Pratt & Whitney
A United Technologies Company

SERVICE BULLETIN

ENGINE — DISK ASSEMBLY, DRUM ROTOR, HIGH PRESSURE COMPRESSOR (HPC) AND BLADE LOCKS, 14TH, AND 15TH STAGE — INTRODUCTION OF, TO IMPROVE DURABILITY

MODEL APPLICATION

PW4052, PW4052(-3), PW4056, PW4056(-3), PW4060, PW4060(-3), PW4062(-3), PW4062A(-3), PW4152, PW4152(-3), PW4156A, PW4156A(-3), PW4158, PW4158(-3), PW4460, PW4460(-3), PW4462, PW4462(-3)

BULLETIN ISSUE SEQUENCE

PW4000 Series 72-817

ATA NUMBER

72-35-00

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Compliance Category

8

P&W Distribution Code

2616, 2618, 2619

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Summary

The purpose of this Service Bulletin is to introduce a new High Pressure Compressor (HPC) rear drum rotor assembly and new 14th and 15th stage HPC blade locks. Cracks are found in the loading and locking slots of the HPC rear drum rotor assembly. The root cause of these cracks is Thermal Mechanical Fatigue (TMF). The new drum rotor assembly and the new seals introduced by Reference 28, Service Bulletin PW4ENG-72-816 will prevent the causes of TMF.

Planning Information

Effectivity Data

Engine Models Applicable

PW4052
Engine Serial Nos. P723701 thru P723706

PW4056
Engine Serial Nos. P724201 thru P724208

PW4056
Engine Serial Nos. P717501 thru P717700

PW4056
Engine Serial Nos. P724301 thru P724500

PW4056
Engine Serial Nos. P724502 thru P724504

PW4056
Engine Serial No. P724506

PW4056(-3)
Engine Serial Nos. P719991 thru P719996

PW4056
Engine Serial No. P724507

PW4060
Engine Serial Nos. P724101 thru P724200

PW4060
Engine Serial No. P724501

PW4060
Engine Serial No. P724505

PW4060
Engine Serial No. P724508

PW4060
Engine Serial No. P724509

PW4060, PW4060(-3), PW4062(-3)
Engine Serial Nos. P724601 thru P724751

PW4052(-3), PW4056, PW4056(-3), PW4060, PW4060(-3), PW4062(-3)
Engine Serial Nos. P727301 thru P728000

PW4052(-3), PW4056, PW4056(-3), PW4060, PW4060(-3), PW4062(-3), PW4062A(-3)
Engine Serial Nos. P729001 thru P729264*

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PW4152
Engine Serial Nos. P717701 thru P717800

PW4152, PW4152(-3)
Engine Serial Nos. P724901 thru P724944*

PW4156A, PW4156A(-3)
Engine Serial Nos. P724551 thru P724578*

PW4158
Engine Serial Nos. P717201 thru P717205

PW4158
Engine Serial Nos. P724001 thru P724100

PW4158, PW4158(-3)
Engine Serial Nos. P724801 thru P724900

PW4158, PW4158(-3)
Engine Serial Nos. P728501 thru P728600

PW4158, PW4158(-3)
Engine Serial Nos. P729800 thru P729867*

PW4460
Engine Serial Nos. P723801 thru P723969

PW4462, PW4462(-3)
Engine Serial Nos. P733701 thru P733721

PW4460(-3), PW4462(-3)
Engine Serial Nos. P733726 thru P733856*

* This estimate of engine serial numbers will be revised, if necessary, when parts are installed in engines at Pratt & Whitney.

NOTE: The engine serial number effectivity data and its related engine model identification contained in this Service Bulletin are taken from the records of part(s) incorporation during initial manufacture.

After initial engine manufacture, but before final delivery, P&W may change part(s) in the engine or change the model identification of the engine. Such action is recorded on FAA337 forms.

To find Service Bulletin PW4ENG 72-817 models that are applicable, the owner/operator of the engine must compare the Service Bulletin List supplied with the engine as sent from P&W and the List of Changes incorporated at the Airframer from FAA337 forms to the Service Bulletin PW4ENG 72-817 Effectivity section.

This Service Bulletin also applies to engines converted to Phase III (-3) configuration by Service Bulletin No. PW4ENG 72-490, No. PW4ENG 72-504, or No. PW4ENG 72-572.

This Service Bulletin (SB) also applies to engines identified with a suffix as follows:

(-3A) configuration introduced by SB No. PW4ENG 72-588.

(-3A) configuration introduced by SB No. PW4ENG 73-150.

(-3B) configuration introduced by SB No. PW4ENG 72-512.

(-1C) configuration introduced by SB No. PW4ENG 72-499 or No. PW4ENG 72-520.

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(-1E) configuration introduced by SB No. PW4ENG 72-521.

(-1C/-1E) configuration introduced by SB No. PW4ENG 72-516.

Concurrent Requirements

This Service Bulletin must be done at the same time or after Reference 28, Service Bulletin No. PW4ENG-72-816.

Reason

1. Problem: More than 200 HPC rear drum rotor assemblies from PW4000-94 and PW4000-100 engine models were reported to have cracks in the blade loading and locking slots.
2. Cause: The root cause is determined to be TMF. The TMF cracks are the result of thermal gradients and related high stresses in the rear of the HPC section. The high stresses are attributed to both the part geometry and shot peening. The loading and locking slot part geometry has structural features that when subjected to high thermal gradients, high stress zones are created. Shot peening adds a residual compressive stress which protects against low cycle fatigue conditions, however shot peening can be a detriment and initiate TMF.
3. Solution: Provide a new HPC rear drum rotor assembly. The new rear drum rotor assembly has a different loading and locking slot geometry and incorporates the new shot peen specification introduced in Reference 28, Service Bulletin PW4ENG-72-816. The new drum rotor assembly is less susceptible to subsequent TMF. Also, Reference 28, Service Bulletin PW4ENG-72-816 introduced new seals to reduce thermal gradients in the rear of the HPC section. New blade locks are necessary to fit the different loading and locking slot design.

Description

Replace the HPC rear drum rotor assembly, 13th, 14th and 15th stage blades and blade locks.

Compliance

Category 8

Do when the operator thinks that the change is necessary because of experience with the parts being replaced.

Approval Data

The part number changes and/or part changes specified in the Material Information section and Accomplishment Instructions of this Service Bulletin agree with the applicable Federal Aviation Regulations and are FAA-Approved for the engine model(s) given.

Manpower

No more man-hours are necessary when done at complete disassembly/assembly.

Weight Data

For PW4052, PW4056, PW4060, PW4152, PW4156A, PW4158, PW4460, PW4462 Engine Models
- 2.999 Pound(s) (- 1.36 kg).

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For PW4052, PW4056, PW4060, PW4152, PW4156A, PW4158, PW4460, And PW4462 Engine Models That Incorporate Reference 9, Service Bulletin No. PW4ENG 72-490, Reference 11, Service Bulletin No. PW4ENG 72-504, Or Reference 16, Service Bulletin No. PW4ENG 72-572
Option 1:- 2.999 Pound(s) (- 1.36 kg).
Option 2:+ 11.3 Pound(s) (+ 5.14 kg).

For PW4052(-3), PW4056(-3), PW4060(-3), PW4062(-3), PW4062A(-3), PW4152(-3), PW4156A(-3), PW4158(-3), PW4460(-3), PW4462(-3) Engines Models
No Change.

Electrical Load Data

Not Applicable.

Software Accomplishment Summary

Not Applicable.

References

1. Turbojet Engine Standard Practices Manual, Part No. 585005.
2. PW4052, PW4052(-3), PW4056, PW4056(-3), PW4060, PW4060(-3), PW4060C, PW4062(-3), PW4062A(-3) Turbofan Engines, Illustrated Parts Catalog, Part No. 50A607.
3. PW4152, PW4152(-3), PW4156A, PW4156A(-3), PW4158, PW4158(-3) Turbofan Engines, Illustrated Parts Catalog, Part No. 50A445.
4. PW4460, PW4460(-3), PW4462, PW4462(-3) Turbofan Engines, Illustrated Parts Catalog, Part No. 50A824.
5. PW4052, PW4052(-3), PW4056, PW4056(-3), PW4060, PW4060(-3), PW4060C, PW4060C(-3), PW4062, PW4062A(-3) Turbofan Engines, Engine Manual, Part No. 50A605.
6. PW4152, PW4152(-3), PW4156A, PW4156A(-3), PW4158, PW4158(-3) Turbofan Engines, Engine Manual, Part No. 50A443.
7. PW4460, PW4460(-3), PW4462, PW4462(-3) Turbofan Engines, Engine Manual, Part No. 50A822.
8. PW4000 Series 94 Inch And 100 Inch Turbofan Engines, Engine Cleaning, Inspection And Repair (CIR) Manual, Part No. 51A357.
9. Service Bulletin No. PW4ENG 72-490; Engine — Conversion Of A PW4460 Or PW4462 To A PW4460(-3) Or PW4462(-3). Issue Sequence 72-490, PW4000 Series.
10. Service Bulletin No. PW4ENG 72-499; Engine — Blade Set, First Stage LPC — Allow Installation Of The FB2C First Stage LPC Blade Sets In Non-Phase 3 Engines To Create The (-1C) Engine Configuration. Issue Sequence 72-499, PW4000 Series.
11. Service Bulletin No. PW4ENG 72-504; Engine — Conversion Of A PW4052, PW4056, PW4060, To A PW4052(-3), PW4056(-3), Or PW4060(-3). Issue Sequence 72-504, PW4000 Series.
12. Service Bulletin No. PW4ENG 72-512; Engine — Blade Set, First Stage LPC — Allow Installation Of The FB2B First Stage LPC Blade Sets In Phase 3 Engines To Create The (-3B) Engine Configuration. Issue Sequence 72-512, PW4000 Series.

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13. Service Bulletin No. PW4ENG 72-516; Engine — Blade Set, First Stage LPC — Allow Installation Of The FB2C First Stage LPC Blade Sets In Pre-Phase 3 Engines To Create The (-1C/-1E) Engine Configuration. Issue Sequence 72-516, PW4000 Series.
14. Service Bulletin No. PW4ENG 72-520; Engine — Blade Set, First Stage LPC — Allow The FB2C First Stage LPC Blade Sets In Non-Phase 3 Engines To Create The (-1C) Engine Configuration (Installation Of Phase 3 Blades In Pre-Phase 3 Engine/Nacelle). Issue Sequence 72-520, PW4000 Series.
15. Service Bulletin No. PW4ENG 72-521; Engine — Blade Set, First Stage LPC — Allow The FB2C First Stage LPC Blade Sets In Non-Phase 3 Engines To Create The (-1E) Engine Configuration (Installation Of Phase 3 Blades In Pre-Phase 3 Engine/ Phase 3 Nacelle). Issue Sequence 72-521, PW4000 Series.
16. Service Bulletin No. PW4ENG 72-572; Engine — Conversion Of A PW4152, PW4156A, PW4158 Engine To A PW4152(-3), PW4156A(-3), Or PW4158(-3) Engine. Issue Sequence 72-572, PW4000 Series.
17. Service Bulletin No. PW4ENG 72-588; Engine — Reidentification Of Engine Model Phase (-3) To (-3A) For Installation In A Pre-Phase (-3) Nacelle. Issue Sequence 72-588, PW4000 Series.
18. Service Bulletin No. PW4ENG 73-150; Engine Fuel And Control — Plug, EEC Programming — Installation Of To Create The (-3A) Engine Configuration. Issue Sequence 73-150, PW4000 Series.
19. Service Bulletin No. PW4ENG 72-446; Engine — Disk Assemblies, HPC Drum Rotor — Replacement Of, For Improved Clearances With Vane Platforms. Issue Sequence 72-446, PW4000 Series.
20. Service Bulletin No. PW4ENG 72-575; Engine — Blade, 13th, 14th And 15th Stage HPC — Replacement Of With Blades That Have Zirconium Oxide Tips To Improve Blade Durability. Issue Sequence 72-575, PW4000 Series.
21. Service Bulletin No. PW4ENG 72-599; Engine — Blade, 13th, 14th And 15th Stage HPC — Availability Of Replacement Blades That Have Thin Zirconium Oxide And Do Not Require Grinding. Issue Sequence 72-599, PW4000 Series.
22. Service Bulletin No. PW4ENG 72-682; Engine — Lock And Setscrew, HPC Blade — Replacement To Ease Removal At Overhaul. Issue Sequence 72-682, PW4000 Series.
23. Service Bulletin No. PW4ENG 72-750; Engine — Disk, High Pressure Compressor (HPC) Drum Rotor Disk Assembly — Replacement Of With A More Durable Rear Hub Scalloped Balance Flange Design. Issue Sequence 72-750, PW4000 Series.
24. Service Bulletin No. PW4ENG 72-755; Engine — Rotor & Stator Module, High Pressure Compressor (HPC) — Modification Of To Incorporate A Ring Case Configuration (RCC) Rear HPC; Boeing Configuration. Issue Sequence 72-755, PW4000 Series.
25. Service Bulletin No. PW4ENG 72-756; Engine — Rotor & Stator Module, High Pressure Compressor (HPC) — Modification Of To Incorporate A Ring Case Configuration (RCC) Rear HPC; Airbus Symmetric Front HPC Configurations. Issue Sequence 72-756, PW4000 Series.
26. Service Bulletin No. PW4ENG 72-757; Engine — Rotor & Stator Module, High Pressure Compressor (HPC) — Modification Of To Incorporate A Ring Case Configuration (RCC) Rear HPC; Mcdonnell Douglas Configuration. Issue Sequence 72-757, PW4000 Series.
27. Service Bulletin No. PW4ENG 72-759; Engine — Rotor & Stator Module, High Pressure Compressor (HPC) — Modification Of To Incorporate A Ring Case Configuration (RCC)

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Rear HPC; Airbus Asymmetric Front HPC Configurations. Issue Sequence 72-759, PW4000 Series.

28. Service Bulletin No. PW4ENG 72-816; Engine — Seal, 13th, 14th, And 15th Stage, High Pressure Compressor (HPC) — Replacement Of, And Introduction Of A New Shot Peen Specification, To Improve Rear Drum Rotor Durability. Issue Sequence 72-816, PW4000 Series.

    NOTE: References 19 thru 27 are shown to help find configurations in relation to this bulletin.

    NOTE: References 9 thru 18 are shown to help find non-production configurations that may incorporate this bulletin.

Publications Changed

PW4052, PW4052(-3), PW4056, PW4056(-3), PW4060, PW4060(-3), PW4060C, PW4062(-3), PW4062A(-3) Turbofan Engines, Illustrated Parts Catalog, Part No. 50A607.
72-35-00, Figures 1, 7, 8, 9, and 10

PW4152, PW4152(-3), PW4156A, PW4156A(-3), PW4158, PW4158(-3) Turbofan Engines, Illustrated Parts Catalog, Part No. 50A445.
72-35-00, Figures 1, 7, 8, 9, and 10

PW4460, PW4460(-3), PW4462, PW4462(-3) Turbofan Engines, Illustrated Parts Catalog, Part No. 50A824.
72-35-00, Figures 1, 7, 8, 9, and 10

PW4052, PW4052(-3), PW4056, PW4056(-3), PW4060, PW4060(-3), PW4060C, PW4060C(-3), PW4062(-3) Turbofan Engines, Engine Manual, Part No. 50A605.
05-10-01
72-35-01

PW4152, PW4152(-3), PW4156A, PW4156A(-3), PW4158, PW4158(-3) Turbofan Engines, Engine Manual, Part No. 50A443.
05-10-01
72-35-01

PW4460, PW4460(-3), PW4462, PW4462(-3) Turbofan Engines, Engine Manual, Part No. 50A822.
05-10-01
72-35-01

PW4000 Series 94 Inch And 100 Inch Turbofan Engines, Engine Cleaning, Inspection And Repair (CIR) Manual, Part No. 51A357.
72-35-00
72-35-10

Interchangeability

Old and new parts are interchangeable only in full sets.

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Information in the Appendix

Alternate Accomplishment Instructions (No)

Progression Charts (Yes)

Added Data (Yes)

Revision to Table of Limits (Yes)

Inspection Procedures (No)

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Material Information

Material — Cost and Availability

1. Part prices were not available at the time of Service Bulletin publication. Contact Pratt & Whitney Spares Management & Logistics for firm quotations.
2. There is no kit provided to do this Service Bulletin.
3. Part availability information is provided in material data Instructions — Disposition.

Industry Support Program

Not Applicable.

The material data that follows is for each engine.

NOTE: It is possible to use the Chapter/Section and Figure/Item reference number shown below the old part number to find the part in the Illustrated Parts Catalog.

Because there are many different configurations used, it is frequently necessary to show more than one group of parts. When this occurs, parts that are interchangeable are shown line-by-line only, unless this is shown differently.

CAUTION: THE FOLLOWING MATERIAL DATA TABLE(S) ARE ORGANIZED BY ILLUSTRATED PARTS CATALOG. ALL PARTS IN THE TABLE(S) MAY OR MAY NOT BE APPLICABLE TO ALL THE ENGINE MODELS SHOWN IN THE TABLE HEADING. YOU MUST REFER TO THE APPROPRIATE ILLUSTRATED PARTS CATALOG FOR ENGINE MODEL APPLICABILITY USING THE OLD PART NUMBER (PN) AND CATALOG SEQUENCE NUMBER. FAILURE TO INSTALL THE PART(S) IN THE CORRECT ENGINE MODEL MAY RESULT IN A CONFIGURATION THAT IS NOT FAA APPROVED.

The material data that follows is for each engine.

For PW4052, PW4056, PW4060, PW4060C Engines:

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
Configuration-1: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 58H597					
50S325	1		COMPRESSOR ROTOR ASSY — AXIAL	58H597 (72-35-00-1-90 Q)	(1)(NP)
50S425-01	1	*	.DISK — ASSY OF, DRUM ROTOR	53H923-01 (72-35-00-1-210 A)	(2)(A)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AE)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-10AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AD)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AC)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AC)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AF)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AG)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AD)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AD)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(1)(B)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AF)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AG)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AH)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
OR					
50S425-01	1	*	.DISK — ASSY OF, DRUM ROTOR	50H936 (72-35-00-1-210)	(2)(A)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AE)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-10AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AD)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AC)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AC)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AF)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AG)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AD)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AD)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AF)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AG)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AH)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)

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The material data that follows is for each engine.

For PW4052, PW4056, PW4060 Engines Converted To Phase (-3) Engines By Reference 11, Service Bulletin No. PW4ENG 72-504:

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
Configuration-1: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 57H678-004					
57H678-005	1		COMPRESSOR ROTOR ASSY — AXIAL	57H678-004 (72-35-00-1-90AH)	(1)(NP)
Replacement Of Drum Rotor Assembly With A Phase (-1) Drum And Modification Of The Drum Rotor Assembly To Convert To A Phase (-3) Drum					
50S425-001	1	*	.DISK — ASSY OF, DRUM ROTOR	53H923-001 (72-35-00-1-210AB)	(1)(M)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AE)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-10AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AD)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AC)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AC)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AF)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AG)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AD)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AD)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AF)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AG)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AH)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
OR					
50S425-001	1	*	.DISK — ASSY OF, DRUM ROTOR	50H936-002 (72-35-00-1-210AA)	(1)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AE)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-10AC)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AD)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AC)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AC)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AF)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AG)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AD)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AD)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AF)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AG)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AH)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
OR					
Replacement Of Drum Rotor Assembly With A Phase(-3) Drum					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	53H923-001 (72-35-00-1-210AB)	(2)(A)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8		.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8		.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AE)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-10AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AD)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AC)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AC)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AF)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AG)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AD)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AD)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AF)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AG)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AH)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
54H767	1	*	SHAFT — HPC DRIVE, TURB		(A)
54H792	1	*	.AIR SEAL	54H846 (72-35-00-1-250 C)	(2)(D)(C)
54H618	50	*	.BOLT	50H376 (72-35-00-1-260)	(2)(D)(C)
55H601	50	*	.CLIP		(2)(D)
50N112	50	*	.WASHER		(2)(D)
786376	50	*	.NUT OPTION	51H516 (72-35-00-1-270 A)	(2)(A)(C)(O1) (O2)
53H367	1	*	.HEAT SHIELD	50H100 (72-35-00-1-190)	(2)(D)(C)
AS3215-180	1	*	.RETAINING RING	AS3215-179 (72-35-00-1-200)	(2)(D)(C)
53H472	5	*	.COUNTER-WEIGHT		(D)
534494	5	*	.RIVET		(D)
	1		.COUNTER-WEIGHT	51H476 (72-35-00-9-50) (72-35-00-10-30)	(C)
51A358	1	*	NUT	50A722 (72-00-52-2-1 A)	(2)(D)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	50H936-002 (72-35-00-1-210AA)	(2)(A)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)

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50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AE)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-10AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AD)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)

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50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AC)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AC)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AF)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AG)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AD)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AD)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)

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50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AF)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AG)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AH)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
54H767	2	*	SHAFT — HPC DRIVE, TURB		(A)
54H792	1	*	.AIR SEAL	54H846 (72-35-00-1-250 C)	(2)(D)(C)
54H618	50	*	.BOLT	50H376 (72-35-00-1-260)	(2)(D)(C)
55H601	50	*	.CLIP		(D)
50N112	50	*	.WASHER		(D)
786376	50	*	.NUT OPTION	51H516 (72-35-00-1-270 A)	(2)(A)(C)(O1) (O2)
53H367	1	*	.HEAT SHIELD	50H100 (72-35-00-1-190)	(2)(D)(C)
AS3215-180	1	*	.RETAINING RING	AS3215-179 (72-35-00-1-200)	(2)(D)(C)
53H472	1	*	.COUNTER-WEIGHT		(D)
534494	1	*	.RIVET		(D)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	1		.COUNTER-WEIGHT	51H476 (72-35-00-9-50) (72-35-00-10-30)	(C)
51A358	1	*	NUT	50A722 (72-35-00-2-1 A)	(2)(D)(C)

The material data that follows is for each engine.

For PW4052 (-3), PW4056 (-3), PW4060 (-3), PW4062 (-3), PW4062A (-3) Engines:

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
Configuration-1: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 58H575					
50S225	1		COMPRESSOR ROTOR ASSY — AXIAL	58H575 (72-35-00-1-90 P)	(1)(NP)
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	56H013-001 (72-35-00-1-210AE)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	58H236-01 (72-35-00-1-210 E)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	54H803-002 (72-35-00-1-210AF)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
Configuration-2: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 56H378-002					
56H378-003	1		COMPRESSOR ROTOR ASSY — AXIAL	56H378-002 (72-35-00-1-90AF)	(1)(NP)
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	56H013-001 (72-35-00-1-210AE)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	58H236-01 (72-35-00-1-210 E)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	54H803-002 (72-35-00-1-210AF)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
Configuration-3: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 57H478-002					
57H478-003	1		COMPRESSOR ROTOR ASSY — AXIAL	57H478-002 (72-35-00-1-90AG)	(1)(NP)
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	56H013-001 (72-35-00-1-210AE)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	58H236-01 (72-35-00-1-210 E)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	54H803-002 (72-35-00-1-210AF)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)

The material data that follows is for each engine.

For PW4152, PW4156A, PW4158 Engines:

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
Configuration-1: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 58H597					
50S325	1		COMPRESSOR ROTOR ASSY — AXIAL	58H597 (72-35-00-1-90 Q)	(1)(NP)
50S425-01	1	*	.DISK — ASSY OF, DRUM ROTOR	53H923-01 (72-35-00-1-210 A)	(2)(A)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AF)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-20AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AE)	(A2)(M)(N)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AC)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AC)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AF)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AG)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AD)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AD)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AF)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AG)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AH)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
OR					
50S425-01	1	*	.DISK — ASSY OF, DRUM ROTOR	50H936 (72-35-00-1-210)	(2)(A)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AF)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-20AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AE)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AC)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AC)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AF)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AG)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AD)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AD)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AF)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AG)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AH)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)

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The material data that follows is for each engine.

For PW4152, PW4156A, PW4158 Engines Converted To Phase (-3) Models By Reference 16, Service Bulletin No. PW4ENG 72-572:

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
Configuration-1: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 57H678-004					
57H678-005	1		COMPRESSOR ROTOR ASSY — AXIAL	57H678-004 (72-35-00-1-90AH)	(1)(NP)
Replacement Of Drum Rotor Assembly With A Phase(-1) Drum And Modification Of The Drum Rotor Assembly To Convert To A Phase(-3) Drum					
50S425-001	1	*	.DISK — ASSY OF, DRUM ROTOR	53H923-001 (72-35-00-1-210AB)	(1)(M)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AF)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-20AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AE)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AC)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AC)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AF)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AG)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AD)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AD)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AF)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AG)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AH)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
			OR		
50S425-001	1	*	.DISK — ASSY OF, DRUM ROTOR	50H936-002 (72-35-00-1-210AA)	(1)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AF)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-20AC)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AE)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AC)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AC)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AF)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AG)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AD)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AD)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AF)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AG)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AH)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
OR					
Replacement Of Drum Rotor Assembly With A Phase(-3) Drum					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	53H923-001 (72-35-00-1-210AB)	(2)(A)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8		.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8		.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AF)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-20AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AE)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AC)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AC)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AF)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AG)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AD)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AD)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AF)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AG)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AH)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
54H767	1	*	SHAFT — HPC DRIVE, TURB		(A)
54H792	1	*	.AIR SEAL	54H846 (72-35-00-1-250 C)	(2)(D)(C)
54H618	50	*	.BOLT	50H376 (72-35-00-1-260)	(2)(D)(C)
55H601	50	*	.CLIP		(2)(D)
50N112	50	*	.WASHER		(2)(D)
786376	50	*	.NUT OPTION	51H516 (72-35-00-1-270 A)	(2)(A)(C)(O1) (O2)
53H367	1	*	.HEAT SHIELD	50H100 (72-35-00-1-190)	(2)(D)(C)
AS3215-180	1	*	.RETAINING RING	AS3215-179 (72-35-00-1-200)	(2)(D)(C)
53H472	5	*	.COUNTER-WEIGHT		(D)
534494	5	*	.RIVET		(D)
	1		.COUNTER-WEIGHT	51H476 (72-35-00-9-50) (72-35-00-10-30)	(C)
51A358	1	*	NUT	50A722 (72-00-52-2-1 A)	(2)(D)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	50H936-002 (72-35-00-1-210AA)	(2)(A)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AF)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-20AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AE)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AE)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AC)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AC)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AF)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AG)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AD)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AD)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AF)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AG)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AH)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
54H767	2	*	SHAFT — HPC DRIVE, TURB		(2)(A)
54H792	1	*	.AIR SEAL	54H846 (72-35-00-1-250 C)	(2)(D)(C)
54H618	50	*	.BOLT	50H376 (72-35-00-1-260)	(2)(D)(C)
55H601	50	*	.CLIP		(D)
50N112	50	*	.WASHER		(D)
786376	50	*	.NUT OPTION	51H516 (72-35-00-1-270 A)	(2)(A)(C)(O1) (O2)
53H367	1	*	.HEAT SHIELD	50H100 (72-35-00-1-190)	(2)(D)(C)
AS3215-180	1	*	.RETAINING RING	AS3215-179 (72-35-00-1-200)	(2)(D)(C)
53H472	1	*	.COUNTER-WEIGHT		(D)
534494	1	*	.RIVET		(D)

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	1		.COUNTER-WEIGHT	51H476 (72-35-00-9-50) (72-35-00-10-30)	(C)
51A358	1	*	NUT	50A722 (72-35-00-2-1 A)	(2)(D)(C)

The material data that follows is for each engine.

For PW4152(-3), PW4156A(-3), PW4158(-3) Engines:

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
Configuration-1: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 58H575					
50S225	1		COMPRESSOR ROTOR ASSY — AXIAL	58H575 (72-35-00-1-90 P)	(1)(NP)
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	56H013-001 (72-35-00-1-210AD)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	58H236-01 (72-35-00-1-210 E)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	54H803-002 (72-35-00-1-210AE)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
Configuration-2: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 56H378-002					
56H378-003	1		COMPRESSOR ROTOR ASSY — AXIAL	56H378-002 (72-35-00-1-90AF)	(1)(NP)
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	56H013-001 (72-35-00-1-210AD)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	58H236-01 (72-35-00-1-210 E)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	54H803-002 (72-35-00-1-210AE)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
Configuration-3: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 57H478-002					
57H478-003	1		COMPRESSOR ROTOR ASSY — AXIAL	57H478-002 (72-35-00-1-90AG)	(1)(NP)
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	56H013-001 (72-35-00-1-210AD)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	58H236-01 (72-35-00-1-210 E)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	54H803-002 (72-35-00-1-210AE)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)

The material data that follows is for each engine.

For PW4460, PW4462 Engines:

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
Configuration-1: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 58H597					
50S325	1		COMPRESSOR ROTOR ASSY — AXIAL	58H597 (72-35-00-1-90 Q)	(1)(NP)
50S425-01	1	*	.DISK — ASSY OF, DRUM ROTOR	53H923-01 (72-35-00-1-210 A)	(2)(A)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AC)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-20AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AE)	(A2)(M)(N)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AG)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AG)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AD)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AD)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AH)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AJ)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AE)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AE)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AG)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AH)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
	8		.BLADE — HPC, 15STG	56H515-02	(C2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AJ)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
			OR		
50S425-01	1	*	.DISK — ASSY OF, DRUM ROTOR	50H936 (72-35-00-1-210)	(2)(A)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AC)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-20AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AE)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AG)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AG)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AD)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AD)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AH)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AJ)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AE)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AE)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AG)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AH)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
	8		.BLADE — HPC, 15STG	56H515-02	(C2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AJ)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)

The material data that follows is for each engine.

For PW4460, PW4462 Engines Converted To Phase (-3) Engines By Reference 9, Service Bulletin No. PW4ENG 72-490:

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
Configuration-1: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 57H678-004					
57H678-005	1		COMPRESSOR ROTOR ASSY — AXIAL	57H678-004 (72-35-00-1-90AH)	(1)(NP)
Replacement Of Drum Rotor Assembly With A Phase(-1) Drum And Modification Of The Drum Rotor Assembly To Convert To A Phase(-3) Drum					
50S425-001	1	*	.DISK — ASSY OF, DRUM ROTOR	53H923-001 (72-35-00-1-210AB)	(1)(M)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AC)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-20AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AE)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AG)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AG)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AD)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AD)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AH)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AJ)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AE)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AE)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AG)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AH)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
	8		.BLADE — HPC, 15STG	56H515-02	(C2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AJ)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
			OR		
50S425-001	1	*	.DISK — ASSY OF, DRUM ROTOR	50H936-002 (72-35-00-1-210AA)	(1)(M)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AC)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-20AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AE)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AG)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AG)	(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AD)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AD)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AH)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AJ)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AE)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AE)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AG)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AH)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
	8		.BLADE — HPC, 15STG	56H515-02	(C2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AJ)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
OR					
Replacement Of Drum Rotor Assembly With A Phase(-3) Drum					

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	53H923-001 (72-35-00-1-210AB)	(2)(A)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8		.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8		.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AC)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-20AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AE)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AG)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AG)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AD)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AD)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AH)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AJ)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AE)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AE)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AG)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AH)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
	8		.BLADE — HPC, 15STG	56H515-02	(C2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AJ)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
54H767	1	*	SHAFT — HPC DRIVE, TURB		(A)
54H792	1	*	.AIR SEAL	54H846 (72-35-00-1-250 C)	(2)(D)(C)
54H618	50	*	.BOLT	50H376 (72-35-00-1-260)	(2)(D)(C)
55H601	50	*	.CLIP		(D)
50N112	50	*	.WASHER		(D)
786376	50	*	.NUT OPTION	51H516 (72-35-00-1-270 A)	(2)(A)(C)(O1) (O2)
53H367	1	*	.HEAT SHIELD	50H100 (72-35-00-1-190)	(2)(D)(C)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
AS3215-180	1	*	.RETAINING RING	AS3215-179 (72-35-00-1-200)	(2)(D)(C)
53H472	5	*	.COUNTER-WEIGHT		(D)
534494	5	*	.RIVET		(D)
	1		.COUNTER-WEIGHT	51H476 (72-35-00-9-50) (72-35-00-10-30)	(C)
51A358	1	*	NUT	50A722 (72-00-52-2-1 A)	(2)(D)(C)
			OR		
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	50H936-002 (72-35-00-1-210AA)	(2)(A)(N)
56H326	4	*	.LOCK ASSY — HPC, 13STG	56H318 (72-35-00-7-60 D)	(2)(A)(C)
	4		.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 C)	(C)
50S154	8	*	.LOCK ASSY — HPC, 14STG		(A)
	4		.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 C)	(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG		(A)
13th Stage Blades					
50S113-01	70	*	.BLADE — HPC, 13STG	54H613-401	(1)(B)(N)
			OR		
50S113-04	70	*	.BLADE — HPC, 13STG	54H613-401	(2)(B)(N)
50S113-02	4	*	.BLADE — HPC, 13STG	54H613-402	(1)(B)(N)
50S113-03	4	*	.BLADE — HPC, 13STG	54H613-403	(1)(B)(N)
50S113-05	AR	*	.BLADE — HPC, 13STG	54H613-405	(1)(F)(N)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
56H313-01	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
			OR		
56H313-04	70	*	.BLADE — HPC, 13STG	54H613-101 (72-35-00-7-10AB)	(A2)(M)(N)
56H313-02	4	*	.BLADE — HPC, 13STG	54H613-102 (72-35-00-7-40AB)	(A2)(M)(N)
56H313-03	4	*	.BLADE — HPC, 13STG	54H613-103 (72-35-00-7-30AB)	(A2)(M)(N)
56H313-05	AR	*	.BLADE — HPC, 13STG	54H613-105 (72-35-00-7-10AC)	(A2)(M)(N)
13th Stage Pre-ground Blades					
56H413-01	7	*	.BLADE — HPC, 13STG	54H613-111 (72-35-00-7-20AC)	(A2)(M)(N)
56H413-02	4	*	.BLADE — HPC, 13STG	54H613-112 (72-35-00-7-40AC)	(A2)(M)(N)
56H413-03	4	*	.BLADE — HPC, 13STG	54H613-113 (72-35-00-7-30AC)	(A2)(M)(N)
56H413-05	7	*	.BLADE — HPC, 13STG	54H613-115 (72-35-00-7-10AE)	(A2)(M)(N)
			OR		
51S013-01	7	*	.BLADE — HPC, 13STG	54H613-501	(1)(F)(N)
51S013-02	4	*	.BLADE — HPC, 13STG	54H613-502	(1)(F)(N)
51S013-03	4	*	.BLADE — HPC, 13STG	54H613-503	(1)(F)(N)
51S013-05	7	*	.BLADE — HPC, 13STG	54H613-505	(1)(F)(N)
14th Stage Blades					
	8		.BLADE — HPC, 14STG	50S114-01	(C)
	8		.BLADE — HPC, 14STG	50S114-04	(C)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
			OR		
	8		.BLADE — HPC, 14STG	56H414-01 (72-35-00-8-10 H)	(C2)
	8		.BLADE — HPC, 14STG	56H414-04 (72-35-00-8-15)	(C2)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-01	60	*	.BLADE — HPC, 14STG		(B)
			OR		
	68		.BLADE — HPC, 14STG	53H314-401	(N)
50S114-04	60	*	.BLADE — HPC, 14STG		(B)
50S114-02	4	*	.BLADE — HPC, 14STG	53H314-402	(B)(M)(N)
50S114-02	4	*	.BLADE — HPC, 14STG		(B)
50S114-03	4	*	.BLADE — HPC, 14STG	53H314-403	(B)(M)(N)
50S114-03	4	*	.BLADE — HPC, 14STG		(B)
50S114-05	AR	*	.BLADE — HPC, 14STG	53H314-405	(1)(F)(N)
			OR		
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AG)	(N)
56H414-01	60	*	.BLADE — HPC, 14STG		(A2)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	68		.BLADE — HPC, 14STG	53H314-101 (72-35-00-8-10AG)	(N)
56H414-04	60	*	.BLADE — HPC, 14STG		(A2)
56H414-02	4	*	.BLADE — HPC, 14STG	53H314-102 (72-35-00-8-30AD)	(A2)(M)(N)
56H414-02	4	*	.BLADE — HPC, 14STG		(A2)
56H414-03	4	*	.BLADE — HPC, 14STG	53H314-103 (72-35-00-8-40AD)	(A2)(M)(N)
56H414-03	4	*	.BLADE — HPC, 14STG		(A2)
56H414-05	AR	*	.BLADE — HPC, 14STG	53H314-105 (72-35-00-8-10AH)	(A2)(M)(N)
14th Stage Pre-ground Blades					
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
			OR		
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
			OR		
56H614-01	7	*	.BLADE — HPC, 14STG	53H314-111 (72-35-00-8-10AJ)	(A2)(M)(N)
56H614-02	4	*	.BLADE — HPC, 14STG	53H314-112 (72-35-00-8-30AE)	(A2)(M)(N)
56H614-02	3	*	.BLADE — HPC, 14STG		(A2)
56H614-03	4	*	.BLADE — HPC, 14STG	53H314-113 (72-35-00-8-40AE)	(A2)(M)(N)
56H614-03	3	*	.BLADE — HPC, 14STG		(A2)
56H614-05	7	*	.BLADE — HPC, 14STG	53H314-115 (72-35-00-8-10AH)	(A2)(M)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
			OR		
51S014-01	7	*	.BLADE — HPC, 14STG	53H314-501	(1)(F)(N)
51S014-02	4	*	.BLADE — HPC, 14STG	53H314-502	(1)(F)(N)
51S014-02	3	*	.BLADE — HPC, 14STG		(F)
51S014-03	4	*	.BLADE — HPC, 14STG	53H314-503	(1)(F)(N)
51S014-03	3	*	.BLADE — HPC, 14STG		(F)
51S014-05	7	*	.BLADE — HPC, 14STG	53H314-505	(1)(F)(N)
15th Stage Blades					
	8		.BLADE — HPC, 15STG	50S415-01	(C)
	8		.BLADE — HPC, 15STG	50S415-04	(C)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
			OR		
	8		.BLADE — HPC, 15STG	56H415-01 (72-35-00-9-10 J)	(C2)
	8		.BLADE — HPC, 15STG	56H415-04 (72-35-00-9-15)	(C2)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-01	54	*	.BLADE — HPC, 15STG		(B)
			OR		

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
	62		.BLADE — HPC, 15STG	52H415-401	(N)
50S415-04	54	*	.BLADE — HPC, 15STG		(B)
50S415-02	4	*	.BLADE — HPC, 15STG	52H415-402	(B)(M)(N)
50S415-02	4	*	.BLADE — HPC, 15STG		(B)
50S415-03	4	*	.BLADE — HPC, 15STG	52H415-403	(B)(M)(N)
50S415-03	4	*	.BLADE — HPC, 15STG		(B)
50S415-05	AR	*	.BLADE — HPC, 15STG	52H415-405	(1)(F)(N)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-01	54	*	.BLADE — HPC, 15STG		(A2)
			OR		
	62		.BLADE — HPC, 15STG	52H415-101 (72-35-00-9-10AE)	(N)
56H415-04	54	*	.BLADE — HPC, 15STG		(A2)
56H415-02	4	*	.BLADE — HPC, 15STG	52H415-102 (72-35-00-9-40AC)	(A2)(M)(N)
56H415-02	4	*	.BLADE — HPC, 15STG		(A2)
56H415-03	4	*	.BLADE — HPC, 15STG	52H415-103 (72-35-00-9-30AC)	(A2)(M)(N)
56H415-03	4	*	.BLADE — HPC, 15STG		(A2)
56H415-05	AR	*	.BLADE — HPC, 15STG	52H415-105 (72-35-00-9-10AG)	(A2)(M)(N)
15th Stage Pre-ground Blades					
51S015-02	3	*	.BLADE — HPC, 15STG		(F)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
			OR		
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
			OR		
56H515-01	7	*	.BLADE — HPC, 15STG	52H415-111 (72-35-00-9-10AH)	(A2)(M)(N)
56H515-02	4	*	.BLADE — HPC, 15STG	52H415-112 (72-35-00-9-40AD)	(A2)(M)(N)
56H515-02	3	*	.BLADE — HPC, 15STG		(A2)
	8		.BLADE — HPC, 15STG	56H515-02	(C2)
56H515-03	4	*	.BLADE — HPC, 15STG	52H415-113 (72-35-00-9-30AD)	(A2)(M)(N)
56H515-03	3	*	.BLADE — HPC, 15STG		(A2)
56H515-05	7	*	.BLADE — HPC, 15STG	52H415-115 (72-35-00-9-10AJ)	(A2)(M)(N)
			OR		
51S015-01	7	*	.BLADE — HPC, 15STG	52H415-501	(1)(F)(N)
51S015-02	4	*	.BLADE — HPC, 15STG	52H415-502	(1)(F)(N)
51S015-02	3	*	.BLADE — HPC, 15STG		(F)
51S015-03	4	*	.BLADE — HPC, 15STG	52H415-503	(1)(F)(N)
51S015-03	3	*	.BLADE — HPC, 15STG		(F)
51S015-05	7	*	.BLADE — HPC, 15STG	52H415-505	(1)(F)(N)
54H767	2	*	SHAFT — HPC DRIVE, TURB		(A)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
54H792	1	*	.AIR SEAL	54H846 (72-35-00-1-250 C)	(2)(D)(C)
54H618	50	*	.BOLT	50H376 (72-35-00-1-260)	(2)(D)(C)
55H601	50	*	.CLIP		(D)
50N112	50	*	.WASHER		(D)
786376	50	*	.NUT OPTION	51H516 (72-35-00-1-270 A)	(2)(A)(C)(O1) (O2)
53H367	1	*	.HEAT SHIELD	50H100 (72-35-00-1-190)	(2)(D)(C)
AS3215-180	1	*	.RETAINING RING	AS3215-179 (72-35-00-1-200)	(2)(D)(C)
53H472	1	*	.COUNTER-WEIGHT		(D)
534494	1	*	.RIVET		(D)
	1		.COUNTER-WEIGHT	51H476 (72-35-00-9-50) (72-35-00-10-30)	(C)
51A358	1	*	NUT	50A722 (72-35-00-2-1 A)	(2)(D)(C)

The material data that follows is for each engine.

For PW4460(-3), PW4462(-3) Engines:

New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
Configuration-1: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 58H575					
50S225	1		COMPRESSOR ROTOR ASSY — AXIAL	58H575 (72-35-00-1-90 P)	(1)(NP)
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	56H013-001 (72-35-00-1-210AE)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	58H236-01 (72-35-00-1-210 E)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	54H803-002 (72-35-00-1-210AF)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
Configuration-2: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 56H378-002					
56H378-003	1		COMPRESSOR ROTOR ASSY — AXIAL	56H378-002 (72-35-00-1-90AF)	(1)(NP)
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	56H013-001 (72-35-00-1-210AE)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	58H236-01 (72-35-00-1-210 E)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	54H803-002 (72-35-00-1-210AF)	(2)(A)(N)

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New PN	Qty	Estimate of Unit Price ($)	Keyword	Old PN	Instructions — Disposition
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
Configuration-3: Drum Rotor Assembly Replacement In Compressor Rotor Assembly, PN 57H478-002					
57H478-003	1		COMPRESSOR ROTOR ASSY — AXIAL	57H478-002 (72-35-00-1-90AG)	(1)(NP)
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	56H013-001 (72-35-00-1-210AE)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	58H236-01 (72-35-00-1-210 E)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)
OR					
50S813-01	1	*	.DISK — ASSY OF, DRUM ROTOR	54H803-002 (72-35-00-1-210AF)	(2)(A)(N)
50S154	8	*	.LOCK ASSY — HPC, 14STG	56H319 (72-35-00-8-50 D)	(2)(A)(C)
50S153	8	*	.LOCK ASSY — HPC, 15STG	56H324 (72-35-00-9-60 D)	(2)(A)(C)

Modification and Spares Information

Estimated part prices are provided when they are available at time of publication. The Estimate of Unit Price is only for planning purposes and does not constitute a firm quotation. An asterisk (*) is shown where part pricing information was unavailable. In either case, contact Pratt & Whitney Spares Management & Logistics for firm quotations.

Parts Modification Conditions

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(1) The new part can be obtained by modification of the old part as specified in the Accomplishment Instructions.

(2) The new part is a replacement part only, and cannot be obtained by modification of the old part.

Spare Parts Availability

(A) The new part is available.

(A2) The new part is an alternate replacement part and will continue to be supplied for use in other engine models.

(B) The new part will be available approximately March 30, 2012.

(C) The old part will continue to be supplied.

(C2) The old part will continue to be supplied for use in other engine models.

(D) The new part is a detail of the assembly. It is available as a replacement part.

(F) The new part will be available on a Full Manufacturing lead time quote basis only.

(M) It is possible to get the new part only by modification.

(N) The old part is not available.

(NP) The part is an item that is usually not procured as a spare item.

(O1) Nut Option, PN 51H516, consists of a Nut, PN 50H353, PN 50H354, PN 50H365 or PN 50H366.

(O2) Nut Option, PN 786376, consists of a Nut, PN ST2115-12, PN ST2116-12, PN ST2117-12 or PN ST2667-12.

Vendor Services or Special Components/Materials

Consumable Materials

Specification	Name
P05-341	Tape, Plastic (Yellow) (PMC 4134)
P06-036	Antigallant Compound (PWA 36035)
P06-041	Lubricant, Dry Film (PWA 36221)
See Standard Practices Source Code List	

Material Data for Each Spare Engine

The material for each spare engine is as stated in the preceding material information section.

Reidentified Parts

Reidentified Parts Data

New PN	Keyword	Old PN
50S325	COMPRESSOR ROTOR ASSY — AXIAL	58H597

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New PN	Keyword	Old PN
57H678-005	COMPRESSOR ROTOR ASSY — AXIAL	57H678-004
50S225	COMPRESSOR ROTOR ASSY — AXIAL	58H575
56H378-003	COMPRESSOR ROTOR ASSY — AXIAL	56H378-002
57H478-003	COMPRESSOR ROTOR ASSY — AXIAL	57H478-002
50S425-001	DISK — ASSY OF, HPC DRUM ROTOR	53H923-001
50S425-001	DISK — ASSY OF, HPC DRUM ROTOR	50H936-002
50S113-01	BLADE — HPC, 13STG	54H613-401
50S113-02	BLADE — HPC, 13STG	54H613-402
50S113-03	BLADE — HPC, 13STG	54H613-403
50S113-05	BLADE — HPC, 13STG	54H613-405
56H313-01	BLADE — HPC, 13STG	54H613-101
56H313-02	BLADE — HPC, 13STG	54H613-102
56H313-03	BLADE — HPC, 13STG	54H613-103
56H313-05	BLADE — HPC, 13STG	54H613-105
51S013-01	BLADE — HPC, 13STG	54H613-501
51S013-02	BLADE — HPC, 13STG	54H613-502
51S013-03	BLADE — HPC, 13STG	54H613-503
51S013-05	BLADE — HPC, 13STG	54H613-505

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New PN	Keyword	Old PN
56H413-01	BLADE — HPC, 13STG	54H613-111
56H413-02	BLADE — HPC, 13STG	54H613-112
56H413-03	BLADE — HPC, 13STG	54H613-113
56H413-05	BLADE — HPC, 13STG	54H613-115
50S114-01	BLADE — HPC, 14STG	53H314-401
50S114-02	BLADE — HPC, 14STG	53H314-402
50S114-03	BLADE — HPC, 14STG	53H314-403
50S114-05	BLADE — HPC, 14STG	53H314-405
56H414-01	BLADE — HPC, 14STG	53H314-101
56H414-02	BLADE — HPC, 14STG	53H314-102
56H414-03	BLADE — HPC, 14STG	53H314-103
56H414-05	BLADE — HPC, 14STG	53H314-105
50S415-01	BLADE — HPC, 15STG	52H415-401
50S415-02	BLADE — HPC, 15STG	52H415-402
50S415-03	BLADE — HPC, 15STG	52H415-403
50S415-05	BLADE — HPC, 15STG	52H415-405
56H415-01	BLADE — HPC, 15STG	52H415-101
56H415-02	BLADE — HPC, 15STG	52H415-102
56H415-03	BLADE — HPC, 15STG	52H415-103

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New PN	Keyword	Old PN
56H415-05	BLADE — HPC, 15STG	52H415-105
51S015-01	BLADE — HPC, 15STG	52H415-501
51S015-02	BLADE — HPC, 15STG	52H415-502
51S015-03	BLADE — HPC, 15STG	52H415-503
51S015-05	BLADE — HPC, 15STG	52H415-505
56H515-01	BLADE — HPC, 15STG	52H415-111
56H515-02	BLADE — HPC, 15STG	52H415-112
56H515-03	BLADE — HPC, 15STG	52H415-113
56H515-05	BLADE — HPC, 15STG	52H415-115

Necessary Tools

Support Equipment available before

Tool No.	Name	Manufacturer
PWA 78064	Gage	Pratt & Whitney
PWA 83135	Driver	Pratt & Whitney
PWA 83136	Extension	Pratt & Whitney
PWA 85595	Spreader, Manual	Pratt & Whitney
PWA 86448	Drift	Pratt & Whitney

Other Material Information Data

Not Applicable.

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Accomplishment Instructions

For PW4052, PW4056, PW4060, PW4152, PW4156A, PW4158, PW4460, And PW4462 Engine Models

1. Replace the Compressor Rotor Assembly, PN 58H597 with PN 50S325 or do a modification of the Compressor Rotor Assembly, PN 58H597 as follows.

   A. Replace the Drum Rotor Assembly, PN 50H936 or PN 53H923-01 with PN 50S425-01. See Figure 1.

   B. Replace lock and setscrew assemblies as follows:

      (1) Replace four 13th Stage Lock And Setscrew Assemblies, PN 56H318 with four PN 56H326. See Figure 2.

      (2) Replace four 14th Stage Lock And Setscrew Assemblies, PN 56H319 with eight PN 50S154. See Figure 3.

      (3) Replace four 15th Stage Lock And Setscrew Assemblies, PN 56H324 with eight PN 50S153. See Figure 4.

   C. Replace 13th, 14th and 15th stage blades as given in Table 1 or do a modification of the 13th, 14th and 15th stage blades by the procedure that follows. See Figure 2, 7, and 8.

Table 1

New PN	Old PN		New PN	Old PN
13th Stage Blades			13th Stage Pre-ground Blades	
50S113-01	54H613-401		51S013-01	54H613-501
50S113-04			51S013-02	54H613-502
50S113-02	54H613-402		51S013-03	54H613-503
50S113-03	54H613-403		51S013-05	54H613-505
50S113-05	54H613-405		56H413-01	54H613-111
56H313-01	54H613-101		56H413-02	54H613-112
56H313-04			56H413-03	54H613-113
56H313-02	54H613-102		56H413-05	54H613-115
56H313-03	54H613-103			
56H313-05	54H613-105			
14th Stage Blades			14th Stage Pre-ground Blades	
50S114-02	50S114-01		51S014-01	53H314-501
50S114-03			51S014-02	53H314-502
50S114-02	50S114-04		51S014-03	53H314-503
50S114-03			51S014-05	53H314-505

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New PN	Old PN		New PN	Old PN
56H414-02	56H414-01		56H614-01	53H314-111
56H414-03			56H614-02	53H314-112
50S414-02	56H414-04		56H614-03	53H314-113
50S414-03			56H614-05	53H314-115
50S114-01	53H314-401			
50S114-04				
50S114-02	53H314-402			
50S114-03	53H314-403			
50S114-05	53H314-405			
56H414-01	53H314-101			
56H414-04				
56H414-02	53H314-102			
56H414-03	53H314-103			
56H414-05	53H314-105			
15th Stage Blades			15th Stage Pre-ground Blades	
50S415-02	50S415-01		51S015-01	52H415-501
50S415-03			51S015-02	52H415-502
50S415-02	50S415-04		51S015-03	52H415-503
50S415-03			51S015-05	52H415-505
56H415-02	56H415-01		56H515-01	52H415-111
56H415-03			56H515-02	52H415-112
50S415-02	56H415-04		56H515-03	52H415-113
50S415-03			56H515-05	52H415-115
50S415-01	52H415-401			
50S415-04				
50S415-02	52H415-402			
50S415-03	52H415-403			
50S415-05	52H415-405			
56H415-01	52H415-101			
56H415-04				
56H415-02	52H415-102			

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New PN	Old PN		New PN	Old PN
56H415-03	52H415-103			
56H415-05	52H415-105			

NOTE: Pre-ground blades (Reference 21, Service Bulletin No. PW4ENG 72-599) can be used in any rotor up to seven blades per stage in any combination in the rotor. No more than three blades can be installed adjacent to each other.

(1) Inspect the 13th, 14th and 15th stage blades for square symbol in the time marking area.

(a) If the blades does not have square symbol, do the modification to include root chamfer as follows:

1 Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-19, 72-35-20, or 72-35-21, Inspection/Check-01 thru Inspection/Check-04.

2 Blend 13th, 14th and 15th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-19, 72-35-20, or 72-35-21, Repair-03.

3 Chamfer blade root to the dimensions specified in Figure 5.

4 Round edges as specified in Figure 5.

5 Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

6 Reidentify the 13th, 14th and 15th stage blades as per Table 2. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

Table 2

New PN	Old PN		New PN	Old PN
13th Stage Blades			13th Stage Pre-ground Blades	
50S113-01	54H613-401		51S013-01	54H613-501
50S113-02	54H613-402		51S013-02	54H613-502
50S113-03	54H613-403		51S013-03	54H613-503
50S113-05	54H613-405		51S013-05	54H613-505
56H313-01	54H613-101		56H413-01	54H613-111
56H313-02	54H613-102		56H413-02	54H613-112
56H313-03	54H613-103		56H413-03	54H613-113
56H313-05	54H613-105		56H413-05	54H613-115
14th Stage Blades			14th Stage Pre-ground Blades	
50S114-01	53H314-401		51S014-01	53H314-501

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New PN	Old PN		New PN	Old PN
50S114-02	53H314-402		51S014-02	53H314-502
50S114-03	53H314-403		51S014-03	53H314-503
50S114-05	53H314-405		51S014-05	53H314-505
56H414-01	53H314-101		56H614-01	53H314-111
56H414-02	53H314-102		56H614-02	53H314-112
56H414-03	53H314-103		56H614-03	53H314-113
56H414-05	53H314-105		56H614-05	53H314-115
15th Stage Blades			15th Stage Pre-ground Blades	
50S415-01	52H415-401		51S015-01	52H415-501
50S415-02	52H415-402		51S015-02	52H415-502
50S415-03	52H415-403		51S015-03	52H415-503
50S415-05	52H415-405		51S015-05	52H415-505
56H415-01	52H415-101		56H515-01	52H415-111
56H415-02	52H415-102		56H515-02	52H415-112
56H415-03	52H415-103		56H515-03	52H415-113
56H415-05	52H415-105		56H515-05	52H415-115

NOTE: Blades without root chamfer must not be used with the new Drum Rotor Assembly, PN 50S425-01, PN 50S425-001 and PN 50S813-01.

(b) If the blades have square symbol, do an inspection of the 13th Stage Blades, PN 54H613-401 and PN 54H613-101 for the platform width dimension. The dimension must be 0.9485 – 0.9515 inch (24.0919 – 24.1681 mm).

NOTE: The 13th Stage Blades, PN 54H613-401 or PN 54H613-101, may have been previously modified (platform width) and marked with a square symbol will require inspection to the following dimension and if acceptable, identify with the new part number.

1 If the blade platform is within the limits, do a modification to include the root chamfer as follows:

a Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-19, Inspection/Check-01 thru Inspection/Check-04.

b Blend 13th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-19, Repair-03.

c Chamfer blade root to the dimensions specified in Figure 5.

d Round edges as specified in Figure 5.

e Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

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f Reidentify the 13th Stage Blades, PN 54H613-401 to PN 50S113-04 and PN 54H613-101 to PN 56H313-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

2 If the blade platform is not within the limits, modify the platform width and to include the root chamfer as follows. See Figure 6.

a Modify the platform width to 0.9485 – 0.9515 inch (24.0919 – 24.1681mm) by machining or grinding as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-45-00, SPOP 530.

b Reidentify the 13th Stage Blades, PN 54H613-401 or PN 54H613-101 as PN 50S113-04 or PN 56H313-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

c Install the modified HPC blades as required to meet the assembly platform gap requirements. Refer to the Reference 5, 6, or 7 Engine Manuals, Chapter/Section 72-35-38, Assembly-01 through -05, for the Front Drum Rotor Assembly or Chapter/Section 72-35-39 Assembly-03, Assembly-05 for the Rear Drum Rotor Assembly. It is permissible to intermix new and modified blades to complete assembly requirements.

d Unless otherwise specified ensure that the surface textures are 125 AA (3.2 microinch) Reference 1, Standard Practice Manual, PWA 388 and break all edges 0.003 – 0.010 inch (0.0762 – 0.254 mm).

e Do a modification to include the root chamfer as follows:

(1) Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-19, Inspection/Check-01 thru Inspection/Check-04.

(2) Blend 13th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-19, Repair-03.

(3) Chamfer blade root to the dimensions specified in Figure 5.

(4) Round edges as specified in Figure 5.

(5) Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

(6) Reidentify the 13th Stage Blades, PN 54H613-401 to PN 50S113-04 and PN 54H613-101 to PN 56H313-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

(c) Do an inspection of the 14th Stage Blades, PN 53H314-401 or PN 53H314-101 for the platform width dimension. The dimension must be 0.9735 – 0.9765 inch (24.7269 – 24.8031 mm).

NOTE: The 14th Stage Blades, PN 53H314-401 or PN 53H314-101, may have been previously modified (platform width) and marked with a

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square symbol will require inspection to the following dimension and if acceptable, identify with the new part number.

1 If the blade platform is within the limits, do a modification to include the root chamfer as follows:

a Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-20, Inspection/Check-01 thru Inspection/Check-04.

b Blend 14th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-20, Repair-03.

c Chamfer blade root to the dimensions specified in Figure 5.

d Round edges as specified in Figure 5.

e Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

f Reidentify the 14th Stage Blades, PN 53H314-401 or PN 53H314-101 as PN 50S114-04 or PN 56H414-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

2 If the blade platform is not within the limits, modify the platform width and to include the root chamfer as follows. See Figure 6.

a Modify the platform width to 0.9735 – 0.9765 inch (24.7269 – 24.8031 mm) by machining or grinding as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-45-00, SPOP 530. See Figure 6.

b Reidentify the 14th Stage Blades, PN 53H314-401 or PN 53H314-101 as PN 50S114-04 or PN 56H414-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

c Install the modified HPC blades as required to meet the assembly platform gap requirements. Refer to the Reference 5, 6, or 7 Engine Manuals, Chapter/Section 72-35-38, Assembly-01 through -05, for the Front Drum Rotor Assembly or Chapter/Section 72-35-39 Assembly-03, Assembly-05 for the Rear Drum Rotor Assembly. It is permissible to intermix new and modified blades to complete assembly requirements.

d Unless otherwise specified ensure that the surface textures are 125 AA (3.2 microinch) Reference 1, Standard Practice Manual, per PWA 388 and break all edges 0.003 – 0.010 inch (0.0762 – 0.254 mm).

e Do a modification to include the root chamfer as follows:

(1) Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-20, Inspection/Check-01 thru Inspection/Check-04.

(2) Blend 14th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-20, Repair-03.

(3) Chamfer blade root to the dimensions specified in Figure 5.

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(4) Round edges as specified in Figure 5.

(5) Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

(6) Reidentify the 14th Stage Blades, PN 53H314-401 or PN 53H314-101 as PN 50S114-04 or PN 56H414-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

(d) Do an inspection of the 15th Stage Blades, PN 52H415-401 or PN 52H415-101 for the platform width dimension. The dimension must be 0.9735 – 0.9765 inch (24.7269 – 24.8031 mm).

NOTE: The 15th Stage Blades, PN 52H415-401 or PN 52H415-101, may have been previously modified (platform width) and marked with a square symbol will require inspection to the following dimension and if acceptable, identify with the new part number.

1 If the blade platform is within the limits, do a modification to include the root chamfer as follows:

a Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-21, Inspection/Check-01 thru Inspection/Check-04.

b Blend the 15th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-21, Repair-03.

c Chamfer blade root to the dimensions specified in Figure 5.

d Round edges as specified in Figure 5.

e Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

f Reidentify the 15th Stage Blades, PN 52H415-401 or PN 52H415-101 as PN 50S415-04 or PN 56H415-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

2 If the blade platform is not within the limits, modify the platform width and to include the root chamfer as follows. See Figure 6.

a Modify the platform width to 1.058 – 1.061 inch (26.8732 – 26.9494 mm) by machining or grinding per SPOP 530. Refer to Reference 1, Standard Practice Manual, Chapter/Section 70-45-00. See Figure 6.

b Identify the modified Blades, PN 52H415-401 or PN 52H415-101 as PN 50S415-04 or PN 56H415-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

c Install the modified HPC blades as required to meet the assembly platform gap requirements. Refer to the Reference 5, 6, or 7 Engine Manuals, Chapter/Section 72-35-38, Assembly-01 through -05, for the Front Drum Rotor Assembly or Chapter/Section

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72-35-39, Assembly-03, Assembly-05 for the Rear Drum Rotor Assembly. It is permissible to intermix new and modified blades to complete assembly requirements.

d Unless otherwise specified ensure that the surface textures are 125 AA (3.2 microinch) Reference 1, Standard Practice Manual, PWA 388 and break all edges 0.003 – 0.010 inch (0.0762 – 0.254 mm).

e Do a modification to include the root chamfer as follows:

(1) Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-21, Inspection/Check-01 thru Inspection/Check-04.

(2) Blend the 15th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-21, Repair-03.

(3) Chamfer blade root to the dimensions specified in Figure 5.

(4) Round edges as specified in Figure 5.

(5) Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

(6) Reidentify the 15th Stage Blades, PN 52H415-401 or PN 52H415-101 as PN 50S415-04 or PN 56H415-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

D. Add three 14th Stage Pre-ground Blades, PN 51S014-02 or PN 56H614-02 and add three 14th Stage Pre-ground Blades, PN 51S014-03 or PN 56H614-03.

E. Add three 15th Stage Pre-ground Blades, PN 51S015-02 or PN 56H515-02 and add three 15th Stage Pre-ground Blades, PN 51S015-03 or 56H515-03.

F. Assemble the 13th stage, 14th stage, 15th stage blade, lock, and seals. See Appendix, Part A, Part B, and Part C for assembly instructions.

G. Reidentify the modified Compressor Rotor Assembly, PN 58H597 as PN 50S325. Mark the new part number as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-11-00, Class 44. See Figure 9.

For PW4052, PW4056, PW4060, PW4152, PW4156A, PW4158, PW4460, And PW4462 Engine Models That Incorporate Reference 9, Service Bulletin No. PW4ENG 72-490, Reference 11, Service Bulletin No. PW4ENG 72-504, Or Reference 16, Service Bulletin No. PW4ENG 72-572

1. Replace Drum Rotor Assembly, PN 50H936-002 or PN 53H923-001 by Options 1 and 2 as follows. See Figure 1.

NOTE: There are two options based as stated below.

Option 1 — Replacement of drum rotor assembly with a Phase(-1) drum and modification of the drum to convert to a Phase(-3) drum.

Option 2 — Replacement of drum rotor assembly with a Phase(-3) drum and replace parts given in Table 5 in sets.

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Option 1 — Replacement of drum rotor assembly with a Phase(-1) drum and modification of the drum to convert to a Phase(-3) drum

A. Replace the Drum Rotor Assembly, PN 50H936-002 or PN 53H923-001 with PN 50S425-01 and do a modification of the Drum Rotor Assembly, PN 50S425-01 as follows. See Figure 3.

(1) Do a modification of the knife edge seals on the Shaft, PN 50H445 as specified in Reference 9, Service Bulletin No. PW4ENG 72-490, Reference 11, Service Bulletin No. PW4ENG 72-504 or Reference 16, Service Bulletin No. PW4ENG 72-572, to support the brush seal configuration.

(2) Reidentify the modified Drum Rotor Assembly, PN 50S425-01 as PN 50S425-001. Mark the new part number as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-11-00, Class 42. See Figure 10.

B. Replace lock and setscrew assemblies as follows:

(1) Replace four 13th Stage Lock And Setscrew Assemblies, PN 56H318 with four PN 56H326. See Figure 2.

(2) Replace four 14th Stage Lock And Setscrew Assemblies, PN 56H319 with eight PN 50S154. See Figure 3.

(3) Replace four 15th Stage Lock And Setscrew Assemblies, PN 56H324 with eight PN 50S153. See Figure 4.

C. Replace 13th, 14th and 15th stage blades as given in Table 3 or do a modification of the 13th, 14th and 15th stage blades by the procedure that follows. See Figure 2, 7, and 8.

Table 3

New PN	Old PN		New PN	Old PN
13th Stage Blades			13th Stage Pre-ground Blades	
50S113-01	54H613-401		51S013-01	54H613-501
50S113-04			51S013-02	54H613-502
50S113-02	54H613-402		51S013-03	54H613-503
50S113-03	54H613-403		51S013-05	54H613-505
50S113-05	54H613-405		56H413-01	54H613-111
56H313-01	54H613-101		56H413-02	54H613-112
56H313-04			56H413-03	54H613-113
56H313-02	54H613-102		56H413-05	54H613-115
56H313-03	54H613-103			
56H313-05	54H613-105			
14th Stage Blades			14th Stage Pre-ground Blades	
50S114-02	50S114-01		51S014-01	53H314-501
50S114-03			51S014-02	53H314-502

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New PN	Old PN		New PN	Old PN
50S114-02	50S114-04		51S014-03	53H314-503
50S114-03			51S014-05	53H314-505
56H414-02	56H414-01		56H614-01	53H314-111
56H414-03			56H614-02	53H314-112
50S414-02	56H414-04		56H614-03	53H314-113
50S414-03			56H614-05	53H314-115
50S114-01	53H314-401			
50S114-04				
50S114-02	53H314-402			
50S114-03	53H314-403			
50S114-05	53H314-405			
56H414-01	53H314-101			
56H414-04				
56H414-02	53H314-102			
56H414-03	53H314-103			
56H414-05	53H314-105			
15th Stage Blades			15th Stage Pre-ground Blades	
50S415-02	50S415-01		51S015-01	52H415-501
50S415-03			51S015-02	52H415-502
50S415-02	50S415-04		51S015-03	52H415-503
50S415-03			51S015-05	52H415-505
56H415-02	56H415-01		56H515-01	52H415-111
56H415-03			56H515-02	52H415-112
50S415-02	56H415-04		56H515-03	52H415-113
50S415-03			56H515-05	52H415-115
50S415-01	52H415-401			
50S415-04				
50S415-02	52H415-402			
50S415-03	52H415-403			
50S415-05	52H415-405			
56H415-01	52H415-101			
56H415-04				
56H415-02	52H415-102			

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New PN	Old PN		New PN	Old PN
56H415-03	52H415-103			
56H415-05	52H415-105			

NOTE: Pre-ground blades (Reference 21, Service Bulletin No. PW4ENG 72-599) can be used in any rotor up to seven blades per stage in any combination in the rotor. No more than three blades can be installed adjacent to each other.

(1) Inspect the 13th, 14th and 15th stage blades for square symbol in the time marking area.

(a) If the blades does not have square symbol, do the modification to include root chamfer as follows:

1 Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-19, 72-35-20, or 72-35-21, Inspection/Check-01 thru Inspection/Check-04.

2 Blend 13th, 14th and 15th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-19, 72-35-20, or 72-35-21, Repair-03.

3 Chamfer blade root to the dimensions specified in Figure 5.

4 Round edges as specified in Figure 5.

5 Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

6 Reidentify the 13th, 14th and 15th stage blades as per Table 4. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

Table 4

New PN	Old PN		New PN	Old PN
13th Stage Blades			13th Stage Pre-ground Blades	
50S113-01	54H613-401		51S013-01	54H613-501
50S113-02	54H613-402		51S013-02	54H613-502
50S113-03	54H613-403		51S013-03	54H613-503
50S113-05	54H613-405		51S013-05	54H613-505
56H313-01	54H613-101		56H413-01	54H613-111
56H313-02	54H613-102		56H413-02	54H613-112
56H313-03	54H613-103		56H413-03	54H613-113
56H313-05	54H613-105		56H413-05	54H613-115
14th Stage Blades			14th Stage Pre-ground Blades	
50S114-01	53H314-401		51S014-01	53H314-501

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New PN	Old PN		New PN	Old PN
50S114-02	53H314-402		51S014-02	53H314-502
50S114-03	53H314-403		51S014-03	53H314-503
50S114-05	53H314-405		51S014-05	53H314-505
56H414-01	53H314-101		56H614-01	53H314-111
56H414-02	53H314-102		56H614-02	53H314-112
56H414-03	53H314-103		56H614-03	53H314-113
56H414-05	53H314-105		56H614-05	53H314-115
15th Stage Blades			15th Stage Pre-ground Blades	
50S415-01	52H415-401		51S015-01	52H415-501
50S415-02	52H415-402		51S015-02	52H415-502
50S415-03	52H415-403		51S015-03	52H415-503
50S415-05	52H415-405		51S015-05	52H415-505
56H415-01	52H415-101		56H515-01	52H415-111
56H415-02	52H415-102		56H515-02	52H415-112
56H415-03	52H415-103		56H515-03	52H415-113
56H415-05	52H415-105		56H515-05	52H415-115

NOTE: Blades without root chamfer must not be used with the new Drum Rotor Assembly, PN 50S425-01, PN 50S425-001 and PN 50S813-01.

(b) If the blades have square symbol, do an inspection of the 13th Stage Blades, PN 54H613-401 and PN 54H613-101 for the platform width dimension. The dimension must be 0.9485 – 0.9515 inch (24.0919 – 24.1681 mm).

NOTE: The 13th Stage Blades, PN 54H613-401 or PN 54H613-101, may have been previously modified (platform width) and marked with a square symbol will require inspection to the following dimension and if acceptable, identify with the new part number.

1 If the blade platform is within the limits, do a modification to include the root chamfer as follows:

a Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-19, Inspection/Check-01 thru Inspection/Check-04.

b Blend 13th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-19, Repair-03.

c Chamfer blade root to the dimensions specified in Figure 5.

d Round edges as specified in Figure 5.

e Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

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f Reidentify the 13th Stage Blades, PN 54H613-401 to PN 50S113-04 and PN 54H613-101 to PN 56H313-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

2 If the blade platform is not within the limits, modify the platform width and to include the root chamfer as follows. See Figure 6.

a Modify the platform width to 0.9485 – 0.9515 inch (24.0919 – 24.1681mm) by machining or grinding as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-45-00, SPOP 530.

b Reidentify the 13th Stage Blades, PN 54H613-401 or PN 54H613-101 as PN 50S113-04 or PN 56H313-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

c Install the modified HPC blades as required to meet the assembly platform gap requirements. Refer to the Reference 5, 6, or 7 Engine Manuals, Chapter/Section 72-35-38, Assembly-01 through -05, for the Front Drum Rotor Assembly or Chapter/Section 72-35-39 Assembly-03, Assembly-05 for the Rear Drum Rotor Assembly. It is permissible to intermix new and modified blades to complete assembly requirements.

d Unless otherwise specified ensure that the surface textures are 125 AA (3.2 microinch) Reference 1, Standard Practice Manual, PWA 388 and break all edges 0.003 – 0.010 inch (0.0762 – 0.254 mm).

e Do a modification to include the root chamfer as follows:

(1) Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-19, Inspection/Check-01 thru Inspection/Check-04.

(2) Blend 13th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-19, Repair-03.

(3) Chamfer blade root to the dimensions specified in Figure 5.

(4) Round edges as specified in Figure 5.

(5) Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

(6) Reidentify the 13th Stage Blades, PN 54H613-401 to PN 50S113-04 and PN 54H613-101 to PN 56H313-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

(c) Do an inspection of the 14th Stage Blades, PN 53H314-401 or PN 53H314-101 for the platform width dimension. The dimension must be 0.9735 – 0.9765 inch (24.7269 – 24.8031 mm).

NOTE: The 14th Stage Blades, PN 53H314-401 or PN 53H314-101, may have been previously modified (platform width) and marked with a

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square symbol will require inspection to the following dimension and if acceptable, identify with the new part number.

1 If the blade platform is within the limits, do a modification to include the root chamfer as follows:

a Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-20, Inspection/Check-01 thru Inspection/Check-04.

b Blend 14th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-20, Repair-03.

c Chamfer blade root to the dimensions specified in Figure 5.

d Round edges as specified in Figure 5.

e Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

f Reidentify the 14th Stage Blades, PN 53H314-401 or PN 53H314-101 as PN 50S114-04 or PN 56H414-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

2 If the blade platform is not within the limits, modify the platform width and to include the root chamfer as follows. See Figure 6.

a Modify the platform width to 0.9735 – 0.9765 inch (24.7269 – 24.8031 mm) by machining or grinding as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-45-00, SPOP 530. See Figure 6.

b Reidentify the 14th Stage Blades, PN 53H314-401 or PN 53H314-101 as PN 50S114-04 or PN 56H414-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

c Install the modified HPC blades as required to meet the assembly platform gap requirements. Refer to the Reference 5, 6, or 7 Engine Manuals, Chapter/Section 72-35-38, Assembly-01 through -05, for the Front Drum Rotor Assembly or Chapter/Section 72-35-39 Assembly-03, Assembly-05 for the Rear Drum Rotor Assembly. It is permissible to intermix new and modified blades to complete assembly requirements.

d Unless otherwise specified ensure that the surface textures are 125 AA (3.2 microinch) Reference 1, Standard Practice Manual, per PWA 388 and break all edges 0.003 – 0.010 inch (0.0762 – 0.254 mm).

e Do a modification to include the root chamfer as follows:

(1) Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-20, Inspection/Check-01 thru Inspection/Check-04.

(2) Blend 14th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-20, Repair-03.

(3) Chamfer blade root to the dimensions specified in Figure 5.

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(4) Round edges as specified in Figure 5.

(5) Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

(6) Reidentify the 14th Stage Blades, PN 53H314-401 or PN 53H314-101 as PN 50S114-04 or PN 56H414-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

(d) Do an inspection of the 15th Stage Blades, PN 52H415-401 or PN 52H415-101 for the platform width dimension. The dimension must be 0.9735 – 0.9765 inch (24.7269 – 24.8031 mm).

NOTE: The 15th Stage Blades, PN 52H415-401 or PN 52H415-101, may have been previously modified (platform width) and marked with a square symbol will require inspection to the following dimension and if acceptable, identify with the new part number.

1 If the blade platform is within the limits, do a modification to include the root chamfer as follows:

a Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-21, Inspection/Check-01 thru Inspection/Check-04.

b Blend the 15th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-21, Repair-03.

c Chamfer blade root to the dimensions specified in Figure 5.

d Round edges as specified in Figure 5.

e Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

f Reidentify the 15th Stage Blades, PN 52H415-401 or PN 52H415-101 as PN 50S415-04 or PN 56H415-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

2 If the blade platform is not within the limits, modify the platform width and to include the root chamfer as follows. See Figure 6.

a Modify the platform width to 1.058 – 1.061 inch (26.8732 – 26.9494 mm) by machining or grinding per SPOP 530. Refer to Reference 1, Standard Practice Manual, Chapter/Section 70-45-00. See Figure 6.

b Identify the modified Blades, PN 52H415-401 or PN 52H415-101 as PN 50S415-04 or PN 56H415-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

c Install the modified HPC blades as required to meet the assembly platform gap requirements. Refer to the Reference 5, 6, or 7 Engine Manuals, Chapter/Section 72-35-38, Assembly-01 through -05, for the Front Drum Rotor Assembly or Chapter/Section

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72-35-39, Assembly-03, Assembly-05 for the Rear Drum Rotor Assembly. It is permissible to intermix new and modified blades to complete assembly requirements.

d Unless otherwise specified ensure that the surface textures are 125 AA (3.2 microinch) Reference 1, Standard Practice Manual, PWA 388 and break all edges 0.003 – 0.010 inch (0.0762 – 0.254 mm).

e Do a modification to include the root chamfer as follows:

(1) Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-21, Inspection/Check-01 thru Inspection/Check-04.

(2) Blend the 15th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-21, Repair-03.

(3) Chamfer blade root to the dimensions specified in Figure 5.

(4) Round edges as specified in Figure 5.

(5) Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

(6) Reidentify the 15th Stage Blades, PN 52H415-401 or PN 52H415-101 as PN 50S415-04 or PN 56H415-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

D. Add three 14th Stage Pre-ground Blades, PN 51S014-02 or PN 56H614-02 and add three 14th Stage Pre-ground Blades, PN 51S014-03 or PN 56H614-03.

E. Add three 15th Stage Pre-ground Blades, PN 51S015-02 or PN 56H515-02 and add three 15th Stage Pre-ground Blades, PN 51S015-03 or 56H515-03.

F. Assemble the 13th stage, 14th stage, 15th stage blade, lock, and seals. See Appendix, Part A, Part B, and Part C for assembly instructions.

G. Reidentify the modified Compressor Rotor Assembly, PN 57H678-004 as PN 57H678-005. Mark the new part number as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-11-00, Class 44. See Figure 9.

OR

Option 2 — Replacement of drum rotor assembly with a Phase(-3) drum and replace parts in sets

A. Replace the Drum Rotor Assembly, PN 53H923-001 or PN 50H936-002 with PN 50S813-01 and do the procedure that follows. See Figure 1.

(1) Replace the parts as specified in Table 5 in sets. See Figure 7 and 8.

Table 5

New PN	Qty	Keyword	Old PN
54H767	1	SHAFT — HPC DRIVE, TURB	

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New PN	Qty	Keyword	Old PN
54H792	1	AIR SEAL	54H846
54H618	50	BOLT	50H376
55H601	50	CLIP	
50N112	50	WASHER	
786376	50	NUT OPTION	51H516
53H367	1	HEAT SHIELD	50H100
AS3215-180	1	RETAINING RING	AS3215-179
53H472	5	COUNTERWEIGHT	
534494	5	RIVET	
	1	COUNTERWEIGHT	51H476
51A358	1	NUT	50A722

B. Replace lock and setscrew assemblies as follows:

(1) Replace four 13th Stage Lock And Setscrew Assemblies, PN 56H318 with four PN 56H326. See Figure 2.

(2) Replace four 14th Stage Lock And Setscrew Assemblies, PN 56H319 with eight PN 50S154. See Figure 3.

(3) Replace four 15th Stage Lock And Setscrew Assemblies, PN 56H324 with eight PN 50S153. See Figure 4.

C. Replace 13th, 14th and 15th stage blades as given in Table 6 or do a modification of the 13th, 14th and 15th stage blades by the procedure that follows. See Figure 2, 7, and 8.

Table 6

New PN	Old PN		New PN	Old PN
13th Stage Blades			13th Stage Pre-ground Blades	
50S113-01	54H613-401		51S013-01	54H613-501
50S113-04			51S013-02	54H613-502
50S113-02	54H613-402		51S013-03	54H613-503
50S113-03	54H613-403		51S013-05	54H613-505
50S113-05	54H613-405		56H413-01	54H613-111
56H313-01	54H613-101		56H413-02	54H613-112
56H313-04			56H413-03	54H613-113
56H313-02	54H613-102		56H413-05	54H613-115
56H313-03	54H613-103			
56H313-05	54H613-105			

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New PN	Old PN		New PN	Old PN
14th Stage Blades			14th Stage Pre-ground Blades	
50S114-02	50S114-01		51S014-01	53H314-501
50S114-03			51S014-02	53H314-502
50S114-02	50S114-04		51S014-03	53H314-503
50S114-03			51S014-05	53H314-505
56H414-02	56H414-01		56H614-01	53H314-111
56H414-03			56H614-02	53H314-112
50S414-02	56H414-04		56H614-03	53H314-113
50S414-03			56H614-05	53H314-115
50S114-01	53H314-401			
50S114-04				
50S114-02	53H314-402			
50S114-03	53H314-403			
50S114-05	53H314-405			
56H414-01	53H314-101			
56H414-04				
56H414-02	53H314-102			
56H414-03	53H314-103			
56H414-05	53H314-105			
15th Stage Blades			15th Stage Pre-ground Blades	
50S415-02	50S415-01		51S015-01	52H415-501
50S415-03			51S015-02	52H415-502
50S415-02	50S415-04		51S015-03	52H415-503
50S415-03			51S015-05	52H415-505
56H415-02	56H415-01		56H515-01	52H415-111
56H415-03			56H515-02	52H415-112
50S415-02	56H415-04		56H515-03	52H415-113
50S415-03			56H515-05	52H415-115
50S415-01	52H415-401			
50S415-04				
50S415-02	52H415-402			
50S415-03	52H415-403			
50S415-05	52H415-405			

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New PN	Old PN		New PN	Old PN
56H415-01	52H415-101			
56H415-04				
56H415-02	52H415-102			
56H415-03	52H415-103			
56H415-05	52H415-105			

NOTE: Pre-ground blades (Reference 21, Service Bulletin No. PW4ENG 72-599) can be used in any rotor up to seven blades per stage in any combination in the rotor. No more than three blades can be installed adjacent to each other.

(1) Inspect the 13th, 14th and 15th stage blades for square symbol in the time marking area.

(a) If the blades does not have square symbol, do the modification to include root chamfer as follows:

1 Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-19, 72-35-20, or 72-35-21, Inspection/Check-01 thru Inspection/Check-04.

2 Blend 13th, 14th and 15th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-19, 72-35-20, or 72-35-21, Repair-03.

3 Chamfer blade root to the dimensions specified in Figure 5.

4 Round edges as specified in Figure 5.

5 Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

6 Reidentify the 13th, 14th and 15th stage blades as per Table 7. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

Table 7

New PN	Old PN		New PN	Old PN
13th Stage Blades			13th Stage Pre-ground Blades	
50S113-01	54H613-401		51S013-01	54H613-501
50S113-02	54H613-402		51S013-02	54H613-502
50S113-03	54H613-403		51S013-03	54H613-503
50S113-05	54H613-405		51S013-05	54H613-505
56H313-01	54H613-101		56H413-01	54H613-111
56H313-02	54H613-102		56H413-02	54H613-112
56H313-03	54H613-103		56H413-03	54H613-113

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New PN	Old PN		New PN	Old PN
56H313-05	54H613-105		56H413-05	54H613-115
14th Stage Blades			14th Stage Pre-ground Blades	
50S114-01	53H314-401		51S014-01	53H314-501
50S114-02	53H314-402		51S014-02	53H314-502
50S114-03	53H314-403		51S014-03	53H314-503
50S114-05	53H314-405		51S014-05	53H314-505
56H414-01	53H314-101		56H614-01	53H314-111
56H414-02	53H314-102		56H614-02	53H314-112
56H414-03	53H314-103		56H614-03	53H314-113
56H414-05	53H314-105		56H614-05	53H314-115
15th Stage Blades			15th Stage Pre-ground Blades	
50S415-01	52H415-401		51S015-01	52H415-501
50S415-02	52H415-402		51S015-02	52H415-502
50S415-03	52H415-403		51S015-03	52H415-503
50S415-05	52H415-405		51S015-05	52H415-505
56H415-01	52H415-101		56H515-01	52H415-111
56H415-02	52H415-102		56H515-02	52H415-112
56H415-03	52H415-103		56H515-03	52H415-113
56H415-05	52H415-105		56H515-05	52H415-115

NOTE: Blades without root chamfer must not be used with the new Drum Rotor Assembly, PN 50S425-01, PN 50S425-001 and PN 50S813-01.

(b) If the blades have square symbol, do an inspection of the 13th Stage Blades, PN 54H613-401 and PN 54H613-101 for the platform width dimension. The dimension must be 0.9485 – 0.9515 inch (24.0919 – 24.1681 mm).

NOTE: The 13th Stage Blades, PN 54H613-401 or PN 54H613-101, may have been previously modified (platform width) and marked with a square symbol will require inspection to the following dimension and if acceptable, identify with the new part number.

1 If the blade platform is within the limits, do a modification to include the root chamfer as follows:

a Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-19, Inspection/Check-01 thru Inspection/Check-04.

b Blend 13th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-19, Repair-03.

c Chamfer blade root to the dimensions specified in Figure 5.

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d Round edges as specified in Figure 5.

e Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

f Reidentify the 13th Stage Blades, PN 54H613-401 to PN 50S113-04 and PN 54H613-101 to PN 56H313-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

2 If the blade platform is not within the limits, modify the platform width and to include the root chamfer as follows. See Figure 6.

a Modify the platform width to 0.9485 – 0.9515 inch (24.0919 – 24.1681mm) by machining or grinding as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-45-00, SPOP 530.

b Reidentify the 13th Stage Blades, PN 54H613-401 or PN 54H613-101 as PN 50S113-04 or PN 56H313-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

c Install the modified HPC blades as required to meet the assembly platform gap requirements. Refer to the Reference 5, 6, or 7 Engine Manuals, Chapter/Section 72-35-38, Assembly-01 through -05, for the Front Drum Rotor Assembly or Chapter/Section 72-35-39 Assembly-03, Assembly-05 for the Rear Drum Rotor Assembly. It is permissible to intermix new and modified blades to complete assembly requirements.

d Unless otherwise specified ensure that the surface textures are 125 AA (3.2 microinch) Reference 1, Standard Practice Manual, PWA 388 and break all edges 0.003 – 0.010 inch (0.0762 – 0.254 mm).

e Do a modification to include the root chamfer as follows:

(1) Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-19, Inspection/Check-01 thru Inspection/Check-04.

(2) Blend 13th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-19, Repair-03.

(3) Chamfer blade root to the dimensions specified in Figure 5.

(4) Round edges as specified in Figure 5.

(5) Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

(6) Reidentify the 13th Stage Blades, PN 54H613-401 to PN 50S113-04 and PN 54H613-101 to PN 56H313-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

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(c) Do an inspection of the 14th Stage Blades, PN 53H314-401 or PN 53H314-101 for the platform width dimension. The dimension must be 0.9735 – 0.9765 inch (24.7269 – 24.8031 mm).

NOTE: The 14th Stage Blades, PN 53H314-401 or PN 53H314-101, may have been previously modified (platform width) and marked with a square symbol will require inspection to the following dimension and if acceptable, identify with the new part number.

1 If the blade platform is within the limits, do a modification to include the root chamfer as follows:

a Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-20, Inspection/Check-01 thru Inspection/Check-04.

b Blend 14th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-20, Repair-03.

c Chamfer blade root to the dimensions specified in Figure 5.

d Round edges as specified in Figure 5.

e Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

f Reidentify the 14th Stage Blades, PN 53H314-401 or PN 53H314-101 as PN 50S114-04 or PN 56H414-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

2 If the blade platform is not within the limits, modify the platform width and to include the root chamfer as follows. See Figure 6.

a Modify the platform width to 0.9735 – 0.9765 inch (24.7269 – 24.8031 mm) by machining or grinding as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-45-00, SPOP 530. See Figure 6.

b Reidentify the 14th Stage Blades, PN 53H314-401 or PN 53H314-101 as PN 50S114-04 or PN 56H414-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

c Install the modified HPC blades as required to meet the assembly platform gap requirements. Refer to the Reference 5, 6, or 7 Engine Manuals, Chapter/Section 72-35-38, Assembly-01 through -05, for the Front Drum Rotor Assembly or Chapter/Section 72-35-39 Assembly-03, Assembly-05 for the Rear Drum Rotor Assembly. It is permissible to intermix new and modified blades to complete assembly requirements.

d Unless otherwise specified ensure that the surface textures are 125 AA (3.2 microinch) Reference 1, Standard Practice Manual, per PWA 388 and break all edges 0.003 – 0.010 inch (0.0762 – 0.254 mm).

e Do a modification to include the root chamfer as follows:

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(1) Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-20, Inspection/Check-01 thru Inspection/Check-04.

(2) Blend 14th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-20, Repair-03.

(3) Chamfer blade root to the dimensions specified in Figure 5.

(4) Round edges as specified in Figure 5.

(5) Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

(6) Reidentify the 14th Stage Blades, PN 53H314-401 or PN 53H314-101 as PN 50S114-04 or PN 56H414-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

(d) Do an inspection of the 15th Stage Blades, PN 52H415-401 or PN 52H415-101 for the platform width dimension. The dimension must be 0.9735 – 0.9765 inch (24.7269 – 24.8031 mm).

NOTE: The 15th Stage Blades, PN 52H415-401 or PN 52H415-101, may have been previously modified (platform width) and marked with a square symbol will require inspection to the following dimension and if acceptable, identify with the new part number.

1 If the blade platform is within the limits, do a modification to include the root chamfer as follows:

a Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-21, Inspection/Check-01 thru Inspection/Check-04.

b Blend the 15th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-21, Repair-03.

c Chamfer blade root to the dimensions specified in Figure 5.

d Round edges as specified in Figure 5.

e Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

f Reidentify the 15th Stage Blades, PN 52H415-401 or PN 52H415-101 as PN 50S415-04 or PN 56H415-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

2 If the blade platform is not within the limits, modify the platform width and to include the root chamfer as follows. See Figure 6.

a Modify the platform width to 1.058 – 1.061 inch (26.8732 – 26.9494 mm) by machining or grinding per SPOP 530. Refer to Reference 1, Standard Practice Manual, Chapter/Section 70-45-00. See Figure 6.

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b Identify the modified Blades, PN 52H415-401 or PN 52H415-101 as PN 50S415-04 or PN 56H415-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

c Install the modified HPC blades as required to meet the assembly platform gap requirements. Refer to the Reference 5, 6, or 7 Engine Manuals, Chapter/Section 72-35-38, Assembly-01 through -05, for the Front Drum Rotor Assembly or Chapter/Section 72-35-39, Assembly-03, Assembly-05 for the Rear Drum Rotor Assembly. It is permissible to intermix new and modified blades to complete assembly requirements.

d Unless otherwise specified ensure that the surface textures are 125 AA (3.2 microinch) Reference 1, Standard Practice Manual, PWA 388 and break all edges 0.003 – 0.010 inch (0.0762 – 0.254 mm).

e Do a modification to include the root chamfer as follows:

(1) Do the procedures in Reference 8, CIR Manual, Chapter/Section 72-35-21, Inspection/Check-01 thru Inspection/Check-04.

(2) Blend the 15th stage blades by the procedure in Reference 8, CIR Manual, Chapter/Section 72-35-21, Repair-03.

(3) Chamfer blade root to the dimensions specified in Figure 5.

(4) Round edges as specified in Figure 5.

(5) Apply antigalling compound to the repair area as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-41-00, SPOP 146.

(6) Reidentify the 15th Stage Blades, PN 52H415-401 or PN 52H415-101 as PN 50S415-04 or PN 56H415-04. Mark the new part number as specified in Reference 1, Standard Practice Manual, Chapter/Section 70-11-00, Class 40. See Figure 5.

D. Add three 14th Stage Pre-ground Blades, PN 51S014-02 or PN 56H614-02 and add three 14th Stage Pre-ground Blades, PN 51S014-03 or PN 56H614-03.

E. Add three 15th Stage Pre-ground Blades, PN 51S015-02 or PN 56H515-02 and add three 15th Stage Pre-ground Blades, PN 51S015-03 or 56H515-03.

F. Assemble the 13th stage, 14th stage, 15th stage blade, lock, and seals. See Appendix, Part A, Part B, and Part C for assembly instructions.

G. Reidentify the modified Compressor Rotor Assembly, PN 57H678-004 as PN 57H678-005. Mark the new part number as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-11-00, Class 44. See Figure 9.

For PW4052(-3), PW4056(-3), PW4060(-3), PW4062(-3), PW4062A(-3), PW4152(-3), PW4156A(-3), PW4158(-3), PW4460(-3), PW4462(-3) Engines Models

1. Replace the Drum Rotor Assembly, PN 54H803-002, PN 58H236-01 or PN 56H013-001 with PN 50S813-01 as follows. See Figure 1.

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A. Replace lock and setscrew assemblies as follows:

(1) Replace eight 14th Stage Lock And Setscrew Assemblies, PN 56H319 with eight PN 50S154. See Figure 3.

(2) Replace eight 15th Stage Lock And Setscrew Assemblies, PN 56H324 with eight PN 50S153. See Figure 4.

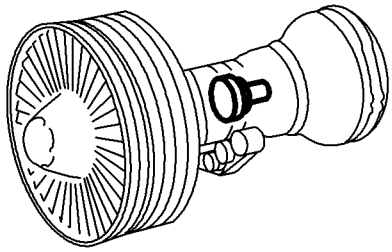
B. Assemble the 13th stage, 14th stage, 15th stage blade, lock, and seals. See Appendix, Part A, Part B, and Part C for assembly instructions.

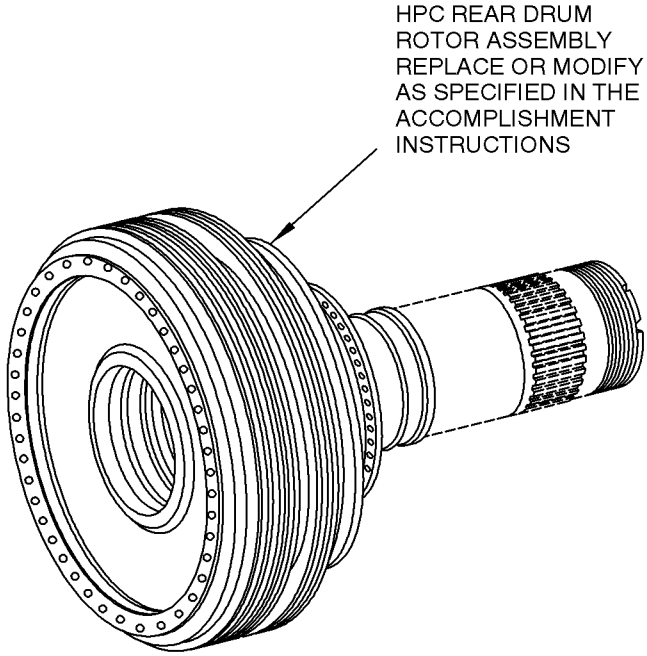
C. Reidentify the modified Compressor Rotor Assembly as specified in Table 8. Mark the new part number as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-11-00, Class 44. See Figure 9.

Table 8

New PN	Old PN
50S225	58H575
56H378-003	56H378-002
57H478-003	57H478-002

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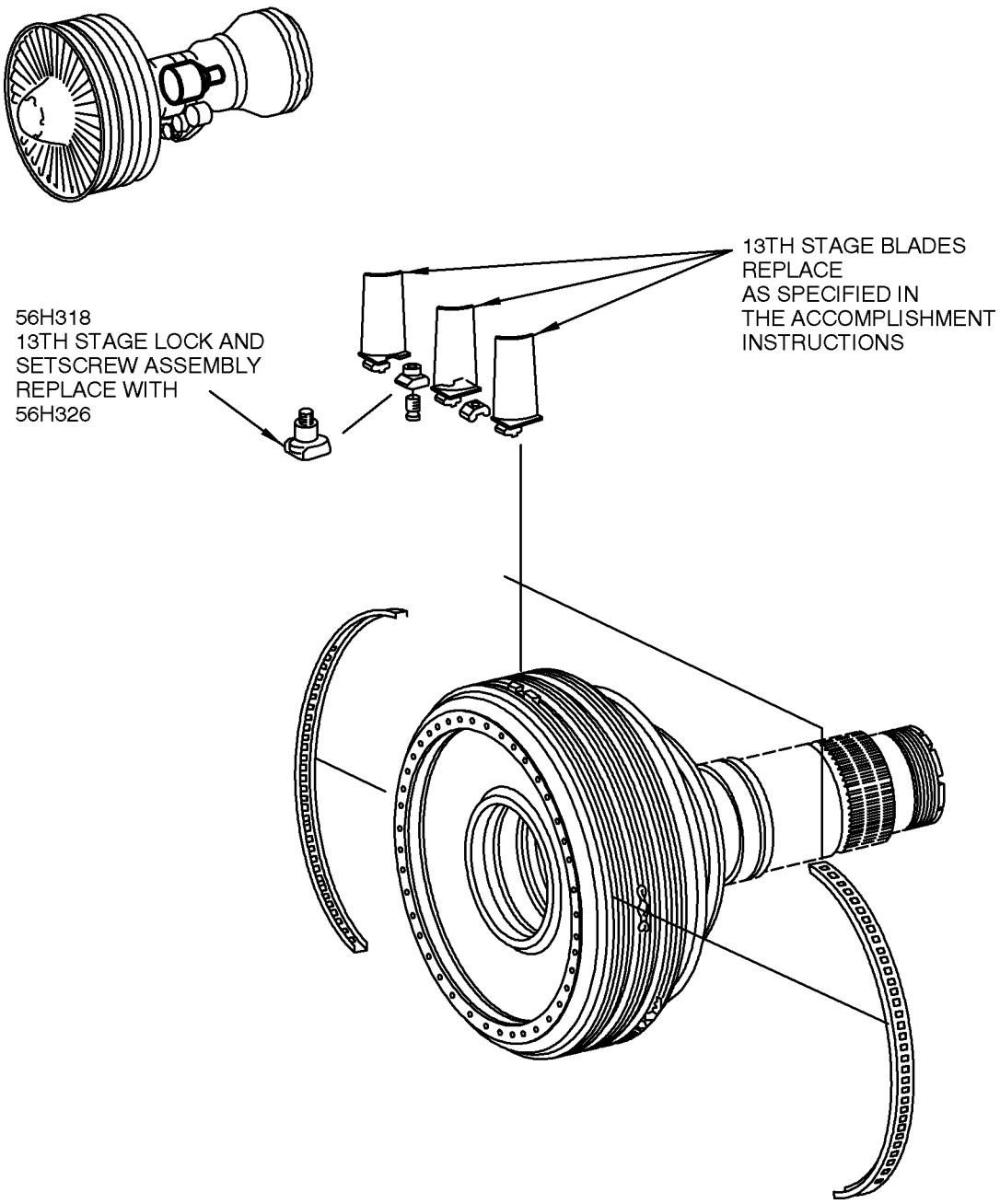




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LOCATION OF THE HPC REAR DRUM ROTOR ASSEMBLY
72-35-00
FIGURE 1

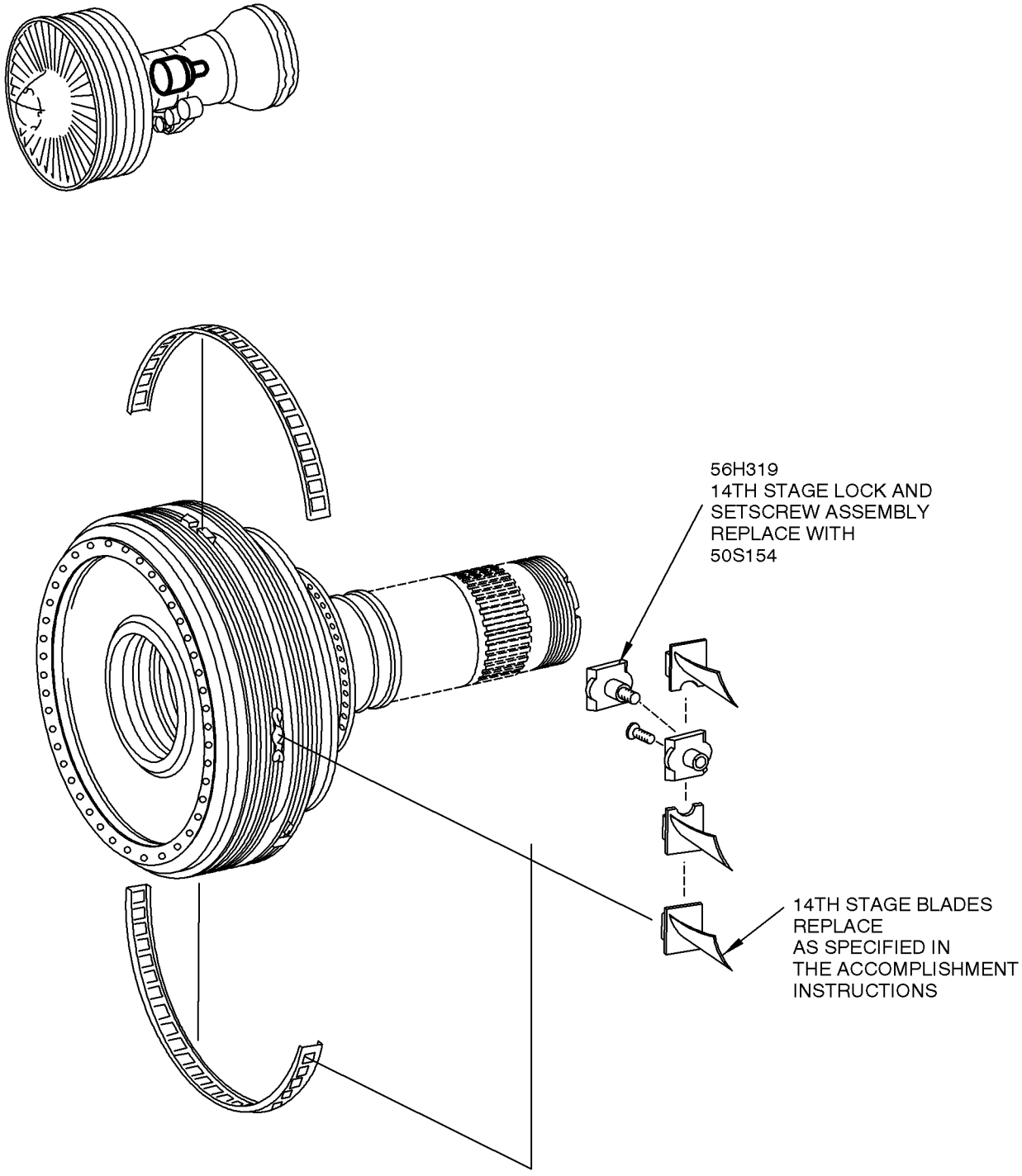
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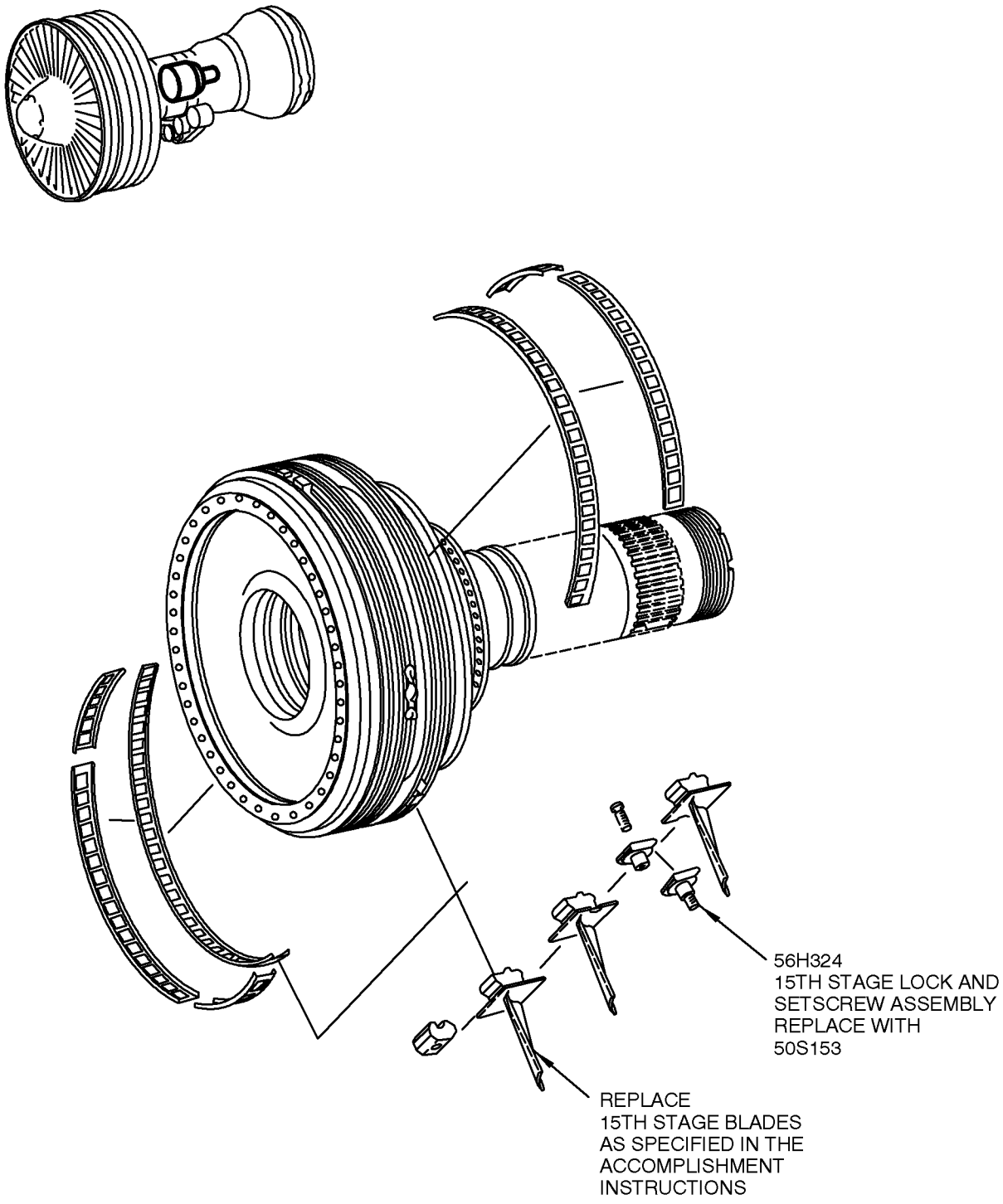
LOCATION OF THE 13TH STAGE LOCK AND SETSCREW ASSEMBLY AND BLADE
72-35-00
FIGURE 2

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LOCATION OF THE 14TH STAGE LOCK AND SETSCREW ASSEMBLY AND BLADE
72-35-00
FIGURE 3

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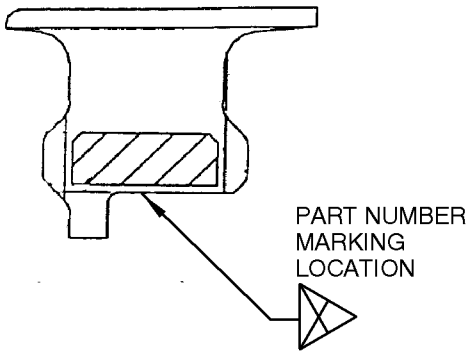
B524092

LOCATION OF THE 15TH STAGE LOCK AND SETSCREW ASSEMBLY AND BLADE
72-35-00
FIGURE 4

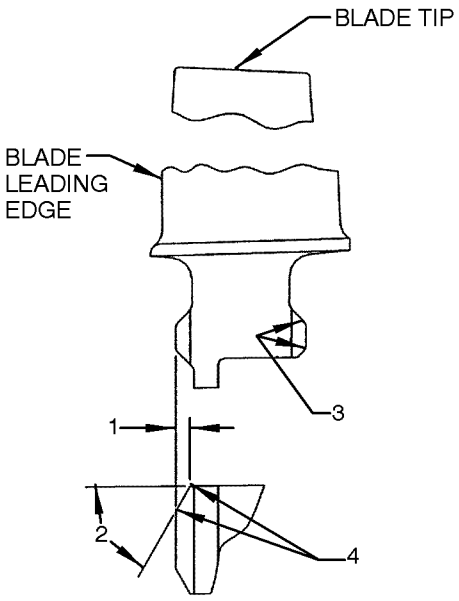
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MARKING LOCATION OF 13TH, 14TH AND 15TH STAGE BLADES



ROOT CHAMFER OF 13TH, 14TH AND 15TH STAGE BLADES

B522772

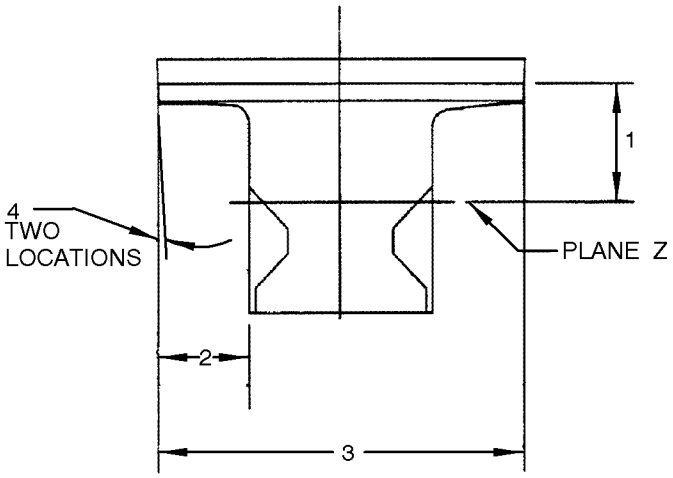
MODIFICATION OF 13TH, 14TH AND 15TH STAGE BLADES
FIGURE 5

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1. 0.040 – 0.060 Inch (1.016 – 1.524 mm) Four Places.
2. 56° 30’ ± 2° Four Places.
3. 0.020 – 0.030 Inch (0.508 – 0.762 mm) Radius, Two Sides.
4. Round Edges, 0.005 – 0.040 Inch (0.127 – 1.016 mm). Smooth Transition Necessary With Adjacent Radii.

KEY TO FIGURE 5

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VIEW A

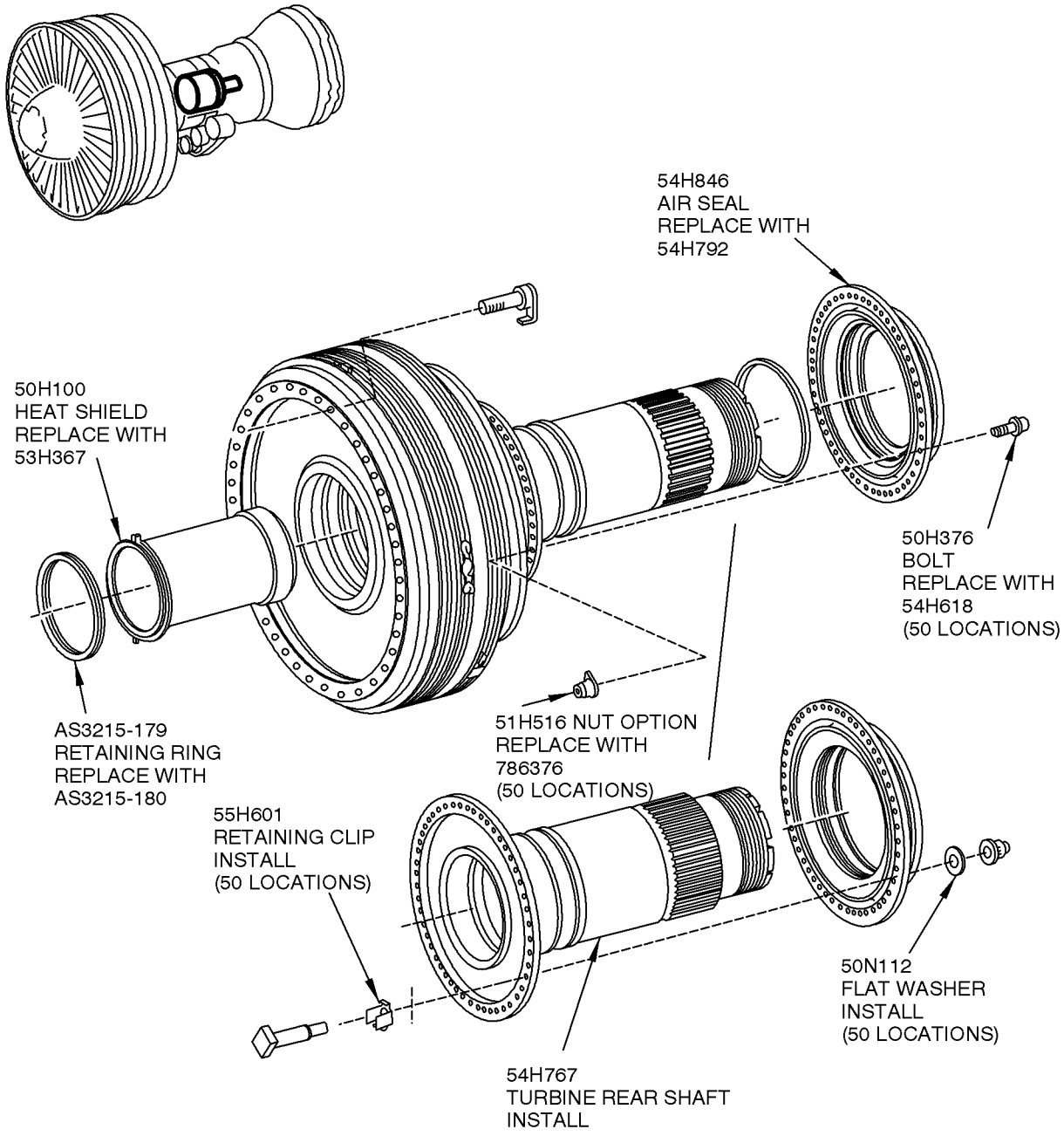
OLD PN	NEW PN	INDEX 1	INDEX 2	INDEX 3	INDEX 4
54H613-401	50S113-04	0.291 (7.391)	0.231 - 0.235 (5.867 - 5.969)	0.948 - 0.951 (24.092 - 24.168)	1°48' - 2°48'
54H613-101	56H313-04	0.291 (7.391)	0.231 - 0.235 (5.867 - 5.969)	0.948 - 0.951 (24.092 - 24.168)	1°48' - 2°48'
53H314-401	50S114-04	0.291 (7.391)	0.238 - 0.242 (6.0452 - 6.1468)	0.9735 - 0.9765 (24.7269 - 24.8031)	1°52' - 2°52'
53H314-101	56H414-04	0.291 (7.391)	0.238 - 0.242 (6.0452 - 6.1468)	0.9735 - 0.9765 (24.7269 - 24.8031)	1°52' - 2°52'

PLATFORM WIDTH MODIFICATION OF 13TH, 14TH AND 15TH STAGE BLADES

B522773

MODIFICATION OF 13TH, 14TH AND 15TH STAGE BLADES
FIGURE 6

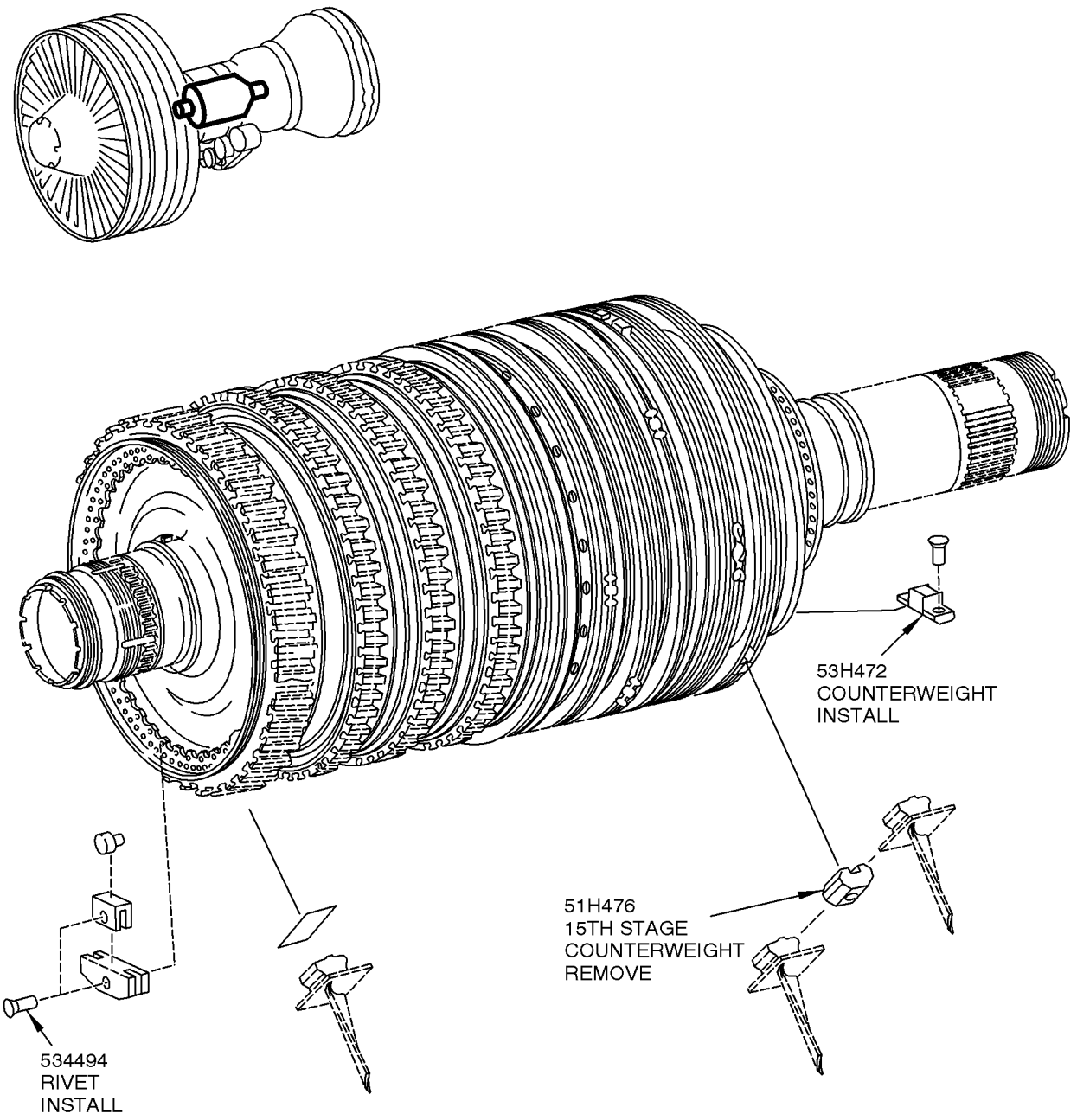
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LOCATION OF THE HPC DRIVE TURBINE SHAFT
72-35-00
FIGURE 7

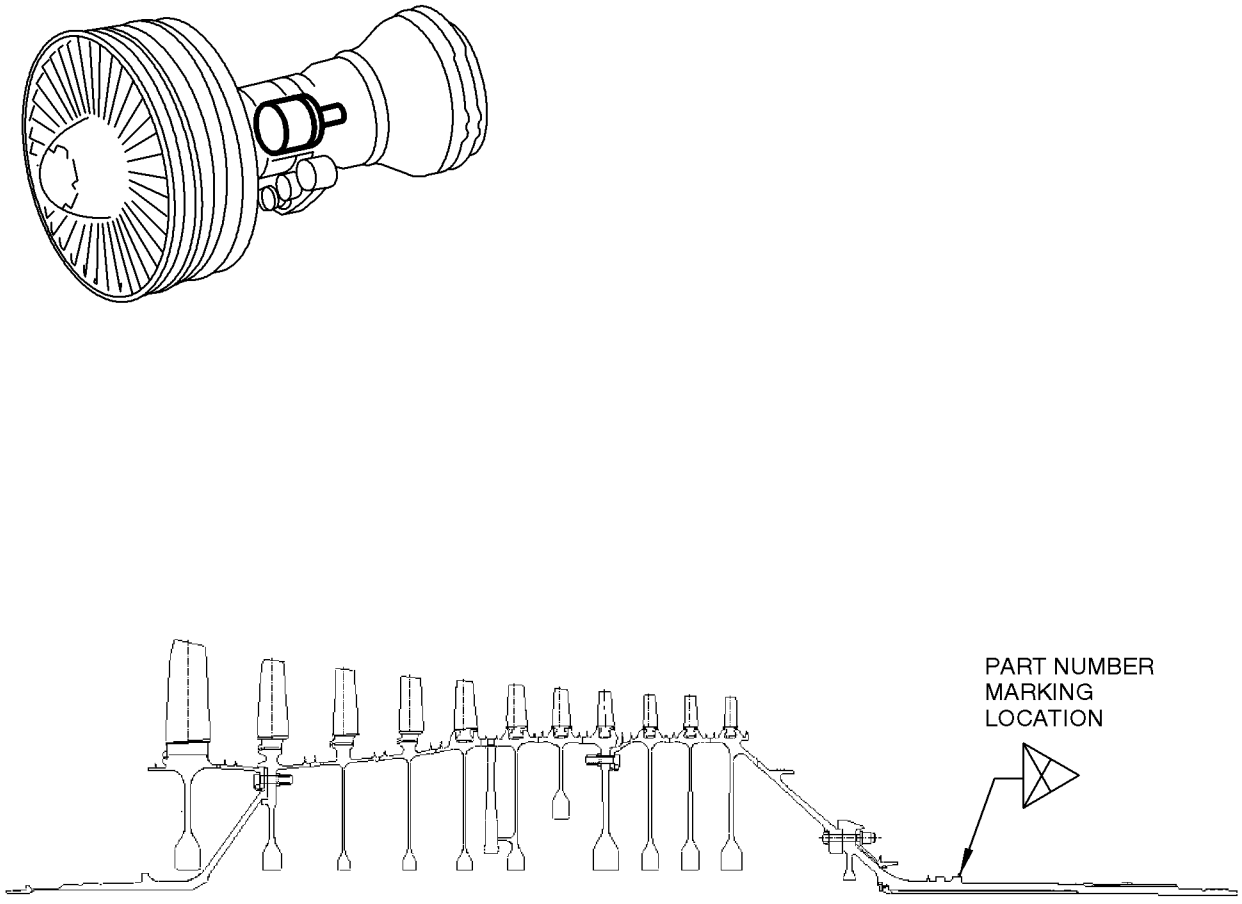
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LOCATION OF THE COUNTERWEIGHTS
72-35-00
FIGURE 8

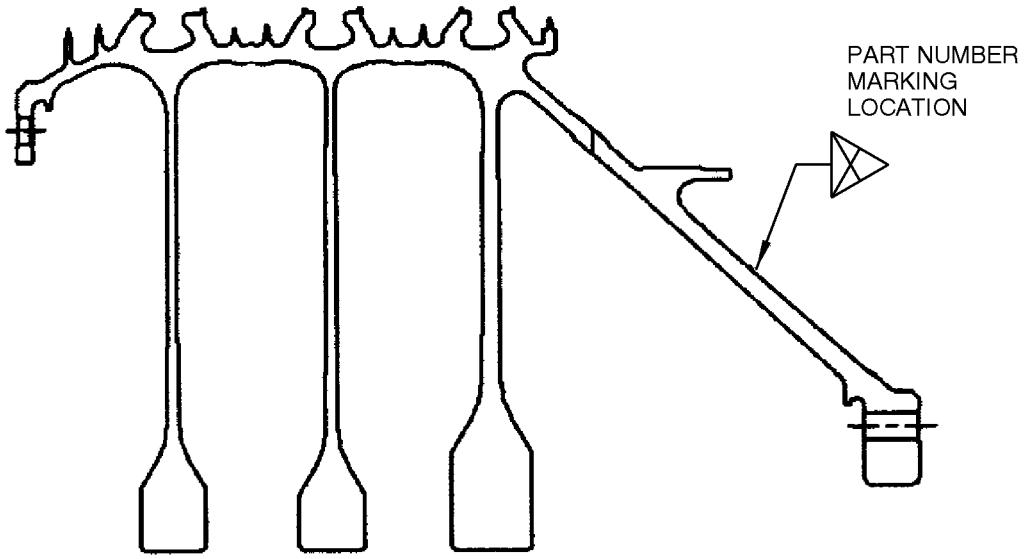
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MARKING LOCATION OF THE COMPRESSOR ROTOR ASSEMBLY
FIGURE 9

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CROSS SECTION VIEW
OF HPC DRUM ROTOR

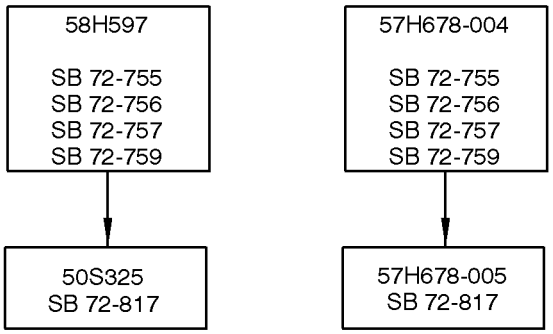
B521846

MARKING LOCATION OF THE DRUM ROTOR DISK ASSEMBLY
FIGURE 10

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Appendix

Parts Progression to Show the Changed Part in Relation to Other Parts



(1) 72-755 - FOR PW4052, PW4052(-3), PW4056, PW4056(-3), PW4060, PW4060(-3), PW4062(-3), PW4062A(-3)

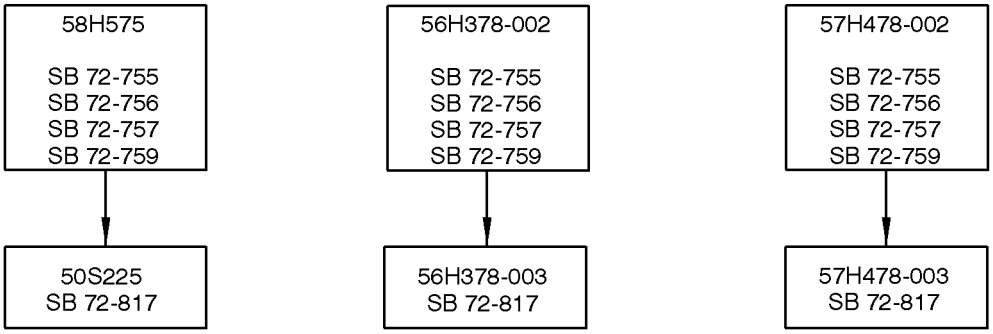
72-756 - FOR PW4152, PW4152(-3), PW4156A, PW4156A(-3), PW4158, PW4158(-3) ENGINES THAT HAVE SYMMETRIC HIGH PRESSURE COMPRESSOR (HPC) CONFIGURATION

72-757 - FOR PW4460, PW4460(-3), PW4462, PW4462(-3)

72-759 - FOR PW4158(-3) ENGINES THAT HAVE ASYMMETRIC HIGH PRESSURE COMPRESSOR (HPC) CONFIGURATION

B521880

COMPRESSOR ROTOR ASSEMBLY FOR PHASE(-1) AND CONVERTED PHASE(-3) ENGINES
CHART A



(1) 72-755 - FOR PW4052, PW4052(-3), PW4056, PW4056(-3), PW4060, PW4060(-3), PW4062(-3), PW4062A(-3)

72-756 - FOR PW4152, PW4152(-3), PW4156A, PW4156A(-3), PW4158, PW4158(-3) ENGINES THAT HAVE SYMMETRIC HIGH PRESSURE COMPRESSOR (HPC) CONFIGURATION

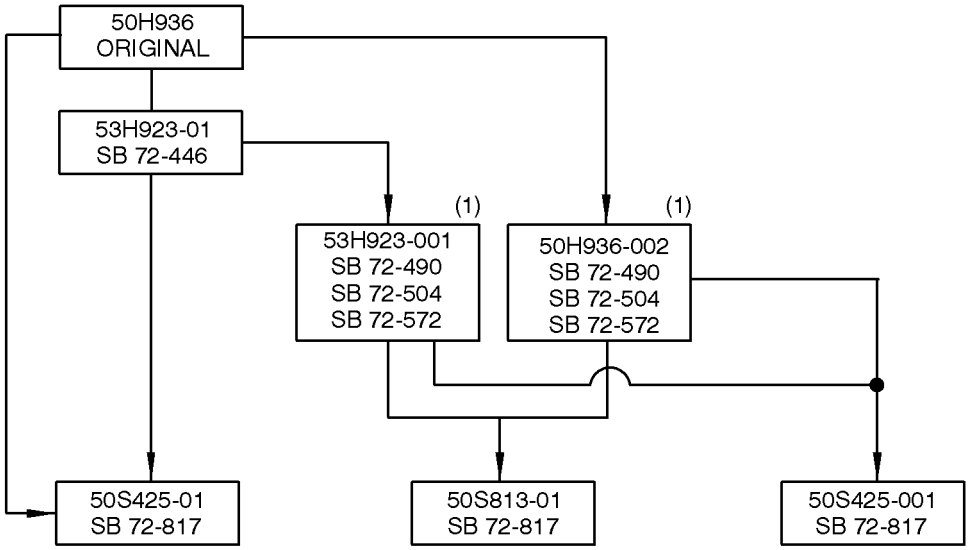
72-757 - FOR PW4460, PW4460(-3), PW4462, PW4462(-3)

72-759 - FOR PW4158(-3) ENGINES THAT HAVE ASYMMETRIC HIGH PRESSURE COMPRESSOR (HPC) CONFIGURATION

B521855

COMPRESSOR ROTOR ASSEMBLY FOR PHASE(-3) ENGINES
CHART B

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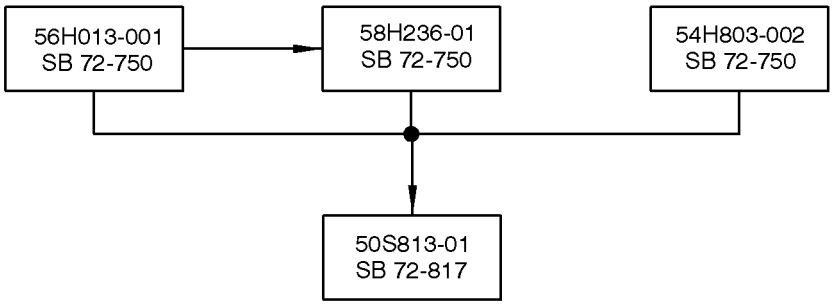
(1) 72-490 - FOR PW4460, PW4462 ENGINE MODELS

72-504 - FOR PW4052, PW4056, PW4060 ENGINE MODELS

72-572 - FOR PW4152, PW4156A, PW4158 ENGINE MODELS

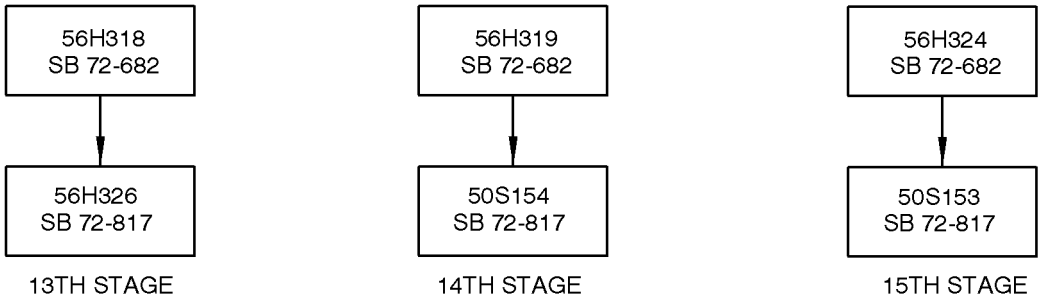
B521879

DRUM ROTOR DISK ASSEMBLY FOR PHASE (-1) AND CONVERTED PHASE(-3) ENGINES
CHART C



B521878

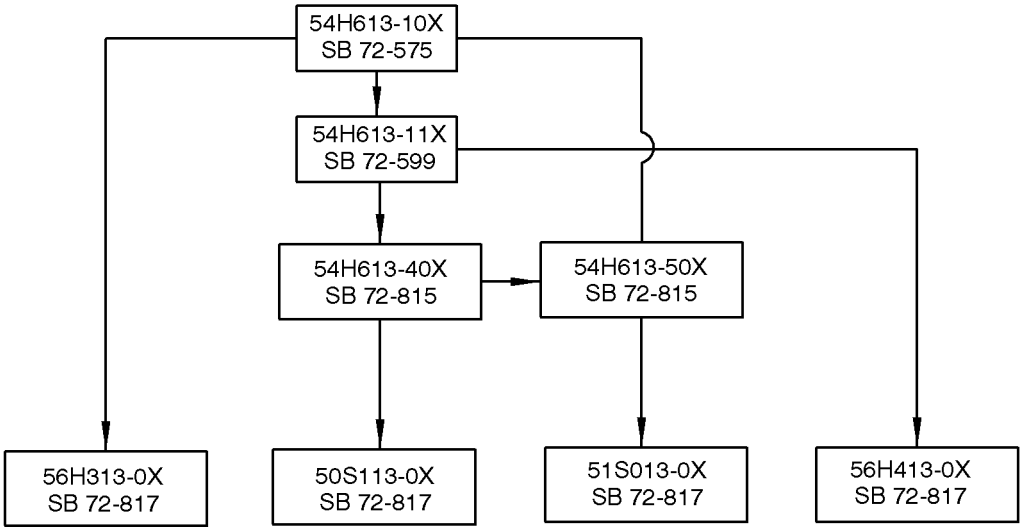
DRUM ROTOR DISK ASSEMBLY FOR PHASE(-3) ENGINES
CHART D



B521856

13TH, 14TH AND 15TH STAGE LOCK AND SETSCREW ASSEMBLY
CHART E

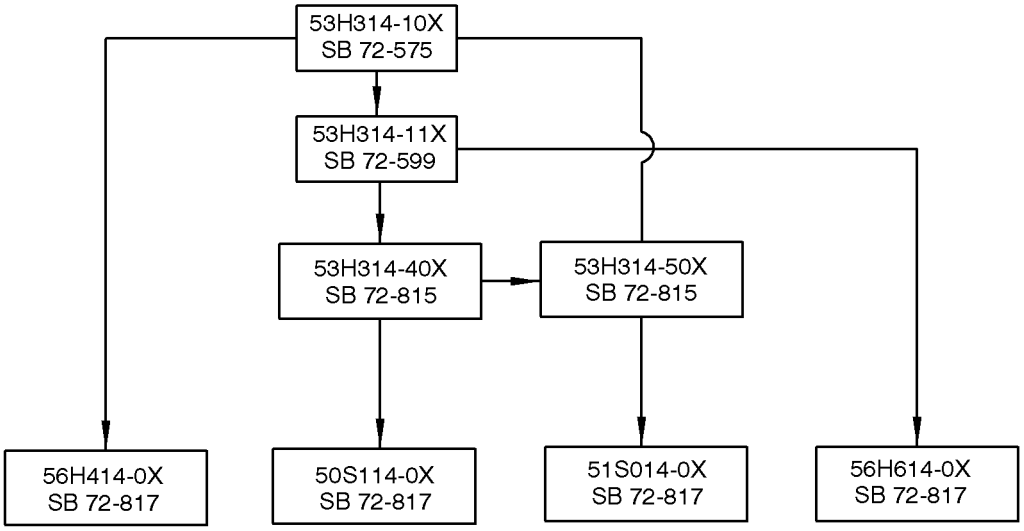
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B522774

* ALL DASH NUMBERS PROGRESS TO THE SAME DASH NUMBER WITH THE SAME FINAL DIGIT

13TH STAGE BLADES
CHART F

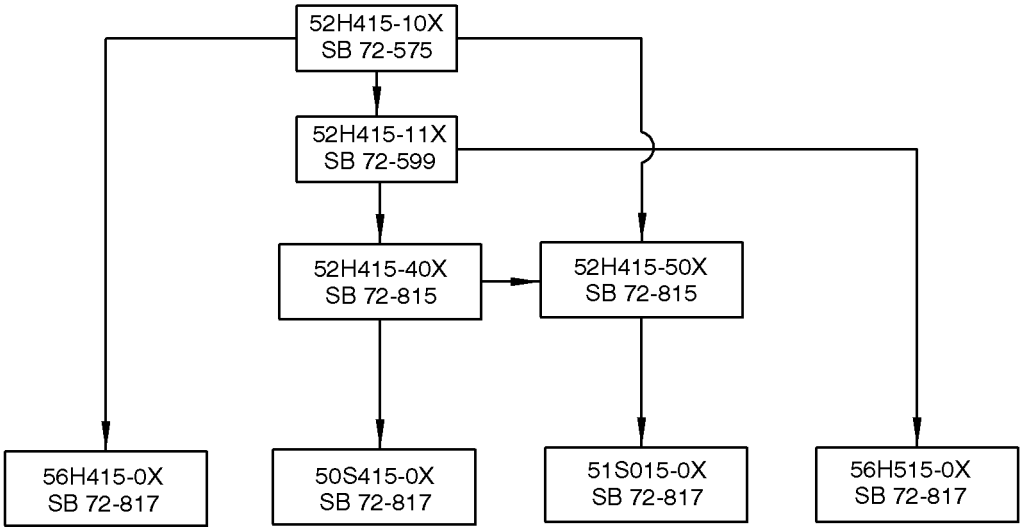


B522775

* ALL DASH NUMBERS PROGRESS TO THE SAME DASH NUMBER WITH THE SAME FINAL DIGIT

14TH STAGE BLADES
CHART G

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* ALL DASH NUMBERS PROGRESS TO THE
SAME DASH NUMBER WITH THE SAME FINAL DIGIT

B522776

15TH STAGE BLADES
CHART H

Added Data

Internal Reference Information

Revision No.	Reference Document	Origination
Original	EC09KA021 EC09KA021G EC09KA021X EC09KA021Y EC10KK044T	RG/IEL

Number values shown in parentheses adjacent to U.S. values are International System of units (SI) equivalents.

To calculate part life, include the hours and/or cycles since the part was made. Use the total hours or cycles to calculate life limits that are the result of part modification, a part used in an engine with different thrust, or for some other reason.

Revision to Table of Limits

Reference 5, 6, and 7 Engine Manuals, Chapter/Section 05-10-00, Revision 99, dated September 1, 2012 is scheduled to incorporate the Part Service Life Limits related to this Service Bulletin and will take precedence over the Service Bulletin.

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Revision to Table of Limits life cycles is as follows:

Model	Part Number	Part Name	Life Limit (cycles)
PW4052, PW4056, PW4152	50S425-01	DISK — ASSY OF, HPC DRUM ROTOR	20,000
PW4060, PW4156A, PW4158, PW4460, PW4462	50S425-01	DISK — ASSY OF, HPC DRUM ROTOR	15,000
PW4052(-3), PW4056(-3), PW4152(-3)	50S425-001	DISK — ASSY OF, HPC DRUM ROTOR	20,000
PW4060(-3), PW4062(-3), PW4062A(-3), PW4156A(-3), PW4158(-3), PW4460(-3), PW4462(-3)	50S425-001	DISK — ASSY OF, HPC DRUM ROTOR	15,000
PW4052(-3), PW4056(-3), PW4152(-3)	50S813-01	DISK — ASSY OF, HPC DRUM ROTOR	20,000
PW4060(-3), PW4062(-3), PW4062A(-3), PW4156A(-3), PW4158(-3), PW4460(-3), PW4462(-3)	50S813-01	DISK — ASSY OF, HPC DRUM ROTOR	15,000

Appendix

NOTE: Reference 5, 6, and 7 Engine Manuals, Revision 99, dated September 1, 2012 are scheduled to incorporate the revised assembly instructions related to this Service Bulletin and will take precedence over the Service Bulletin.

Part A: Assemble 13th Stage Blades, Locks And Ladder Seals By The Procedure That Follows:

1. Install 13th stage blades in the axial compressor rotor assembly with Drum Rotor Assembly, PN 50S813-01 by the procedure that follows. See Figures 11 thru 17.

   NOTE: There are three part numbers (sets) of blades provided for this stage. Set Type A, contains most of the blades to be installed around the drum. Set Type B, has notches in the right edge of blade platforms. Set Type C, has notches in the left edge of blade platforms. When Types B and C blades are placed together, clearance is formed for a blade lock. Set Type A has wide and narrow platforms based on part number so that these blades can be used for fitting. For ease of assembly, blades in this procedure will be referred to as Types A, B, and C. See Figure 11.

   A. Use an approved marking pen to make a "V" mark directly above the two loading slots 180° apart and four locking slots. Make the marks on the upper rail of the 13th stage disk. These

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marks will be used for future reference. Refer to temporary marking of parts as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-11-00. See Figure 12.

CAUTION: WHEN YOU NEED TO MOVE AND SET THE BLADES IN THE ASSEMBLY PROCEDURE WHICH FOLLOWS, USE THE PWA 86448 DRIFT. THE USE OF A DIFFERENT METHOD TO MOVE AND SET THE BLADES CAN CAUSE AIRFOIL DAMAGE.

B. Remove the 13th stage blades from their storage rack and put them on a work bench. Find the four Type B and four Type C blades and move them to one side. See Figure 11.

C. Move to the one of the loading slots and install blades into the 13th stage disk rail with the blades convex side up as follows:

(1) Install four Type B blades into the loading slot and put them so that the right side platform of the fourth blade is located midway in the loading slot located 180° from the assembler.

(2) Install four Type C against the last installed blades.

(3) Install 35 Type A wide platform (regular) blades against the locking blade.

D. Install blades counter-clockwise (left to right) with the blades convex side up as follows:

(1) Install 14 Type A wide platform (regular) blades against the locking blades.

(2) Install 20 Type A narrow platform (spacer) blades against the last installed blade.

NOTE: A total of 77 blades are installed at this time. One regular blade is not installed at this time.

E. Measure and record the width of the remaining regular blade platform.

NOTE: Do not install the remaining blade at this time.

F. At the blade gap, move the blades tangentially to make the widest possible space between two blades. This space will be measured and used to calculate the specified clearance between the blades.

(1) Use a PWA 85595, Spreader, with grooves in the jaws against the blade platforms, to apply a tangential force to the blades.

(2) Expand the spreader to get the widest possible distance between the blade platforms. Make sure that each blade platform touches the adjacent blade platform. If you need help to move the blades, you can tap lightly on the base of the airfoil with a PWA 86448, Drift.

(3) Pull the blades in a radially outward direction to prevent a circumferential serpentine shape to the blades.

(4) If necessary, adjust the spreader to get the widest possible distance between the blade platforms.

(5) With the blade spreader in place, use a dial caliper to measure the blade gap (space dimension made by the missing blade).

(6) Record the clearance dimension.

G. Calculate the initial blade clearance dimension. Initial clearance "C" = Blade Space Dimension - Blade Width

H. If the initial clearance "C" is equal to or greater than 0.010 inch (0.254 mm) and less than or equal to 0.030 inch (0.762 mm) go to blade installation.

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I. If the initial clearance "C" is greater than 0.030 inch (0.762 mm), go to blade installation Method A.

J. If the initial clearance "C" is less than 0.010 inch (0.254 mm), go to blade installation Method B.

K. Type A blade selection, Method A.

(1) Calculate the number of Type A narrow platform (spacer) blades you must replace with Type A wide platform (regular) blades.

(2) Calculate Clearance "D". Clearance "D" = Initial Clearance "C" - 0.020 inch or Clearance "D" = Initial Clearance "C" - (0.508 mm).

(3) Calculate the number of blades to replace "E". "E" = Clearance "D"/0.010 inch or "E" = Clearance "D"/(0.254 mm).

(4) Round off the number of blades "E" to the nearest whole number to get the number of Type A wide platform (regular) blades that you must add. Remove one narrow platform (spacer) blade for each wide platform (regular) blade that you add.

Example 1:

Blade Width = 0.960 inch. Blade Space = 0.991 inch.

Initial Clearance "C" = Blade Space - Blade Width Dimension

"C" = 0.991 - 0.960 inch. "C" = 0.031 inch

Clearance "D" = Initial Space "C" - 0.020 inch

"D" = 0.031 - 0.020 inch. "D" = 0.011 inch

Calculate the number of blades to replace "E"

"E" = "D"/0.010 inch "E" = 0.011 inch/0.010 inch "E" = 1.1

Round to the nearest whole number to get the number of blades to add.

"E" = 1 Type A wide platform (regular) blade

L. Type A blade selection, Method B.

(1) Calculate the number of Type A wide platform (regular) blades you must replace with Type A narrow platform (spacer) blades.

(2) Calculate the Clearance "D".

Clearance "D" = Initial Clearance "C" - 0.020 inch or,

Clearance "D" = Initial Clearance "C" - (0.508 mm)

(3) Calculate the number of blades to replace "E".

"E" = Clearance "D"/0.010 inch or, "E" = Clearance "D"/(0.254 mm)

(4) Round off the number of blades "E" to the nearest whole number to get the number of Type A narrow platform (spacer) blades that you must add. Remove one wide platform (regular) blade for each narrow platform (spacer) blade that you add.

Example 2:

Blade Width = 0.960 inch. Blade Space = 0.926 inch

Initial Clearance "C" = Blade Space - Blade Width Dimension

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"C" = 0.926 - 0.960 inch. "C" = -0.034 inch

Clearance "D" = Initial Clearance "C" - 0.020 inch

"D" = -0.034 - 0.020 inch. "D" = -0.054 inch

Calculate the number of blades to replace "E".

"E" = "D"/0.010 inch "E" = -0.054 inch/0.010 inch "E" = -5.4.

Round "E" to the nearest whole number and drop the minus sign to get the number of blades to add.

"E" = 5 Type A narrow platform (spacer) blades.

M. Turn the entire blade set clockwise approximately half the width of a blade platform to get the blade loading slot.

NOTE: You can use Tape (P05-341) or equivalent at the opposite loading slot so that the blades will not fall from the loading slot.

N. Install the remaining blade(s), including any replacement blades convex side up.

O. Move the blades tangentially to make the widest possible clearance. Make sure that each blade platform touches the adjacent blade platform. Pull the blades in a radially outward direction to prevent a circumferential serpentine shape to the blades.

P. Use a feeler gage to make sure that the gap (clearance) between the blade platforms is between 0.010 − 0.030 inch (0.25 − 0.76 mm). If the clearance is not in the limits, you must do the above blade installation procedure and clearance calculation again.

Q. Turn the blade set to remove the blades from the drum.

R. Based on the part number suffix, put the blades into a tray in the sequence shown in Table 15 if you will use 18 spacer blades, Table 16 if you will use 20 spacer blades, or Table 17 if you will use 22 spacer blades.

S. If you replace Type A blades to get the correct blade clearance space, put the replacement blades in the correct position as follows:

(1) Put the Type A wide platform (regular) blades 180° apart and the Type A narrow platform (spacer) blades 180° apart as best possible.

(2) Equally space the wide platform (regular) and narrow platform (spacer) blades around the disk as best possible.

T. Use an approved marking pen to make a mark on each blade to show its sequence number shown in Table 15. The mark should be on the convex side of the upper tip corner.

Table 15: Blade Location/Blade Part Number Suffix

BLADE LOCATION NUMBERS IF YOU USE 18 SPACER BLADES											
Column 1		Column 2		Column 3		Column 4		Column 5		Column 6	
#	Blade	#	Blade	#	Blade	#	Blade	#	Blade	#	Blade
1	-01	14	-01	27	-04	40	-01	53	-01	66	-04
2	-01	15	-04	28	-01	41	-01	54	-04	67	-01
3	-04	16	-01	29	-01	42	-04	55	-01	68	-01

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BLADE LOCATION NUMBERS IF YOU USE 18 SPACER BLADES											
4	-01	17	-01	30	-04	43	-01	56	-01	69	-04
5	-01	18	-01	31	-01	44	-01	57	-01	70	-01
6	-01	19	-02	32	-01	45	-01	58	-02	71	-01
7	-04	20	-03	33	-04	46	-04	59	-03	72	-04
8	-01	21	-02	34	-01	47	-01	60	-02	73	-01
9	-01	22	-03	35	-01	48	-01	61	-03	74	-01
10	-01	23	-01	36	-04	49	-01	62	-01	75	-04
11	-04	24	-01	37	-01	50	-04	63	-01	76	-01
12	-01	25	-01	38	-01	51	-01	64	-01	77	-01
13	-01	26	-04	39	-01	52	-01	65	-04	78	-01

NOTE: The blade part number suffixes in this table are based on Type A (regular) blades that have wide platforms with Suffix -01, Type A (spacer) blades that have narrow platforms with Suffix -04, Type B blades with Suffix -02, and Type C blades with Suffix -03.

This chart does not show Type A replaced blades, if any, that can be necessary to adjust the clearance between the blade platforms. See the text for replacement blade requirements.

Table 16: Blade Location/Blade Part Number Suffix

BLADE LOCATION NUMBERS IF YOU USE 20 SPACER BLADES											
Column 1		Column 2		Column 3		Column 4		Column 5		Column 6	
#	Blade	#	Blade	#	Blade	#	Blade	#	Blade	#	Blade
1	-01	14	-01	27	-01	40	-01	53	-01	66	-01
2	-01	15	-04	28	-01	41	-01	54	-04	67	-01
3	-04	16	-01	29	-04	42	-04	55	-01	68	-04
4	-01	17	-01	30	-01	43	-01	56	-01	69	-01
5	-01	18	-01	31	-01	44	-01	57	-01	70	-01
6	-04	19	-02	32	-04	45	-04	58	-02	71	-04
7	-01	20	-03	33	-01	46	-01	59	-03	72	-01
8	-01	21	-02	34	-01	47	-01	60	-02	73	-01
9	-04	22	-03	35	-04	48	-04	61	-03	74	-04
10	-01	23	-01	36	-01	49	-01	62	-01	75	-01
11	-01	24	-01	37	-01	50	-01	63	-01	76	-01

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BLADE LOCATION NUMBERS IF YOU USE 20 SPACER BLADES											
12	-04	25	-04	38	-04	51	-04	64	-04	77	-04
13	-01	26	-01	39	-01	52	-01	65	-01	78	-01

NOTE: The blade part number suffixes in this table are based on Type A (regular) blades that have wide platforms with Suffix-01, Type A (spacer) blades that have narrow platforms with Suffix -04, Type B blades with Suffix -02, and Type C blades with Suffix -03.

This chart does not show Type A replaced blades, if any, that can be necessary to adjust the clearance between the blade platforms. See the text for replacement blade requirements.

Table 17: Blade Location/Blade Part Number Suffix

BLADE LOCATION NUMBERS IF YOU USE 22 SPACER BLADES											
Column 1		Column 2		Column 3		Column 4		Column 5		Column 6	
#	Blade	#	Blade	#	Blade	#	Blade	#	Blade	#	Blade
1	-04	14	-01	27	-01	40	-04	53	-01	66	-01
2	-01	15	-01	28	-04	41	-01	54	-01	67	-04
3	-01	16	-04	29	-01	42	-01	55	-04	68	-01
4	-04	17	-01	30	-01	43	-04	56	-01	69	-01
5	-01	18	-01	31	-04	44	-01	57	-01	70	-04
6	-01	19	-02	32	-01	45	-01	58	-02	71	-01
7	-04	20	-03	33	-01	46	-01	59	-03	72	-01
8	-01	21	-02	34	-04	47	-01	60	-02	73	-04
9	-01	22	-03	35	-01	48	-01	61	-03	74	-01
10	-04	23	-01	36	-01	49	-04	62	-01	75	-01
11	-01	24	-01	37	-04	50	-01	63	-01	76	-04
12	-01	25	-04	38	-01	51	-01	64	-04	77	-01
13	-04	26	-01	39	-01	52	-04	65	-01	78	-01

NOTE: The blade part number suffixes in this table are based on Type A (regular) blades that have wide platforms with Suffix-01, Type A (spacer) blades that have narrow platforms with Suffix-04, Type B blades with Suffix-02, and Type C blades with Suffix-03.

This chart does not show Type A replaced blades, if any, that can be necessary to adjust the clearance between the blade platforms. See the text for replacement blade requirements.

U. Make marks to identify the two ladder seals as follows:

(1) Put the two ladder seals on a work bench with the "X" mark down.

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(2) Put a Number 1 (#1) mark on one of the ladder seals and a Number 2 (#2) mark on the second seal.

NOTE: Ladder seal #1 blade slot farthest to the right is the position for blade No. 1 and the next slot to the left is the blade No. 2 and so on. The 19th, 20th, 21st, and 22nd slots are locking blade slots. The openings (cut rungs) between the 19th, 20th, 21st, and 22nd slots are for blade locks.

Ladder seal #2 blade slot farthest to the right is the position for blade No. 40 and the next slot to the left is for blade No. 41 and so on. The 58th, 59th, 60th and 61st slots are locking blade slots. The openings (cut rungs) between the 58th and 59th, 60th and 61st slots are for blade locks.

V. Install blades with two assemblers (preferred method).

CAUTION: IN THE FOLLOWING STEPS HANDLE THE LADDER SEAL WITH CARE. DO NOT BEND OR FOLD THE SEAL SUCH THAT THE SHAPE BECOMES DEFORMED.

(1) In the following steps, you can apply Antigallant Compound, P06-036 or Dry Film Lubricant, P06-041 to the ladder seal, disk rim and rails to help assemble the blades and seals in the disk.

(2) Assembler 1:

(a) Put the ladder seal #1 over one loading slot on the 13th stage disk rim with the X mark on the seal up (engine forward) and the flat surface toward the assembler.

(b) Align the seal circumferentially so that the cut ring (lock position) on the seal is over one disk lock slot at one location. A rung of the seal must be over the loading slot.

(c) Adjust the seal as necessary to install blade No. 21 through the seal and the loading slot.

NOTE: When you install the blades, make sure that the seals are installed between the disk rails. Move the blades, locks, and seals in the disk rail as necessary to complete the blade installation procedure.

(3) Assembler 2:

(a) Put the ladder seal #2 over the remaining loading slot on the disk rim. The X mark on the seal up (engine forward) and the flat surface toward the assembler.

NOTE: In the following steps you will install the blades clockwise (right to left).

(b) Align the seal circumferentially so that the cut rung (lock position) on the seal is over one 13th stage disk lock slot 180° from seal No. 1. A rung of the seal must be over the loading slot.

(c) Adjust the ladder seal as necessary to install blade No. 60 through the seal and the loading slot.

NOTE: When you install the blades, make sure that the seals are installed between the disk rails. Move the blades, locks, and seals in the disk rail as necessary to complete the blade installation procedure.

(4) Assembler 1:

(a) Install blade No. 21 (-02) through the ladder seal and into the loading slot, convex side up.

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(5) Assembler 2:

(a) Install blade No. 60 (-02) through the ladder seal and into the loading slot, convex side up.

(6) Turn the blades and seals in the disk rail as needed to put the cut ring in the ladder seal with the loading slot in the disk.

(7) Install one lock assembly each, through the loading slot into the disk rail and hold the lock assembly against the installed blade Nos. 21 and 60.

(8) Turn the blades and seals in the disk rail as needed to install the next blade in each ladder seal.

(9) Assembler 1:

(a) Install blade No. 22 (-03) through the ladder seal and the loading slot.

(10) Assembler 2:

(a) Install blade No. 61 (-03) through the ladder seal and the loading slot.

(11) Turn the blades and seals in the disk rail as needed to install the next blade in each seal.

(12) Assembler 1:

(a) Install blade No. 23 through the ladder seal and the loading slot.

(13) Assembler 2:

(a) Install blade No. 62 through the ladder seal and the loading slot.

(14) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(15) Assembler 1:

(a) Install blade No. 24 through the ladder seal and the loading slot.

(16) Assembler 2:

(a) Install blade No. 63 through the ladder seal and the loading slot.

(17) Use the above procedure and continue to assemble the blades in ascending numerical order.

(18) Assembler 1:

(a) Use the same loading slot to install blade Nos. 40, 41, and so on in ladder seal #2 until the set of locking blades and lock assembly slots (cut rung) is at the disk loading slot.

(19) Assembler 2:

(a) Use the same loading slot to install blade Nos. 1, 2, and so on in ladder seal #1 until the set of locking blades and lock assembly slots (cut rung) is at the disk loading slot.

(20) Put Tape, P05-341 over the two groups of installed blades to loosely hold the blade groups together.

(21) Turn the blades, locks, and seals around the disk rail to install the remaining locking blades and lock assemblies.

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(22) Assembler 1:

(a) Install blade No. 58 (-02) through the ladder seal and the loading slot.

(23) Assembler 2:

(a) Install blade No. 19 (-02) through the ladder seal and the loading slot.

(24) Turn the blades, locks, and seals around the disk rail to put the cut rung in the ladder seal at the loading slot in the disk.

(25) Install one lock assembly each, through the loading slot into the disk rail and hold the lock assembly against the installed blade Nos. 19 and 58.

(26) Turn the blades and seals in the disk rail as needed to install the next blade in each seal.

(27) Assembler 1:

(a) Install blade No. 59 (-03) through the ladder seal and the loading slot.

(28) Assembler 2:

(a) Install blade No. 20 (-03) through the ladder seal and the loading slot.

(29) Make sure that no part of the ladder seal can be seen.

(30) Assembler 1 and 2: Move the blades, locks, and ladder seals in the disk rail in the opposite direction until the blade locks line up with the reference ink marks on the outer diameter of the 13th stage disk rail.

(31) Tighten and torque the set screws in the four lock and setscrew assemblies.

(a) Torque the setscrew to the running torque plus 4 − 8 lb-in (0.452 − 0.904 N.m). Use a PWA 83135 Driver and PWA 83136 Extension for multi-spline setscrews.

(32) Check the clearance of the blade lock and the top of the blade platform by one of the methods that follow:

(a) Method 1: Measure the height clearance between blade lock and the top of the blade platform, with PWA 78064 Gage. Lock shank must be flush to 0.035 inch (0.889 mm) below blade platform.

(b) Method 2: The lock shank top surface must be approximately flush with or below the blade platform. The top of the setscrew can have up to one full thread exposed above or recessed below the face of the lock shank.

(c) If these limits are not kept, make sure that the lock is correctly assembled in the disk.

(33) Blade clearance (called gap) inspection on the both sides of the drum.

(a) Create a blade gap by forcing the (-01) and/or (-04) blades against the locking blades in each Arc BG. See Figure 12.

(b) Use a feeler gage to make sure that the clearance in each arc is 0.005 inch (0.127 mm) or greater.

1 If the clearance is less than 0.005 inch (0.127 mm), the blades must be removed, re-distributed and assembled again to obtain this clearance.

NOTE: You can change the quantity of regular and spacer blades to get the 0.005 inch (0.127 mm) or greater clearance.

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(34) Examine the assembly for foreign objects, damage, and correct assembly.

(35) Install all the necessary protection covers.

Part B: Assemble 14th Stage Blades, Locks And Ladder Seals By The Procedure That Follows:

1. Install 14th stage blades in the (debladed) axial compressor rotor assembly with Drum Rotor Disk Assembly, PN 50S813-01 by the procedure that follows. See Figures 11 thru 17.

   NOTE: There are three part numbers (sets) of blades provided for this stage. Set Type A, contains most of the blades to be installed around the drum. Set Type B, has notches in the right edge of blade platforms. Set Type C, has notches in the left edge of blade platforms. When Types B and C blades are placed together, clearance is formed for a blade lock. Set Type A has wide and narrow platforms based on part number so that these blades can be used for fitting. For ease of assembly, blades in this procedure will be referred to as Types A, B, and C. See Figure 11.

   A. Use an approved marking pen to make a "V" mark directly above the two loading slots 180° apart and eight locking slots. Make the marks on the upper rail of the 15th stage disk. These marks will be used for future reference. Refer to temporary marking of parts as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-11-00. See Figure 13.

      CAUTION: WHEN YOU NEED TO MOVE AND SET THE BLADES IN THE ASSEMBLY PROCEDURE WHICH FOLLOWS, USE THE PWA 86448 DRIFT. THE USE OF A DIFFERENT METHOD TO MOVE AND SET THE BLADES CAN CAUSE AIRFOIL DAMAGE.

   B. Remove the 14th stage blades from their storage rack and put them on a work bench. Find the eight Type B and eight Type C blades and move them to one side. See Figure 11.

   C. Separate the Type A blades that have a part number with a -04 suffix. These are called spacer blades. Use an approved marking pen to make an "S" mark on the blade tip on the convex side of the airfoil.

   D. Install a lock and setscrew assembly into the locking slot to the right of either loading slot on the 14th stage disk. Assemble the radius on the lock into the locking openings. Use the PWA 83135, Driver to tighten the setscrew.

   E. Move to the loading slot 180° from the blade lock you installed and install the blades and blade locks into the 14th stage disk rail as follows:

   F. Install blades and locks clockwise (right to left), with the blades convex side up as follows:

      (1) Install one Type B blade next to the lock.

      (2) Install one Type C blade next to the locking blade.

      (3) Install one lock and set screw assembly next to the locking blade.

      (4) Install one Type B blade next to the lock.

      (5) Install one Type C blade next to the locking blade.

      (6) Install one lock and set screw assembly next to the locking blade.

      (7) Install one Type B blade next to the lock.

   G. Continue to install blades and locks clockwise (right to left), with the blades convex side up as follows:

      (1) Install 27 Type A wide platform (regular) blades.

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(2) Install two Type A narrow platform (spacer) blades.

(3) Install one Type C locking blade.

(4) Install one lock and setscrew assembly.

(5) Install one Type B locking blade next to the lock.

NOTE: A total of 35 blades and four locks are installed at this time. One regular blade is not installed at this time.

H. Install blades and locks counter-clockwise (left to right), with the blades convex side up as follows:

(1) Install one Type C locking blade next to the lock that was installed before.

(2) Install one Type B locking blade next to the locking blade.

(3) Install one lock and setscrew assembly next to the locking blade.

(4) Install one Type C locking blade next to the lock.

(5) Install one Type B locking blade next to the locking blade.

(6) Install one lock and setscrew assembly next to the locking blade.

(7) Install one Type C locking blade next to the lock.

(8) Install one Type B locking blade next to the locking blade.

(9) Install one lock and setscrew assembly next to the locking blade.

(10) Install one Type C locking blade next to the lock.

I. Continue to install blades and locks counter-clockwise (left to right), with the blades convex side up as follows:

(1) Install 27 Type A wide platform (regular) blades.

(2) Install two Type A narrow platform (spacer) blades.

(3) Install one Type B locking blade.

(4) Install one lock and setscrew assembly next to the locking blade.

(5) Install one Type C locking blade next to the lock.

NOTE: A total of 74 blades and eight locks are installed at this time. Two Type A wide platform (regular) blades are not installed at this time.

J. Make sure that four locking blades and two locks are positioned at each loading slot.

K. Position and tighten two locks at the two loading slots only.

L. From the loading slot, move approximately 90° to the assembler's right and make a clearance between the blades.

M. Use an approved marking pen to make an "X" mark on the slanted surface of the drum assembly above the clearance.

N. Move the blades tangentially to make the widest possible space between two blades as follows:

NOTE: This space will be measured and used to calculate the initial clearance between the blades.

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(1) Use a PWA 85595, Spreader with grooves in the jaws against the blade platforms, to apply a tangential force to the blades.

(2) Expand the spreader to get the widest possible distance between the blade platforms. Make sure that each blade platform touches the adjacent blade platform. If you need help to move the blades, you can tap lightly on the base of the airfoil with a PWA 86448, Drift.

(3) Pull the blades in a radially outward direction to prevent a circumferential serpentine shape to the blades.

(4) If necessary, adjust the spreader to get the widest possible distance between the blade platforms.

(5) With the blade spreader in place, use a dial caliper to measure the blade space dimension.

(6) Record the clearance dimension as "X1".

(7) Remove the blade spreader from the drum assembly.

O. Measure the width of the remaining regular blade platform. Record the width of the blade platform as "X2".

P. Move to the opposite side of the drum (approximately 180° form where the blade clearance was measured and make one clearance between the blades.

Q. Use an approved marking pen to make a "Y" mark on the slanted surface of the drum assembly above the clearance location.

R. Move the blades tangentially to make the widest possible space between two blades as follows:

NOTE: This space will be measured and used to calculate the initial clearance between the blades.

(1) Use a PWA 85595, Spreader, with grooves in the jaws against the blade platforms, to apply a tangential force to the blades.

(2) Expand the spreader to get the widest possible distance between the blade platforms. Make sure that each blade platform touches the adjacent blade platform. If you need help to move the blades, you can tap lightly on the base of the airfoil with a PWA 86448, Drift.

(3) Pull the blades in a radially outward direction to prevent a circumferential serpentine shape to the blades.

(4) If necessary, adjust the spreader to get the widest possible distance between the blade platforms.

(5) With the blade spreader in place, use a dial caliper to measure the blade space dimension. Record the dimension as "Y1".

(6) Remove the blade spreader from the drum assembly.

S. Measure the width of the remaining regular blade platform. Record the width of the blade platform as "Y2".

T. Calculate the initial clearance dimension between the blade platforms for each side of the drum (Sides X and Y).

Initial Clearance "C" = Blade Space Dim. — Blade Width

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U. If the Initial Clearance "C" is equal to or greater than 0.030 inch (0.762 mm) and less than or equal to 0.050 inch (1.270 mm) go to blade installation.

V. If the Initial Clearance "C" is less than 0.030 inch (0.762 mm), go to the step below for Type A Blade Selection, Method A.

W. If the Initial Clearance "C" is more than 0.050 inch (1.270 mm), go to the step below for Type A Blade Selection Method B.

X. Type A Blade Selection, Method A.

(1) Calculate the number of Type A wide platform (regular) blades you must replace with Type A narrow platform (spacer) blades.

(2) Calculate Clearance "D".

Clearance "D" = Initial Clearance "C" − 0.040 inch, or,

Clearance "D" = Initial Clearance "C" − (1.016 mm)

(3) Calculate the number of blades to replace "E".

"E" = Clearance "D"/0.010 inch, or,

"E" = Clearance "D"/(0.254 mm)

(4) Round off the number of blades "E" to the nearest whole number to get the number of Type A narrow platform (spacer) blades that you must add. Remove one wide (regular) blade for each narrow platform (spacer) blade that you must add.

Example 1:

Blade Width = 0.960 inch, Blade Space = 0.931 inch

Initial Clearance "C" = Blade Space − Blade Width

"C" = 0.931 − 0.960 inch. "C" = −0.029 inch

Clearance "D" = Initial Clearance "C" − 0.040 inch

"D" = −0.029 − 0.040 inch. "D" = −0.069 inch

Calculate the number of blades to replace "E".

"E" = "D"/0.010 inch. "E" = −0.069 inch/0.010 inch. "E" = −6.9

Round to the nearest whole number and drop the minus sign to determine the number of blades to replace.

"E" = 7 Type A narrow platform (spacer) blades

Y. Type A blade selection, Method B.

(1) Calculate the number of Type A narrow platform (spacer) blades you must replace with Type A wide platform (regular) blades.

(2) Calculate Clearance "D".

Clearance "D" = Initial Clearance "C" − 0.040 inch, or,

Clearance "D" = Initial Clearance "C" − (1.016 mm)

(3) Calculate the number of blades to replace "E".

"E" = Clearance "D"/0.010 inch, or,

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"E" = Clearance "D"/(0.254 mm)

(4) Round off the number of blades "E" to the nearest whole number to get the number of Type A wide platform (regular) blades required. Remove one narrow platform (spacer) blade for each wide platform (regular) blade.

Example 2:

Blade Width = 0.950 inch. Blade Space = 1.015 inches

Initial Clearance "C" = Blade Space − Blade Width

"C" = 1.015 − 0.950 inch "C" = 0.065 inch

Clearance "D" = Initial Clearance "C" − 0.040 inch

"D" = 0.065 − 0.040 inch "D" = 0.025 inch

Calculate the number of blades to replace "E".

"E" = "D"/0.010 inch "E" = 0.025 inch/0.010 inch "E" = 2.5

Round “E” to the nearest whole number and drop the minus sign to determine the number of blades to replace.

"E" = 3 Type A wide platform (regular) blades

Z. At the two loading slots, loosen the four set screws in the blade locks that were installed before.

NOTE: You can use Tape (P05-341) or equivalent so that the blades will not fall out as they pass the loading slots.

AA. Install the remaining Type A blade(s).

(1) Turn the blade and seal assembly counter-clockwise as necessary to get the full length of the blade loading slot open.

(2) Install the remaining blades, including any replacement blades for side "X" and side "Y" of the 14th stage disk.

NOTE: The full set of blades for this stage should be installed at this time.

AB. Turn the blade and seal assembly clockwise to line up the blade locks with the ink marks on the disk at the loading slots.

AC. Tighten the four setscrews at the two loading slots.

NOTE: Only tighten the four blade locks at the blade loading slots at this time.

AD. Check the space between the blades.

(1) Locate the "X" mark on the drum above the 15th stage disk. At the "X" mark location, move the blades tangentially to make the widest possible clearance.

(2) Pull the blades in a radially outward direction to prevent a circumferential serpentine shape to the blades. Make sure that each blade platform touches the adjacent blade platform and blade lock.

(3) Use a feeler gage to make sure that the clearance between the Type A blade platforms is 0.030 − 0.050 inch (0.76 − 1.27 mm).

NOTE: There can only be one clearance on each side of the 14th stage disk.

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AE. Repeat the above step to check the space between the blades at the "Y" location on the opposite side of the disk.

AF. If the clearance at the "X" or "Y" side of the disk is less than 0.030 inch (0.762 mm) or greater than 0.050 inch (1.270 mm), the blades must be removed, redistributed, and reassembled to meet the requirement.

(1) You can change the quantity of the regular and spacer blades to meet the clearance requirement at each location.

AG. Loosen the four locks installed at the two blade loading slots.

CAUTION: DO NOT MIX THE BLADES FROM THE "X" SIDE OF THE DRUM WITH BLADES FROM THE "Y" SIDE OF THE DRUM OR INCORRECT BLADES PLATFORM SPACES CAN OCCUR.

AH. Remove the blades from the "X" side of the drum and put them in tray locations 1 thru 38 based on part number suffix. Remove the blades from the "Y" side of the drum and put them in tray locations 39 thru 76 based on part number suffix. See Table 18. If you replaced Type A wide platform (regular) and narrow platform (spacer) blades to get the correct blade clearance space, use Table 18 to put the replacement blades in the correct position as follows:

(1) Equally space the Type A wide platform (regular) and narrow platform (spacer) blades around the disk as best possible.

(2) Put the Type A wide platform (regular) blades 180° apart and the Type A narrow platform (spacer) blades 180° apart as best possible.

AI. Use an approved marking pen to make a mark on each blade to show its sequence number. The mark should be on the convex side of the upper tip corner.

Table 18: Blade Location/Blade Part Number Suffix

BLADE LOCATION NUMBERS IF YOU USE 22 SPACER BLADES											
Column 1		Column 2		Column 3		Column 4		Column 5		Column 6	
#	Blade	#	Blade	#	Blade	#	Blade	#	Blade	#	Blade
1	-01	14	-01	27	-01	40	-01	53	-01	66	-01
2	-01	15	-01	28	-01	41	-01	54	-01	67	-01
3	-01	16	-01	29	-01	42	-01	55	-01	68	-01
4	-01	17	-01	30	-01	43	-01	56	-06	69	-01
5	-01	18	-06	31	-01	44	-06	57	-07	70	-06
6	-06	19	-07	32	-06	45	-07	58	-06	71	-07
7	-07	20	-06	33	-07	46	-01	59	-07	72	-01
8	-01	21	-07	34	-01	47	-01	60	-01	73	-01
9	-01	22	-01	35	-01	48	-01	61	-01	74	-01
10	-01	23	-01	36	-01	49	-01	62	-01	75	-01
11	-01	24	-01	37	-01	50	-01	63	-01	76	-01

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BLADE LOCATION NUMBERS IF YOU USE 22 SPACER BLADES											
12	-01	25	-01	38	-01	51	-04	64	-04		
13	-04	26	-04	39	-01	52	-01	65	-01		

NOTE: The blade part number suffixes in this table are based on Type A blades that have wide platforms with suffix -01, and narrow platforms with Suffix -04, Type B blades with Suffix -07, and Type C blades with Suffix -06.

This table does not show Type A replacement blades, if any, that was necessary to adjust the clearance between the blade platforms. See the text for replacement blade requirements.

AJ. Make sure that the center points of the two loading slots and the eight locking slots in the disk have the ink marks. Reapply the marks if necessary.

AK. Obtain the two ladder seals.

(1) Locate the "X" marks by the cut rung on each seal, and put the seals on a work bench with the "X" mark side down.

(2) Use an approved marking pen to make a mark on one of the seals with the Number 1 and the other seal with the Number 2.

NOTE: Ladder seal Number 1 − from the "X" Mark, the slot farthest to the right is the position for blade #1 and the next slot to the left is for blade #2, and so on. The 6th, 7th, 18th, 19th, 20th, 21st, 32nd, and 33rd slots are locking blade slots. The openings (cut rungs) between the 6th and 7th, 18th and 19th, 20th and 21st, and 32nd and 33rd are for blade locks.

Ladder seal Number 2 − from the "X" Mark, the slot farthest to the right is the position for blade #39 and the next slot to the left is for blade #40, and so on. The 44th, 45th, 56th, 57th, 58th, 59th, 70th, and 71st slots are locking blade slots. The openings (cut rungs) between the 44th and 45th, 56th and 57th, 58th and 59th, 70th and 71st slots are for blade locks.

AL. Install blades with two assemblers (preferred method).

CAUTION: HANDLE THE SEALS WITH CARE. DO NOT BEND OR FOLD THE LADDER SEALS SO THE SHAPE BECOMES DEFORMED.

(1) In the following steps, you can apply Antigallant Compound, P06-036 or Dry Film Lubricant, P06-041 to the ladder seal, disk rim and rails to help assemble the blades and seals in the disk.

(2) Assembler 1:

(a) In the following steps, when you install the blades, make sure that the seals are installed between the disk rails. Move the blades, locks, and seal in the disk rail to complete the blade installation procedure.

NOTE: The blade installation process will be clockwise (right to left) except for blade Numbers 5 thru 1.

(b) Put the seal Number 1 over one loading slot on the disk rim. The "X" mark on the seal up (engine forward) and with the flat surface toward the assembler.

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(c) Align the seal circumferentially so that the left cut rung (lock position at the center of the seal) is over one disk lock slot at one location.

NOTE: A rung of the seal must be over the loading slot.

(d) Adjust the seal as necessary so you can install blade Number 20 through the slot and the disk loading slot.

(3) Assembler 2:

(a) In the following steps, when you install the blades, make sure that the seals are installed between the disk rails. Move the blades, locks, and seal in the disk rail to complete the blade installation procedure.

NOTE: The blade loading process will be clockwise (right to left).

(b) Put the seal Number 2 over the remaining loading slot on the disk rim. The "X" mark on the seal up (engine forward) and with the flat surface toward the assembler.

(c) Align the seal circumferentially so that the right cut rung (lock position at the center of the seal) is over the lock slot 180° from seal Number 1.

NOTE: A rung of the seal must be over the loading slot.

(d) Adjust the seal as necessary so you can install blade Number 58 through the slot and the disk loading slot.

(4) Assembler 1:

(a) Install blade Number 20 (-06) through the ladder seal and the loading slot, convex side up.

(5) Assembler 2:

(a) Install blade Number 58 (-06) through the ladder seal and the loading slot, convex side up.

(6) Turn the blades and seal in the disk rail as needed to put the cut rung in the seal with the loading slot in the disk.

(7) Install one lock assembly each, through the loading slot into the disk rail. Hold the lock assembly against the installed blades (Numbers 20 and 58).

(8) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(9) Assembler 1:

(a) Install blade Number 21 (-07) through the ladder seal and the loading slot, convex side up.

(10) Assembler 2:

(a) Install blade Number 59 (-07) through the ladder seal and the loading slot, convex side up.

(11) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(12) Assembler 1:

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(a) Install blade Number 22 through the ladder seal and the loading slot, convex side up.

(13) Assembler 2:

(a) Install blade Number 60 through the ladder seal and the loading slot, convex side up.

(14) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(15) Assembler 1:

(a) Install blade Number 23 through the ladder seal and the loading slot, convex side up.

(16) Assembler 2:

(a) Install blade Number 61 through the ladder seal and the loading slot, convex side up.

(17) Use the above procedure and continue to install the blades in ascending numerical order until you reach the next set of locking blades and lock assembly slots (cut rung).

(18) Turn the blades, locks, and seals in the disk rail as needed to install blade Numbers 32 and Number 70 in the applicable seal.

(19) Assembler 1:

(a) Install blade Number 32 (-06) through the ladder seal and the loading slot, convex side up.

(20) Assembler 2:

(a) Install blade Number 70 (-06) through the ladder seal and the loading slot, convex side up.

(21) Turn the blades, locks, and seals in the disk rail as needed to get the cut rungs in the seal at the loading slot in the disk.

(22) Install one lock assembly each, through the loading slot into the disk rail. Hold the lock assembly against the installed blades (Numbers 32 and 70).

(23) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(24) Assembler 1:

(a) Install blade Number 33 (-07) through the ladder seal and the loading slot, convex side up.

(25) Assembler 2:

(a) Install blade Number 71 (-07) through the ladder seal and the loading slot, convex side up.

(26) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(27) Assembler 1:

(a) Install blade Number 34 through the ladder seal and the loading slot, convex side up.

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(28) Assembler 2:

(a) Install blade Number 72 through the ladder seal and the loading slot, convex side up.

(29) Use the above procedure and continue to install the blades in ascending numerical order until you install blade Numbers 38 and 76 in the applicable seals.

(30) Assembler 1:

(a) Use the same blade loading slot and install blade Numbers 39, 40, and so on in seal Number 2 until you reach the set of locking blades and the lock assembly slots (cut rung) is at the disk loading slot.

(31) Assembler 2:

(a) Use the same slot and install blade Numbers 1, 2, and so on in seal Number 1 until you reach the set of locking blades and the lock assembly slots (cut rung) is at the disk loading slot.

(32) Turn the blades, locks, and seals in the disk rail as needed to install blade Numbers 44 and 6 in the applicable seal.

(33) Assembler 1:

(a) Install blade Number 44 (-06) through the ladder seal and the loading slot, convex side up.

(34) Assembler 2:

(a) Install blade Number 6 (-06) through the ladder seal and the loading slot, convex side up.

(35) Turn the blades, locks, and seals in the disk rail as needed to get the cut rung in the seals at the loading slot in the disk.

(36) Install one lock assembly each, through the loading slot into the disk rail. Hold the lock assembly against the installed blades (Numbers 44 and 6).

(37) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(38) Assembler 1:

(a) Install blade Number 45 (-07) through the ladder seal and the loading slot, convex side up.

(39) Assembler 2:

(a) Install blade Number 7 (-07) through the ladder seal and the loading slot, convex side up.

(40) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(41) Assembler 1:

(a) Install blade Number 46 through the ladder seal and the loading slot, convex side up.

(42) Assembler 2:

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(a) Install blade Number 8 through the ladder seal and the loading slot, convex side up.

(43) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(44) Assembler 1:

(a) Install blade Number 47 through the ladder seal and the loading slot, convex side up.

(45) Assembler 2:

(a) Install blade Number 9 through the ladder seal and the loading slot, convex side up.

(46) Use the above procedure and continue to install the blades in ascending numerical order until you have the next set of locking blades and lock assembly slots (cut rung) at the disk loading slot.

(47) Turn the blades, locks, and seals in the disk rail as needed to install blade Numbers 56 and Number 18 in the applicable seal.

(48) Assembler 1:

(a) Install blade Number 56 (-06) through the ladder seal and the loading slot, convex side up.

(49) Assembler 2:

(a) Install blade Number 18 (-06) through the ladder seal and the loading slot, convex side up.

(50) Turn the blades, locks, and seals in the disk rail as needed to get the cut rung in the seals at the loading slot in the disk.

(51) Install one lock assembly each, through the loading slot into the disk rail. Hold the lock assembly against the installed blades (Numbers 56 and 18).

(52) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(53) Assembler 1:

(a) Install blade Number 57 (-07) through the ladder seal and the loading slot, convex side up.

(54) Assembler 2:

(a) Install blade Number 19 (-07) through the ladder seal and the loading slot, convex side up.

(55) Make sure that no part of the ladder seal can be seen.

(56) Turn the blades, locks, and seals in the opposite direction until the blade locks line up with the reference ink marks on the outer diameter of the 14th stage disk rail.

AM. If necessary, remove tape.

AN. Tighten and torque the set screws in the eight lock and setscrew assemblies.

(1) Torque the setscrew to the running torque plus 4 − 8 lb-in (0.452 − 0.904 N.m). Use a PWA 83135, Driver and PWA 83136, Extension for multi-spline setscrews.

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AO. Check the clearance of the blade lock and the top of the blade platform by one of the methods that follow:

(1) Method 1: Measure the height clearance between blade lock and the top of the blade platform, with PWA 78064, Gage. Lock shank must be flush to 0.035 inch (0.889 mm) below blade platform.

(2) Method 2: The lock shank top surface must be approximately flush with or below the blade platform. The top of the setscrew can have up to one full thread exposed above or recessed below the face of the lock shank.

(3) If these limits are not kept, check the lock for correct assembly in the disk.

AP. Blade clearance (called gap) inspection on the "X" and "Y" sides of the drum.

(1) Create a blade gap by forcing the (-01) and/or (-04) blades against the locking blades in each arc.

(2) There are three gaps to check in the "X" side, and three in the "Y" side of the drum. See Arcs DG and DH in Figure 13.

(3) Use a feeler gage to make sure that the clearance in each of the six arcs is 0.009 inch (0.229 mm) or greater.

(a) If the clearance is less than 0.009 inch (0.229 mm), you must remove the blades, redistribute and assemble the blades again to get in this requirement.

NOTE: You can also change the quantity of regular and spacer blades to get the 0.009 inch (0.229 mm) dimension.

AQ. Examine the assembly for foreign objects, damage, and correct assembly.

AR. Install all the necessary protection covers.

Part C: Assemble 15th Stage Blades, Locks And Ladder Seals By The Procedure That Follows:

1. Install 15th stage blades in the (debladed) axial compressor rotor assembly with Drum Rotor Assembly, PN 50S813-01 by the procedure that follows. See Figures 11 thru 17.

NOTE: There are three part numbers (sets) of blades provided for this stage. Set Type A, contains most of the blades to be installed around the drum. Set Type B, has notches in the right edge of blade platforms. Set Type C, has notches in the left edge of blade platforms. When Types B and C blades are placed together, clearance is formed for a blade lock. Set Type A has wide and narrow platforms based on part number so that these blades can be used for fitting. For ease of assembly, blades in this procedure will be referred to as Types A, B, and C. See Figure 11.

A. Use an approved marking pen to make a "V" mark directly above the two loading slots 180° apart and eight locking slots. Make the marks on the upper rail of the 15th stage disk. These marks will be used for future reference. Refer to temporary marking of parts as specified in Reference 1, Standard Practices Manual, Chapter/Section 70-11-00. See Figure 14.

CAUTION: WHEN YOU NEED TO MOVE AND SET THE BLADES IN THE ASSEMBLY PROCEDURE WHICH FOLLOWS, USE THE PWA 86448 DRIFT. THE USE OF A DIFFERENT METHOD TO MOVE AND SET THE BLADES CAN CAUSE AIRFOIL DAMAGE.

B. Remove the 15th stage blades from their storage rack and put them on a work bench. Find the eight Type B and eight Type C blades and move them to one side. See Figure 11.

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C. Separate the Type A blades that have a part number with a -04 suffix. These are called spacer blades. Use an approved marking pen to make an "S" mark on the blade tip on the convex side of the airfoil.

D. Install a lock and setscrew assembly into the locking slot to the right of either loading slot on the 15th stage disk (lower disk). Assemble the radius on the lock into the locking openings. Use the PWA 83135, Driver and PWA 83136, Extension to tighten the setscrew.

E. Move to the loading slot 180° from the blade lock you installed and install the blades and blade locks into the 15th stage disk rail as follows:

F. Install blades and locks in a clockwise (right to left) with the blades convex side up as follows:

(1) Install one Type B blade next to the lock.

(2) Install one Type C blade next to the locking blade.

(3) Install one lock and set screw assembly next to the locking blade.

(4) Install one Type B blade next to the lock.

(5) Install one Type C blade next to the locking blade.

(6) Install one lock and set screw assembly next to the locking blade.

(7) Install one Type B blade next to the lock.

G. Continue to install blades and locks in a clockwise (right to left) with the blades convex side up as follows:

(1) Install 20 Type A wide platform (regular) blades.

(2) Install six Type A narrow platform (spacer) blades.

(3) Install one Type C locking blade.

(4) Install one lock and setscrew assembly.

(5) Install one Type B locking blade next to the lock.

NOTE: A total of 33 blades and four locks are installed at this time. One regular blade is not installed at this time.

H. Install blades and locks in a counter-clockwise (left to right) with the blades convex side up as follows:

(1) Install one Type C locking blade next to the lock that was installed before.

(2) Install one Type B locking blade next to the locking blade.

(3) Install one lock and setscrew assembly.

(4) Install one Type C locking blade next to the lock.

(5) Install one Type B locking blade next to the locking blade.

(6) Install one lock and setscrew assembly.

(7) Install one Type C locking blade next to the lock.

(8) Install one Type B locking blade next to the locking blade.

(9) Install one lock and setscrew assembly.

(10) Install one Type C locking blade next to the lock.

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I. Continue to install blades and locks, counter-clockwise (left to right), with the blades convex side up as follows:

(1) Install 20 Type A wide platform (regular) blades.

(2) Install six Type A narrow platform (spacer) blades.

(3) Install one Type B locking blade.

(4) Install one lock and setscrew assembly.

(5) Install one Type C locking blade.

NOTE: A total of 68 blades and eight locks are installed at this time. Two Type A wide platform (regular) blades are not installed at this time.

J. Make sure that four locking blades and two locks are positioned at each loading slot.

K. Position and tighten two locks at the two loading slots only.

L. From the loading slot, move approximately 90° to the assembler's right and make a clearance between the blades.

M. Use an approved marking pen to make an "X" mark on the slanted surface of the drum assembly above the clearance.

N. Move the blades tangentially to make the widest possible space between two blades. This space will be measured and used to calculate the specified clearance gap between the blades. See Figure 17, Sheet 3.

(1) Use a PWA 85595, Spreader, with grooves in the jaws against the blade platforms, to apply a tangential force to the blades.

(2) Expand the spreader to get the widest possible distance between the blade platforms. Make sure that each blade platform touches the adjacent blade platform. If you need help to move the blades, you can tap lightly on the base of the airfoil with a PWA 86448, Drift.

(3) Pull the blades in a radially outward direction to prevent a circumferential serpentine shape to the blades.

(4) If necessary, adjust the spreader to get the widest possible distance between the blade platforms.

(5) With the blade spreader in place, use a dial caliper to measure the blade space dimension.

(6) Record the clearance dimension as "X1".

(7) Remove the blade spreader from the drum assembly.

O. Measure the width of the remaining regular blade platform. Record the width of the blade as "X2".

P. Move to the opposite side of the drum (approximately 180° form where the blade clearance was measured and make one clearance between the blades.

Q. Use an approved marking pen to make a "Y" mark on the slanted surface of the drum assembly above the clearance location.

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R. Move the blades tangentially to make the widest possible space between two blades as follows:

NOTE: This space will be measured and used to calculate the initial clearance between the blades.

(1) Use a PWA 85595 Spreader, with grooves in the jaws against the blade platforms, to apply a tangential force to the blades.

(2) Expand the spreader to get the widest possible distance between the blade platforms. Make sure that each blade platform touches the adjacent blade platform. If you need help to move the blades, you can tap lightly on the base of the airfoil with a PWA 86448 Drift.

(3) Pull the blades in a radially outward direction to prevent a circumferential serpentine shape to the blades.

(4) If necessary, adjust the spreader to get the widest possible distance between the blade platforms.

(5) With the blade spreader in place, use a dial caliper to measure the blade space dimension. Record the dimension as "Y1".

(6) Remove the blade spreader from the drum assembly.

S. Measure the width of the remaining regular blade platform. Record the width of the blade as "Y2".

T. Calculate the initial clearance dimension between the blade platforms for the "X" and "Y" sides of the drum.

Initial Clearance "C" = Blade Space Dim. − Blade Width

U. If the Initial Clearance "C" is equal to or greater than 0.060 inch (1.524 mm) and less than or equal to 0.080 inch (2.032 mm) go to blade installation.

V. If the Initial Clearance "C" is less than 0.060 inch (1.524 mm), go to Type A blade replacement selection Method A.

W. If the Initial Clearance "C" is more than 0.080 inch (2.032 mm), go to Type A blade replacement selection Method B.

X. Type A Blade Selection, Method A.

(1) Calculate the number of Type A wide platform (regular) blades you must replace with Type A narrow platform (spacer) blades.

(2) Calculate Clearance "D".

Clearance "D" = Initial Clearance "C" − 0.070 inch or,

Clearance "D" = Initial Clearance "C" − (1.778 mm)

(3) Calculate the number of blades to replace "E".

"E" = Clearance "D"/0.010 inch or, "E" = Clearance "D"/(0.254 mm)

(4) Round off the number of blades "E" to the nearest whole number to get the number of Type A narrow platform (spacer) blades that you must add. Remove one wide (regular) blade for each narrow platform (spacer) blade that you must add.

Example 1:

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Blade Width = 0.960 inch. Blade Space = 0.931 inch

Initial Clearance "C" = Blade Space − Blade Width

"C" = 0.931 − 0.960 inch. "C" = −0.029 inch

Clearance "D" = Initial Clearance "C" − 0.070 inch

"D" = −0.029 − 0.070 inch. "D" = −0.099 inch

Calculate the number of blades to replace "E".

"E" = "D"/0.010 inch. "E" = −0.099 inch/0.010 inch. "E" = −9.9

Round "E" to the nearest whole number and drop the minus sign to determine the number of wide platform (regular) blades to replace.

"E" = 10 Type A narrow platform (spacer) blades

Y. Type A Blade Selection, Method B.

(1) Calculate the number of Type A narrow platform (spacer) blades you must replace with Type A wide platform (regular) blades.

(2) Calculate Clearance "D".

Clearance "D" = Initial Clearance "C" − 0.070 inch, or,

Clearance "D" = Initial Clearance "C" − (1.778 mm)

(3) Calculate the number of blades to replace "E".

"E" = "D"/0.010 inch or, "E" = "D"/(0.254 mm)

(4) Round off the number of blades E to the nearest whole number to get the number of Type A wide platform (regular) blades required. Remove one narrow platform (spacer) blade for each wide platform (regular) blade that you must add.

Example 2:

Blade Width = 0.920 inch. Blade Space = 1.001 inches

Initial Clearance "C" = Blade Space − Blade Width

"C" = 1.001 − 0.920 inch. "C" = 0.081 inch

Clearance "D" = Initial Clearance "C" − 0.070 inch

"D" = 0.081 − 0.070 inch. "D" = 0.011 inch

Calculate the number of blades to replace "E".

"E" = "D"/0.010 inch. "E" = 0.011 inch/0.010 inch. "E" = 1.1

Round "E" to the nearest whole number to determine the number of blades to replace.

"E" = 1 Type A wide platform (regular) blade

Z. At the two loading slots, loosen the four set screws in the blade locks that were installed before.

NOTE: You can use Tape, P05-341 or equivalent at the opposite loading slot so that the blades will not fall out.

AA. Install the remaining Type A blade(s).

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(1) Turn the full blade set counter-clockwise as necessary to get the full length of the blade loading slot open.

(2) Install the remaining blades, including any replacement blades for side "X" and side "Y" of the 15th stage disk.

NOTE: The full set of blades for this stage should be installed at this time.

AB. Turn the full blade set clockwise until the blade locks line up with the ink marks on the disk at the loading slots.

AC. Tighten the four setscrews at the two loading slots.

NOTE: Only tighten the four blade locks at the blade loading slots.

AD. Check the space between the blades.

(1) Locate the "X" mark on the drum above the 15th stage disk. At the "X" mark location, move the blades tangentially to make the widest possible clearance.

(2) Pull the blades in a radially outward direction to prevent a circumferential serpentine shape to the blades. Make sure that each blade platform touches the adjacent blade platform and blade lock.

NOTE: There can only be one clearance on each side of the 15th stage disk.

(3) Use a feeler gage to make sure that the clearance between the Type A blade platforms is 0.060 − 0.080 inch (1.52 − 2.03 mm). If the clearance is not in the limits, you must remove and redistribute the blades and calculate the clearance dimension again.

NOTE: You can change the quantity of regular and spacer blades to get the 0.060 − 0.080 inch (1.52 − 2.03 mm) clearance.

AE. Repeat the above step to check the space between the blades at the "Y" location on the opposite side of the disk.

AF. The total clearance for both sides is 0.120 − 0.160 inch (3.05 − 4.06 mm).

AG. If the clearance at the "X" or "Y" side of the disk is less than 0.060 inch (1.524 mm) or greater than 0.080 inch (2.032 mm), the blades must be removed, redistributed, and reassembled to get the requirement.

NOTE: You can change the quantity of the regular and spacer blades to get the clearance requirement at each location.

AH. Loosen the four locks installed at the two blade loading slots.

CAUTION: DO NOT MIX THE BLADES FROM THE "X" SIDE OF THE DRUM WITH BLADES FROM THE "Y" SIDE OF THE DRUM OR INCORRECT BLADE PLATFORM SPACES CAN OCCUR.

AI. Remove the blades from the "X" side of the drum and put them in tray locations 1 through 35 based on part number suffix. Remove the blades from the "Y" side of the drum and put them in tray locations 36 through 70 based on part number suffix. See Table 19. If you replaced Type A wide platform (regular) and narrow platform (spacer) blades to get the correct blade clearance space, use Table 19 to put the replacement blades in the correct position as follows:

(1) Equally space the wide platform (regular) and narrow platform (spacer) blades around the disk as best possible.

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(2) Put the Type A wide platform (regular) blades 180° apart and the Type A narrow platform (spacer) blades 180° apart as best possible.

AJ. Use an approved marking pen to make a mark on each blade to show its sequence number. The mark should be on the convex side of the upper tip corner.

Table 19: Blade Location/Blade Part Number Suffix

Column 1		Column 2		Column 3		Column 4		Column 5		Column 6	
#	Blade	#	Blade	#	Blade	#	Blade	#	Blade	#	Blade
1	-04	14	-01	27	-01	40	-01	53	-07	66	-07
2	-01	15	-01	28	-01	41	-06	54	-06	67	-01
3	-01	16	-01	29	-01	42	-07	55	-07	68	-01
4	-01	17	-06	30	-06	43	-01	56	-01	69	-01
5	-01	18	-07	31	-07	44	-01	57	-01	70	-04
6	-06	19	-06	32	-01	45	-01	58	-01		
7	-07	20	-07	33	-01	46	-01	59	-04		
8	-01	21	-01	34	-01	47	-04	60	-04		
9	-01	22	-01	35	-04	48	-04	61	-01		
10	-01	23	-01	36	-04	49	-01	62	-01		
11	-01	24	-04	37	-01	50	-01	63	-01		
12	-04	25	-04	38	-01	51	-01	64	-01		
13	-04	26	-01	39	-01	52	-06	65	-06		

NOTE: The blade part number suffixes in this table are based on Type A blades that have wide platforms with Suffix -01 and narrow platforms with Suffix -04, Type B blades with Suffix -07, and Type C blades with Suffix -06.

This table does not show Type A replacement blades, if any, that was necessary to adjust the clearance between the blade platforms. See the text for replacement blade requirements.

AK. Make sure that the center points of the two loading slots and the eight locking slots in the disk have the ink marks. Reapply the marks if necessary.

AL. Obtain the two ladder seals.

(1) Locate the "X" marks by the cut rung on each seal, and put the seals on a work bench with the "X" mark side down.

(2) Use an approved marking pen to make a mark on one of the seals with the Number 1 and the other seal with the Number 2.

NOTE: Ladder seal Number 1 − from the "X" Mark, the slot farthest to the right is the position for blade #1 and the next slot to the left is for blade #2, and so on. The 6th, 7th, 17th, 18th, 19th, 20th, 30th, and 31st slots are locking blade slots. The openings (cut rungs) between the 6th and 7th, 17th and 18th, 19th and 20th, 30th and 31st are for blade locks.

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Ladder seal Number 2 − from the "X" Mark, the slot farthest to the right is the position for blade #36 and the next slot to the left is for blade #37, and so on. The 41st, 42nd, 52nd, 53rd, 54th, 55th, 65th, and 66th slots are locking blade slots. The openings (cut rungs) between the 41st and 42nd, 52nd and 53rd, 54th and 55th, 65th and 66th slots are for blade locks.

AM. Install blades with two assemblers (preferred method).

CAUTION: HANDLE THE SEALS WITH CARE. DO NOT BEND OR FOLD THE LADDER SEALS SO THE SHAPE BECOMES DEFORMED.

(1) In the following steps, you can apply Antigallant Compound, P06-036 or Dry Film Lubricant, P06-041 to the ladder seal, disk rim and rails to help assemble the blades and seals in the disk.

(2) Assembler 1:

(a) In the following steps, when you install the blades, make sure that the seals are installed between the disk rails. Move the blades, locks, and seal in the disk rail to complete the blade installation procedure.

NOTE: The blade installation process will be clockwise (left to right) except for blade Numbers 5 thru 1.

(b) Put the ladder seal Number 1 over one loading slot on the disk rim. The "X" mark on the seal up (engine forward) and with the flat surface toward the assembler.

(c) Align the seal circumferentially so that the right cut rung (lock position at the center of the seal) is over one disk lock slot at one location.

NOTE: A rung of the seal must be over the loading slot.

(d) Adjust the seal as necessary so you can install blade Number 19 through the slot and the disk loading slot.

(3) Assembler 2:

(a) In the following steps, when you install the blades, make sure that the seals are installed between the disk rails. Move the blades, locks, and seal in the disk rail to complete the blade installation procedure.

NOTE: The blade loading process will be clockwise (left to right).

(b) Put the ladder seal Number 2 over the remaining loading slot on the disk rim. The "X" mark on the seal up (engine forward) and with the flat surface toward the assembler.

(c) Align the seal circumferentially so that the right cut rung (lock position at the center of the seal) is over the lock slot 180° from ladder seal Number 1.

NOTE: A rung of the seal must be over the loading slot.

(d) Adjust the seal as necessary so you can install blade Number 54 through the slot and the disk loading slot.

(4) Assembler 1:

(a) Install blade Number 19 (-06) through the ladder seal and the loading slot, convex side up.

(5) Assembler 2:

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(a) Install blade Number 54 (-06) through the ladder seal and the loading slot, convex side up.

(6) Turn the blades and seal in the disk rail as needed to put the cut rung in the seal with the loading slot in the disk.

(7) Install one lock assembly each, through the loading slot into the disk rail. Hold the lock assembly against the installed blades (Numbers 19 and 54).

(8) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(9) Assembler 1:

(a) Install blade Number 20 (-07) through the ladder seal and the loading slot, convex side up.

(10) Assembler 2:

(a) Install blade Number 55 (-07) through the ladder seal and the loading slot, convex side up.

(11) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(12) Assembler 1:

(a) Install blade Number 21 through the ladder seal and the loading slot, convex side up.

(13) Assembler 2:

(a) Install blade Number 57 through the ladder seal and the loading slot, convex side up.

(14) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(15) Assembler 1:

(a) Install blade Number 22 through the ladder seal and the loading slot, convex side up.

(16) Assembler 2:

(a) Install blade Number 58 through the ladder seal and the loading slot, convex side up.

(17) Use the above procedure and continue to install the blades in ascending numerical order until you reach the next set of locking blades and lock assembly slots (cut rung).

(18) Turn the blades, locks, and seals in the disk rail as needed to install blade Numbers 30 and Number 65 in the applicable seal.

(19) Assembler 1:

(a) Install blade Number 30 (-06) through the ladder seal and the loading slot, convex side up.

(20) Assembler 2:

(a) Install blade Number 65 through the ladder seal and the loading slot, convex side up.

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(21) Turn the blades, locks, and seals in the disk rail as needed to get the cut rungs in the seal at the loading slot in the disk.

(22) Install one lock assembly each, through the loading slot into the disk rail. Hold the lock assembly against the installed blades (Numbers 30 and 65).

(23) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(24) Assembler 1:

(a) Install blade Number 31 (-07) through the ladder seal and the loading slot, convex side up.

(25) Assembler 2:

(a) Install blade Number 66 (-07) through the ladder seal and the loading slot, convex side up.

(26) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(27) Assembler 1:

(a) Install blade Number 32 through the ladder seal and the loading slot, convex side up.

(28) Assembler 2:

(a) Install blade Number 67 through the ladder seal and the loading slot, convex side up.

(29) Use the above procedure and continue to install the blades in ascending numerical order until you install blade Numbers 35 and 70 in the applicable seals.

(30) Assembler 1:

(a) Use the same slot and install blade Numbers 36, 37, and so on in ladder seal Number 2 until you reach the set of locking blades and the lock assembly slots (cut rung) is at the disk loading slot.

(31) Assembler 2:

(a) Use the same slot and install blade Numbers 1, 2, and so on in ladder seal Number 1 until you reach the set of locking blades and the lock assembly slots (cut rung) is at the disk loading slot.

(32) Turn the blades, locks, and seals in the disk rail as needed to install blade Numbers 41 and 6 in the applicable seal.

(33) Assembler 1:

(a) Install blade Number 41 (-06) through the ladder seal and the loading slot, convex side up.

(34) Assembler 2:

(a) Install blade Number 6 (-06) through the ladder seal and the loading slot, convex side up.

(35) Turn the blades, locks, and seals in the disk rail as needed to get the cut rung in the seals at the loading slot in the disk.

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(36) Install one lock assembly each, through the loading slot into the disk rail. Hold the lock assembly against the installed blades (Numbers 41 and 6).

(37) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(38) Assembler 1:

(a) Install blade Number 42 (-07) through the ladder seal and the loading slot, convex side up.

(39) Assembler 2:

(a) Install blade Number 7 (-07) through the ladder seal and the loading slot, convex side up.

(40) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(41) Assembler 1:

(a) Install blade Number 43 through the ladder seal and the loading slot, convex side up.

(42) Assembler 2:

(a) Install blade Number 8 through the ladder seal and the loading slot, convex side up.

(43) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(44) Assembler 1:

(a) Install blade Number 44 through the ladder seal and the loading slot, convex side up.

(45) Assembler 2:

(a) Install blade Number 9 through the ladder seal and the loading slot, convex side up.

(46) Use the above procedure and continue to install the blades in ascending numerical order until you have the next set of locking blades and lock assembly slots (cut rung) at the disk loading slot.

(47) Turn the blades, locks, and seals in the disk rail as needed to install blade Numbers 52 and Number 17 in the applicable seal.

(48) Assembler 1:

(a) Install blade Number 52 (-06) through the ladder seal and the loading slot, convex side up.

(49) Assembler 2:

(a) Install blade Number 17 (-06) through the ladder seal and the loading slot, convex side up.

(50) Turn the blades, locks, and seals in the disk rail as needed to get the cut rung in the seals at the loading slot in the disk.

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(51) Install one lock assembly each, through the loading slot into the disk rail. Hold the lock assembly against the installed blades (Numbers 52 and 17).

(52) Turn the blades, locks, and seals in the disk rail as needed to install the next blade in each seal.

(53) Assembler 1:

(a) Install blade Number 53 (-07) through the ladder seal and the loading slot, convex side up.

(54) Assembler 2:

(a) Install blade Number 18 (-07) through the ladder seal and the loading slot, convex side up.

(55) Make sure that no part of the ladder seal can be seen.

(56) Assembler 1 and 2: Move the blades, locks, and seals in the disk rail in the opposite direction until the blade locks line up with the reference ink marks on the outer diameter of the 15th stage disk rail.

AN. If necessary, remove tape.

AO. Tighten and torque the set screws in the eight lock and setscrew assemblies.

(1) Torque the setscrew to the running torque plus 4 − 8 lb-in (0.452 − 0.904 N.m). Use a PWA 83135 Driver, and PWA 83136, Extension for multi-spline setscrews.

AP. Check the clearance of the blade lock and the top of the blade platform by one of the methods that follow:

(1) Method 1: Measure the height clearance between blade lock and the top of the blade platform, with PWA 78064, Gage. Lock shank must be flush to 0.035 inch (0.889 mm) below blade platform.

(2) Method 2: The lock shank top surface must be approximately flush with or below the blade platform. The top of the setscrew can have up to one full thread exposed above or recessed below the face of the lock shank.

(3) If these limits are not kept, check the lock for correct assembly in the disk.

AQ. Blade clearance (to be referred as gap) inspection on the "X" and "Y" sides of the drum.

(1) Create a blade gap by forcing the (-01) and/or (-04) blades against the locking blades in each arc.

(2) There are three gaps to check in the "X" side, and three in the "Y" side of the drum. See Arcs DG and DH in Figure 14.

(3) Use a feeler gage to make sure that the clearance in each of the six arcs is 0.019 inch (0.483 mm) or greater.

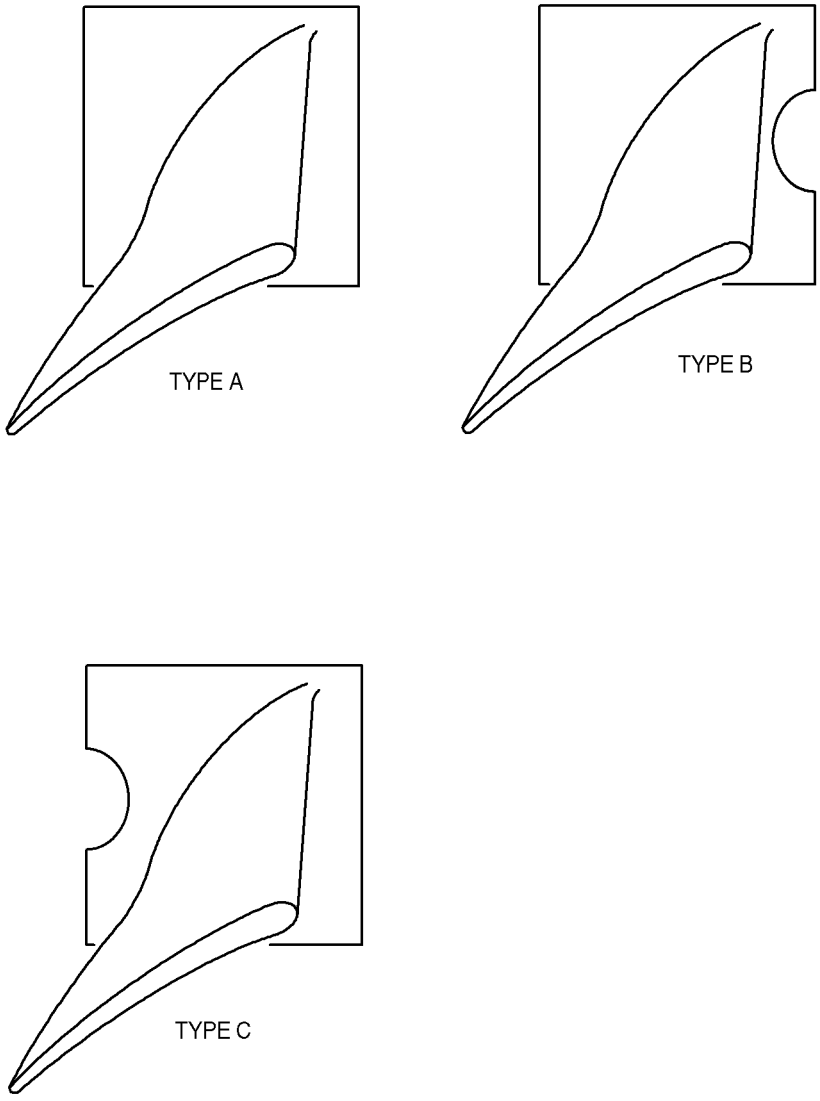
(a) If the clearance is less than 0.019 inch (0.483 mm), you must remove, redistribute, and assemble the blades again to get in this clearance.

NOTE: You can also change the quantity of regular and spacer blades to get the 0.019 inch (0.483 mm) requirement.

AR. Examine the assembly for foreign objects, damage, and correct assembly.

AS. Install all the necessary protection covers.

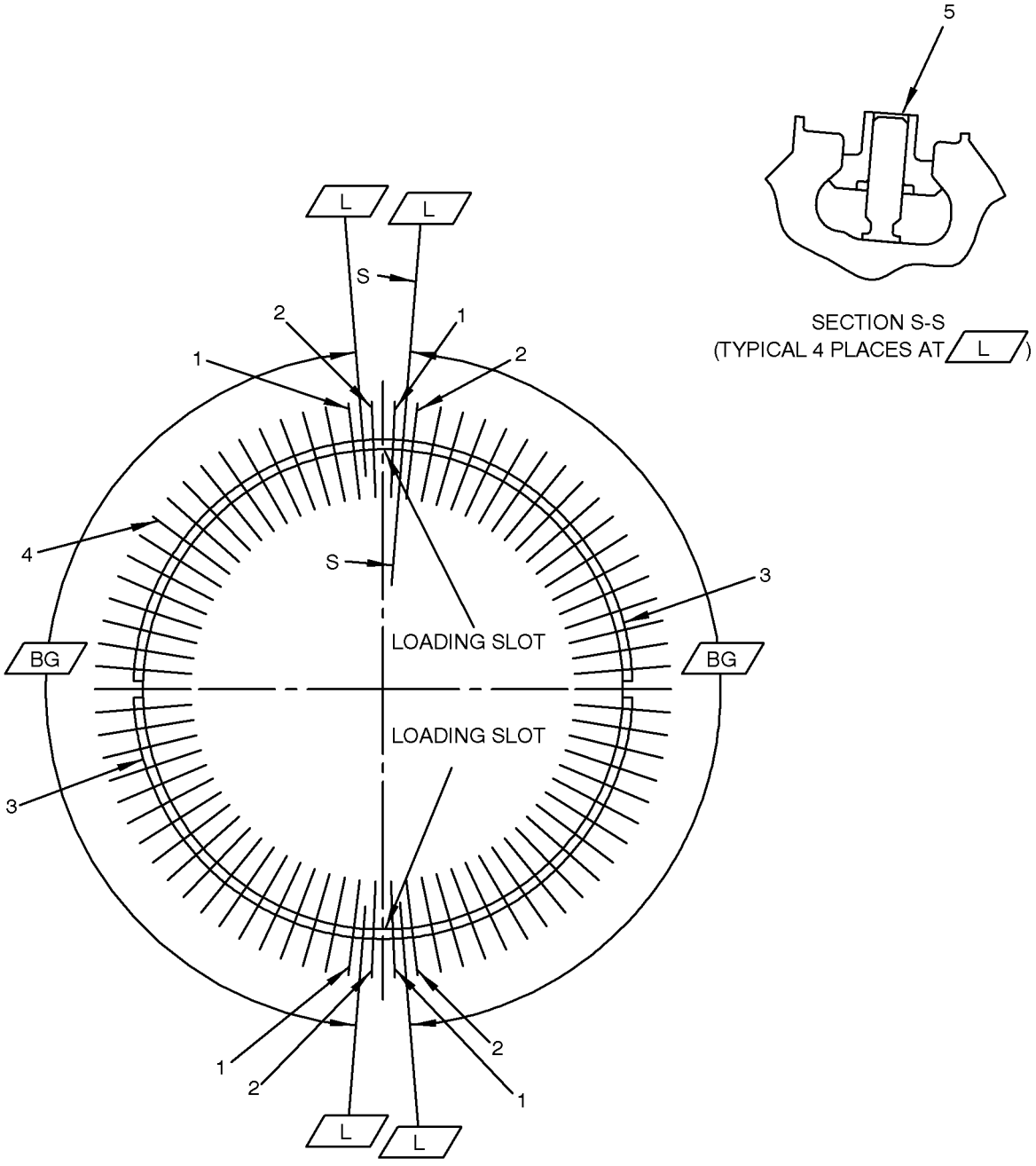
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BLADE IDENTIFICATION
FIGURE 11

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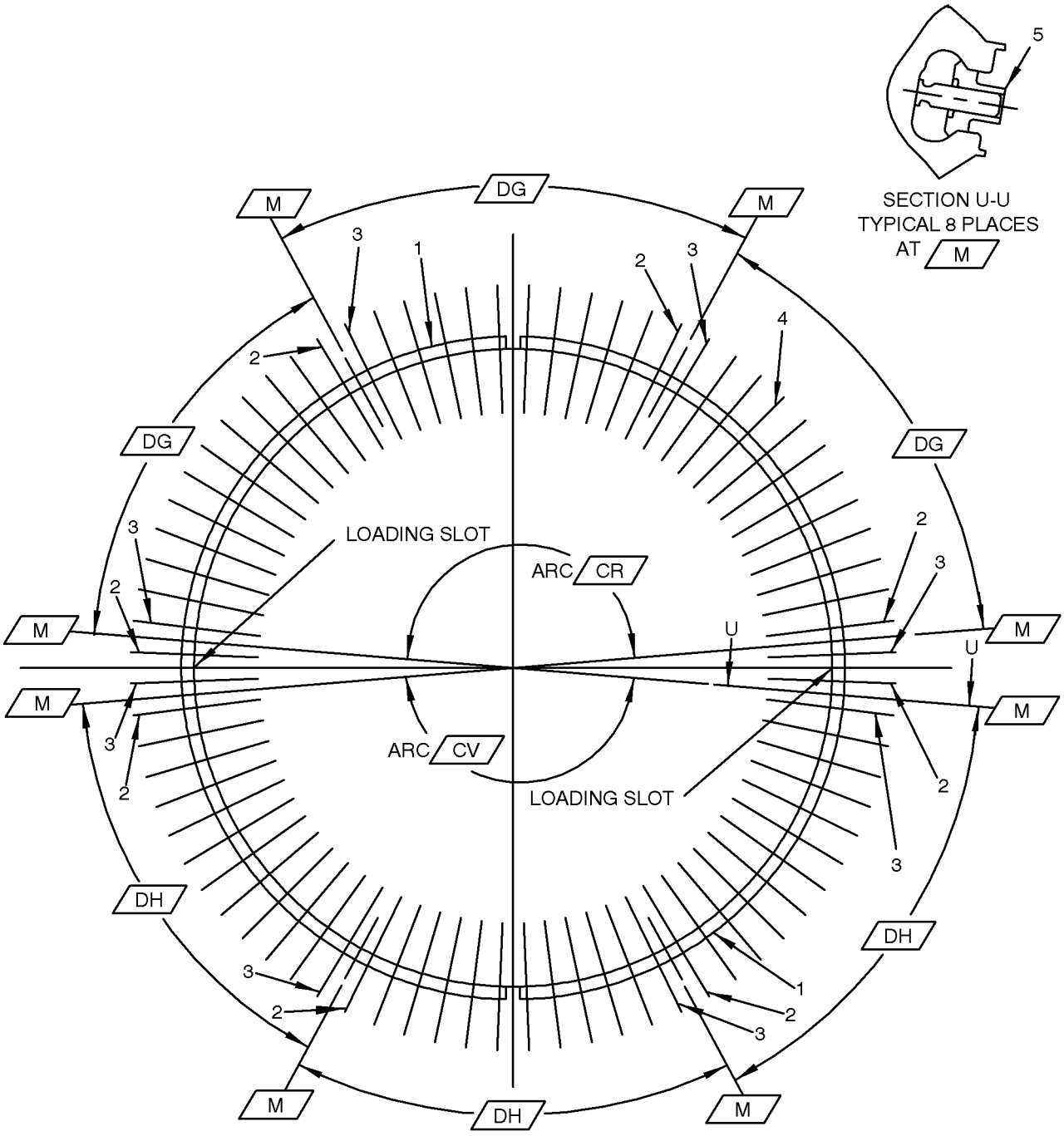
SCHEMATIC FRONT VIEW OF 13TH STAGE BLADE AND LOCK INSTALLATION
(DRUM ROTOR (REAR) DISK, PN 50S813-01)
FIGURE 12

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1. Type B Blades
2. Type C Blades
3. Ladder Seals
4. Type A Blades
5. Lock And Setscrew Assembly

KEY TO FIGURE 12

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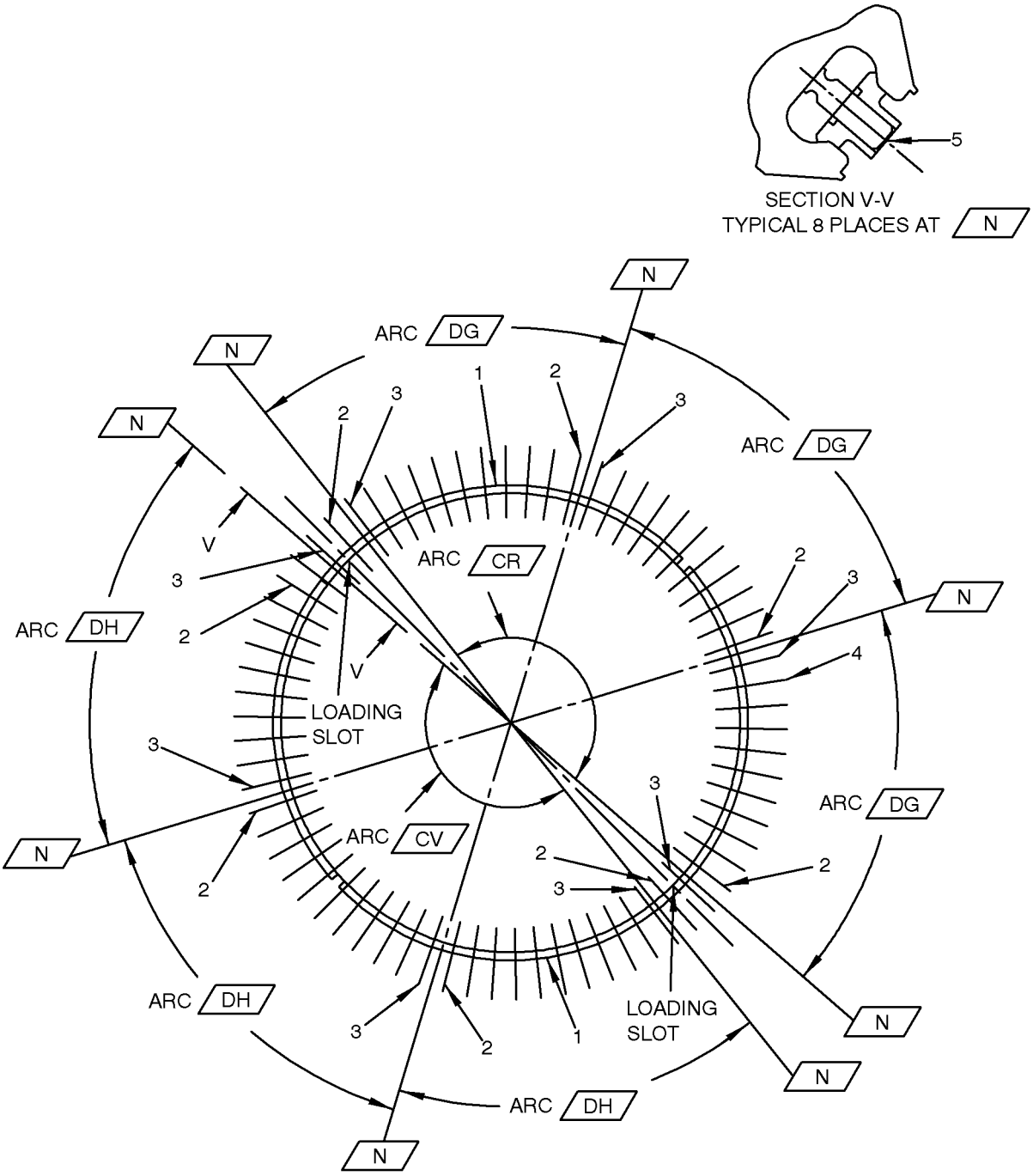
SCHEMATIC FRONT VIEW OF 14TH STAGE BLADE AND LOCK INSTALLATION
(DRUM ROTOR (REAR) DISK, PN 50S813-01)
FIGURE 13

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1. Ladder Seals
2. Type C Blades
3. Type B Blades
4. Type A Blades
5. Lock And Setscrew Assembly

KEY TO FIGURE 13

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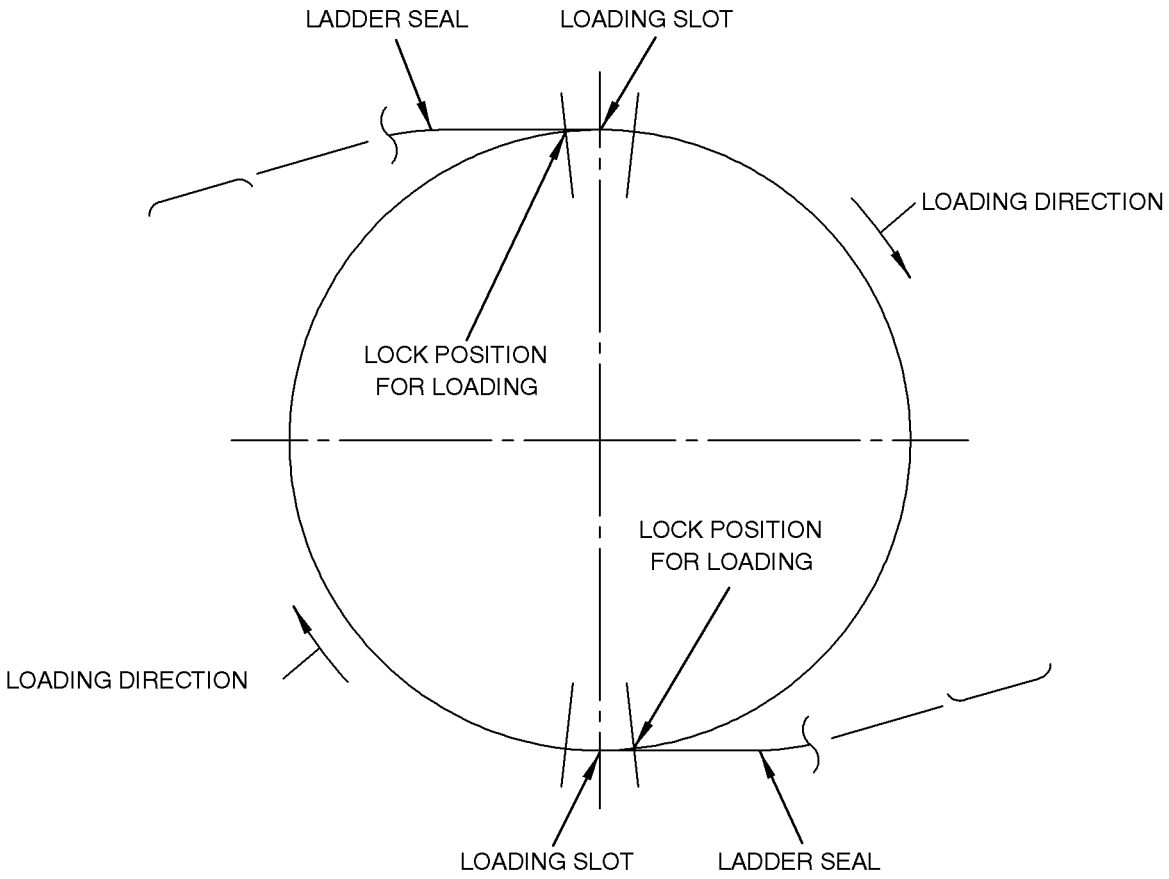
SCHEMATIC FRONT VIEW OF 15TH STAGE BLADE AND LOCK INSTALLATION
(DRUM ROTOR (REAR) DISK, PN 50S813-01)
FIGURE 14

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1. Ladder Seals
2. Type C Blades
3. Type B Blades
4. Type A Blades
5. Lock And Setscrew Assembly

KEY TO FIGURE 14

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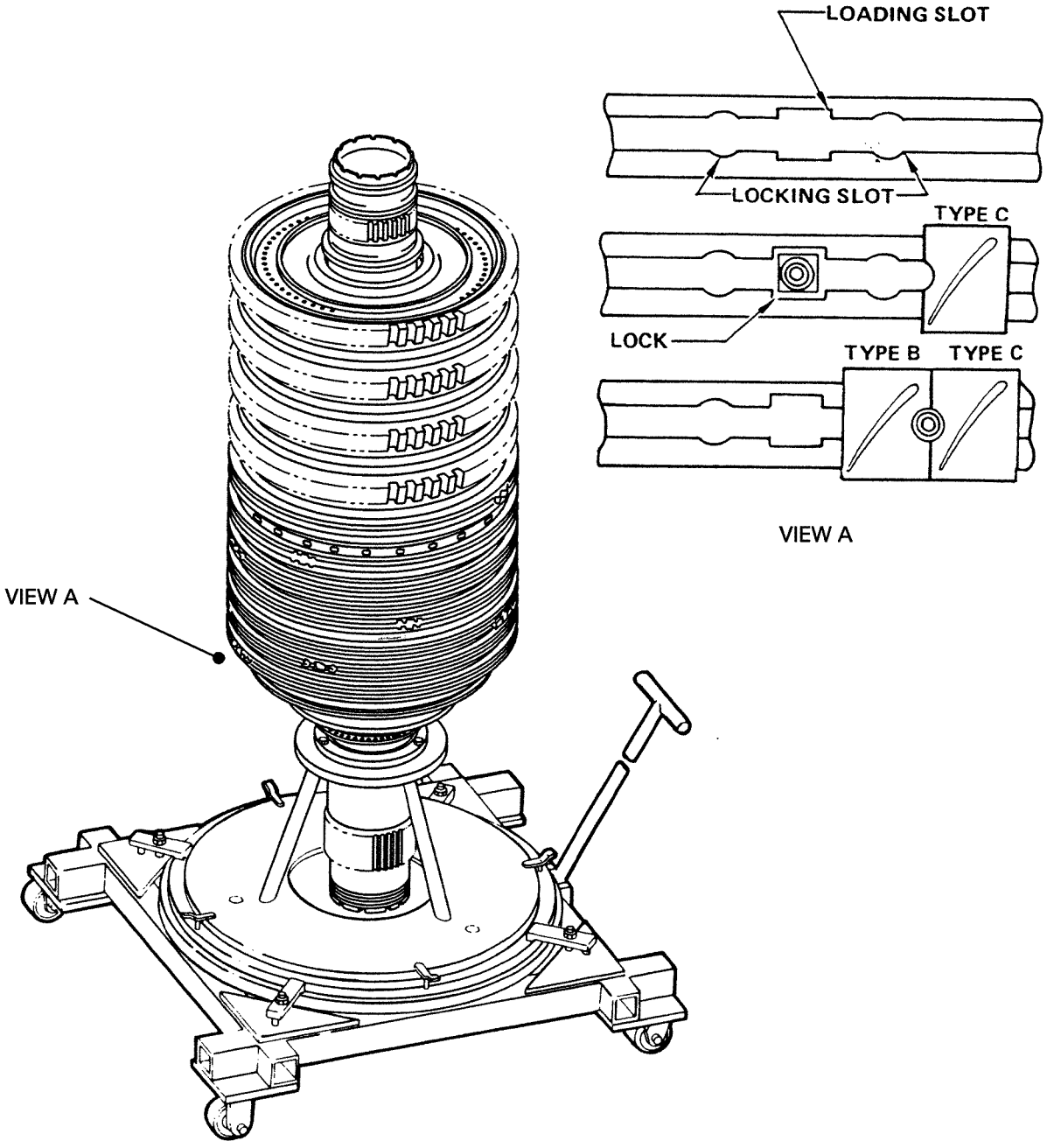


SCHEMATIC FRONT VIEW
TYPICAL STAGES 13 THRU 15
SHOWING INSTALLATION OF LADDER SEALS

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LADDER SEALS INSTALLATION (DRUM ROTOR (REAR) DISK PN 50S813-01)
FIGURE 15

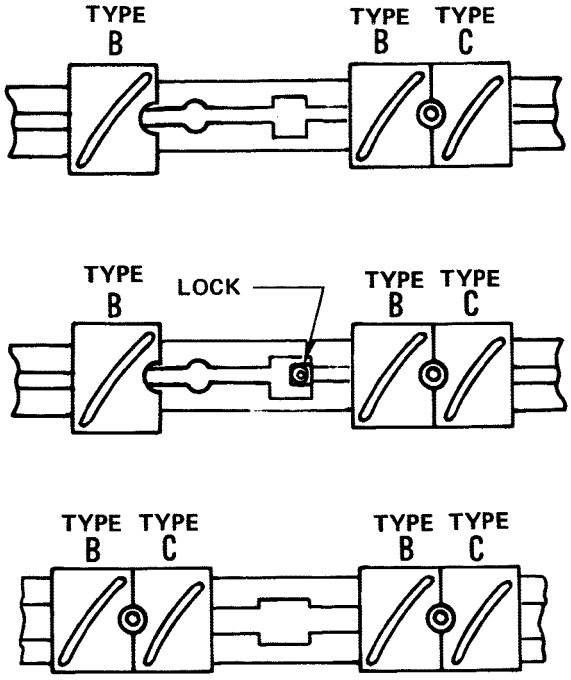
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BLADE AND LOCK INSTALLATION
FIGURE 16, SHEET 1

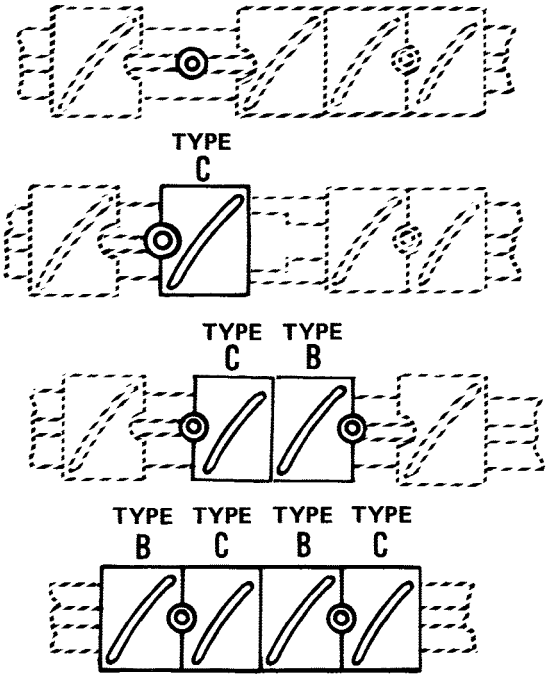
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BLADE AND LOCK INSTALLATION
FIGURE 16, SHEET 2

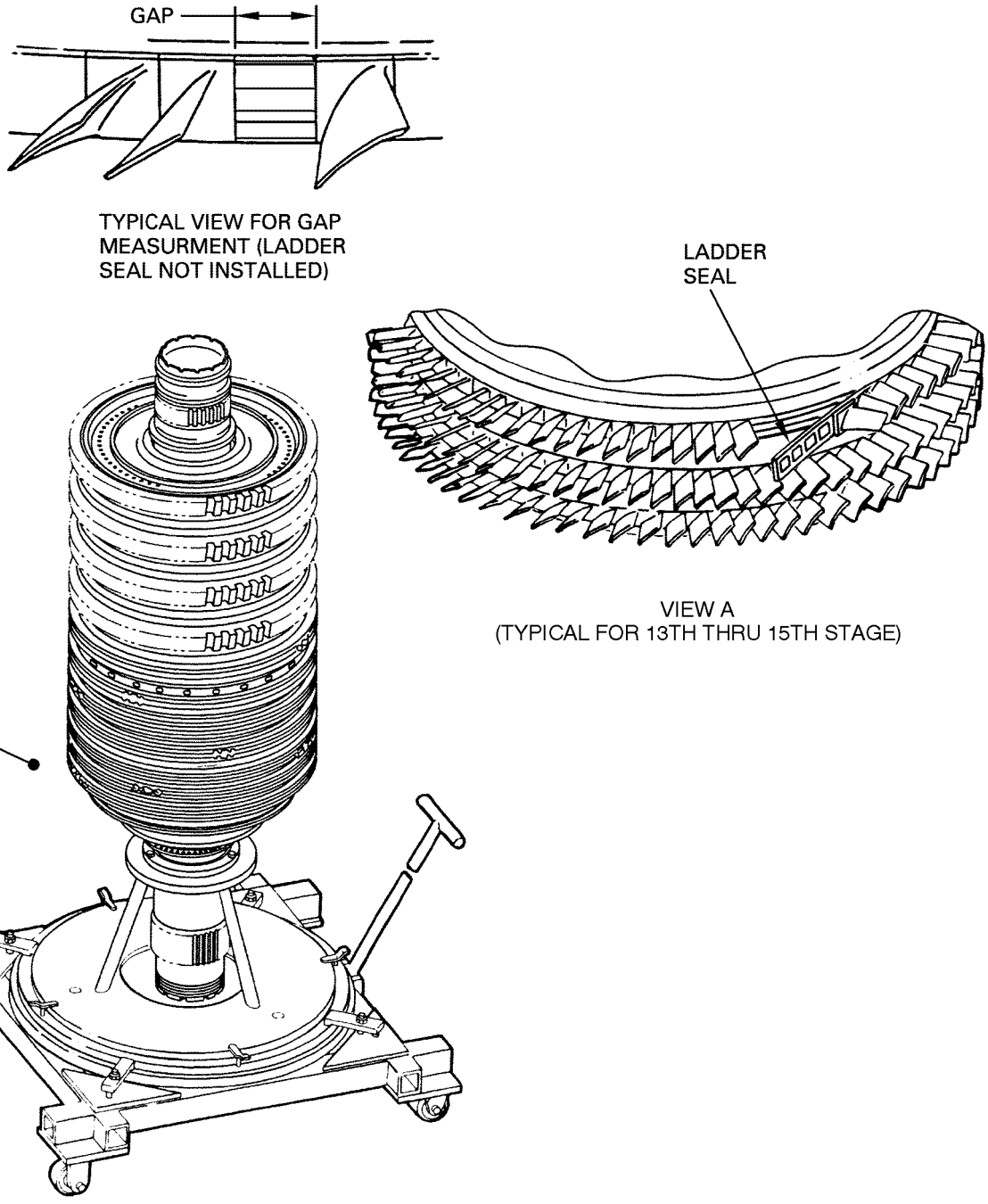
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BLADE AND LOCK INSTALLATION
FIGURE 16, SHEET 3

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GAP MEASUREMENT AND LADDER SEAL INSTALLATION
FIGURE 17

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