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SERVICE BULLETIN

ENGINE - REDUCTION GEAR AND SHAFT SECTION - Replace/Rework Propeller Pitch Control (PPC) Assemblies, PN 869130-11 thru -14, -16 thru -19, -30 and PN 895481-1, -2, -4 thru -7, -17 thru -20, -22

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Transmittal Information

ATA Number TPE331-72-2190 (Publication Number D201108000067)

Summary

This is the INITIAL release.

Revision History

This service bulletin has had no revision(s) as shown in Table 1.

Table 1. Revision History

Revision Number	Revision Date
0	21 Dec 2011

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1. Planning Information

A. Effectivity

(1) This is a CATEGORY 2, RELIABILITY service bulletin.

(2) This service bulletin is applicable to the PPC assemblies shown in Table 2.

Table 2. Applicable Component(s)

PN	Series Number [1]
869130-11	All Series 1 thru 4
869130-12	All Series 1 thru 5
869130-13	All Series 1 thru 6
869130-14	All Series 1
869130-16	All Series 1 thru 5
869130-17	All Series 1 thru 7
869130-18	All Series 1, 2, and 3
869130-19	All Series 1 thru 6
869130-30	All Series 1
895481-1	All Series 1 and 2
895481-2	All Series 1 thru 4
895481-4	All Series 1 and 2
895481-5	All Series 1 and 2
895481-6	All Series 1 and 2
895481-7	All Series 1 and 2
895481-17	All Series 1
895481-18	All Series 1
895481-19	All Series 1
895481-20	All Series 1
895481-22	All Series 1

NOTE:

1. Refer to PPC assembly nameplate for series number identification.

(3) The component(s) shown in Table 2 are used on turboprop aircraft engines. This service bulletin is applicable to the serial numbers shown in Table 3.

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Table 3. Applicable Engine(s)

PN	Model Number	Serial Number	Application
893130-1-1, -2	TPE331-1-100F	All	Pilatus Porter
893400-1-1, -2	TPE331-1-101B	All	Turbo 18, Turboliner
894120-1-1, -2	TPE331-1-101E	All	Jetliner 600 (Dove)
896760-1 thru -4	TPE331-1-101F	All	Peacemaker
3101850-1	TPE331-1-101Z	All	S2R Turbo Thrush, Turbo Ag Cat
893250-1-1, -2	TPE331-1-151A	All	Mitsubishi MU-2DP, -2F, - 2G
869595-1-1, -2	TPE331-1-151G	All	Merlin IIB
3101260-1, -2	TPE331-1-151K	All	Century Turbo Commander
869480-1-1, -2	TPE331-2-201A	All	Skyvan
894820-1-1, -2	TPE331-2-201C	All	CASA 212
894980-1, -2	TPE331-2UA-203D	All	Goose
894040-1, -2	TPE331-3U-303G	All	Merlin III, IIIA, IV, IVA, Metro, Metro II, Metro IIA
3101800-1	TPE331-3U-303V	All	Century Jetstream III
3102550-1 thru -4	TPE331-3U-304G	All	Merlin III, IIIA, IV, IVA, Metro, Metro II, Metro IIA
895880-1, -2	TPE331-3UW-303G	All	Merlin III, IIIA, IV, IVA, Metro, Metro II, Metro IIA
896950-1, -2, -3	TPE331-5-251C	All	CASA 212-100
895720-1, -2, -3	TPE331-5-251K	All	Jetprop Commander 690, 690A, 690B
3103860-1	TPE331-5-252C	All	CASA 212-100
3102200-1	TPE331-5-252D	All	Dornier 228
3102520-1	TPE331-5-252K	All	Jetprop Commander 690A, 690B
3101840-1	TPE331-5-252M	All	Mitsubishi MU-2N, -2P
3102520-2, -3	TPE331-5-254K	All	Jetprop Commander 690C, 690D
895720-4	TPE331-5-255K	All	Jetprop Commander 690, 690A, 690B
3103330-1	TPE331-5A-252D	All	Dornier 228
3103330-2	TPE331-5AB-252D	All	Dornier 228

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Table 3. Applicable Engine(s) (Cont)

PN	Model Number	Serial Number	Application
3102200-3	TPE331-5B-252D	All	Dornier 228
896160-1, -3, -5	TPE331-6-251M	All	Mitsubishi MU-2J, -2K, - 2L, -2M
3101630-1	TPE331-6-252B	All	Beechcraft B100
3103300-1	TPE331-6-252L	All	Merlin IIB
3101300-2	TPE331-6-252M	All	Mitsubishi MU-2J, -2K, - 2L, -2M
3103340-1	TPE331-6-252T	All	Skyvan
3101630-2	TPE331-6-253B	All	Beechcraft B100
3102450-1	TPE331-6A-251M	All	Mitsubishi MU-2J, -2K, - 2L, -2M
3101300-3	TPE331-6A-252M	All	Mitsubishi MU-2J, -2K, - 2L, -2M
3101470-1, -3	TPE331-8-401S	All	Conquest II
3102510-1, -8	TPE331-8-402S	All	Conquest II
3102510-2, -9	TPE331-8-403S	All	Conquest II
3101470-2, -4	TPE331-8-404S	All	Conquest II
3102510-4	TPE331-8-406S	All	Conquest II
3102510-10, -11	TPE331-8-422S	All	Conquest II
3102510-12, -13	TPE331-8-423S	All	Conquest II
3102510-14	TPE331-8-426S	All	Conquest II
3102170-1, -2	TPE331-10-501C	All	CASA 212-200
3102190-1	TPE331-10-501K	All	Jetprop Commander 695, 695A, 695B
3102180-1	TPE331-10-501M	All	Mitsubishi Marquise, Solitaire
3102170-5	TPE331-10-511C	All	CASA 212-200
3102190-2	TPE331-10-511K	All	Jetprop Commander 695, 695A, 695B
3102180-2	TPE331-10-511M	All	Mitsubishi Marquise, Solitaire
3108160-1	TPE331-10-513K	All	Jetprop Commander 695, 695A, 695B
3108150-1	TPE331-10AV-511B	All	Beechcraft B100
3108240-1	TPE331-10AV-511KA	All	Beechcraft C90, E90

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Table 3. Applicable Engine(s) (Cont)

PN	Model Number	Serial Number	Application
3108200-1	TPE331-10AV-511M	All	Mitsubishi MU-2J, -2K, - 2L, -2M
3108150-2	TPE331-10AV-512B	All	Beechcraft B100
3108200-2	TPE331-10AV-512M	All	Mitsubishi MU-2J, -2K, - 2L, -2M
3108140-2	TPE331-10GP-511D	All	Dornier 228
3108140-1	TPE331-10GT-511D	All	Dornier 228
3103700-1	TPE331-10N-511S	All	Conquest II
3103700-2	TPE331-10N-512S	All	Conquest II
3103700-3	TPE331-10N-513S	All	Conquest II
3103700-4	TPE331-10N-514S	All	Conquest II
3103700-5	TPE331-10N-515S	All	Conquest II
3103700-6	TPE331-10N-531S	All	Conquest II
3103700-7	TPE331-10N-532S	All	Conquest II
3103700-8	TPE331-10N-533S	All	Conquest II
3103700-9	TPE331-10N-534S	All	Conquest II
3103700-10	TPE331-10N-535S	All	Conquest II
3108130-2	TPE331-10P-511D	All	Dornier 228
3102170-3	TPE331-10R-501C	All	CASA 212-200
3102170-4	TPE331-10R-502C	All	CASA 212-200
3102170-6	TPE331-10R-511C	All	CASA 212-200
3102170-7	TPE331-10R-512C	All	CASA 212-200
3102170-8	TPE331-10R-513C	All	CASA 212-200, -300
3108130-1	TPE331-10T-511D	All	Dornier 228
3108110-1	TPE331-10T-511K	All	Jetprop Commander 690C, 690D
3108190-1	TPE331-10T-511M	All	Mitsubishi MU-2N, -2P
3108110-2	TPE331-10T-512K	All	Jetprop Commander 690B
3108110-3	TPE331-10T-513K	All	Jetprop Commander 690C, 690D
3108120-1	TPE331-10T-515K	All	Jetprop Commander 690A, 690B

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Table 3. Applicable Engine(s) (Cont)

PN	Model Number	Serial Number	Application
3108120-2	TPE331-10T-516K	All	Jetprop Commander 690A, 690B
3108120-3	TPE331-10T-517K	All	No Current Application
3102050-1, -2	TPE331-10U-501G	All	Merlin IIIB
3102050-3	TPE331-10U-502G	All	Merlin IIIB
3102940-1	TPE331-10U-503G	All	Merlin IIIC
3102050-4	TPE331-10U-511G	All	Merlin IIIB
3102050-5	TPE331-10U-512G	All	Merlin IIIB
3102940-2	TPE331-10U-513G	All	Merlin IIIC
3103230-1	TPE331-10UA-511G	All	Merlin III, IIIA, IV, IVA, Metro, Metro II, Metro IIA
3102600-1	TPE331-10UF-501H	All	Jetstream 31
3102600-2	TPE331-10UF-511H	All	Jetstream 31
3102600-5	TPE331-10UF-512H	All	Jetstream 31
3102600-6	TPE331-10UF-513H	All	Jetstream 31
3102600-9	TPE331-10UF-514H	All	Jetstream 31
3102600-10	TPE331-10UF-515H	All	Jetstream 31
3102600-11	TPE331-10UF-516H	All	Jetstream 31
3103310-1	TPE331-10UG-513H	All	Jetstream 31
3103310-3	TPE331-10UG-514H	All	Jetstream 31
3103310-5	TPE331-10UG-515H	All	Jetstream 31
3103310-7	TPE331-10UG-516H	All	Jetstream 31
3103310-2	TPE331-10UGR-513H	All	Jetstream 31
3103310-4	TPE331-10UGR-514H	All	Jetstream 31
3103310-6	TPE331-10UGR-515H	All	Jetstream 31
3103310-8	TPE331-10UGR-516H	All	Jetstream 31
3102600-7	TPE331-10UR-513H	All	Jetstream 31
3102600-12	TPE331-10UR-516H	All	Jetstream 31
3102540-1, -5, -9	TPE331-11U-601G	All	Metro III, 23, Merlin IVC
3102540-2	TPE331-11U-602G	All	Metro III, 23, Merlin IVC
3102540-3, -6, -7, - 10	TPE331-11U-611G	All	Metro III, 23, Merlin IVC

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Table 3. Applicable Engine(s) (Cont)

PN	Model Number	Serial Number	Application
3102540-4, -8, -11	TPE331-11U-612G	All	Metro III, 23, Merlin IVC
3108170-1, -3	TPE331-12JR-701C	All	CASA 212-400
3108250-1	TPE331-12JR-701S	All	Aero Twin Inc Caravan
3108250-3	TPE331-12JR-702AT	All	Aero Twin Inc Caravan
3108170-2, -4	TPE331-12JR-702C	All	CASA 212-400
3108250-2	TPE331-12JR-702TT	All	Texas Turbines Conversion Inc Caravan
3108250-5	TPE331-12JR-703AT	All	Aero Twin Inc Caravan
3108250-4	TPE331-12JR-703TT	All	Texas Turbines Conversion Inc Caravan
3103870-1	TPE331-12UA-701G	All	Metro III, 23
3103870-3, -4, -8, -9	TPE331-12UAR-701G	All	Metro III, 23
3103380-4, -12, -32, -40	TPE331-12UAR-701H	All	Jetstream 32
3103380-5, -13, -33, -41	TPE331-12UAR-702H	All	Jetstream 32
3103380-6, -14, -34, -42	TPE331-12UAR-703H	All	Jetstream 32
3103380-7, -15, -35, -43	TPE331-12UAR-704H	All	Jetstream 32
3103380-8, -16, -36, -44	TPE331-12UAR-705H	All	Jetstream 32
3103380-9, -17, -37, -45	TPE331-12UAR-706H	All	Jetstream 32
3103380-10, -18, -38, -46	TPE331-12UAR-707H	All	Jetstream 32
3103380-11, -19, -39, -47	TPE331-12UAR-708H	All	Jetstream 32
3103870-6, -7, -11, -12	TPE331-12UHR-701G	All	Metro 23
3103380-20, -24, -48, -52	TPE331-12UHR-701H	All	Jetstream 32
3103380-21, -25, -49, -53	TPE331-12UHR-702H	All	Jetstream 32
3103380-22, -26, -50, -54	TPE331-12UHR-703H	All	Jetstream 32
3103380-23, -27, -51, -55	TPE331-12UHR-704H	All	Jetstream 32
3103380-28, -30	TPE331-12UHR-705H	All	Jetstream 32
3103380-29, -31	TPE331-12UHR-706H	All	Jetstream 32

B. Concurrent Requirements

(1) The service bulletin(s) listed in Table 4 shall be accomplished prior to or concurrent with this service bulletin. The accomplishment instructions outlined in each service bulletin stand alone; therefore, compliance with this service bulletin does not indicate compliance with any other service bulletin.

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Table 4. Concurrent Service Bulletin(s)

Service Bulletin Number	Service Bulletin Title
TPE331-72-0958	ENGINE - REDUCTION GEAR AND SHAFT SECTION - Replace Identified Packings in Propeller Pitch Control Assembly

(2) Review of the service bulletin(s) listed in Table 5 should be accomplished by the operator for possible incorporation at the time this service bulletin is accomplished.

Table 5. Optional Service Bulletin(s)

Service Bulletin Number	Service Bulletin Title
TPE331-72-0968	ENGINE - REDUCTION GEAR AND SHAFT SECTION - Replace/Rework Propeller Pitch Control Assembly

C. Reason

(1) Problem: Some PPC assemblies, PN 869130-11 thru -14, -16 thru -19, -30 and PN 895481-1, -2, -4 thru -7, -17 thru -20, -22, do not have an internally-threaded hole in the splined end of the shouldered shaft, PN 865567-2 and PN 895472-2.

(2) Background: The threaded hole in the splined end of the shouldered shaft can be used to accommodate a secondary retention feature for the aircraft control linkage interface. The secondary retention feature is supplied by the aircraft.

(3) Technical Validation: This design was validated by similarity to other units with similar operational properties and requirements.

D. Description

(1) This service bulletin gives instructions to rework the PPC assemblies, PN 869130-11 thru -14, -16 thru -19, -30 and PN 895481-1, -2, -4 thru -7, -17 thru -20, -22, to incorporate a threaded hole in the splined end of the shouldered shaft, PN 865567-2 and PN 895472-2, as applicable. This service bulletin also gives authorization to install PPC assemblies, PN 70000295-11 thru -14, -16 thru -19, -30 or PN 70000298-1, -2, -4 thru -7, -17 thru -20, -22, as applicable, that have been identified as having a shouldered shaft with the threaded hole.

E. Compliance

(1) Compliance addresses a substantial improvement to reliability, or non-conforming hardware.

(2) The warranty/program data is listed in Table 6.

NOTE: The procedures outlined in this service bulletin may be accomplished at the Major Service Center level or greater.

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Table 6. Warranty/Program Data

Warranty/Program	Yes	No
GMA/MSP		X
Warranty/Special Program		X

(3) Honeywell recommends that this service bulletin be accomplished at the operator's convenience but not later than the next access to affected parts.

F. Approval

(1) The change to the engine type design authorized by this service bulletin complies with applicable Federal Aviation Regulations and is FAA approved.

G. Manpower

(1) An estimated 4.0 man-hour(s) is/are required for this change when accomplished at the maintenance level.

H. Weight and Balance

(1) None.

I. Electrical Load Data

(1) Not changed.

J. Software Accomplishment Summary

(1) Not applicable.

K. References

(1) The sources of information used in the preparation of this service bulletin include Honeywell engineering documentation and the documents listed in Table 7.

NOTE: If the revision of a document is identified, subsequent revisions are permitted unless specified differently.

Table 7. Sources of Information

Part/Model Number	Engine Overhaul Manual	Engine Maintenance Manual [1]	Illustrated Parts Catalog [1]
TPE331-1-100F	72-00-93	72-00-92	72-00-91
TPE331-1-101B	72-00-93	72-00-92	72-00-91
TPE331-1-101E	72-00-93	72-00-92	72-00-91
TPE331-1-101F	72-00-93	72-00-92	72-00-91
TPE331-1-101Z	72-00-93	72-00-92	72-00-91
TPE331-1-151A	72-00-93	72-00-92	72-00-91
TPE331-1-151G	72-00-93	72-00-92	72-00-91
TPE331-1-151K	72-00-93	72-00-92	72-00-91
TPE331-10-501C	72-00-22	72-00-28	72-01-17

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Table 7. Sources of Information (Cont)

Part/Model Number	Engine Overhaul Manual	Engine Maintenance Manual [1]	Illustrated Parts Catalog [1]
TPE331-10-501K	72-00-22	72-00-29	72-01-18
TPE331-10-501M	72-00-22	72-00-27	72-01-16
TPE331-10-511C	72-00-22	72-00-28	72-01-17
TPE331-10-511K	72-00-22	72-00-29	72-01-18
TPE331-10-511M	72-00-22	72-00-27	72-01-16
TPE331-10-513K	72-00-22	72-00-29	72-01-18
TPE331-10AV-511B	72-01-33	72-01-32	72-01-30
TPE331-10AV-511KA	72-01-47	72-01-46	72-01-45
TPE331-10AV-511M	72-01-33	72-01-32	72-01-30
TPE331-10AV-512B	72-01-33	72-01-32	72-01-30
TPE331-10AV-512M	72-01-33	72-01-32	72-01-30
TPE331-10GP-511D	72-01-23	72-01-22	72-01-20
TPE331-10GT-511D	72-01-23	72-01-22	72-01-20
TPE331-10N-511S	72-00-12	72-00-13	72-00-11
TPE331-10N-512S	72-00-12	72-00-13	72-00-11
TPE331-10N-513S	72-00-12	72-00-13	72-00-11
TPE331-10N-514S	72-00-12	72-00-13	72-00-11
TPE331-10N-515S	72-00-12	72-00-13	72-00-11
TPE331-10N-531S	72-00-12	72-00-13	72-00-11
TPE331-10N-532S	72-00-12	72-00-13	72-00-11
TPE331-10N-533S	72-00-12	72-00-13	72-00-11
TPE331-10N-534S	72-00-12	72-00-13	72-00-11
TPE331-10N-535S	72-00-12	72-00-13	72-00-11
TPE331-10P-511D	72-01-23	72-01-22	72-01-20
TPE331-10R-501C	72-00-22	72-00-28	72-01-17
TPE331-10R-502C	72-00-22	72-00-28	72-01-17
TPE331-10R-511C	72-00-22	72-00-28	72-01-17
TPE331-10R-512C	72-00-22	72-00-28	72-01-17
TPE331-10R-513C	72-00-22	72-00-28	72-01-17
TPE331-10T-511D	72-01-23	72-01-22	72-01-20

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Table 7. Sources of Information (Cont)

Part/Model Number	Engine Overhaul Manual	Engine Maintenance Manual [1]	Illustrated Parts Catalog [1]
TPE331-10T-511K	72-00-22	72-00-29	72-01-18
TPE331-10T-511M	72-00-22	72-00-27	72-01-16
TPE331-10T-512K	72-00-22	72-00-29	72-01-18
TPE331-10T-513K	72-00-22	72-00-29	72-01-18
TPE331-10T-515K	72-00-22	72-00-29	72-01-18
TPE331-10T-516K	72-00-22	72-00-29	72-01-18
TPE331-10T-517K	72-00-22	72-00-29	72-01-18
TPE331-10U-501G	72-00-22	72-00-23	72-01-15
TPE331-10U-502G	72-00-22	72-00-23	72-01-15
TPE331-10U-503G	72-00-22	72-00-30	72-01-19
TPE331-10U-511G	72-00-22	72-00-23	72-01-15
TPE331-10U-512G	72-00-22	72-00-23	72-01-15
TPE331-10U-513G	72-00-22	72-00-30	72-01-19
TPE331-10UA-511G	72-00-46	72-00-45	72-00-44
TPE331-10UF-501H	72-00-43	72-00-42	72-00-41
TPE331-10UF-511H	72-00-43	72-00-42	72-00-41
TPE331-10UF-512H	72-00-43	72-00-42	72-00-41
TPE331-10UF-513H	72-00-43	72-00-42	72-00-41
TPE331-10UF-514H	72-00-43	72-00-42	72-00-41
TPE331-10UF-515H	72-00-43	72-00-42	72-00-41
TPE331-10UF-516H	72-00-43	72-00-42	72-00-41
TPE331-10UG-513H	72-00-43	72-00-42	72-00-41
TPE331-10UG-514H	72-00-43	72-00-42	72-00-41
TPE331-10UG-515H	72-00-43	72-00-42	72-00-41
TPE331-10UG-516H	72-00-43	72-00-42	72-00-41
TPE331-10UGR-513H	72-00-43	72-00-42	72-00-41
TPE331-10UGR-514H	72-00-43	72-00-42	72-00-41
TPE331-10UGR-515H	72-00-43	72-00-42	72-00-41
TPE331-10UGR-516H	72-00-43	72-00-42	72-00-41
TPE331-10UR-513H	72-00-43	72-00-42	72-00-41

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Table 7. Sources of Information (Cont)

Part/Model Number	Engine Overhaul Manual	Engine Maintenance Manual [1]	Illustrated Parts Catalog [1]
TPE331-10UR-516H	72-00-43	72-00-42	72-00-41
TPE331-11U-601G	72-00-26	72-00-25	72-00-24
TPE331-11U-602G	72-00-26	72-00-25	72-00-24
TPE331-11U-611G	72-00-26	72-00-25	72-00-24
TPE331-11U-612G	72-00-26	72-00-25	72-00-24
TPE331-12JR-701C	72-01-41	72-01-40	72-01-38
TPE331-12JR-701S	72-01-41	72-01-40	72-01-38
TPE331-12JR-702-AT	72-01-41	72-01-40	72-01-38
TPE331-12JR-702C	72-01-41	72-01-40	72-01-38
TPE331-12JR-702-TT	72-01-41	72-01-40	72-01-38
TPE331-12JR-703-AT	72-01-41	72-01-40	72-01-38
TPE331-12JR-703-TT	72-01-41	72-01-40	72-01-38
TPE331-12UA-701G	72-01-37	72-01-36	72-01-34
TPE331-12UAR-701G	72-01-37	72-01-36	72-01-34
TPE331-12UAR-701H	72-00-80	72-00-79	72-00-78
TPE331-12UAR-702H	72-00-80	72-00-79	72-00-78
TPE331-12UAR-703H	72-00-80	72-00-79	72-00-78
TPE331-12UAR-704H	72-00-80	72-00-79	72-00-78
TPE331-12UAR-705H	72-00-80	72-00-79	72-00-78
TPE331-12UAR-706H	72-00-80	72-00-79	72-00-78
TPE331-12UAR-707H	72-00-80	72-00-79	72-00-78
TPE331-12UAR-708H	72-00-80	72-00-79	72-00-78
TPE331-12UHR-701G	72-01-37	72-01-36	72-01-34
TPE331-12UHR-701H	72-00-80	72-00-79	72-00-78
TPE331-12UHR-702H	72-00-80	72-00-79	72-00-78
TPE331-12UHR-703H	72-00-80	72-00-79	72-00-78
TPE331-12UHR-704H	72-00-80	72-00-79	72-00-78
TPE331-12UHR-705H	72-00-80	72-00-79	72-00-78
TPE331-12UHR-706H	72-00-80	72-00-79	72-00-78
TPE331-2-201A	72-00-93	72-00-92	72-00-91

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Table 7. Sources of Information (Cont)

Part/Model Number	Engine Overhaul Manual	Engine Maintenance Manual [1]	Illustrated Parts Catalog [1]
TPE331-2-201C	72-00-93	72-00-92	72-00-91
TPE331-2UA-203D	72-00-93	72-00-92	72-00-91
TPE331-3U-303G	72-00-99	72-00-98	72-00-97
TPE331-3U-303V	72-00-99	72-00-98	72-00-97
TPE331-3U-304G	72-00-99	72-00-98	72-00-97
TPE331-3UW-303G	72-00-99	72-00-98	72-00-97
TPE331-5-251C	72-01-28	72-01-27	72-01-25
TPE331-5-251K	72-01-28	72-01-27	72-01-25
TPE331-5-252C	72-01-28	72-01-27	72-01-25
TPE331-5-252D	72-01-23	72-01-22	72-01-20
TPE331-5-252K	72-01-28	72-01-27	72-01-25
TPE331-5-252M	72-01-28	72-01-27	72-01-25
TPE331-5-254K	72-01-28	72-01-27	72-01-25
TPE331-5-255K	72-01-28	72-01-27	72-01-25
TPE331-5A-252D	72-01-23	72-01-22	72-01-20
TPE331-5AB-252D	72-01-23	72-01-22	72-01-20
TPE331-5B-252D	72-01-23	72-01-22	72-01-20
TPE331-6-251M	72-01-33	72-01-32	72-01-30
TPE331-6-252B	72-01-33	72-01-32	72-01-30
TPE331-6-252L	72-01-96	72-01-95	72-01-94
TPE331-6-252M	72-01-33	72-01-32	72-01-30
TPE331-6-252T	72-01-96	72-01-95	72-01-94
TPE331-6-253B	72-01-33	72-01-32	72-01-30
TPE331-6A-251M	72-01-33	72-01-32	72-01-30
TPE331-6A-252M	72-01-33	72-01-32	72-01-30
TPE331-8-401S	72-00-12	72-00-13	72-00-11
TPE331-8-402S	72-00-12	72-00-13	72-00-11
TPE331-8-403S	72-00-12	72-00-13	72-00-11
TPE331-8-404S	72-00-12	72-00-13	72-00-11
TPE331-8-406S	72-00-12	72-00-13	72-00-11

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Table 7. Sources of Information (Cont)

Part/Model Number	Engine Overhaul Manual	Engine Maintenance Manual [1]	Illustrated Parts Catalog [1]
TPE331-8-422S	72-00-12	72-00-13	72-00-11
TPE331-8-423S	72-00-12	72-00-13	72-00-11
TPE331-8-426S	72-00-12	72-00-13	72-00-11

NOTE:

1. Affected Chapter/Section/Subject 72-10-02.

(2) The service bulletin(s) listed in Table 8 is/are applicable to this service bulletin.

Table 8. Service Bulletin References

Service Bulletin Number	Service Bulletin Title
TPE/TSE331-72-0019	ENGINE - Service Life Limits of Critical Life Limited Components
TPE331-72-0117	ENGINE - Service Life Limits of Critical Life Limited Components
TPE331-72-0180	ENGINE - Service Life Limits of Critical Life Limited Components
TPE331-72-0476	ENGINE - Service Life Limits of Critical Life Limited Components, and Periodic Maintenance Schedules

L. Other Publications Affected

(1) Same as those listed under Paragraph 1.K.(1).

(2) Propeller Pitch Control Overhaul Manual (OHM), 72-13-11.

(3) Propeller Pitch Control OHM, 72-13-12.

M. Interchangeability or Intermixability of Parts

(1) Not applicable.

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2. Material Information

A. Material - Price and Availability

(1) Information regarding price and availability of parts may be obtained from Honeywell, Global Customer Care Center, Telephone: (800) 601-3099 (Toll Free U.S.A./Canada), (602) 365-3099 (International Direct), 00-800-601-30999 (EMEA Toll Free), 420-234-625-500 (EMEA Direct).

B. Industry Support Information

(1) Not applicable.

C. Material Necessary for Each Engine

(1) The parts required to accomplish the instructions outlined in this service bulletin are shown in Table 9. Refer to Table 10 for the Instructions/Disposition Codes. Refer to Table 11 for the PPC assembly part number applicability.

NOTE: Applicable illustrated parts catalogs and spare parts bulletins, dated later than the original issue date of this service bulletin, may introduce different parts for installation. Refer to these documents before ordering parts.

NOTE: Expendable parts, discarded in gaining access to the affected area of the equipment, are not included.

NOTE: The inclusion of vendor names/addresses and part numbers in the following parts listing shall not be construed as an authorization of the vendor, pursuant to FAA regulations, to ship directly to the user. Neither shall it be construed as a certification by Honeywell that parts shipped by vendors directly to users will conform to the type design or that such parts are airworthy or safe for installation.

Table 9. Operator-Purchased Material

New PN	Keyword/ Nomenclature	Old PN	Qty	Unit Price [1]	Instructions/ Disposition Codes
70000294-13 [2] or 70100079-13 [2]	Cam assembly	865558-13	1		C, N
70000294-15 [2] or 70100079-15 [2]	Cam assembly	865558-15	1		C, N
70000294-16 [2] or 70100079-16 [2]	Cam assembly	865558-16	1		C, N
70000294-17 [2] or 70100079-17 [2]	Cam assembly	865558-17	1		C, N
70000294-19 [2] or 70100079-19 [2]	Cam assembly	865558-19	1		C, N

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Table 9. Operator-Purchased Material (Cont)

New PN	Keyword/ Nomenclature	Old PN	Qty	Unit Price [1]	Instructions/ Disposition Codes
70000294-20 [2] or 70100079-20 [2]	Cam assembly	865558-20	1		C, N
70000294-21 [2] or 70100079-21 [2]	Cam assembly	865558-21	1		C, N
70000294-26 [2] or 70100079-26 [2]	Cam assembly	865558-26	1		C, N
70000294-8 [2] or 70100079-8 [2]	Cam assembly	865558-8	1		C, N
70000295-11	PPC assembly	869130-11 [3]	1		C, N, S
70000295-12	PPC assembly	869130-12 [3]	1		C, N, S
70000295-13	PPC assembly	869130-13 [3]	1		C, N, S
70000295-14	PPC assembly	869130-14 [3]	1		C, N, S
70000295-16	PPC assembly	869130-16 [3]	1		C, N, S
70000295-17	PPC assembly	869130-17 [3]	1		C, N, S
70000295-18	PPC assembly	869130-18 [3]	1		C, N, S
70000295-19	PPC assembly	869130-19 [3]	1		C, N, S
70000295-30	PPC assembly	869130-30 [3]	1		C, N, S
70000297-1 [2]	Cam assembly	895475-1			C, N
70000297-14 [2] or 70100080-14 [2]	Cam assembly	895475-14	1		C, N
70000297-15 [2] or 70100080-15 [2]	Cam assembly	895475-15	1		C, N
70000297-16 [2] or 70100080-16 [2]	Cam assembly	895475-16	1		C, N
70000297-17 [2] or 70100080-17 [2]	Cam assembly	895475-17	1		C, N

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Table 9. Operator-Purchased Material (Cont)

New PN	Keyword/ Nomenclature	Old PN	Qty	Unit Price [1]	Instructions/ Disposition Codes
70000297-18 [2] or 70100080-18 [2]	Cam assembly	895475-18	1		C, N
70000297-2 [2] or 70100080-2 [2]	Cam assembly	895475-2	1		C, N
70000297-5 [2] or 70100080-5 [2]	Cam assembly	895475-5	1		C, N
70000297-6 [2] or 70100080-6 [2]	Cam assembly	895475-6	1		C, N
70000297-7 [2] or 70100080-7 [2]	Cam assembly	895475-7	1		C, N
70000297-8 [2] or 70100080-8 [2]	Cam assembly	895475-8	1		C, N
70000298-1	PPC assembly	895481-1 [3]	1		C, N, S
70000298-17	PPC assembly	895481-17 [3]	1		C, N, S
70000298-18	PPC assembly	895481-18 [3]	1		C, N, S
70000298-19	PPC assembly	895481-19 [3]	1		C, N, S
70000298-2	PPC assembly	895481-2 [3]	1		C, N, S
70000298-20	PPC assembly	895481-20 [3]	1		C, N, S
70000298-22	PPC assembly	895481-22 [3]	1		C, N, S
70000298-4	PPC assembly	895481-4 [3]	1		C, N, S
70000298-5	PPC assembly	895481-5 [3]	1		C, N, S
70000298-6	PPC assembly	895481-6 [3]	1		C, N, S
70000298-7	PPC assembly	895481-7 [3]	1		C, N, S

NOTES:

1. Refer to Paragraph 2.A. for information regarding price and availability of parts.

2. Component of PPC assembly. Refer to Table 11 for applicability.

3. Refer to Table 2 for applicable series number.

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Table 10. Instructions/Disposition Codes

Code	Description
Disposition Code C	Rework part as specified in this service bulletin.
Disposition Code N	Old part will no longer be available for this application.
Disposition Code S	Send the old part to Honeywell International Inc., Material Receiving, 1944 E. Sky Harbor Circle, Phoenix, AZ 85034-3440.

Table 11. PPC Assembly Part Number Applicability

Old PPC Assembly PN	Old Cam Assembly PN	Reworked Cam Assembly PN	Alternate, New Production Cam Assembly PN [1]	Reworked PPC Assembly PN
869130-11	865558-16	70000294-16	70100079-16	70000295-11
869130-12	865558-8	70000294-8	70100079-8	70000295-12
869130-13	865558-15	70000294-15	70100079-15	70000295-13
869130-14	865558-17	70000294-17	70100079-17	70000295-14
869130-16	865558-13	70000294-13	70100079-13	70000295-16
869130-17	865558-19	70000294-19	70100079-19	70000295-17
869130-18	865558-20	70000294-20	70100079-20	70000295-18
869130-19	865558-21	70000294-21	70100079-21	70000295-19
869130-30	865558-26	70000294-26	70100079-26	70000295-30
895481-1	895475-1 or -2	70000297-1 or -2	70100080-2	70000298-1
895481-2	895475-2	70000297-2	70100080-2	70000298-2
895481-4	895475-5	70000297-5	70100080-5	70000298-4
895481-5	895475-6	70000297-6	70100080-6	70000298-5
895481-6	895475-7	70000297-7	70100080-7	70000298-6
895481-7	895475-8	70000297-8	70100080-8	70000298-7
895481-17	895475-14	70000297-14	70100080-14	70000298-17
895481-18	895475-15	70000297-15	70100080-15	70000298-18
895481-19	895475-16	70000297-16	70100080-16	70000298-19
895481-20	895475-17	70000297-17	70100080-17	70000298-20
895481-22	895475-18	70000297-18	70100080-18	70000298-22

NOTE:

1. Manufactured with a shouldered shaft with a threaded hole.

D. Material Necessary for Each Spare

(1) The same as given in Paragraph 2.C.

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E. Reidentified Parts

(1) Refer to Table 12 for the reidentified parts data.

Table 12. Reidentified Parts

New PN	Keyword/Nomenclature	Old PN
70000293-1	Shouldered shaft	865567-2
70000294-8 [1]	Cam assembly	865558-8
70000294-13 [1]	Cam assembly	865558-13
70000294-15 [1]	Cam assembly	865558-15
70000294-16 [1]	Cam assembly	865558-16
70000294-17 [1]	Cam assembly	865558-17
70000294-19 [1]	Cam assembly	865558-19
70000294-20 [1]	Cam assembly	865558-20
70000294-21 [1]	Cam assembly	865558-21
70000294-26 [1]	Cam assembly	865558-26
70000295-11	PPC assembly	869130-11
70000295-12	PPC assembly	869130-12
70000295-13	PPC assembly	869130-13
70000295-14	PPC assembly	869130-14
70000295-16	PPC assembly	869130-16
70000295-17	PPC assembly	869130-17
70000295-18	PPC assembly	869130-18
70000295-19	PPC assembly	869130-19
70000295-30	PPC assembly	869130-30
70000296-1	Shouldered shaft	895472-2
70000297-1 [1]	Cam assembly	895475-1
70000297-2 [1]	Cam assembly	895475-2
70000297-5 [1]	Cam assembly	895475-5
70000297-6 [1]	Cam assembly	895475-6
70000297-7 [1]	Cam assembly	895475-7
70000297-8 [1]	Cam assembly	895475-8
70000297-14 [1]	Cam assembly	895475-14
70000297-15 [1]	Cam assembly	895475-15
70000297-16 [1]	Cam assembly	895475-16

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Table 12. Reidentified Parts (Cont)

New PN	Keyword/Nomenclature	Old PN
70000297-17 [1]	Cam assembly	895475-17
70000297-18 [1]	Cam assembly	895475-18
70000298-1	PPC assembly	895481-1
70000298-2	PPC assembly	895481-2
70000298-4	PPC assembly	895481-4
70000298-5	PPC assembly	895481-5
70000298-6	PPC assembly	895481-6
70000298-7	PPC assembly	895481-7
70000298-17	PPC assembly	895481-17
70000298-18	PPC assembly	895481-18
70000298-19	PPC assembly	895481-19
70000298-20	PPC assembly	895481-20
70000298-22	PPC assembly	895481-22

NOTE:

1. Component of PPC assembly. Refer to Table 11 for applicability.

F. Tooling - Price and Availability

(1) No special tooling is required except that already listed in publications referenced in Paragraph 1.K.(1).

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3. Accomplishment Instructions

A. General Information

NOTE: Publications listed in Paragraph 1.K.(1) provide applicable disassembly, cleaning, inspection, reassembly, and testing instructions and shall be referred to during the accomplishment of the following instructions.

NOTE: The service bulletins listed in Paragraph 1.B. shall be accomplished prior to or in conjunction with the following instructions.

NOTE: Shelf stock can be inspected, reworked, and reidentified in accordance with these accomplishment instructions.

B. Replacement of PPC Assembly, PN 869130-11 thru -14, -16 thru -19, -30 or PN 895481-1, -2, -4 thru -7, -17 thru -20, -22 with PN 70000295-11 thru -14, -16 thru -19, -30 or PN 70000298-1, -2, -4 thru -7, -17 thru -20, -22

Table 13. PPC Assembly Part Numbers

Remove PN	Install PN
869130-11	70000295-11
869130-12	70000295-12
869130-13	70000295-13
869130-14	70000295-14
869130-16	70000295-16
869130-17	70000295-17
869130-18	70000295-18
869130-19	70000295-19
869130-30	70000295-30
895481-1	70000298-1
895481-2	70000298-2
895481-4	70000298-4
895481-5	70000298-5
895481-6	70000298-6
895481-7	70000298-7
895481-17	70000298-17
895481-18	70000298-18
895481-19	70000298-19

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Table 13. PPC Assembly Part Numbers (Cont)

Remove PN	Install PN
895481-20	70000298-20
895481-22	70000298-22

(1) Remove the PPC assembly (refer to Table 13 for the applicable part number). Refer to the instructions in the applicable engine maintenance manual (MM).

(2) Install the PPC assembly (refer to Table 13 for the applicable part number). Refer to the instructions in the applicable engine MM.

(3) Upon completion of engine reassembly, check and ensure proper engine operation in accordance with the engine test instructions.

(4) Make an entry in the engine log book noting date of compliance, engine operating time, part number(s) and serial number(s) of installed component(s) (as applicable), and compliance with this service bulletin (and service bulletin revision number, if applicable).

(5) Reidentification of equipment is not required.

(6) Complete the Certificate of Compliance form in Paragraph 4.A. and send to Honeywell.

C. Rework of PPC Assembly, PN 869130-11 thru -14, -16 thru -19, -30 or PN 895481-1, -2, -4 thru -7, -17 thru -20, -22 to PN 70000295-11 thru -14, -16 thru -19, -30 or PN 70000298-1, -2, -4 thru -7, -17 thru -20, -22

NOTE: An updated Life Limited Part Log Card or a Component Maintenance/Modification Record Card is required for all reworked PPC assemblies. Refer to Service Bulletin TPE/TSE331-72-0019, or Service Bulletin TPE331-72-0117, or Service Bulletin TPE331-72-0180, or Service Bulletin TPE331-72-0476.

(1) Remove the PPC Assembly from engine, if necessary. Refer to the instructions in the applicable engine MM.

(2) Remove the cam assembly (refer to Table 11 for the applicable part number). Refer to the instructions in the applicable engine MM or component OHM.

(3) Inspect for the presence and condition of a threaded hole at the splined end of the shouldered shaft. Refer to Figure 1.

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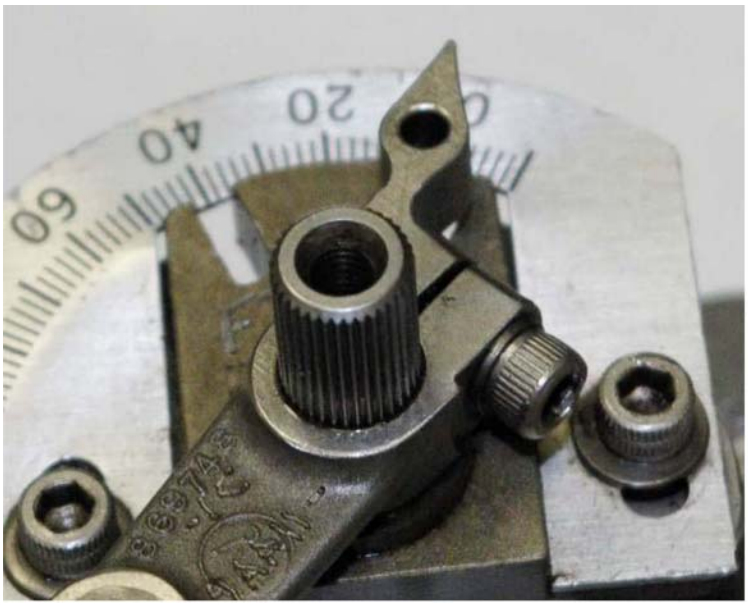


Figure 1. (Sheet 1 of 1) Example of a Threaded Hole In the Splined End of the Shouldered Shaft on the Cam Assembly

(a) If the threaded hole feature is present and the threads are in acceptable condition, proceed to Paragraph 3.C.(4).

(b) If the threaded hole feature is present but is damaged, repair in accordance with standard practices and proceed to Paragraph 3.C.(4).

(c) If the threaded hole feature is present, but is damaged and cannot be repaired in accordance with standard practices, replace with a serviceable cam assembly.

1 If replacement cam assembly is identified with a part number listed as an Old Cam Assembly PN in Table 11, proceed to Paragraph 3.C.(4).

2 If replacement cam assembly is identified with a part number listed as a New Cam Assembly PN in Table 11, proceed to Paragraph 3.C.(6).

(d) If threaded hole is not present, perform Paragraph 3.C.(3)(d)1 or Paragraph 3.C.(3)(d)2.

1 Replace cam assembly. Proceed to Paragraph 3.C.(3)(c)1 or Paragraph 3.C.(3)(c)2, as applicable.

2 Rework cam assembly as follows:

NOTE: Do not disassemble the cam assembly from the shouldered shaft.

a Mount shouldered shaft and cam assembly in a suitable soft-jaw fixture.

b Drill, tap, and counter-sink shouldered shaft/cam assembly in accordance with Figure 2 for shouldered shaft, PN 895472-2, or Figure 3 for shouldered shaft, PN 865567-2.

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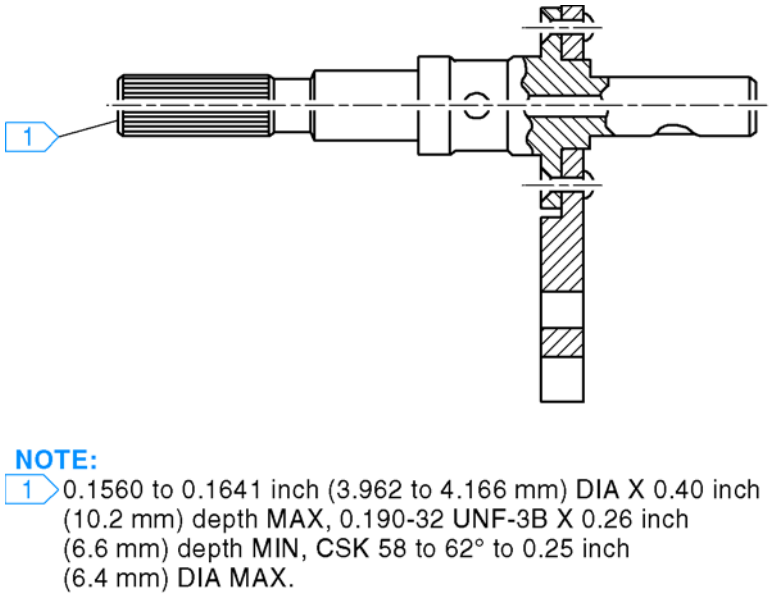


Figure 2. (Sheet 1 of 1) Rework Definition for the Shouldered Shaft, PN 895472-2, Portion of the Cam Assembly, PN 898475-1, -2, -5 thru -8, -14 thru -18

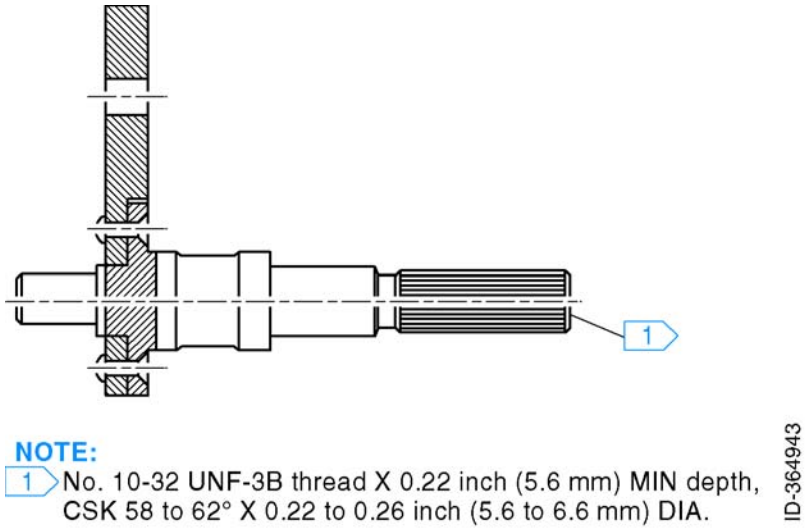


Figure 3. (Sheet 1 of 1) Rework Definition for the Shouldered Shaft, PN 865567-2, Portion of the Cam Assembly, PN 865558-8, -13, -15, -16, -17, -19, -20, -21, -26

c Visually inspect with 10X magnification. No cracks or damaged threads allowed.

(4) Reidentify the part number of the shouldered shaft as follows:

NOTE: Do not disassemble the cam assembly from the shouldered shaft.

(a) Line through the old part number on the shouldered shaft in accordance with Aerospace Standard AS478-7A1, while maintaining the part number legibility as shown in Figure 4. Refer to Table 12.

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Figure 4. (Sheet 1 of 1) Example of Shouldered Shaft Reidentification

(b) Mark the new part number adjacent to the old part number on the shouldered shaft in accordance with Aerospace Standard AS478-7A1, as shown in Figure 4. Refer to Table 12.

(5) Reidentify the part number of the cam assembly as follows:

NOTE: Do not disassemble the cam assembly from the shouldered shaft.

(a) Line through the old part number on the cam assembly in accordance with Aerospace Standard AS478-7A1, while maintaining the part number legibility as shown in Figure 5. Refer to Table 12.



Figure 5. (Sheet 1 of 1) Example of Cam Assembly Reidentification

(b) Mark the new part number adjacent to the old part number on the cam assembly in accordance with Aerospace Standard AS478-7A1, as shown in Figure 5. Refer to Table 12.

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(6) Install the cam assembly (refer to Table 11 for the applicable part number). Refer to the instructions in the applicable engine MM or component OHM.

(7) Reidentify the PPC Assembly nameplate as follows:

(a) On identification plate, using AS478-2D, -2E, -3A, -3B, -5A, -7A, or -15A, line out original part number and series number and maintain legibility, and mark new PPC assembly part number as defined in Table 12. Refer to Figure 6.



Figure 6. (Sheet 1 of 1) Example of PPC Assembly Nameplate Reidentification

(b) If the part number and serial number are engraved on the body of the PPC assembly, line through old part number and reidentify with new part number in accordance with Aerospace Standard AS478-3A. Refer to Table 12.

(8) Upon completion of reassembly and reidentification, check operation in accordance with the applicable engine MM or component OHM.

(9) Update Life Limited Part Log Card or Component Maintenance/Modification Record Card. Refer to Service Bulletin TPE/TSE331-72-0019, or Service Bulletin TPE331-72-0117, or Service Bulletin TPE331-72-0180, or Service Bulletin TPE331-72-0476.

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4. Appendix

A. Appendix A, Certificate of Compliance

To: Operator or Service Center Performing Modification

Upon modification of equipment, please fill in the information requested below, then mail or fax the completed Certificate of Compliance (refer to Figure 7) to:

Honeywell International Inc.
111 S 34th Street, Mail Stop 503-320
Phoenix, AZ 85034-2802
Fax: (602) 231-3014

Owner/Operator

Aircraft Model | Aircraft Serial Number

I certify that the following engine/equipment has been modified in accordance with the listed service bulletins.

ENGINE/EQUIPMENT

NUMBER 1		NUMBER 2		NUMBER 3		NUMBER 4	
PART NUMBER		PART NUMBER		PART NUMBER		PART NUMBER	
MODEL NUMBER		MODEL NUMBER		MODEL NUMBER		MODEL NUMBER	
SERIAL NUMBER		SERIAL NUMBER		SERIAL NUMBER		SERIAL NUMBER	
TSN/TSO		TSN/TSO		TSN/TSO		TSN/TSO	
CYCLES		CYCLES		CYCLES		CYCLES	
SERVICE BULLETIN NUMBER	REV. NUMBER	SERVICE BULLETIN NUMBER	REV. NUMBER	SERVICE BULLETIN NUMBER	REV. NUMBER	SERVICE BULLETIN NUMBER	REV. NUMBER
NUMBER 1		**NUMBER 2**		**NUMBER 3**		**NUMBER 4**	

Signature | Date

Repair Facility

ID-306376

Figure 7. (Sheet 1 of 1) Certificate of Compliance

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