

Raytheon

AIRCRAFT COMPANY

INTERCHANGEABILITY

COMPONENT NUMBER

25-8TE3-1A

COMPONENT NAME

Elevator Trim Tab

PURPOSE:

This brochure is to document data used to ensure interchangeability between the Elevator Trim Tab and the Elevator Assembly. This is in accordance with Chapter 20 and the Model 800 Aircraft Design specifications.

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COMPONENT NUMBER

25-8TE3-1A

COMPONENT NAME

Elevator Trim Tab

RAC

Supplier

Originator

ICY Engineering

Quality Assurance

Quality Assurance

Program Manager

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CONFIGURATION

PART

COUNTERPART

<p>Elevator Tab Aperture Guage 101S059270D</p>	<p>Elevator Ref Jig. S38907R</p>	<p>Elevator Assy. Jig. 051S059263</p>
<p>Elevator Tab Assy Jig. 051S059259</p>	<p>LOFT GEOMETRY DRAWINGS 25-Q 67 Laser Tracker</p>	<p>Elevator Tab Aperture Guage 101S059270D</p>
	<p>***** Note:- ICY and Drawing data Qualified through MOD Audit trail— 252500 600 to 700 series 252900 700 to 800 series *****</p>	

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SECTION	SHEET	ISSUE	DATE	NAME
1	1	B	August 2005	Mike Cavey
2	1	B	“	“
3	1	A	“	“
3	2	B	“	“
4	2	B	“	“
5	1	B	“	“
6	1	B	“	“
7	1	B	“	“

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PART

Elevator Trim Tab

Part Number:- 25-8TE3-1A

Tooling Data

Tool No.	Issue	Description
S59259		Elevator Tab Assembly Jig.
101S059270D		Elevator Tab Aperture Guage

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Manufacturers Serial Number:

PART : Elevator Trim Tab General

1) 101S059270D Elevator Tab Aperture Gauge.

The Aperture Gauge was manufactured from a combination of lofts and dimensions to control the following ICY Features:-

- . The Elevator Tab Hinge Line.

2) 051S29259D Elevator Tab Assembly Jig.

The Elevator Tab Assembly Jig was manufactured from a combination of lofts and dimensions to control the following ICY Features:-

- . The Elevator Tab Hinge Line.
- . The Elevator Tab Leading Edge.
- . The Inboard Skin Edges.
- . The Outboard Skin Edges.

NOTE! All Pins and Gauges used to check ICY features must be subject to an annual calibration check.

Pins used on ICY Features as part of an Assembly Jig must be included as part of the Jig Cycle check.

Indicate tool Copy No. used.....

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Manufacturers Serial Number:

PART : Elevator Trim Tab ICY CHECKS

General

This is in accordance with Chapter 20 Model 800 Aircraft Specifications.

Ref. Elevator Tab Assy. Jig S59259

1. Remove and replace hinge pin to check for free rotation and undue deflection.
2. Check Leading Edge profile at 4-places with 0.30"-0.60" Slip Guages.
3. Check Inboard Skin Edge gap against jig plate 0.180" to 0.225"
4. Check Outboard Skin Edge gap against jig plate 0.185" to 0.220"
5. Carry out waviness check not to exceed +/-0.03" in 2.0"

Remarks : -

Yes	Date

Indicate tool Copy No. used.....

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COUNTERPART NUMBER

25-8TE1-1A

COUNTERPART NAME

Elevator

RAC

Supplier

Originator

ICY Engineering

Quality Assurance

Quality Assurance

Program Manager

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COUNTERPART

Elevator

Part Number:- 25-8TE1-1A

Tooling Data

Tool No.	Issue	Description
051S059263		Elevator Assembly Jig
S38907R		Elevator Reference Guage
S059270D		Elevator Tab Ref and Aperture Guage

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Manufacturers Serial Number:

COUNTERPART : Elevator ICY CHECKS

General

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

Ref Elevator Assy. jig 051S059263

Stage 1

1. Remove and replace jig pins at tab hinges and check for free rotation and undue deflection.
2. Check tab Shroud trim using 0.230"/0.250" Slip Guage.

Ref Tab Aperture Guage 101S059270D

Stage 2

1. Load Aperture Guage onto Elevator
2. Check the inboard aperture skin edge with Go-No Go guage 0.320"- 0.355"
3. Check the Outboard Aperture Skin Edge with Go-No Go guage 0.330"- 0.365"
4. Check Shroud clearance with Go-No Go guage 0.080"-0.110".

Yes	Date

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PERIODIC RECERTIFICATION PLAN

GENERAL

This recertification plan is to ensure interchangeability of the Port Elevator Trim Tab.

PART

A periodic recertification in accordance with QAIS No. Q5B-003A shall be carried out on Elevator Trim Tab Assembly Jig 051S059259D and Elevator Tab Aperture Guage 101S059270D using ECDS Master file data pack.

COUNTERPART

A periodic recertification in accordance with QAIS No. Q5B-003A shall be carried out on Elevator Assembly Jig 051S0595263D Elevator Tab Aperture Guage 101S059270D and Elevator Reference Guage 101S38907/R.

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ELEVATOR TAB AND ELEVATOR INSTALLATION CHECKS -

General :

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

ELEVATOR TRIM TAB SERIAL NO:		ELEVATOR SERIAL NO :		ELEVATOR TRIM TAB TO ELEVATOR	
Serial No.	Date / Stamp	Serial No.	Date / Stamp	Tab Serial No.	Date / Stamp
				Elevator Serial No.	Date / Stamp

Remarks :