

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

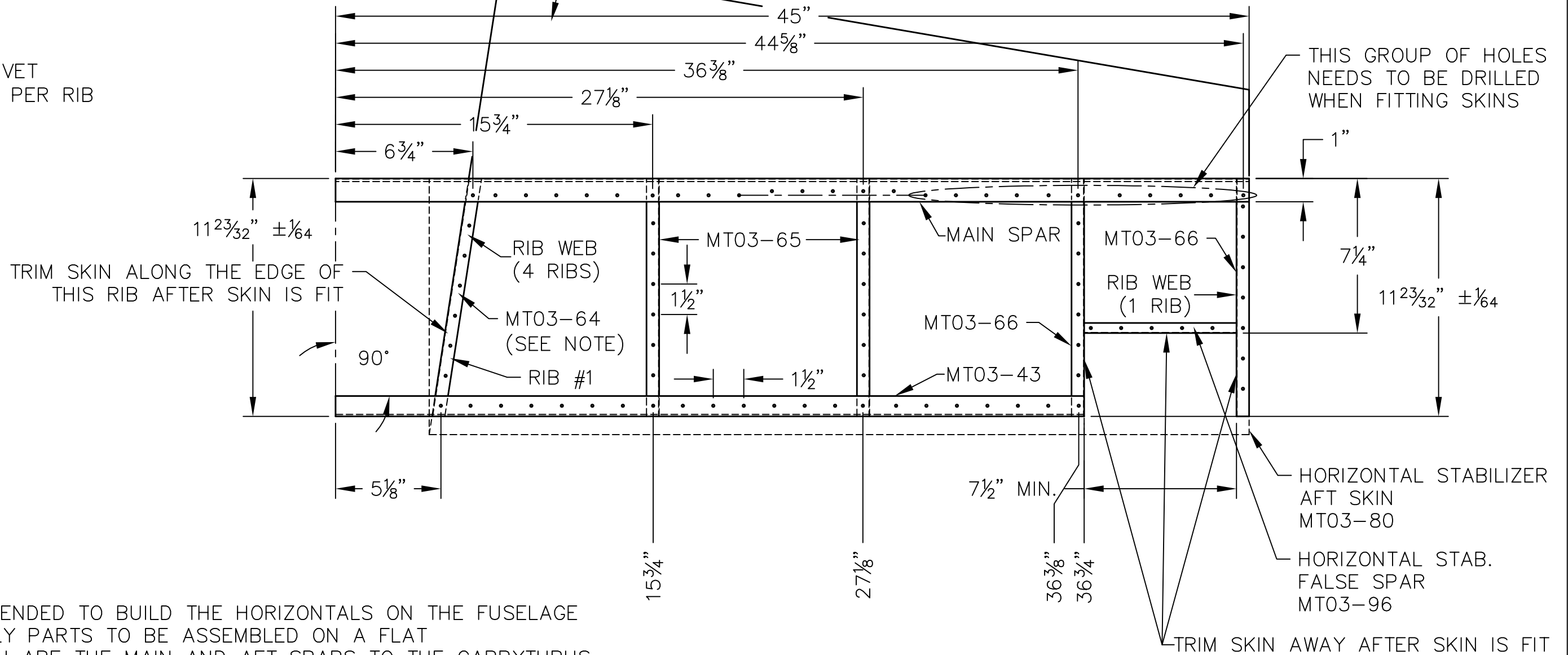
DRILL & RIVET
(2) RIVETS PER RIB

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 1⁵/₈".

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

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