



Raytheon Corporate Jets

INTERCHANGEABILITY

COMPONENT NUMBER

25-8WS3105-1

COMPONENT NAME

**Wing to Fuselage Sidelink
(Front Spar Port Side Only)**

PURPOSE:

These checks are to ensure interchangeability between the Sidelink Port side, Wing/Fuselage Assy's and the vertical link in accordance to Chapter 20 Model 800 Aircraft specification.

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Raytheon Corporate Jets

COMPONENT NUMBER

25-8WS3105-1

COMPONENT NAME

Wing to Fuselage Sidelink

RCJ

Supplier

Originator

Quality Assurance

ICY Team Leader

Production Engineering

Head - Quality Assurance

Program Manager



Raytheon Corporate Jets

SECTION ISSUE SHEET

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

Issue;

Amend:

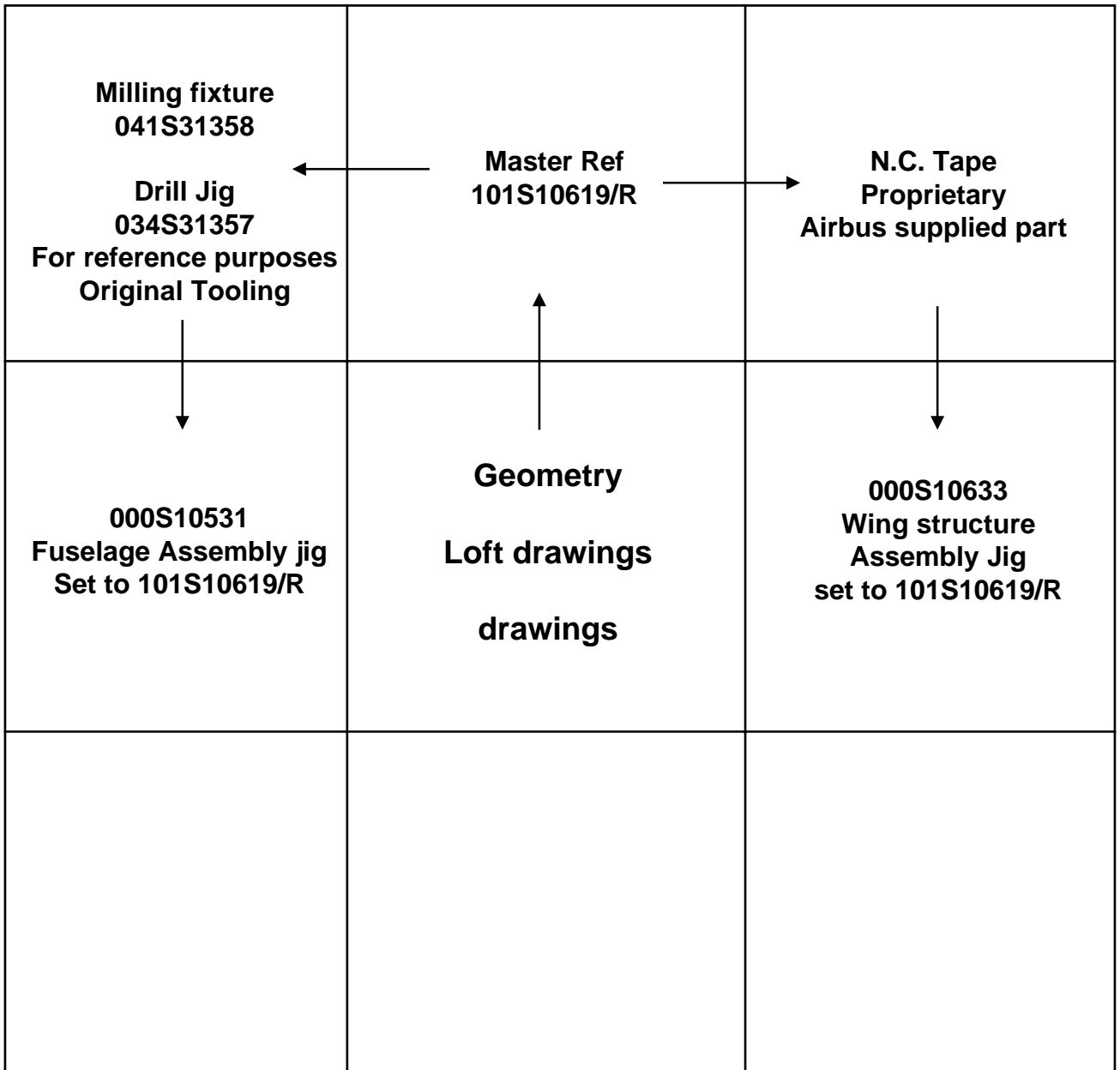
Effective:

BROCHURE ISSUE SHEET:

COMPONENT NAME: Wing to Fuselage sidelink

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

CONFIGURATION



PART

Wing to Fuselage Sidelink - Port side

Part Number:- 25-8WS3105-1

Tooling Data

Tool No.	Issue	Description
034S31357		N.C. Data
041S31358		<u>Original Tooling</u>
		Drill Jig controls hole centres
		Milling fixture



Raytheon Corporate Jets

Manufacturers Serial Number

PART : Wing to Fuselage Sidelink Port side ICY CHECKS

Yes	Date

General

This check is to ensure hole pattern interchangeability between sidelink, Wing/Fuselage attachment points, and 25-8WS3103-1 vertical link (port side only).

Part made by N.C. tapes and milling machine.

ICY Checks

1. Check 0.750" +0.0008", -0.0000" and 0.625" +0.0007", -0.0000" diameter holes.
2. Check 5.654" pitch for hole centres.
3. Check 0.6005" / 0.6050" and gapping as respective fork ends.
4. Check outside profile to drawing.

Remarks :-

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Indicate Tool Copy No. used.....



Raytheon Corporate Jets

COUNTERPART NUMBER

25-8WA1 / 25-8FC1

COUNTERPART NAME

Wing / Centre Fuselage

RCJ

Supplier

Originator

Quality Assurance

ICY Team Leader

Production Engineering

Head - Quality Assurance

Program Manager

COUNTERPART

- 1) *Wing Assembly*
- 2) *Fuselage Assembly*
- 3) *Vertical link (port side only)*

Part Number:- 1) 25-8WA1 (See brochure 018)
 2) 25-8FC1
 3) 25-8WS3103-1 (See brochure 19PSA)

Tooling Data

Tool No.	Issue	Description
000S10633		Wing Assy Jig set to 101A10619/R
0000S10531		Fuselage Assy Jig set to 101S10619/R
N.C. Tapes		Part made by N.C. tapes (See brochure 019PSA)
		<u>Original Tooling</u>
034S10426		Drill Jig controls hole centres
041S10427		Milling fixture



Raytheon Corporate Jets

Manufacturers Serial Number

COUNTERPART : Wing / Fuselage ICY CHECKS

Yes	Date

General

This check is to ensure hole pattern interchangeability between sidelink, wing / fuselage attachment points, and vertical link 25-8WS3103-1 (Port side only).

1. Check wing attachment Port set by 000S10633. Pins to move at normal hand pressure at front and rear spar positions, port and stbd. (Ensure pins are correctly located).
2. Check Fuselage attachment point set by 000S10531. Pins to move at normal hand pressure at frame 13 position, port. (Ensure pins are correctly located).

Remarks : -

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PERIODIC RECERTIFICATION PLAN

GENERAL

This recertification plan is to ensure that the interchangeability of the side link is maintained in accordance with chapter 20 model 800 aircraft.

PART

Verify N.C. data by inspection of component to drill Jig 034S31357 for hole concentricity by a periodic check of 30 units or 12 months whichever is greater.

COUNTERPART

A periodic check of 30 units or 12 months whichever is greater shall be performed on Wing Assy Jig 000S10633, Fuselage Assy Jig 000S10531 to master ref 101S10619/R.

Verify N.C. Data for vertical link 25-8WS3103-1 check hole for concentricity to drill jig 034S10426.

**WING CENTRE FUSELAGE
COUNTERPART
INSTALLATION CHECKS -**

General :

The following ICY checks are to assure the consistent interchangeability at Installation of all Counterparts of the wing to fuselage sidelink front spar Port side only in accordance to Chapter 20 of the "Corporate 800 Aircraft Specification Manual."

WING TO FUSELAGE SIDELINK FRONT SPAR PORT SIDE ONLY TO WING/ CENTRE FUSELAGE	WING TO FUSELAGE SIDE LINK FRONT SPAR PORT SIDE ONLY SERIAL NO:	WING/FUSELAGE ASSEMBLY SERIAL NO:	DATE	STAMP

Remarks :