

Raytheon

AIRCRAFT COMPANY

INTERCHANGEABILITY

COMPONENT NUMBER

25-8WS3299-4A

COMPONENT NAME

Wing Leading Edge (Stbd)

PURPOSE:

These checks are to ensure Interchangeability between the Leading Edge, Wing, T.K.S. Panel, Landing Lamp Cover and Vortilon, in accordance to Chapter 20 Model 800 Aircraft Specification

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AIRCRAFT COMPANY

COMPONENT NUMBER

25-8WS3299-4A

COMPONENT NAME

Wing Leading Edge (Stbd)

RCJ

Supplier

Originator

Quality Assurance

ICY Team Leader

Production Engineering

Head - Quality Assurance

Program Manager



AIRCRAFT COMPANY

SECTION ISSUE SHEET

SECTION	SHEET	ISSUE	DATE	NAME
1	1	A	May 2000	Mark Arnold
2	1	A	“	“
3	1	A	“	“
3	2	A	“	“
4	1	A	“	“
5	1	A	“	“
6	1	A	“	“
7	1	A	“	“

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BROCHURE ISSUE SHEET:

COMPONENT NAME: Wing L/Edge

Issue;

Amend:

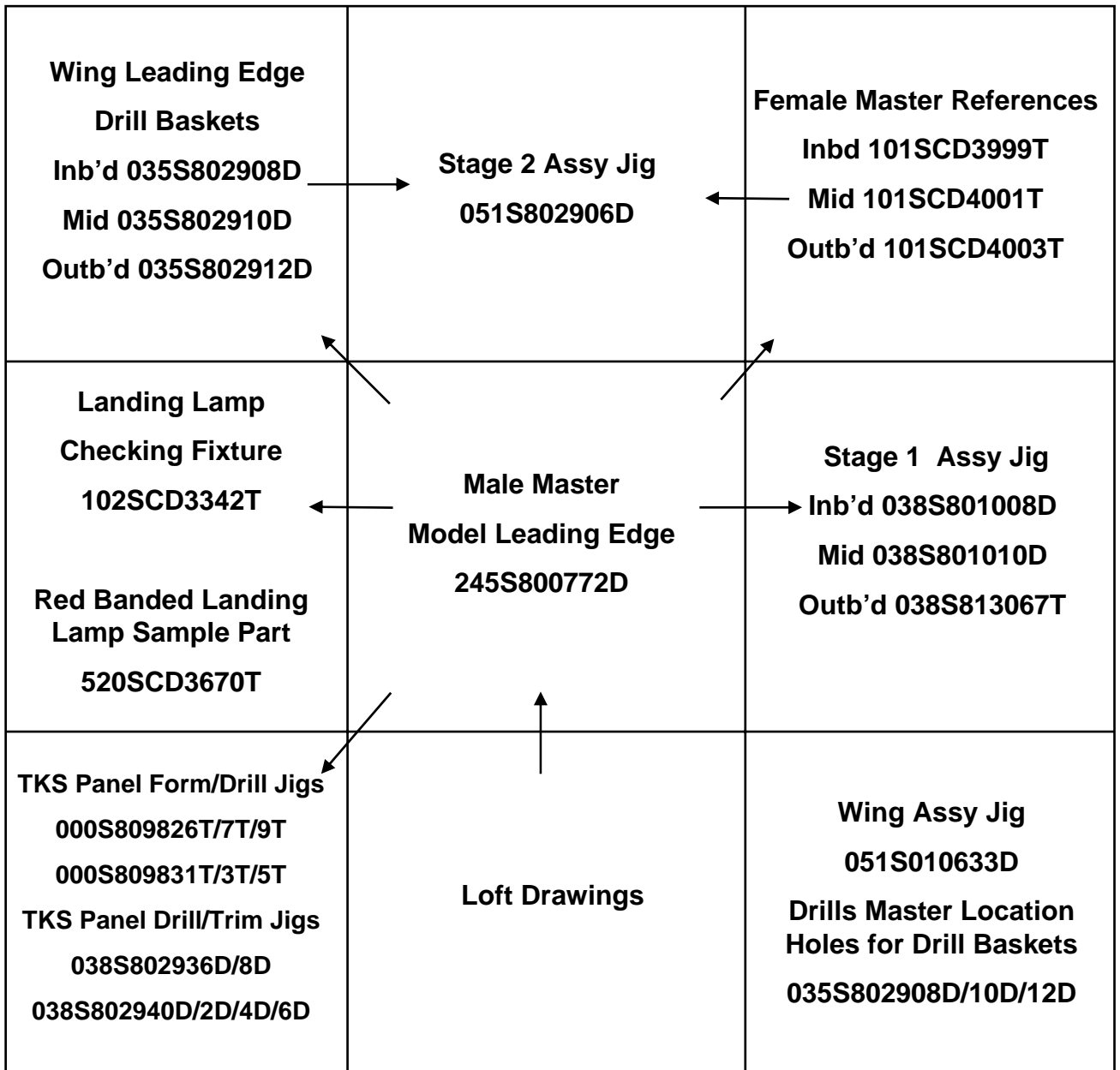
Effective:

Amendment Number	Sections/ Pages Affected	Reason for Amendment or Reference	Date	Authorised

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CONFIGURATION



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PART Wing Leading Edge (Stbd)

Part Number:- 25-8WS3299-4A

ICY Date:-

Tooling Data

Tool No.	Issue	Description
038S801008D		Stage 1 Inb'd Drill & Assy Jig
038S801010D		Stage 1 Mid Drill & Assy Jig
038S813067D		Stage 1 Outb'd Drill & Assy Jig
051S802906D		Stage 2 Assembly Jig
520SCD3670T		Red Banded Landing Lamp Sample Part

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Manufacturers Serial Number

PART : Wing Leading Edge (Stbd) ***ICY CHECKS***

General

These checks are to ensure the profile, boundary, and hole pattern interchangeability between the Wing, T.K.S. Panel, Landing Lamp Cover, Vortilon and Leading Edge, in accordance to Chapter 20 Model 800 Aircraft Specification.

Assy Jig 038S801008D (Stage 1) Inboard Section

1. Check Aft/Inbd/Outbd Trims $\pm 0.015''$ to edge of assembly Jig.
2. Check hole pattern concentricity to component attachment (Wing spar) using 0.005" down size pin, including vortillon holes x 4.
3. Check hole pattern concentricity to component attachment (TKS panel) using a 0.005" downsize pin.
4. Check hole pattern concentricity to component attachment (Landing Lamp Cover) using a 0.005" downsize pin.

Assy Jig 038S801010D (Stage 1) Mid Section

1. Check Aft/Inbd/Outbd Trims $\pm 0.015''$ to edge of assembly Jig.
2. Check hole pattern concentricity to component attachment (Wing Spar) using a 0.005" downsize pin.
3. Check hole pattern concentricity to component attachments (TKS Panel) using a 0.005" downsize pin.

Assy Jig 038S813067T (Stage 1) Outboard Section

1. Check Aft/Inbd/Outbd Trims $\pm 0.015''$ to edge of assembly Jig.
2. Check hole pattern concentricity to component attachment (Wing Spar) using a 0.005" downsize check pin.

Assy Jigs 051S802906D (Stage 2) Leading Edge Complete Assy

1. Check pin for freedom at location hole blocks using 0.005" downsize pin.
2. Check gaps between sections to drawing requirements.
3. Locate Red Banded Master Landing Lamp 520SCD3669T to Leading Edge, Check:- Hole positions, Boundary Gaps, and profile to Leading Edge and TKS Panels.
4. Check internal clearance between Landing Lamp box structure and Landing Lamp glass.
5. Refer to Section 3 Sheet 2 for profile tolerance checks in accordance with drawing 25-8GF1 requirements.

Yes	Date

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Indicate Tool Copy No Used.....

Section 3
Sheet 1 of 2

Ref: icy020S/ppt/f

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Stbd Leading Edge Assembly
25-8WS3299-4A
Serial Number :

Stbd										
Flag	Top				Nose		Bottom			
	Ck 1	Tolerance	Ck 2	Tolerance	Ck 3	Tolerance	Ck 4	Tolerance	Ck 5	Tolerance
1	0.15	0.19 0.11	0.15	0.19 0.11	0.187	0.227 0.147	0.15	0.19 0.11	0.154	0.194 0.114
2	0.16	0.2 0.12	0.158	0.198 0.118	0.15	0.19 0.11	0.134	0.174 0.094	0.128	0.168 0.088
3	0.158	0.198 0.118	0.154	0.194 0.114	0.141	0.181 0.101	0.128	0.168 0.088	0.122	0.162 0.082
4	0.132	0.172 0.092	0.132	0.172 0.092	0.151	0.191 0.111	0.138	0.178 0.098	0.138	0.178 0.098
5	0.146	0.176 0.116	0.146	0.176 0.116	0.149	0.179 0.119	0.174	0.204 0.144	0.174	0.204 0.144
6	0.148	0.178 0.118	0.148	0.178 0.118	0.15	0.18 0.12	0.132	0.162 0.102	0.132	0.162 0.102
7	0.134	0.164 0.104	0.136	0.166 0.106	0.15	0.18 0.12	0.162	0.192 0.132	0.162	0.192 0.132
8	0.134	0.164 0.104	0.134	0.164 0.104	0.137	0.167 0.107	0.134	0.164 0.104	0.134	0.164 0.104
9	0.13	0.16 0.1	0.13	0.16 0.1	0.154	0.184 0.124	0.155	0.185 0.125	0.155	0.185 0.125
10	0.144	0.174 0.114	0.144	0.174 0.114	0.116	0.146 0.086	0.15	0.18 0.12	0.15	0.18 0.12
11	0.125	0.155 0.095	0.125	0.155 0.095	0.144	0.174 0.114	0.173	0.203 0.143	0.2	0.23 0.17
12	0.18	0.21 0.15	0.19	0.22 0.16	0.252	0.282 0.222	0.146	0.176 0.116	0.146	0.176 0.116

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COUNTERPART NUMBER

25-8WA5

COUNTERPART NAME

Wing Assembly

RCJ

Supplier

Originator

Quality Assurance

ICY Team Leader

Production Engineering

Head - Quality Assurance

Program Manager

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COUNTERPART Wing Assembly

Part Number:- 25-8WA5

ICY Date:-

Tooling Data

Tool No.	Issue	Description
051S010633D		Wing Assy Jig Drills Master location holes in Wing Spar Top and Bottom Skins for positioning Drill Baskets to Wing Structure.
035S802908D		Inb'd Drill Basket
035S802910D		Mid Section Drill Basket
035S802912D		Outb'd Drill Basket Drill Leading Edge Assy attachment holes in Wing Spar Landing Angles Top and Bottom Skins.

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Manufacturers Serial Number

COUNTERPART: Wing Assy ICY COMPONENT CHECKS

Wing Assy Jig 051S010633D

1. Verify position of front Spar Master Holes Top and Bottom Skins.

Drill Baskets 035S802908D/10D/12D

1. Ensure Drill Baskets are located to Wing Structure by means of Master Holes in Front Spar Top and Bottom skins.
2. Check holes for position using Drill Baskets.
3. Check hole diameter to drawing.
4. Check gap from Drill Basket to Wing Skin Top and Bottom 0.000" - 0.120".

Yes	Date

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Indicate Tool Copy No Used.....

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PERIODIC RECERTIFICATION PLAN

GENERAL

This recertification plan is to ensure interchangeability of the Wing Leading Edge.

PART

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

- 1) Stage 2 Assy Jig 035S802906D using female Master References 101SCD3999T and 101SCD4001T and 101SCD4003T.
- 2) Stage 1 Assy Jigs 038S801008D, 038S801010D and 038S813067T using male Master Model 245S800772D and tooling representing Leading Edge attachment holes made from male Master Model.

COUNTERPART

A periodic recertification in accordance with QUAIS No. Q5B-003A shall be carried out on Wing Assy Jig 051S010633D and Drill Baskets 035S802908D/10D/12D.

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WING ASSEMBLY TIP TO TIP COUNTERPART INSTALLATION CHECKS -

General :

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

Wing Leading Edge Stbd to Wing Assembly Tip to Tip	Wing Leading Edge to Wing Assembly	Wing Tip to Tip Serial No.	Date	Stamp

Remarks :