

DRILL & CLECO IN PLACE,
RIVET WHEN SKINNING
(TOP & BOTTOM FLANGES)

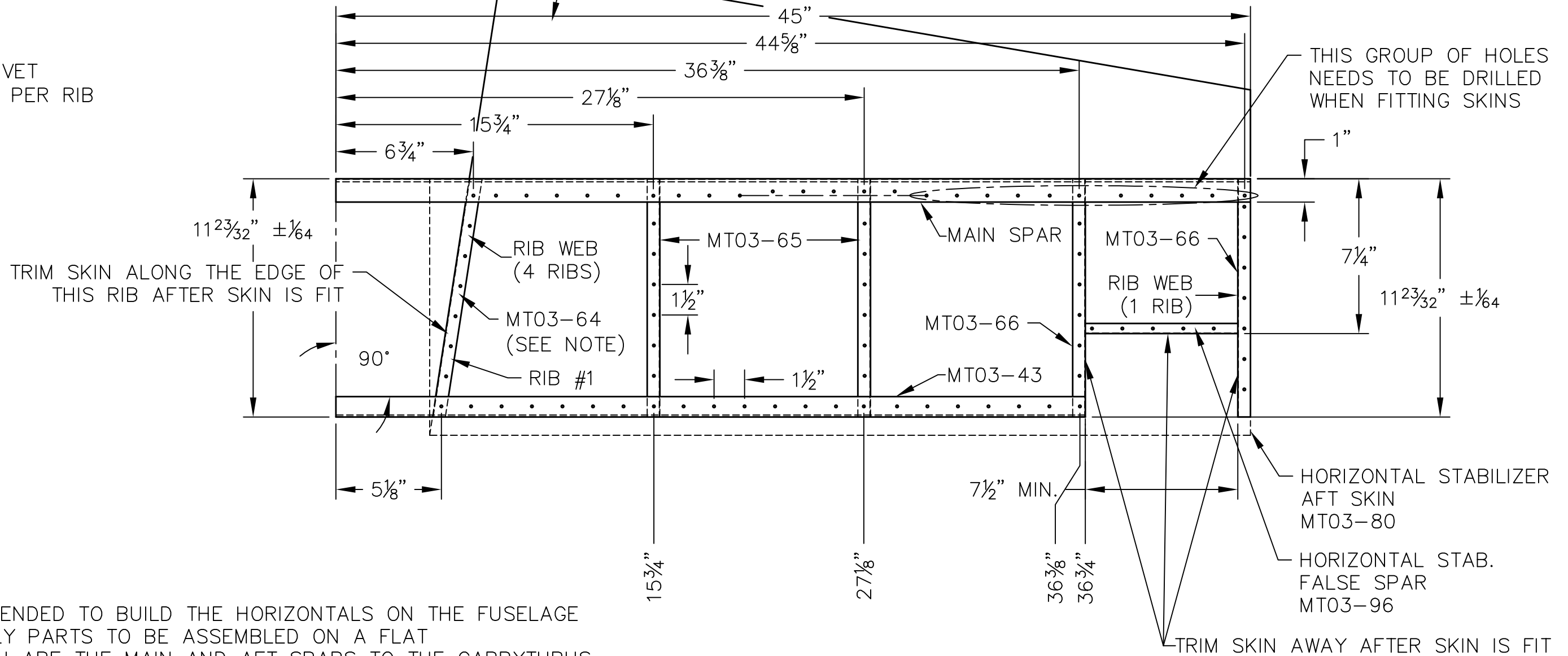
DRILL & RIVET
(2) RIVETS PER RIB

HORIZONTAL STABILIZER
LEADING EDGE D-CELL
MT03-63

DRILL & RIVET
(2) RIVETS PER RIB

REVISIONS

E.C. NO.	REV.	DESCRIPTION	BY	DATE
0626	G	NOTES ADDED/CHANGED	SH	2/08
1083	H	NOTES ADDED	BH	8/10
1146	I	NOTES CHANGED	BH	10/12



NOTES:

- IT IS RECOMMENDED TO BUILD THE HORIZONTALS ON THE FUSELAGE FRAME, THE ONLY PARTS TO BE ASSEMBLED ON A FLAT TABLE OR BENCH ARE THE MAIN AND AFT SPARS TO THE CARRYTHRUS.
- BE SURE TO KEEP BOTH SPARS SQUARE WHILE ASSEMBLING THE HORIZONTALS.
- MT03-64 IS SAME AS MT03-65, EXCEPT FOR THE ANGLE OF THE LEADING AND TRAILING EDGE FLANGES. THE BUILDER WILL NEED TO ADJUST THE ANGLE OF THE FLANGES ON TWO OF THE MT03-65 RIBS TO MAKE THE MT03-64 RIBS. THIS CAN BE DONE BY USING A PAIR OF PLIERS TO BEND THE FLANGES ACCORDINGLY.
- SHIMMING MAY BE REQUIRED ON THE RIBS, WHEN FITTING THE SKINS.
- SLIDE AFT SKIN 1" UNDER FORWARD SKIN.
- RIB (MT03-64) HAS AN APPROX. OFFSET OF 1 5/8".

TITAN AIRCRAFT SUPPLY
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DETAIL NAME		HORIZONTAL STABILIZER INSTRUCTIONS	
DRAWN	DATE	SCALE	PART NO.
B. HODGKINSON	7/14/03	1/4"=1"	
CHECKED	DATE	ASSEMBLY NAME	
K. BROOKS	1/17/13		
APPROVED	DATE	PART NO.	DRAWING NO.
B. KOLENO	2/18/13		F34
		DRAWING NO. B T51-03-INS-0821-I	

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