0001 and all engines converted to engine model PT6A-41 (Ref. P&WC engine conversion SB3273).

PT6A-42 engines which are between and include serial no. PCE-94731 and PCE-94819.

PT6A-42 engines which are before and include serial number PCE-PJ0066 but not including PCE-PJ0063 and PCE-PJ0064

Date Issued: November 26, 1996

QUESTIONS OR CONCERNS MAY BE ADDRESSED TO THE:
MANAGER, CORPORATE WARRANTY &
MATERIAL CONTROL ADMINISTRATION
TEL. (514) 647-2803, FAX (514) 647-2831

IN THE EVENT OF A CONFLICT BETWEEN THE PROVISIONS
OF THIS DOCUMENT AND OTHER NOTIFICATIONS,
THIS NOTIFICATION SHALL PREVAIL.

APPLICABILITY: (continued)

- PT6A-45 engines refer to Notes 1 and 2 below.
- PT6A-45A engines refer to Notes 1 and 2 below.
- PT6A-45B engines refer to Notes 1 and 2 below.
- PT6A-45R engines refer to Notes 1 and 2 below.
- PT6A-50 engines refer to Notes 1 and 2 below.
- PT6A-60A engines which are between and include serial no. PCE-95797 and PCE-95828.
- PT6A-60A engines which are before and include serial number PCE-PK0038.
- PT6A-60AG engine serial number PCE-RG0001.
- PT6A-62 engines which are between and include serial no. PCE-103226 and PCE-103248.
- PT6A-62 engines which are before and include serial number PCE-PL00006.
- PT6A-64 engines which are between and include serial no. PCE-111104 and PCE-111114.
- PT6A-64 engines which are before and include serial number PCE-PM0005.
- PT6A-66 engines refer to Notes 1 and 2 below.
- PT6A-67 engine serial number PCE-105191 and PCE-105192.
- PT6A-67A engines refer to Notes 1 and 2 below.
- PT6A-67AF engines refer to Notes 1 and 2 below.
- PT6A-67AG engines refer to Notes 1 and 2 below.
- PT6A-67B engines which are between and include serial no. PCE-110024 and PCE-110050.
- PT6A-67B engines which are before and include serial number PCE-PR0027.
- PT6A-67D engines which are between and include serial no. PCE-114321 and PCE-114482.
- PT6A-67D engines which are before and include serial number PCE-PS0112 but not including PCE-PS0096.
- PT6A-67R engines which are between and include serial no. PCE-106217 and PCE-106224 and all engines converted to engine model PT6A-67R (Ref. P&WC engine conversion SB14221).
- PT6A-67R engines which are before and include serial number PCE-PY0002 and all engines converted to engine model PT6A-67R (Ref. P&WC engine conversion SB14221).
- PT6A-67AF engine serial number PCE-107025 and PCE-107026.
- PT6A-67AF engine serial number PCE-PX0001.
- PT6A-67AG engines converted to engine model PT6A-67AG (Ref. P&WC engine conversion SB14192).

APPLICABILITY: (continued)

PT6A-110 engines refer to Notes 1 and 2 below.

PT6A-112 engines which are between and include serial no. PCE-12663 and PCE-12672

PT6A-112 engines which are before and include serial number PCE-PA0005.

PT6A-114 engines which are between and include serial no. PCE-17489 and PCE-17497.

PT6A-114 engines which are between and include serial no. PCE-PB0498 and PCE-PB0509.

PT6A-114A engines which are between and include serial no. PCE-19307 and PCE-19423 and all engines converted to engine model PT6A-114A (Ref. P&WC engine conversion SB1453).

PT6A-114A engines which are between and include serial number PCE-PC-0424 and PCE-PC0481 and all engines converted to engine model PT6A-114A (Ref. P&WC engine conversion SB1453).

PT6A-135 engine serial number PCE-92772.

PT6A-135A engine serial number PCE-35102.

PT6A-135A engines which are before and include serial number PCE-PZ0003.

Note: 1 This program applies to all BOV (Supplier Code Number 8070) and to all installed BOV's on engines not identified in the above list, and including all spare BOV's with that supplier code number. This code number is found on the compressor bleed valve cover assembly.

Note: 2 The serial numbers of the affected BOV's are listed in Table 1 of Service Bulletins identified under "REFERENCE DOCUMENT". BOV's that have been reidentified to RE71 have been inspected and no further action is necessary.

PROGRAM DESCRIPTION:

It has been shown that possible movements of the guide shaft pin can result in wear indications or fracture of the cotter pin. This program is issued to offer some labour allowance and consumables at no charge. If the BOV cover fails inspection, this program will also offer a replacement bleed valve cover at no charge.

PROGRAM DURATION:

This program will start November 26, 1996 and terminate October 31, 1997.

REFERENCE DOCUMENT:

P&WC SB1538R2, SB3344, SB4204, SB12134, SB13287, SB14251

CLAIM INSTRUCTIONS:

To obtain the offered parts covered by this program, operators should submit a no-charge Purchase Order to their normal Parts Distribution Centers.

If the BOV was installed on an engine and has the Supplier code 8070 on the cover, submit an RSA/SATIN claim to obtain the offered labour allowance, ensuring the engine model, engine serial number, the removed BOV serial number, the installed BOV serial number and this program number (**A96036**) is included on all documentation.

If the BOV is off the shelf as a spare part and has the Supplier code 8070 on the cover, submit an RSA/SATIN claim to obtain the offered one (1) hour labour allowance for BOV dis-assembly, inspection and re-assembly only. Ensure BOV serial number, original Purchase Order number and this program number (**A96036**) is included on all documentation.

COVERAGE:

Labour Allowance:

A maximum of three (3) hours for Removal & Installation(R&I) and a maximum of one (1) hour for BOV dis-assembly, inspection and re-assembly is covered by this program. A maximum of six (6) hours for R&I is allowed for Cessna Caravan installations only.

For spare parts on the shelf, a maximum of one (1) hour for BOV dis-assembly, inspection and re-assembly is covered by this program.

Consumables:

A list of consumables offered free of charge is found under "PARTS AFFECTED"

Bleed Valve Covers: (BOV)

Bleed valve covers as listed under "PARTS AFFECTED" is offered free of charge if replacement is required. Replacement is only required if any wear indications are found on the cotter pin or any movement of the guide shaft pin is found during inspection as outlined in the applicable Service Bulletins listed under ":REFERENCE DOCUMENT".

REMOVED MATERIAL DISPOSITION:

Bleed Valve Covers that are deemed unserviceable after inspection are to be scrapped locally with a P&WC Field Service Representative's confirming signature on the RSA/SATIN claim.

PARTS AFFECTED:

For engines PT6A-10, 11, 11AG, 21, 25, 25A, 25C, 27, 28, 34, 34AG, 34B, 110, 114, 114A, 135, 135A Ref. in SB1538R2:

For engines PT6A-15AG, 112as referenced in SB12134:

<u>Part Number</u>	<u>Qty/BOV</u>	<u>Description</u>
MS9245-30	1	Cotter Pin
AS3209-009	1	Packing
AS3208-01	2	Packing
AS3208-02	1	Packing
3103347-01	1	Diaphragm
3105436-01	1	Bleed Valve Cover Assy - if removed cover is determined unserviceable after inspection

PARTS AFFECTED: (continued)

For engine PT6A-38, 40, 41, 42, 45, 45A, 45B, 45R for each BOV as referenced in SB3344:

<u>Part Number</u>	<u>Qty/BOV</u>	<u>Description</u>
MS9245-30	1	Cotter Pin
AS3209-010	1	Packing
AS3208-02	1	Packing
AS3208-01	1	Packing
3103346-01	1	Diaphragm
3027425	1	Bleed Valve Cover Assy - if removed cover is determined unserviceable after inspection

For engine PT6A-50, as referenced in SB4204:

<u>Part Number</u>	<u>Qty/BOV</u>	<u>Description</u>
MS9245-30	1	Cotter Pin
AS3209-010	1	Packing
AS3209-011	1	Packing
AS3208-01	1	Packing
AS3208-05	1	Packing
3102065-01	1	Diaphragm
3102070-02	1	Bleed Valve Cover Assy - if removed cover is determined unserviceable after inspection

For engine PT6A-60A, 60AG, 62 as referenced in SB13287:

<u>Part Number</u>	<u>Qty/BOV</u>	<u>Description</u>
MS9245-30	1	Cotter Pin
AS3209-010	1	Packing
AS3209-011	1	Packing
AS3208-01	1	Packing
AS3208-02	1	Packing
AS3208-05	1	Packing
3102065-01	1	Diaphragm
3102070-02	1	Bleed Valve Cover Assy - if removed cover is determined unserviceable after inspection

For engine PT6A-64, 67, 67AF, 67AG, 67B, 67D, 67R as referenced in SB14251:

<u>Part Number</u>	<u>Qty/BOV</u>	<u>Description</u>
MS9245-30	1	Cotter Pin
AS3209-010	1	Packing
AS3208-01	1	Packing
AS3208-02	1	Packing
3115928-02	1	Gasket
3118422-01	1	Bleed Valve Cover Assy - if removed cover is determined unserviceable after inspection

