

# **Raytheon**

**AIRCRAFT COMPANY**

## ***INTERCHANGEABILITY***

**COMPONENT NUMBER**

**25-8WA1**

**COMPONENT NAME**

**Wing Assy Tip to Tip**

### **PURPOSE:**

**This brochure is to document data to ensure interchangeability between the Wing Assy and the following sub-assemblies: Wing to Fuse Links, Leading Edges, Ailerons, Flaps and Vanes, Airbrakes, Access Doors, Main Landing Gears Main Gear Fairing, Main Gear Doors, Landing Lamp Assy. This is in accordance to Chapter 20 and the Model 800 Aircraft Design Specifications.**

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**Q7B489A - ISS 1**

**Reference : icy018/ppt/f**

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**AIRCRAFT COMPANY**

**COMPONENT**  
**NUMBER**  
**25-8WA1**

**COMPONENT NAME**  
**Wing Assy Tip to Tip**

**RCJ**

**Supplier**

Originator

Quality Assurance

ICY Team Leader

Production Engineering

Head - Quality Assurance

Program Manager

**Q7B489B - ISS 1**

**Reference : icy018/ppt/f**

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### CONFIGURATION

<b>S801005/6</b> <b>Rear Spar</b> <b>Sub-Assy Jig</b> <b>Port and Stbd</b>	<b>S010633</b> <b>Wing Assy Jig</b>	<b>S800981/2</b> <b>Front Spar</b> <b>Sub-Assy Jig</b> <b>Port and Stbd</b>
<b><u>Counterparts</u></b>  <b>S011153/4</b> <b>Flap Assy Jigs</b> <b>Port and Stbd</b>	<b>Loft Drawings</b>  <b>Drawing</b>  <b>Geometry</b>	<b><u>Counterparts</u></b>  <b>S805875/6</b> <b>Aileron Assy Jigs</b> <b>Port and Stbd</b>
<b>S019494/5/6/7</b> <b>Airbrake Assy Jigs</b> <b>Top and Btm</b> <b>Port and Stbd</b>	<b>Wing to Fuse Links</b> <b>Access Doors</b> <b>N.C.Data</b>	<b>S802907/12</b> <b>Drill Cages</b> <b>Leading Edge Assy</b>



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SECTION	SHEET	ISSUE	DATE	NAME
1	1	A	April 97	M.Arnold
2	1	A	“ “	“ “
3	1	A	“ “	“ “
3	2	A	“ “	“ “
3	3	A	“ “	“ “
4	1	A	“ “	“ “
5	1	A	“ “	“ “
6	1	B	Jan 2001	“ “
7	1	A	March 1998	D.Clark

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***PART***

**Wing**

**Part Number:-**

**25-8WA1**

### ***Tooling Data***

<b>Tool No.</b>	<b>Issue</b>	<b>Description</b>
S10633D		Wing Assy Jig
038S800981/2D		Front Spar Sub-Assy Jig Port and Stbd
038S801005/6D		Rear Spar Sub-Assy Jig Port and Stbd
S810296		Boxed Set of ICY Check Pins
051S010590D		Wing Equipping (Low Loader)
051S818835D		Wing Equipping (High Loader)

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### Manufacturers Serial Number

# **PART : Wing Assy**

## **ICY CHECKS**

### General

This brochure is to document data to ensure interchangeability between the Wing Assy and the following Sub Assy's. Wing to Fuse Links, Leading Edges, Ailerons, Flaps and Vanes, Airbrakes, Access Doors, Main Landing Gears, Main Gear Fairings, Main Gear Doors, Landing Lamp Assy's.

1. Using Drill Jigs (Items 1352 to 1355) check Master Leading Edge Holes for position to jig and diameter to drawing.
2. With Wing Skins attached to structure check Leading Edge Skin Trim using tool 142S818363T.
3. Check plunger (Item 1517 and 1518) is located in drive spigot.  
Note:- If possible slide plunger out to see if any movement occurs.
- 4a. Check 4 off Fuselage attachments by removing build pins and checking alignment of hole using ICY check pin from kit S810296 pin no. 13. **Important Note** : Remove one pin at a time.
- b. Check 4 off Fuselage attachments for fwd/aft position using feeler gauges 0.050"/0.060" to casting face (front spar positions).  
Note : Total deviation from front to rear pick ups not to exceed 0.015".
5. Check sidestay pin for location to jig.
- 6a. Check flap hinge rib 4 by removing build pin and using pin from kit S810296 pin number 15.
- b. Check hinge for inbd/outbd position using slip from kit S810296 items 1 and 2.

Yes	Date

### Remarks : -

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Indicate Tool Copy No used.....

Ref: icy018/ppt/f

Q7B489G - ISS 1

**Section 3 Iss A**  
**Sheet 1 of 3**

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### ***PART: Wing Assy Continued*** ***ICY CHECKS***

Yes	Date

- 7. Check skin gap inbd/otbd shroud to skin using dummy panel 520S812435 for inbd top and 299S907597 for otbd gap +0.015"/0.020" from nominal.
- 8a. Remove build pin from hinge rib 6 (Top and Btm) check hinge line using pins from kit S810296 item 17 top, item 18 btm.
- 8b. Check position of hinges inbd/outbd using slip 0.173"/0.183" top and btm.
- 9. Check Airbrake Aperture using gauge number 142S812415 inbd/outbd and fwd/aft.
- 10. Remove build pin from flap hinge rib 8 and check hinge line for position using pin from kit S810296 item 19.
- 11. Check fixed shroud top and bottom skin at inboard end for .100" dimension from rib datum as per drawing 25-8WS2039 (trim allowance for flap installation)
- 12. Check fixed shroud top and bottom skin at outboard end for .200" dimension from rib datum as per drawing 25-8WS2039 (trim allowance for aileron installation)
- 13. Check aileron inbd hinge position (rib 10) for inbd/outbd position using slip from kit S810296 items 7 and 8.
  - a. Release jig pin nut and ensure free rotation, if pin will not rotate by hand carry out check as part (b).
  - b. Remove jig pin from hinge line and check hinge line using pin from kit S810296 item 21 (rib 10). Note : Replace build pin.

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Q7B489G - ISS 1

**Section 3 Iss A**  
**Sheet 2 of 3**



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## COUNTERPART NUMBER

See Section 5 For Items Relevant To  
Counterpart Criteria

## COUNTERPART NAME

RCJ

Supplier

Originator

Quality Assurance

ICY Team Leader

Production Engineering

Head - Quality Assurance

Program Manager

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## **COUNTERPART**

See Section 5 for items relevant to  
Counterpart criteria

Part Number:-

## ***Tooling Data***

Tool No.	Issue	Description
		See section 5 for items relevant to counterpart criteria, tooling details in respective brochure.

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### Manufacturers Serial Number

# COUNTERPART ICY CHECKS

### General

This is in accordance with Chapter 20 and the Model 800 Aircraft Specifications.

Refer to relevant ICY brochures for requirements, Wing Tip to Tip comprises the following items:-

Wing to Fuselage Links	ICY019	Section 5
Leading Edge	ICY020	“
Ailerons	ICY022	“
Flaps & Vanes	ICY026	“
Airbrakes Top	ICY024	“
Airbrakes Btm	ICY025	“
Access Doors Front Spar	ICY029	“
Access Doors Rear Spar	ICY030	“
Access Doors Top and Btm Skin	ICY031	“
Main Landing Gear Oleo	ICY034	“
Main Landing Gear Fairing	ICY035	“
Main Landing Gear Door	ICY036	“

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## ***PERIODIC RECERTIFICATION PLAN: 25-8WA1***

### **GENERAL**

The recertification plan is to ensure interchangeability of the Wing Assembly

### **PART**

A periodic Recertification in accordance with QUAIS No. Q5B-003A shall be carried out on :-

1. Wing Assembly Jig 051S010633D using Hawker Jet Wing Recertification datapack 125RD001.
2. Wing Equipping (Low Loader) 051S010590D using Hawker Jet Wing Recertification Datapack HWKRD034.
3. Wing Equipping (High Loader) 051S818835D using Hawker Jet Wing Recertification Datapack HWKRD035.

### **COUNTERPART**

A periodic Recertification in accordance with QUAIS No. Q5B-003A shall be carried out on Wing Assembly counterparts as as detailed in Section 5 as per relevant ICY brochure information.

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### FUSELAGE COUNTERPART INSTALLATION CHECKS -

#### General :

The following ICY checks are to assure the consistent interchangeability at Installation of all Counterparts of the Wing tip to tip in accordance to Chapter 20 of the "Corporate 800 Aircraft Specification Manual."

WING TIP TO TIP TO FUSELAGE	WING TIP TO TIP SERIAL NO :	AIRCRAFT SERIAL NO:	DATE	STAMP

#### Remarks :