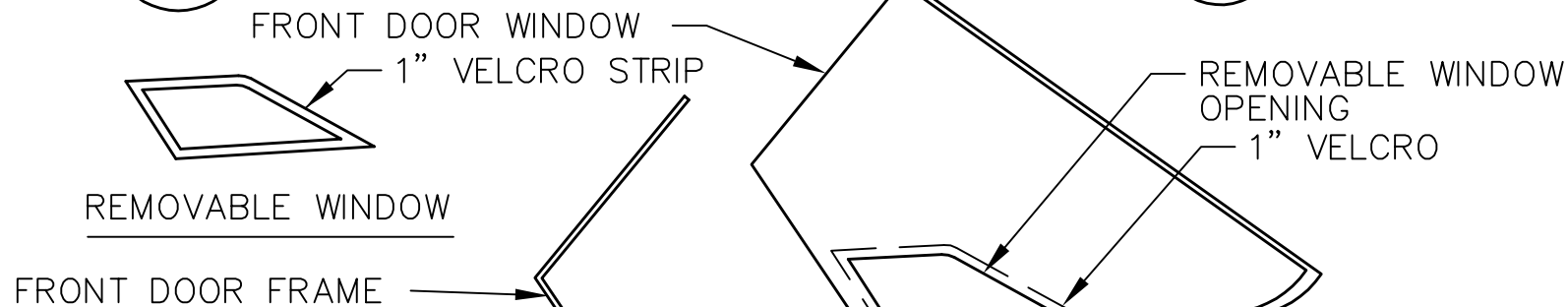


EXAMPLE OF STAGGERD HOLE PATTERN IN HINGE



REMOVABLE WINDOW



FRONT DOOR WINDOW

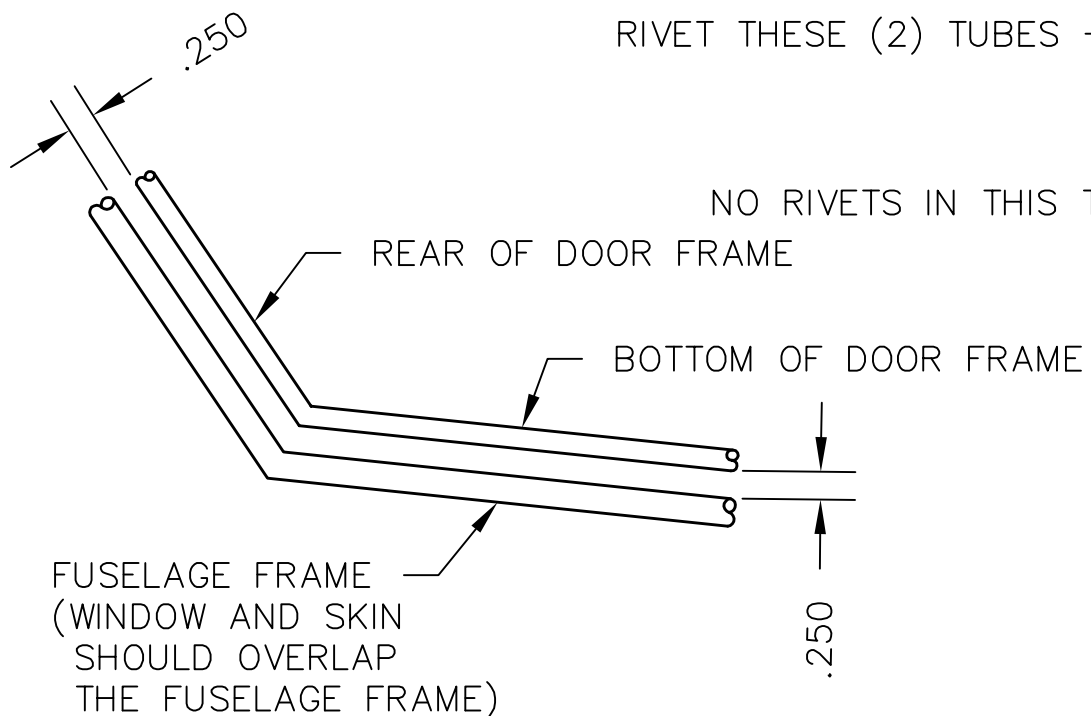
1" VELCRO STRIP

REMOVABLE WINDOW OPENING

1" VELCRO

FRONT DOOR FRAME

RIVET THESE (2) TUBES



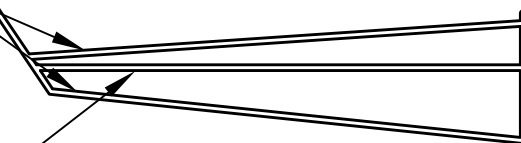
REAR OF DOOR FRAME

BOTTOM OF DOOR FRAME

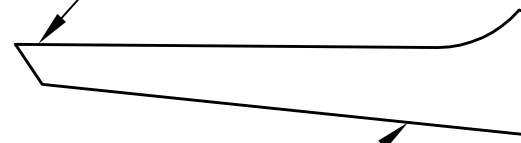
FUSELAGE FRAME  
(WINDOW AND SKIN SHOULD OVERLAP THE FUSELAGE FRAME)

EXAMPLE OF DOOR FRAME PLACEMENT IN FUSELAGE

NO RIVETS IN THIS TUBE



THIS EDGE SHOULD LINE UP WITH BELLY SKIN ON LEFT SIDE.



FRONT DOOR SKIN

NOTES:

- ALL DIMENSIONS ARE INCHES.
- CUT FRONT DOOR SKIN OUT OF SHEET ALUMINUM USING THE PATTERN PROVIDED.
- CUT FRONT DOOR WINDOW OUT OF LEXAN USING THE PATTERN PROVIDED.
- CLAMP FRONT DOOR FRAME ONTO FUSELAGE LEAVING APPROXIMATELY .250 INCH CLEARANCE BETWEEN THE BOTTOM AND REAR OF THE DOOR FRAME AND THE FUSELAGE FRAME. WE RECOMMEND THAT A .250 INCH THICK SPACER BE CLAMPED BETWEEN THE FUSELAGE AND DOOR FRAME FOR THIS.
- CLAMP DOOR SKIN SO THAT ITS TOP EDGE IS IN LINE WITH TOP EDGE OF THE BELLY SKIN ON THE OPPOSITE SIDE OF THE AIRCRAFT AND SO IT LINES UP EVENLY AT THE NOSE.
- DRILL ALL MOUNTING HOLES ON 2.000 INCH CENTERS USING #30 DRILL (.1285 DIA). CLECO AS YOU DRILL.
- TRACE OUT DOOR FRAME ON DOOR SKIN FROM INSIDE AIRCRAFT.
- REMOVE AND PREDRILL DOOR SKIN.
- REINSTALL DOOR SKIN WITH CLAMPS TO INSURE PREDRILLED HOLES ALIGN WITH CENTER OF THE DOOR FRAME TUBES. DRILL AND CLECO.
- REMOVE LEFT SIDE WINDOW.
- CLAMP FRONT DOOR WINDOW INTO POSITION. THE DOOR SKIN SHOULD OVERLAP THE DOOR WINDOW.
- DRILL MOUNTING HOLES THRU BOTTOM OF DOOR WINDOW AND DOOR SKIN FIRST.
- DRILL MOUNTING HOLES ALONG REAR SIDE AND TOP OF DOOR NEXT.
- CLECO LEFT SIDE WINDOW BACK ONTO FUSELAGE, INCLUDING HINGE AND LEXAN SPACER STRIP.
- DRILL MOUNTING HOLES THRU HINGE AND FRONT DOOR WINDOW. NOTE: STAGGER THE HOLES FROM THOSE ON THE LEFT HAND SIDE OF THE HINGE.
- USING REMOVABLE WINDOW AS A TEMPLATE, CUT LEXAN AS SHOWN LEAVING A 1" OVERLAP. APPLY 1" VELCRO STRIP AROUND OUTSIDE EDGE OF REMOVABLE WINDOW AND INSIDE EDGE OF OPENING.
- DO NOT RIVET UNTIL ALL WINDOWS HAVE BEEN FITTED.
- USE AD42ABS RIVETS (.125 DIA X .265 LONG) FOR MOUNTING HOLES THRU DOOR SKIN AND DOOR FRAME.
- USE AD42ABS RIVETS AND #4 RIVET WASHERS FOR MOUNTING HOLES THRU DOOR SKIN AND WINDOW.
- USE AD42ABSLF RIVETS (.125 DIA X .265 LONG) FOR MOUNTING HOLES THRU WINDOW AND DOOR FRAME.
- USE AD42ABSLF RIVETS AND #4 RIVET WASHERS FOR MOUNTING HOLES THRU WINDOW AND HINGE.

**TITAN AIRCRAFT SUPPLY**  
 1419 STATE ROUTE 45 SOUTH  
 AUSTINBURG, OHIO 44010

DETAIL NAME FRONT DOOR W/ REMOVABLE WINDOW INSTALLATION

DRAWN K. BOHRER	DATE 10/29/96
CHECKED B. PASSAFIUME	DATE 11/14/96
APPROVED J. WILLIAMS	DATE 11/14/96

SCALE N/A	PART NO.
ASSEMBLY NAME SINGLE AND TWO PLACE TORNADO	
PART NO.	DRAWING NO.
DRAWING NO. <b>B 96-INS-0767-A</b>	

THIS DOCUMENT PROPRIETARY TO TITAN AIRCRAFT, AND IS NOT TO BE USED, CIRCULATED, REPRODUCED, COPIED, OR DISCLOSED IN ANY MANNER WITHOUT PRIOR WRITTEN PERMISSION OF AN AUTHORIZED OFFICIAL OF TITAN AIRCRAFT.