

**SUBJECT: P&WC SERVICE BULLETIN (SB) No. 14498**

To all Customers, Operators and Service Centers:

Date: May 01/15

Effectivity: All PC-12 aircraft with a PT6A-67B or PT6A-67P engine.

This Service Letter is issued to draw attention to the following vendor information:

P&WC have issued a service bulletin to advise operators to review engine and overhaul records to identify if the correct weld repair procedure was performed.

Pilatus recommends that operators of PC-12 aircraft, read the P&WC SB No. 14498 (latest revision) and take the recommended action.

Operators who require further information on this subject should contact the address given below.

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**Attachments:**

- P&WC SERVICE BULLETIN (SB) No. 14498

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PRATT & WHITNEY CANADA  
**SERVICE BULLETIN**

P&WC S.B. No. 14498

**BULLETIN INDEX LOCATOR**  
**72-50-03**

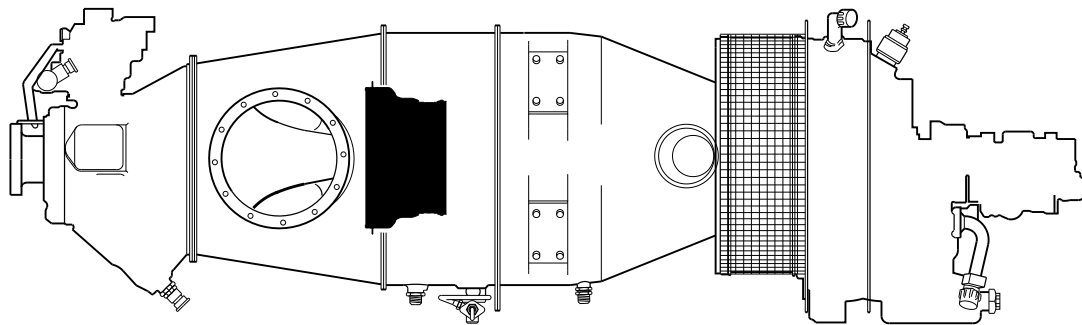
TURBOPROP ENGINE  
POWER TURBINE STATOR HOUSING - INSPECTION OF

MODEL APPLICATION

PT6A-64, PT6A-66, PT6A-66A, PT6A-66B, PT6A-66D, PT6A-67, PT6A-67A, PT6A-67AF,  
PT6A-67AG, PT6A-67B, PT6A-67D, PT6A-67F, PT6A-67P, PT6A-67R, PT6A-67T

Compliance: CATEGORY 3

Summary: Overhaul Manual (OHM) instructions for the power turbine stator housing repair specified incorrect post-weld heat treat criteria as of OHM revision dated Mar 24/2014. Parts repaired in accordance with this OHM version may have been improperly processed. The OHM criteria was subsequently revised in the OHM revision Nov 18/2014, to provide the correct heat treat requirements.



Mar 20/2015

**PT6A-72-14498**  
Cover Sheet

24-Hour Global Service

**CFIRST CENTRE**

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International ..... (IAC\*)+8000-268-8000

\* International Access Code

Other..... 1-450-647-8000

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	USML (ITAR)*	
	P-USML **	

PRATT & WHITNEY CANADA  
**SERVICE BULLETIN**

P&WC S.B. No. 14498

TURBOPROP ENGINE  
POWER TURBINE STATOR HOUSING - INSPECTION OF

1. Planning Information

A. Effectivity

PT6A-64, PT6A-66, PT6A-66A, PT6A-66B, PT6A-66D, PT6A-67, PT6A-67A, PT6A-67AF, PT6A-67AG, PT6A-67B, PT6A-67D, PT6A-67P, PT6A-67R, PT6A-67T and PT6A-67F Engines.

NOTE: Affected engines incorporate power turbine stator housings (P/N 3121524-01 or 3043706-01) weld repaired in accordance with OHM dated Mar 24/2014.

B. Concurrent Requirements

None.

C. Reason

(1) Problem

Overhaul Manual (OHM) instructions for power turbine stator housing repair specified incorrect post-weld heat treat cycle in revisions dated Mar 24/2014. The OHM was revised Nov 18/2014 to correct the error.

(2) Cause

OHM dated Mar 24/2014 specified heat treat SPOP 459-3 as opposed to the required SPOP 465-1 or SPOP 474-1.

(3) Solution

Review engine overhaul and repair records to identify if weld repair of the power turbine stator housing P/N 3121524-01 or 3043706-01 was performed to OHM dated Mar 24/2014. If the weld repair was performed with heat treat other than SPOP 465-1 or 474-1, then a hardness check inspection and possibly heat treat is required.

D. Description

Affected housings requires hardness check and possible heat treat.

E. Compliance

**Part A**

CATEGORY 3 - P&WC recommends to do this service bulletin within 100 flight-hours or 6 months (which ever comes first).

**Part B**

CATEGORY 3 - If weld repair was performed per Mar 24/2014 OHM instruction with SPOP 459-3, verify part material hardness within 5 calendar years of date of issue of this Service Bulletin.

PRATT & WHITNEY CANADA  
**SERVICE BULLETIN**

P&WC S.B. No. 14498

TURBOPROP ENGINE  
POWER TURBINE STATOR HOUSING - INSPECTION OF

1. Planning Information (Cont'd)

F. Approval

D.A.A. approved

G. Manpower

**For Hardness Check:**

Once you have access to the part, an estimate of 1 man-hours is required to include this service bulletin at maintenance.

NOTE: If heat treat is required, a 24 hour process including up to 2 man-hours is needed.

H. Weight and Balance

None.

I. Electrical Load Data

Not changed.

J. Software Accomplishment Summary

Not applicable.

K. References

Overhaul Manual P/N 3038322 (PT6A-64)  
Overhaul Manual P/N 3036123 (PT6A-66, PT6A-66B)  
Overhaul Manual P/N 3058083 (PT6A-66A)  
Overhaul Manual P/N 3070903 (PT6A-66D)  
Overhaul Manual P/N 3036133 (PT6A-67/67A/67AF/67AG/67R/67T)  
Overhaul Manual P/N 3038337 (PT6A-67B, PT6A-67D, PT6A-67P)  
Overhaul Manual P/N 3071153 (PT6A-67F)  
PWA Overhaul Standard Practices Manual P/N 585005

L. Publications Affected

None.

M. Interchangeability and Intermixability of Parts

Not applicable.

PRATT & WHITNEY CANADA  
**SERVICE BULLETIN**

P&WC S.B. No. 14498

TURBOPROP ENGINE  
POWER TURBINE STATOR HOUSING - INSPECTION OF

2. Material Information

A. Industry Support Information

Not applicable.

B. Material - Cost and Availability

Not applicable.

C. Material Necessary for Each

Not applicable.

D. Reidentified Parts

None.

E. Tooling - Price and Availability

Not applicable.

3. Accomplishment Instructions

A. **Part A:**

- (1) For power turbine stator housing P/N 3121524-01 or 3043706-01 weld repaired per OHM in a P&WC Service Center or P&WC DOF, no action is required and go to accomplishment instruction step C.
- (2) If weld repair was performed at another facility, per Mar 24/2014 OHM instruction with SPOP 459-3, comply with Part B.

B. **Part B:**

- (1) For power turbine stator housing P/N 3121524-01 or 3043706-01 weld repaired per OHM dated Mar 24/2014 in another facility (not P&WC Service Centers or P&WC DOFs), measure the hardness of the part at two (2) locations equally apart on the area shown. (Ref. Fig. 1).

- (a) If the measured hardness check is equal to or more than 36 Rockwell C do as follows:

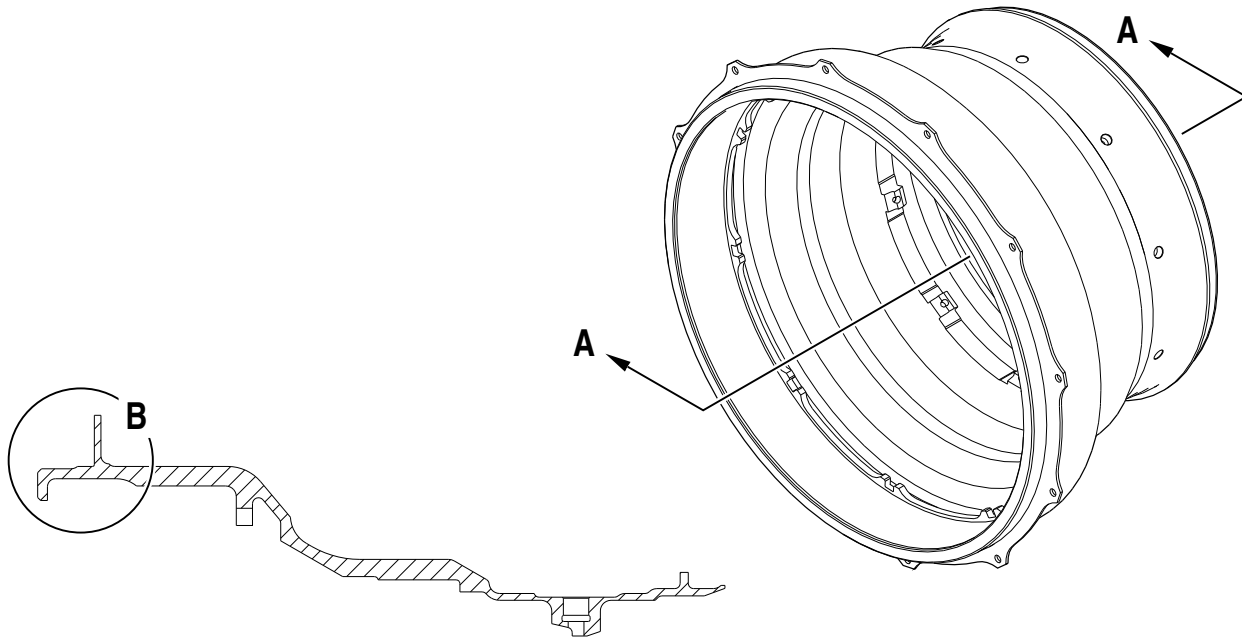
**WARNING:** USE EYE PROTECTION WHEN YOU WRITE WITH THE VIBRATION PEENING PROCEDURE.

- 1 Use the vibration peening procedure, 0.003 to 0.006 in. (0.08-0.15 mm) deep, and write SB 14498 after the part number.

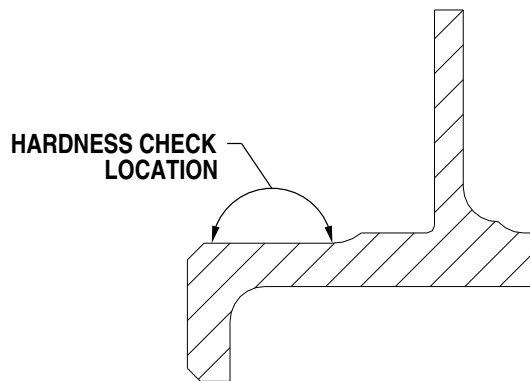
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TURBOPROP ENGINE  
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**SECTION A-A**



**DETAIL B**

**NOTE:**

**HARDNESS MUST BE 36 ROCKWELL C MINIMUM.  
DO NOT MEASURE THE HARDNESS ON THE ADJACENT RADIUS.**

C235365

Power Turbine Hardness Check Inspection.  
Figure 1



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**SERVICE BULLETIN**

P&WC S.B. No. 14498

TURBOPROP ENGINE  
POWER TURBINE STATOR HOUSING - INSPECTION OF

3. Accomplishment Instructions (Cont'd)

(b) If the measured hardness check is below 36 Rockwell C, do as follows:

- 1 Do a full heat treatment to the power turbine stator housing per SPOP 474-1.
- 2 Fluorescent penetrant inspect the power turbine stator housing per SPOP 62.
- 3 Dimensionally inspect the surface and position tolerances of the anti-rotation lugs and the sealing diameter for distortion in accordance with the applicable overhaul manual instructions (Ref. OHM 72-50-03 POWER TURBINE INTERSTAGE - REPAIR).

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

- 4 Use the vibration peening procedure, 0.003 to 0.006 in. (0.08-0.15 mm) deep, and write "RE 14498" to indicate heat-treat completed, after the part number.

C. Write accomplishment of P&WC S.B. No. 14498 in the engine module log book.

4. Appendix

Not applicable.