



Raytheon Corporate Jets

INTERCHANGEABILITY

COMPONENT NUMBER

25-9WG5-43A

COMPONENT NAME

Aileron Tab

PURPOSE:

This brochure is to ensure interchangeability between the Aileron Tab and Aileron in accordance with Chapter 20 Model 800 Aircraft Design Specifications.

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Q7B489A - ISS 1

Reference: icy023/ppt/f



Raytheon Corporate Jets

COMPONENT NUMBER

25-9WG5-43A

COMPONENT NAME

Aileron Tab

RCJ

Supplier

Originator

Quality Assurance

ICY Team Leader

Production Engineering

Head - Quality Assurance

Program Manager



CONFIGURATION

<p>051S804167D Tab Assy Jig</p>	<p>101S807487D Tab Reference Tool</p>	
<p>245S806052T 245S806053T 245S806054T 245S806055T 245S806056T 245S806057T Male Master Models of Upper & Lower Aileron Skin Profiles</p>	<p>LOFTS DRAWINGS GEOMETRY</p>	
<p>038S805875/76D Aileron Assy & Drill fixtures</p>		

Issue;

Amend:

Effective:

BROCHURE ISSUE SHEET:

COMPONENT NAME: Aileron Tab

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	Feb '96	DeFever
2	1	A	“	“
3	1	A	“	“
4	1	A	“	“
5	1	A	“	“
6	1	A	“	“
7	1	A	March 1998	D.Clark

PART

Aileron Tabs, Port and StBD

Part Number:- 25-9WG5-43A

Tooling Data

Tool No.	Issue	Description
101S807487D		Tab Reference
051S804167D		Tab Assy and Drill Jig



Raytheon Corporate Jets

Manufacturers Serial Number:

PART : Aileron Tab, Port & Stbd ICY CHECKS

Yes	Date

General

Aileron Tab and the Aileron, in accordance to This brochure is to ensure interchangeability between the Chapter 20 Model 800 Aircraft Specification.

1. Ensure Tab is located in Assy Jig by means of:
 - 1A. Leading Edge Spar making contact with Spar Stops (2 PLCS). Using (3) three screw plates at trailing edge.
 - B. Inbd & Outb'd location by means of Tab secured against side stop and by using screw clamp.
 - C. Tab to be secured to six nesting blocks by means of two toggle clamps.
2. Hinges
 - 2A. Drill for Hinge Locations via Dummy Hinge Drill Blocks.

Remarks : -

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Indicate Tool Copy No used.....



Raytheon Corporate Jets

COUNTERPART NUMBER

25-8WG111-61A/62A

COUNTERPART NAME

Aileron

RCJ

Supplier

Originator

Quality Assurance

ICY Team Leader

Production Engineering

Head - Quality Assurance

Program Manager



COUNTERPART Aileron

Part Number:- 25-8WG111-61A/62A

Tooling Data

Tool No.	Issue	Description
038S805875D 038S805876D		Aileron Assy Jigs
24S806052 24S806053 24S806054 24S806055 24S806056 24S806057	<div data-bbox="505 1321 619 1549" style="border: 1px solid black; width: 80px; height: 110px; margin: 0 auto;"></div>	Male Master Models



Raytheon Corporate Jets

Manufacturers Serial Number:

COUNTERPART : Aileron ICY CHECKS

Yes	Date

General

This brochure is to ensure interchangeability between the Aileron Tab and the Aileron in accordance with Chapter 20 and the Model 800 Aircraft Specification.

Ref 038S805875/6D Aileron Assy Jig

1. Ensure .475 Hinge Pins rotate freely

Ref 101S807484D Tab Hinge and Aperture Fixture

Ensure correct aperture Boundaries by means of:

1. Check Shroud Edges using .070”/.090” Slip gauge
2. Check Inbd & Outbd trim by the following means:
 - A. Port & Stbd outbd trim use .050”/.125” slip gauge
 - B. Port & Stbd inbd trim use .040”/.080” slip gauge

Remarks : -

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Raytheon Corporate Jets

PERIODIC RECERTIFICATION PLAN

GENERAL

This brochure is to ensure interchangeability between Aileron Tab and the Aileron in accordance to Chapter 20 Model 800 Aircraft Specification.

PART

Recertify 051S804167D Tab Assy Jig, the greater of once a year or 30 units, using 101S807487D Tab reference master Jig.

COUNTERPART

038S805875/6D

Recertify the greater of once a year or 30 units, per design specifications.



AILERON COUNTERPART INSTALLATION CHECKS -

General :

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

AILERON TAB TO AILERON	AILERON TAB SERIAL NO :	AILERON SERIAL NO:	DATE	STAMP

Remarks :