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SERVICE BULLETIN

ENGINE - COMPRESSOR SECTION - Install Improved Annular Ball (Tower Shaft) Bearing, PN 3033024-2, -4 or -6

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18 Apr 2011
Revision 2, 6 Sep 2018

AS907-72-9045

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Transmittal Information

ATA Number AS907-72-9045 (Publication Number D201102000045)

Summary

This revision is a FULL replacement. This revision includes the changes that follow:

- Added annular ball (tower shaft) bearing, PN 3033024-6.
- Changed Table 2 to add engine models AS907-2-1A, AS907-2-1S and AS907-3-1E and bearing note.
- Added Table 3 in Concurrent Requirements.
- Changed Step (1) to add PN 3033024-6 in Paragraph 1.C.
- Changed Description section to add PN 3033024-6 in Paragraph 1.D.
- Added information regarding steel rivet implementation in Paragraph 1.D.
- Updated Table 4 to the current table format and added SPGM 18.
- Added Footnote 1 and 2 to Table 4.
- Added references for engine models AS907-2-1A, AS907-2-1S and AS907-3-1E. to Paragraph 1.K.
- Added -A01 to all Task sections for AS907-1-1A and AS907-2-1G.
- Added engine models AS907-2-1A, AS907-2-1S and AS907-3-1E in Table 5.
- Changed Table 6 to add PN 3033024-6 and added footnote 2.
- Changed Step 3.B thru 3.B.(5) to add PN 3033024-6 and all engine models.
- Changed Step 3.B.(2) thru 3.B.(5) to distinguish between Task sections for AS907-1-1A, AS907-2-1A, AS907-2-1G, AS907-2-1S and AS907-3-1E.
- Added Acronyms and Abbreviations.
- Changed the content and format to agree with Honeywell processes in effect at the time of the release of this revision.

The information that is identified with revision bars is listed in the Revision History section. Revision bars are not used before Paragraph 1.A. The editorial changes and information that was moved or reformatted is not identified with revision bars.

Refer to Paragraph 4.A. for a list of the acronyms and abbreviations used in this service bulletin.

Revision History

This service bulletin has had two revision(s) as shown in Table 1.

Table 1. Revision History

Revision Number	Revision Date
0	18 Apr 2011
1	19 Jul 2012
2	6 Sep 2018

Highlights

This section issues Revision 2 to Service Bulletin, ATA Number AS907-72-9045 (Publication Number D201102000045), and contains these changes:

The list of highlights tells the users about the changes that the revision makes. The list has three columns. The "Page" column shows the block of data that the revision changes and the page on which the block begins.

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The block can be a section, subsection, graphic, table, etc. Revision marks give the location of the change in the block. The "Description" column tells the user about the change or changes in each block. A paragraph, table, or figure reference often comes before the description. The "Effectivity" column tells the user about the part number(s) to which the block of information applies. The default value for this column is "All." "All" means that the block applies to all parts.

Page	Description	Effectivity
7	Paragraph 1.A.(2). Changed Table 2 to add engine models AS907-2-1A, AS907-2-1S and AS907-3-1E and bearing note.	All
7	Paragraph 1.B. Added Table 3 to Concurrent Requirements.	All
7	Paragraph 1.C. Changed Step (1) to add PN 3033024-6.	All
7	Paragraph 1.D. Changed Description section to add PN 3033024-6.	All
7	Paragraph 1.D. Added information regarding steel rivet implementation.	All
8	Paragraph 1.E. Updated Table 4 to the current table format and added SPGM 18.	All
8	Paragraph 1.E. Added Footnote 1 and 2 to Table 4.	All
9	Paragraph 1.K. Added references for engine models AS907-2-1A, AS907-2-1S and AS907-3-1E.	All
9	Paragraph 1.K. Added -A01 to all Task sections for AS907-1-1A and AS907-2-1G.	All
9	Paragraph 1.K.(1). Added engine models AS907-2-1A, AS907-2-1S and AS907-3-1E in Table 5.	All
11	Paragraph 2.C.(1). Changed Table 6 to add PN 3033024-6 and added footnote 2.	All
13	Paragraph 3.B. Changed Step 3.B thru 3.B.(5) to add PN 3033024-6 and all engine models.	All
13	Paragraph 3.B. Changed Step 3.B.(2) thru 3.B.(5) to distinguish between Task sections for AS907-1-1A, AS907-2-1A, AS907-2-1G, AS907-2-1S and AS907-3-1E.	All
14	Paragraph 4.A. Added Acronyms and Abbreviations.	All

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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 turbofan aircraft engines shown in Table 2.

Table 2. Applicable Engine(s)

PN	Model Number	Applicable to Serial Numbers	Application
3030001-4	AS907-1-1A	ALL	Bombardier BD-100-1A10, Challenger 300
70040702-1	AS907-2-1A	Prior to 136556 ¹	Bombardier BD-100-1A10, Challenger 350
3033002-1 3033002-2	AS907-2-1G	Prior to 130389 ¹	Gulfstream G280
70041011-1	AS907-2-1S	Prior to 144121 ¹	Textron Aviation Model 700 Cessna Citation Longitude
70040119-1	AS907-3-1E	Prior to 131309 ¹	EMB-545 (Embraer Legacy 450) EMB-545 (Embraer Legacy 500)

NOTE:

1. Engine SN indicates when the PN 3033024-4 bearings with stainless steel rivets were introduced into new engine production beginning with bearing SN 17-16225-20524.

B. Concurrent Requirements

- (1) Incorporation of the service bulletin(s) listed in Table 3 is recommended at the time this service bulletin is accomplished.

Table 3. Recommended Service Bulletin(s)

Service Bulletin Number	Service Bulletin Title
AS907-72-9080	ENGINE - TURBINE SECTION - Install Improved No. 4 Roller Bearing, PN 3035647-7, on AS907 Model Engines

C. Reason

- (1) Honeywell has developed annular ball (tower shaft) bearings, PN 3033024-2, -4 and -6 which provide enhanced bearing life.

D. Description

- (1) Annular ball (tower shaft) bearings PN 3033024-2, -4 and -6 utilize stainless steel rivets to secure the two bronze cage halves. Use of stainless steel rivets contributes to enhanced bearing life as the stainless steel rivets provide a 60X increase in fatigue strength.
 - PN 3033024-2: Stainless steel rivets are used to secure the two cage halves

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- PN 3033024-4: Beginning with bearing SN 17-16225-20524, stainless steel rivets were incorporated to secure the two cage halves. Fielded engines which had a tower shaft bearing replacement after November 1, 2017, received 3033024-4 bearings which utilized stainless steel rivets.
 - PN 3033024-6: The -6 is a reidentification of the aforementioned -4 bearing with stainless steel rivets.
- (2) Annular ball (tower shaft) bearing, PN 3033024-2, -4 (SN 17-162255-20524 and subsequent) or -6 should be installed when the tower shaft upper bevel gear housing assembly is removed from the engine.

E. Compliance

- (1) Compliance addresses a substantial improvement to reliability, or non-conforming hardware.
- (2) The warranty/program data is listed in Table 4.

NOTE: The procedures outlined in this service bulletin may be accomplished at the Minor Maintenance level or greater.

Table 4. Warranty/Program Data

Warranty/Program	Yes ^{1 2}	No
In Warranty		
OEM Warranty (Standard new engine warranty)	X	
Spare Part Warranty (Standard new spare part warranty)		X
Special Program Number (SPGM) 18 (Programs in which special pricing and/or special conditions may apply)	X	
Special Pricing Notice (SPN) Number (Reduction from catalog list pricing, i.e., "P" condition pricing may apply)		X
Out of Warranty		
Special Program Number (SPGM) 18 (Programs in which special pricing and/or special conditions may apply)	X	
Warranty/Program	Yes ^{1 2}	No
Special Pricing Notice (SPN) Number (Reduction from catalog list pricing, i.e., "P" condition pricing may apply)		X
MSP	X	

NOTES:

1. The costs of compliance with this service bulletin may be covered by Warranty, MSP, or other Programs marked with an "X" in the "Yes" column, subject to the terms and conditions of the applicable Warranty, MSP, or other Program contracts. This service bulletin in no way alters, modifies, or extends the terms of any Warranty, MSP, or other Programs contract. For clarification or questions, contact Honeywell Warranty Department at 800-601-3099, International and select Option No. 2.
2. Send claims through the Honeywell MyAerospace web portal (www.myaerospace.com). Select the Maintenance Plans tab and use the Claims-Maintenance Programs sub-option.

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- (3) Honeywell recommends that this service bulletin be accomplished at first access to the affected parts. Access is defined as when the tower shaft upper bevel gear housing assembly is removed from the engine.

F. Approval

- (1) The accomplishment instructions are FAA approved.

G. Manpower

- (1) An additional 2.0 man-hour(s) is/are required to accomplish this change after the tower shaft upper bevel gear housing assembly is removed from the engine.

H. Weight and Balance

- (1) No change.

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 5.

Table 5. Sources of Information

Part/Model Number	Heavy Maintenance Manual ¹	Light Maintenance Manual ¹	Illustrated Parts Catalog ¹
AS907-1-1A	72-05-13	72-05-12	72-05-11
AS907-2-1A	72-05-23	72-05-22	72-05-21
AS907-2-1G	72-05-17	72-05-16	72-05-15
AS907-2-1S	72-05-26	72-05-25	72-05-24
AS907-3-1E	72-05-20	72-05-19	72-05-18

NOTE:

1. Affected Chapter/Section/Subject 72-30-01.

- (2) (AS907-1-1A) Refer to the following tasks in engine light maintenance manual (LMM) 72-05-12:
- Task 72-30-01-020-801-A01, Removal
 - Task 72-30-01-030-801-A01, Disassembly
 - Task 72-30-01-430-801-A01, Assembly
 - Task 72-30-01-420-801-A01, Installation.
- (3) (AS907-2-1A) Refer to the following tasks in engine LMM 72-05-22:
- Task 72-30-01-020-801-A01, Removal
 - Task 72-30-01-030-801-A01, Disassembly

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- Task 72-30-01-430-801-A01, Assembly
 - Task 72-30-01-420-801-A01, Installation.
- (4) (AS907-2-1G) Refer to the following tasks in engine LMM 72-05-16:
- Task 72-30-01-020-801-A01, Removal
 - Task 72-30-01-030-801-A01, Disassembly
 - Task 72-30-01-430-801-A01, Assembly
 - Task 72-30-01-420-801-A01, Installation.
- (5) (AS907-2-1S) Refer to the following tasks in engine LMM 72-05-25:
- Task 72-30-01-020-801-A01, Removal
 - Task 72-30-01-030-801-A01, Disassembly
 - Task 72-30-01-430-801-A01, Assembly
 - Task 72-30-01-420-801-A01, Installation.
- (6) (AS907-3-1E) Refer to the following tasks in engine LMM 72-05-19:
- Task 72-30-01-99C-801-A01, Removal
 - Task 72-30-01-99C-803-A01, Disassembly
 - Task 72-30-01-99C-806-A01, Assembly
 - Task 72-30-01-99C-802-A01, Installation.

L. Other Publications Affected

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

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).
- (2) Refer to Paragraph 2.C. for information regarding price of parts required to accomplish this service bulletin.

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 6. Refer to Table 7 for the Instructions/Disposition Codes.

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 6. Operator-Purchased Material

New PN	Keyword/ Nomenclature	Old PN	Qty	Unit Price ¹	Instructions/ Disposition Codes
3033024-2, 3033024-4 ² or 3033024-6	Annular ball (tower shaft) bearing	3033024-3, 3033024-4 prior to bearing SN 17-162255-20524	1		K, S

NOTES:

1. Refer to Paragraph 2.A. for information regarding price and availability of parts.
2. PN 3033024-4 beginning with bearing SN 17-162255-20524.

Table 7. Instructions/Disposition Codes

Code	Description
Disposition Code K	Old and new parts are interchangeable.
Disposition Code S	Send the old part to Honeywell International Inc., Material Receiving, 1944 E. Sky Harbor Circle, Phoenix, AZ 85034-3440.

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D. Material Necessary for Each Spare

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

E. Reidentified Parts

(1) Not applicable.

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.

B. Install Improved Annular Ball (Tower Shaft) Bearing, PN 3033024-2, -4 or -6

NOTE: PN 3033024-4 beginning with bearing SN 17-162255-20524.

- (1) Annular ball (tower shaft) bearing, PN 3033024-2, -4 (serial number 17-162255-20524 and subsequent) or -6 should be installed when the tower shaft upper bevel gear housing assembly is removed from the engine.
- (2) Remove the tower shaft upper bevel gear housing assembly.
 - For AS907-1-1A, AS907-2-1A, AS907-2-1G, and AS907-2-1S, refer to the applicable engine LMM, Task 72-30-01-020-801-A01, Removal.
 - For AS907-3-1E, refer to the applicable engine LMM, Task 72-30-01-99C-801-A01, Removal.
- (3) Disassemble the tower shaft upper bevel gear housing assembly.
 - For AS907-1-1A, AS907-2-1A, AS907-2-1G, and AS907-2-1S, refer to the applicable engine LMM, Task 72-30-01-030-801-A01, Disassembly.
 - For AS907-3-1E, refer to the applicable engine LMM, Task 72-30-01-99C-803-A01, Disassembly.
- (4) Using annular ball (tower shaft) bearing PN 3033024-2, -4 or -6, reassemble the tower shaft upper bevel gear housing assembly.
 - For AS907-1-1A, AS907-2-1A, AS907-2-1G, and AS907-2-1S, refer to the applicable engine LMM, Task 72-30-01-430-801-A01, Assembly.
 - For AS907-3-1E, refer to the applicable engine LMM, Task 72-30-01-99C-806-A01, Assembly.
- (5) Install the tower shaft upper bevel gear housing assembly.
 - For AS907-1-1A, AS907-2-1A, AS907-2-1G, and AS907-2-1S, refer to the applicable engine LMM, Task 72-30-01-420-801-A01, Installation.
 - For AS907-3-1E, refer to the applicable engine LMM, Task 72-30-01-99C-802-A01, Installation.
- (6) Upon completion of engine reassembly, check and ensure proper engine operation in accordance with the engine test instructions.
- (7) 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).
- (8) Reidentification of equipment is not required.
- (9) Complete the Certificate of Compliance form in Paragraph 4.B. and send it to Honeywell.

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4. Appendix

A. **Appendix A, Acronyms and Abbreviations**

(1) Refer to Table 8 for a list of the acronyms and abbreviations used in this service bulletin.

Table 8. List of Acronyms and Abbreviations

Term	Full Term
ATA	Air Transport Association
CAGE	commercial and government entity
ECCN	Export Control Classification Number
FAA	Federal Aviation Administration
LMM	light maintenance manual
No.	number
OSHA	Occupational Safety and Health Administration
PMA	Parts Manufacturer Approval
PN	part number
Qty	quantity
SFAR	Special Federal Aviation Regulation
SN	serial number

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B. Appendix B, 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 1) 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 _____							

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

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FAX TO U.S.A.

602-231-3014

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