



Raytheon Corporate Jets

INTERCHANGEABILITY

COMPONENT NUMBER

25-WS3709-10A

COMPONENT NAME

Access Door No. 5

PURPOSE:

These checks are to ensure interchangeability between the Door and Front Spar in accordance to Chapter 20 Model 800 Aircraft Specification.

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Raytheon Corporate Jets

COMPONENT NUMBER

25-WS3709-10A

COMPONENT NAME

**Access Door No. 5
(Front Spar)**

RCJ

Supplier

Originator

Quality Assurance

ICY Team Leader

Production Engineering

Head - Quality Assurance

Program Manager

CONFIGURATION

| | | |
|---|---|--|
| <p>Router Template 77S17741ND Drill Jig 141S39247</p> <p style="text-align: center;">←</p> <p>Original Tools</p> | <p>Reference Temp 101S10755/R</p> <p style="text-align: center;">↑</p> | <p>N.C. Tape Proprietary</p> <p style="text-align: center;">→</p> |
| <p>Reference Temp 101S10755/R</p> <p style="text-align: center;">←</p> <p style="text-align: center;">↓</p> | <p>Geometry Loft Drawing Drawings</p> | |
| <p>Drill Plates 184S10805 (Port)184S10873 (Stb'd)</p> | <p>Used with 038S800981-2D Assy. Jig</p> | |

Issue;

Amend:

Effective:

BROCHURE ISSUE SHEET:

COMPONENT NAME:

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



Raytheon Corporate Jets

SECTION ISSUE SHEET

| SECTION | SHEET | ISSUE | DATE | NAME |
|----------------|--------------|--------------|---------------|-------------|
| 1 | 1 | A | February 1997 | M.Arnold |
| 2 | 1 | A | “ “ | “ “ |
| 3 | 1 | A | “ “ | “ “ |
| 4 | 1 | A | “ “ | “ “ |
| 5 | 1 | A | “ “ | “ “ |
| 6 | 1 | A | “ “ | “ “ |
| 7 | 1 | A | March 1998 | D.Clark |

PART

Front Spar Access Door No. 5

Part Number:- 25-WS3709-10A
Installation No. - 25-8WS71

Tooling Data

| Tool No. | Issue | Description |
|--|-------|---|
| 101S10755/R | | <p><u>N.C. Data</u></p> <p>Reference Template</p> |
| 101S10755/R 141S39247 77S17741ND | | <p><u>Original Tooling</u></p> <p>Ref Template Drill Jig Router Temp.</p> |



Raytheon Corporate Jets

Manufacturers Serial Number:

PART: Access Door No. 5
ICY CHECKS

General

This check is to ensure Hole Pattern interchangeability between Access Door and Front Spar in accordance to Chapter 20 Model 800 Aircraft Specification.

1. Part made by N.C. Data.

ICY Checks

1. Check holes for position and diameter to master reference standard, and component drawing.
2. Check outside profile to component drawing.

Remarks : -

| Yes | Date |
|-----|------|
| | |

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Indicate Tool Copy No Used.....

Q7B489G - ISS 1

Ref: icy029PSE/ppt/f

Section 3
Sheet 1 of 1



Raytheon Corporate Jets

COUNTERPART NUMBER

25-8WS1067

COUNTERPART NAME

Wing Front Spar

RCJ

Supplier

Originator

Quality Assurance

ICY Team Leader

Production Engineering

Head - Quality Assurance

Program Manager

COUNTERPART

Front Spar

Part Number:- 25-8WS1067

Tooling Data

| Tool No. | Issue | Description |
|---------------------------------------|--------------|---|
| 101S10755/R 184S10805 184S10873 | | Reference Template Port Drill Plate Stbd Drill Plate (Drill plates used with 038S800981-2D Assy Jig). |



Raytheon Corporate Jets

Manufacturers Serial Number:

COUNTERPART : Front Spar ICY CHECKS

General

This check is to ensure Hole Pattern Interchangeability between Access Door and Front Spar in accordance to Chapter 20 Model 800 Aircraft Specification.

1. With Drill Template correctly located check attachment holes for concentricity (ensuring spar is correctly located in jig).
2. Check holes for size 0.250" +.011"/+.007" and 0.190" + .011"/+.007".

Remarks : -

| Yes | Date |
|-----|------|
| | |

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PERIODIC RECERTIFICATION PLAN

GENERAL

To maintain Master Reference Template and all Tools made from Reference used to meet ICY requirements, in accordance to Chapter 20 Model 800 Aircraft Specification.

PART

- 1. Verify 101S10755/R Master Reference Template once every five years.**
- 2. Verify N.C. Data by first part inspection to Reference Template with change in Vendors.**
- 3. Verify original Tooling to Reference Template before use.**

COUNTERPART

- 1. Verify 184S10805 (Port) and 184S10873 (Stb'D) Drill Plates to Master Reference Template, the greater of once a year or 30 units.**

**WING FRONT SPAR
COUNTERPART
INSTALLATION CHECKS -**

General :

The following ICY checks are to assure the consistent interchangeability at Installation of all Counterparts of the Access Doors No (5) Front Spar Port & Stbd in accordance to Chapter 20 of the "Corporate 800 Aircraft Specification Manual."

| ACCESS DOORS NO (5) FRONT SPAR PORT & STBD TO WING FRONT SPAR | ACCESS DOORS NO (5) FRONT SPAR PORT & STBD SERIAL NO'S : | WING FRONTSPAR SERIAL NO'S: | DATE | STAMP |
|--|---|-----------------------------------|------|-------|
| | | | | |

Remarks :