



Raytheon Corporate Jets

INTERCHANGEABILITY

COMPONENT

NUMBER

NF24016-158

COMPONENT NAME

**Windscreen Panel 'A' -
Stbd**

PURPOSE:

This brochure is used to document data used to ensure interchangeability between Aperture in fuse and boundaries of glass. To ensure contour between fuse and glass in accordance to Chapter 20 Model 800 Aircraft Specification

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Q7B489A - ISS 1

Reference: icy005AS/ppt/f



Raytheon Corporate Jets

COMPONENT NUMBER

NF24016-158

COMPONENT NAME

Windscreen Panel 'A'

RCJ

Supplier

Originator

Quality Assurance

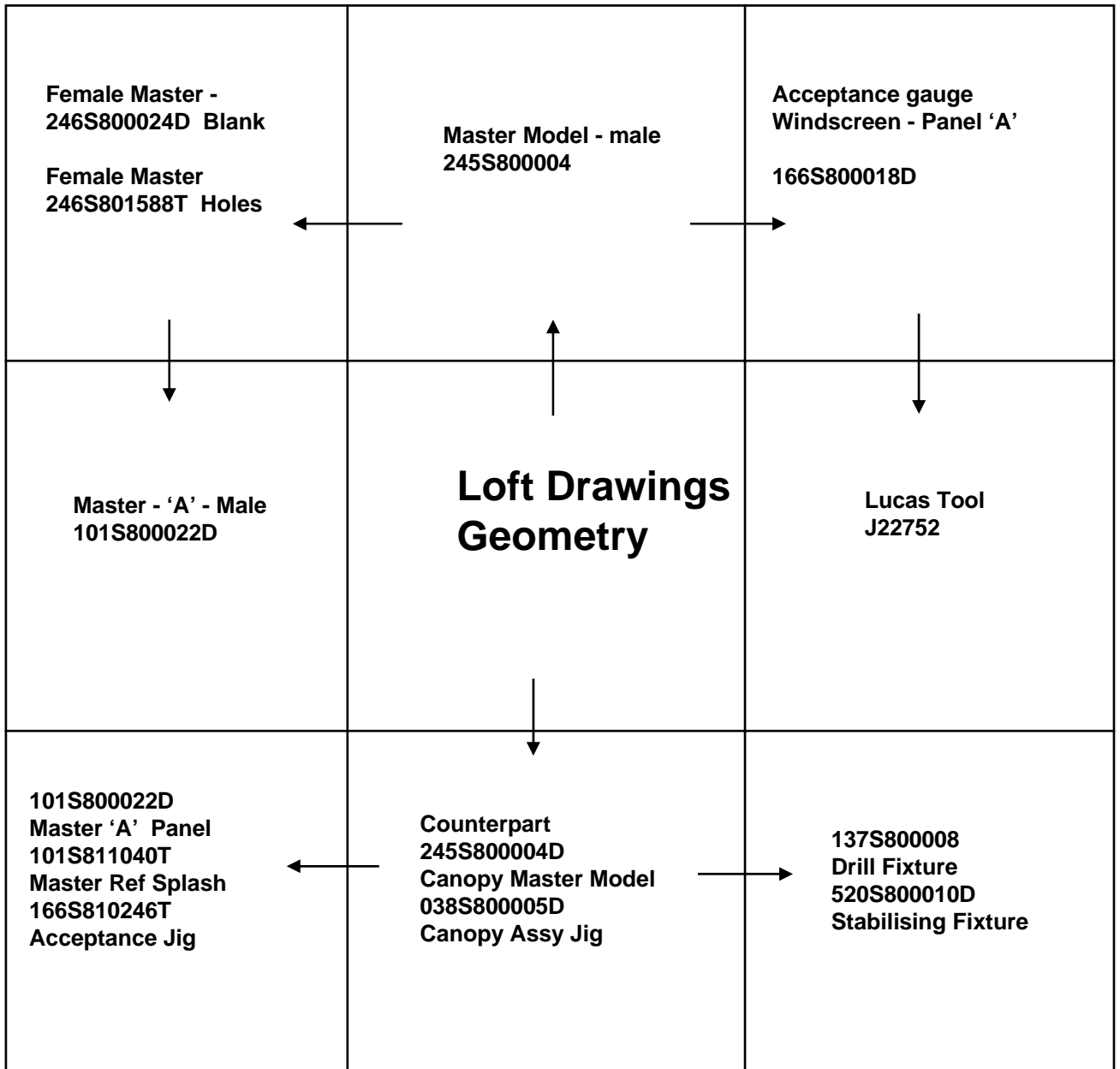
ICY Team Leader

Production Engineering

Head - Quality Assurance

Program Manager

CONFIGURATION



Issue:

Amend:

Effective:

BROCHURE ISSUE SHEET:

COMPONENT NAME: Windscreen Panel 'A'

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 1996	M Broad
2	1	A	“	“
3	1	A	“	“
4	1	A	“	“
5	1	A	“	“
6	1	A	“	“
7	1	A	March 1998	D.Clark

PART

**Windscreen Panel 'A'
R.H.**

Part Number:- NF24016-158

Tooling Data

Tool No.	Issue	Description
245S800004	D	Master Model
246S801588T	A	Female Master - holes
101S800022D	A	Master 'A' - Windscreen - male
166S800018D	A	Acceptance gauge - panel A



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Manufacturers Serial Number:

PART : Windscreen Panel 'A' ***ICY CHECKS***

Yes	Date

General

To check profile, contour, rebates are correct to drawing requirements in accordance with Chapter 20 Model 800 Aircraft Specification.

With window clamped in acceptance jig 166S800018D

1. Check profile to $0.130 \pm .03$ as per drawing
NF24016 - 158.....
2. Check weather seal to $0.120 \pm .02$ as per drawing
NF24016 - 158.....
3. Check contour to ensure gap does not exceed 0.03
(note clamp point pressure not to exceed
22lbs).....
4. Check outer rebate width using gauge J20891
Item 21.....
5. Check rebate thickness using gauge J20891
item 19.....

Remarks : -

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Indicate Tool Copy No used.....

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Section 3
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Raytheon Corporate Jets

COUNTERPART NUMBER

25-8FN353

COUNTERPART NAME

Canopy Assembly

RCJ

Supplier

Originator

Quality Assurance

ICY Team Leader

Production Engineering

Head - Quality Assurance

Program Manager

Counterpart

Canopy Assembly

Part Number:- 25-8FN353

Tooling Data

Tool No.	Issue	Description
038S800005D	A19	Canopy Assy Jig
137S8001008D	A12	Windscreen Surround Drill fixture
166S810246T	A	Panel 'A' surround acceptance fixture
25.8FN277/ 8		Clamp Ring
234S805142T		Contoured Drill Jig
104S810182T	A	Spindle Jig



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Manufacturers Serial Number:

Counterpart: Canopy Assembly ICY CHECKS

General

To check gap between fuse and windscreen, bolting requirements, into and out of wind and rate of change with acceptance gauge installed, in accordance to Chapter 20 Model 800 Aircraft Specification.

1. Use 166S810246T Acceptance gauge canopy 'A' aperture, in lieu of master panel. Max deviation from gauge $\pm .08$ at any point, rate of change no more than .02 in any 4.00 along any edge.....
2. Max. bedding step at corners must not exceed .01.....

Yes	Date

Remarks : -

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Indicate Tool Copy No used.....

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Section 5
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***PERIODIC RECERTIFICATION
PLAN:***

GENERAL

Using Master Model 245S800004 all tools that control ICY will be certified to this master to assure interchangeability between all aircraft, in accordance to Chapter 20 Model 800 Aircraft Specification.

PART

1. Check female master 246S801588T to master model 245S80004, the greater of once a year or 30 units.
2. Check male masters 101S800022D to design and master model 245S80004, the greater of once a year or 30 units.

COUNTERPART

1. Check 166S810246T acceptance gauges to design and Master Model 245S80004, the greater of once a year or 30 units.

**CANOPY ASSEMBLY COUNTERPART
INSTALLATION CHECKS -**

General :

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

WINDSCREEN PANEL "A" TO CANOPY ASSEMBLY STBD	WINDSCREEN PANEL "A" SERIAL NO :	AIRCRAFT SERIAL NO:	DATE	STAMP

Remarks :