

Raytheon

AIRCRAFT COMPANY

INTERCHANGEABILITY

COMPONENT NUMBER

25-8KT1-132

COMPONENT NAME

Tailplane T.K.S. Panels

PURPOSE:

This brochure is to ensure interchangeability between T.K.S. Panels and Tailplane Leading Edge, in accordance with Chapter 20 Model 800 Aircraft Specification.

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COMPONENT NUMBER

25-8KT1-132

COMPONENT NAME

Tailplane T.K.S. Panels

RAC

Supplier

Originator

ICY Engineering

Quality Assurance

Quality Assurance

Program Manager

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CONFIGURATION

PART

COUNTERPART

<p>TKS Drill & Trim Fixtures 036S803769D</p>	<p>Tailplane L/Edge Reference Gauge S010780/R</p>	<p>Tailplane Leading Edge Red Master 520SCD7321T</p>
<p>Profile Checking Jig S40822</p>	<p>Loft Drawings Drawings 25-Q 45 Geometry</p> <p>Laser tracker</p>	<p>Tailplane Leading Edge Skin Drill & Trim Jig 227SCD7021T 227SCD7235T</p>
<p>***** Note:- ICY and Drawing data Qualified through MOD Audit trail— 252500 600 to 700 series 252900 700 to 800 series *****</p>	<p>TKS Landing Strip Drill Jig 038S100408TH</p>	<p>Tailplane Leading Edge Assembly Fixture SCD2250</p>

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BROCHURE ISSUE SHEET:

COMPONENT NAME: Tailplane TKS Panels

Issue; 01

Amend: 2

Effective: January 2006

Amendment Number	Sections/ Pages Affected	Reason for Amendment or Reference	Date	Authorized
2	ALL	Hamble/Prestwick Transfer	Jan 2006	Mike Cavey



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SECTION ISSUE SHEET

SECTION	SHEET	ISSUE	DATE	NAME
1	1	B	January 2006	Mike Cavey
2	1	B	“	“
2	2	B	“	“
3	1	B	“	“
4	1	B	“	“
4	2	A	“	“
5	1	B	“	“
6	1	B	“	“
7	1	B	“	“

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PART

Tailplane TKS Panel

Part Number:- 25-8KT1-132

Tooling Data

Tool No.	Issue	Description
S010780/R		Tailplane L/Edge Reference Gauge
036S803769D		TKS Drill and trim Fixture
S40822		Profile Checking Jig

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Manufacturers Serial Number:

PART: Tailplane TKS Panel General

Part Tooling Description

S10780/R Tailplane L/Edge Reference Gauge.

The reference gauge was manufactured to represent the Leading Edge and to co-ordinate the manufacturing tooling. The Reference jig contains the following ICY features: -

1. The TKS Panel to Tailplane Leading Edge Index and Attachment Hole Positions.
2. The Tailplane Attachment Index Hole Positions.
3. The Skin Edge in way of the Tailplane
4. Inboard Skin Edge.
5. Outboard Skin Edge.
6. Scribe Line to represent Skin Edge in way of TKS Panels.

036S803769D TKS Drill and Trim Fixtures

The Assembly Fixture was manufactured to control the following ICY features: -

1. The TKS to Tailplane Leading Edge attachment holes.
2. The Upper and Lower Skin Edges.
3. The Inboard and Outboard Skin Edges.
4. The Leading Edge Profile..

The Drill and Trim Fixtures are co-ordinated from the Tailplane L/Edge Reference Jig Tool No S10780/R

S40822 Profile Checking Jigs.

The Profile Checking Jigs was manufactured to check the following ICY Features: -

1. The TKS Panel Profile.

Remarks :-

Indicate Tool Copy No. used.....

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Manufacturers Serial Number:

PART : Tailplane TKS Panel ICY CHECKS

General

These checks are to ensure the Boundary and Hole Pattern interchangeability between the Tailplane TKS Panel and Tailplane Leading Edge in accordance with Chapter 20 Model 800 Aircraft Specification.

Yes	Date

STAGE 1

S40822 Profile Checking Jigs.

With the TKS Panel positioned and secured in the profile checking tool. Carry out the following ICY Check.

1. Check L/Edge contour to Checking Jig to $\pm 0.010''$

STAGE 2

036S803769D TKS Drill and Trim Fixtures

With TKS Panel positioned and secured in Trim and Drill Jig. Carry out the following ICY Checks.

1. Check Upper and lower Skin Edges to Trim Edge to $+0.010''/-0.015''$
2. Check Inboard and Outboard Skin Edges to $\pm 0.015''$
3. Check attachment holes with $0.005''$ undersize pins.

Remarks : -

Indicate Tool Copy No. used.....

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COUNTERPART NUMBER

25-8TP259

COUNTERPART NAME

Tailplane Leading Edge

RAC

Supplier

Originator

ICY Engineer

Quality Assurance

Quality Assurance

Program Manager

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COUNTERPART Tailplane Leading Edge

Part Number:- 25-8TP259

Tooling Data

Tool No.	Issue	Description
S10780/R		Tailplane L/Edge Ref Gauge
520SCD7321T		Tailplane L/Edge Red Master
227SCD7021T 227SCD7235T		Tailplane L/Edge Skin Drill and Trim Jigs
SCD2250		Trim and Drill Tool.
038S100408TH		TKS Landing Strip Drill Jig.
166SCD7735D		ICY Checking Pins.

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Manufacturers Serial Number:

COUNTERPART : Tailplane Leading Edge General

Counterpart Tooling Description

S10780/R Tailplane L/Edge Reference Gauge.

The reference gauge was manufactured to represent the Leading Edge and to co-ordinate the manufacturing tooling. The Reference jig contains the following ICY features: -

1. The TKS Panel to Tailplane Leading Edge Index and Attachment Hole Positions.
2. The Tailplane Attachment Index Hole Positions.
3. Skin Edge in way of the Tailplane
4. Inboard Skin Edge.
5. Outboard Skin Edge.
6. Scribe Line to represent Skin Edge in way of TKS Panels.

520SCD7321T Tailplane Leading Edge Red Master

The Red Master was manufactured to represent the Leading Edge and also be used as a facility gauge to control the following ICY Features:-

1. The tailplane attachment holes including the Index Holes.
2. The inboard and outboard skin edges.
3. The skin edge in way of the TKS panel
4. The skin edge in way of the tailplane

The tailplane leading edge red master index holes match the tailplane leading edge reference gauge.

227SCD7021T & 227SCD7235T Tailplane L/Edge Skin Drill & Trim Jigs

The skin drill and trim fixtures were manufactured to control the following ICY features: -

1. The tailplane attachment holes including the Index Holes.
2. The Skin Edge in way of the tailplane
3. The outboard skin edge
4. The inboard skin edge
5. The skin edge in way of the TKS. Panels

The Drill and Trim fixtures are co-ordinated from the Tailplane Leading Edge Red Master Tool No 520SCD7321T

Remarks : -

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Manufacturers Serial Number:

COUNTERPART : Tailplane Leading Edge General

Counterpart Tooling Description

SCD2250 Tailplane Leading Edge Assembly Jig

The Tailplane Leading Edge was manufactured to control the following ICY Features:

1. The TKS Attachment Holes
2. The Skin Edge in way of the TKS Panel
3. The Inboard Skin Edge
4. The Outboard Skin Edge
5. The Tailplane Attachment Index Holes

The Tailplane Leading Edge was manufactured in conjunction with the Tailplane L/Edge Reference Gauge Tool No S10780/R

038S100408TH TKS Landing Strip Drill Jigs

The Landing Strip Drill Jigs were manufactured to drill off the TKS attachment holes in the Landing Strips.

The Drill jigs were co-related to the Leading Edge Reference Gauge.

Remarks : -

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Manufacturers Serial Number:

COUNTERPART : Tailplane Leading Edge ICY CHECKS

General

These checks are to ensure the Boundary and Hole Pattern interchangeability between the Tailplane TKS Panel and Tailplane Leading Edge, in accordance with Chapter 20 Model 800 Aircraft Specification.

STAGE 1

SCD2250 T/Plane L/Edge Assembly Jig

After completing the Leading Edge and before removing from the Leading Edge Assembly Jig. Carry out the following ICY Checks

1. Remove and replace the TKS Index hole location pins and check for free rotation and any noticeable deflection.
2. Check Skin Edge in way of TKS Panels with Go - Not Go Gauge Detail 5 (0.085" - 0.115")
3. Check Leading Edge contour through slots in shroud tight to 0.010" feeler.

STAGE 2

038S100408TH TKS Landing Strip Drill Jigs

After the Landing strips have been drilled off locate to and before removing the jig, carry out the following ICY checks.

1. Remove and replace the TKS Index hole location pins and check for free rotation and any noticeable deflection.
2. Check through the remaining TKS attachment hole pattern to drill jig with a 0.005" undersize stepped pin Tool No 166SCD7735D Detail 4 for free rotation and any noticeable deflection..

Yes	Date

Remarks : -

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PERIODIC RECERTIFICATION PLAN

GENERAL

To maintain all Tools made from Master Models that are used to meet ICY requirements in accordance with Chapter 20 Model 800 Aircraft Specification.

PART

1. Verify 036S803769D Drill and Trim to Reference Master Model no greater than 24 months or 60 units.
2. Verify S40822 Profile checking Jig to reference paste model no greater than 24 months or 60 units.

COUNTERPART

1. Verify Tailplane Leading Assembly Fixture SCD2250 with Leading Edge Red Master Tool No 520SCD7321T no greater than 24 months or 60 units.

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TKS PANEL TO TAILPLANE LEADING EDGE INSTALLATION CHECKS -

General :

The following ICY checks are to assure the consistent interchangeability at Installation of the Tailplane T.K.S. Panel to the Tailplane L/Edge in accordance to Chapter 20 of the "Corporate 800 Aircraft Specification Manual."

T.K.S. PANEL TO TAILPLANE LEADING EDGE	TAILPLANE LEADING EDGE SERIAL NO :	T.K.S. PANEL SERIAL NO:	DATE	STAMP

Refer to relevant ICY Brochures as noted below :

ICY Brochure

041PA/PPT/F, 041SA/PPT/F, 041PB/PPT/F, 041SB/PPT/F, 041PC/PPT/F,
041SC/PPT/F, 041PD/PPT/F, 041SD/PPT/F.

Remarks :