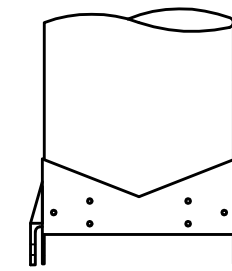
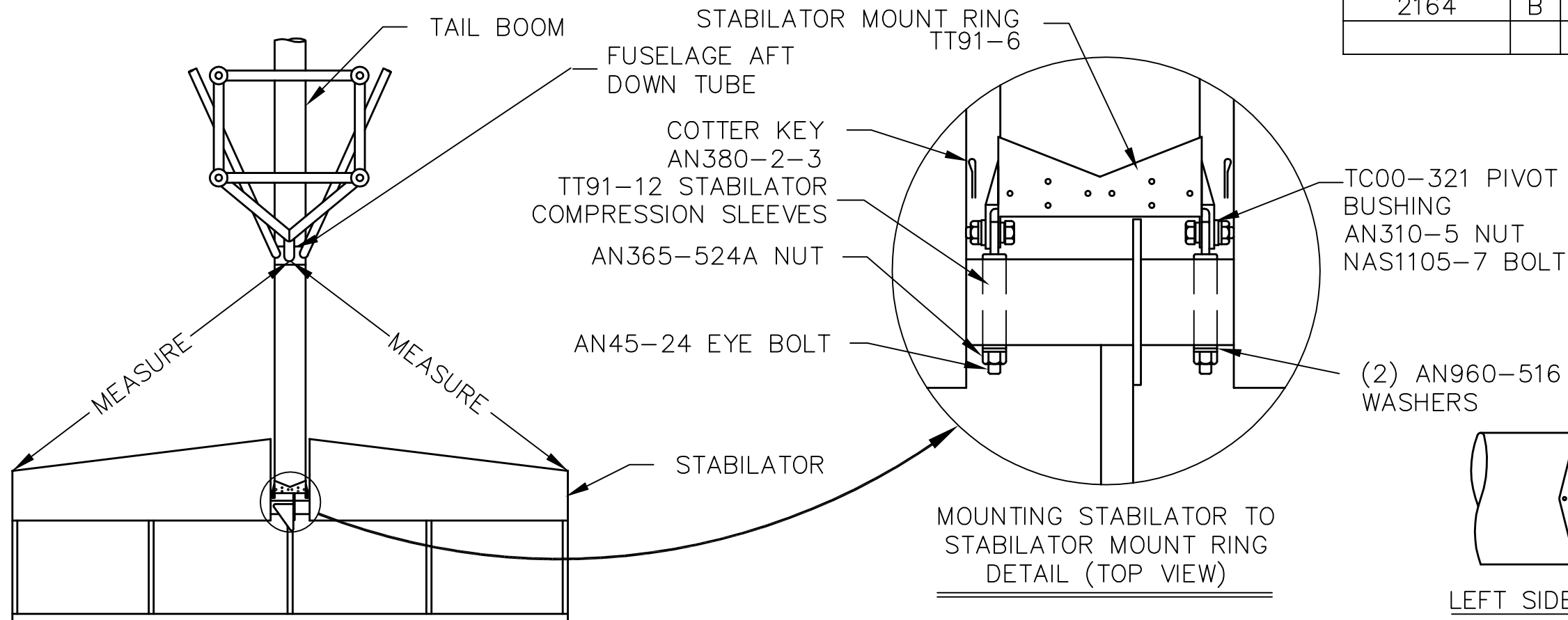
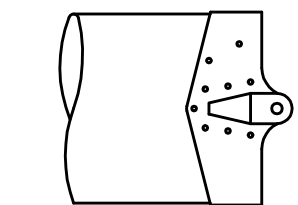


REVISIONS

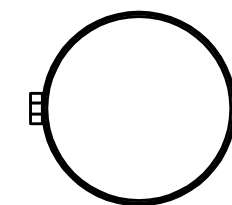
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	K.L.	10/01
2164	B	REMOVED TOP GUSSET	CE	10/05



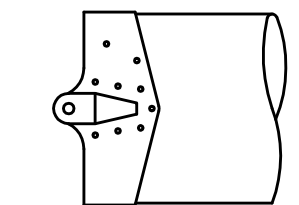
TOP VIEW



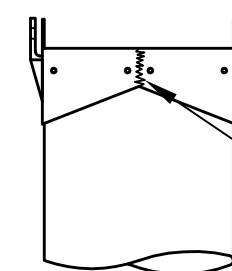
LEFT SIDE VIEW



END VIEW



RIGHT SIDE VIEW




BOTTOM VIEW

NOTE:  
- WELD ON MOUNT RING MUST FACE DOWNWARD.

STABILATOR MOUNT RING DETAIL

ASSEMBLY PROCEDURES:

- USE TAIL BOOM STAND OR WEIGHT NOSE TO RAISE TAIL BOOM OFF THE GROUND.
- SLIDE STABILATOR MOUNT RING OVER END OF TAIL BOOM ORIENTATED AS SHOWN. EDGES OF STABILATOR MOUNT RING AND TAIL BOOM SHOULD BE FLUSH.
- TEMPORARILY MOUNT STABILATOR TO STABILATOR MOUNT RING.
- LEVEL THE AIRPLANE BY PLACING A BOLT THROUGH BOTH MAIN WING FITTINGS AND LAYING A STRAIGHT EDGE ACROSS THE BOLTS. USE THIS AS A BASE FOR THE LEVEL.
- LEVEL STABILATOR.
- MEASURE FROM THE ENDS OF THE STABILATOR LEADING EDGE TO THE AFT FUSELAGE DOWN TUBE. ADJUST STABILATOR UNTIL BOTH MEASUREMENTS ARE EQUAL.
- RECHECK LEVEL AND ALIGNMENT.
- DRILL MOUNTING HOLES FOR THE STABILATOR MOUNT RING THROUGH THE TAIL BOOM AND THEN CLECO. USE EXISTING HOLES IN THE MOUNTING RING AS A GUIDE. USE #30 DRILL (.1285 DIA). STABILATOR MAY BE REMOVED FOR EASY ACCESS TO SIDE MOUNTING HOLES.
- REMOVE STABILATOR MOUNT RING, DEBURR MOUNTING HOLES, AND SAND MATING SURFACES FOR BONDING.
- PERMANENTLY INSTALL STABILATOR MOUNT RING USING EPOXY. RIVET WITH SD42BS RIVETS.

 <b>TITAN AIRCRAFT SUPPLY</b> 1419 STATE ROUTE 45 SOUTH AUSTINBURG, OHIO 44010	
DETAIL NAME STABILATOR MOUNTING INSTRUCTIONS	
SCALE N/A	PART NO.
ASSEMBLY NAME ALL TORNADO AIRCRAFT STARTING 6/2000	
PART NO.	DRAWING NO.
DRAWING NO. <b>B 01-INS-1297-B</b>	

DRAWN K. LIPLIN	DATE 10/22/01
CHECKED G. TRUEX	DATE 10/4/05
APPROVED J. WILLIAMS	DATE 10/5/05

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