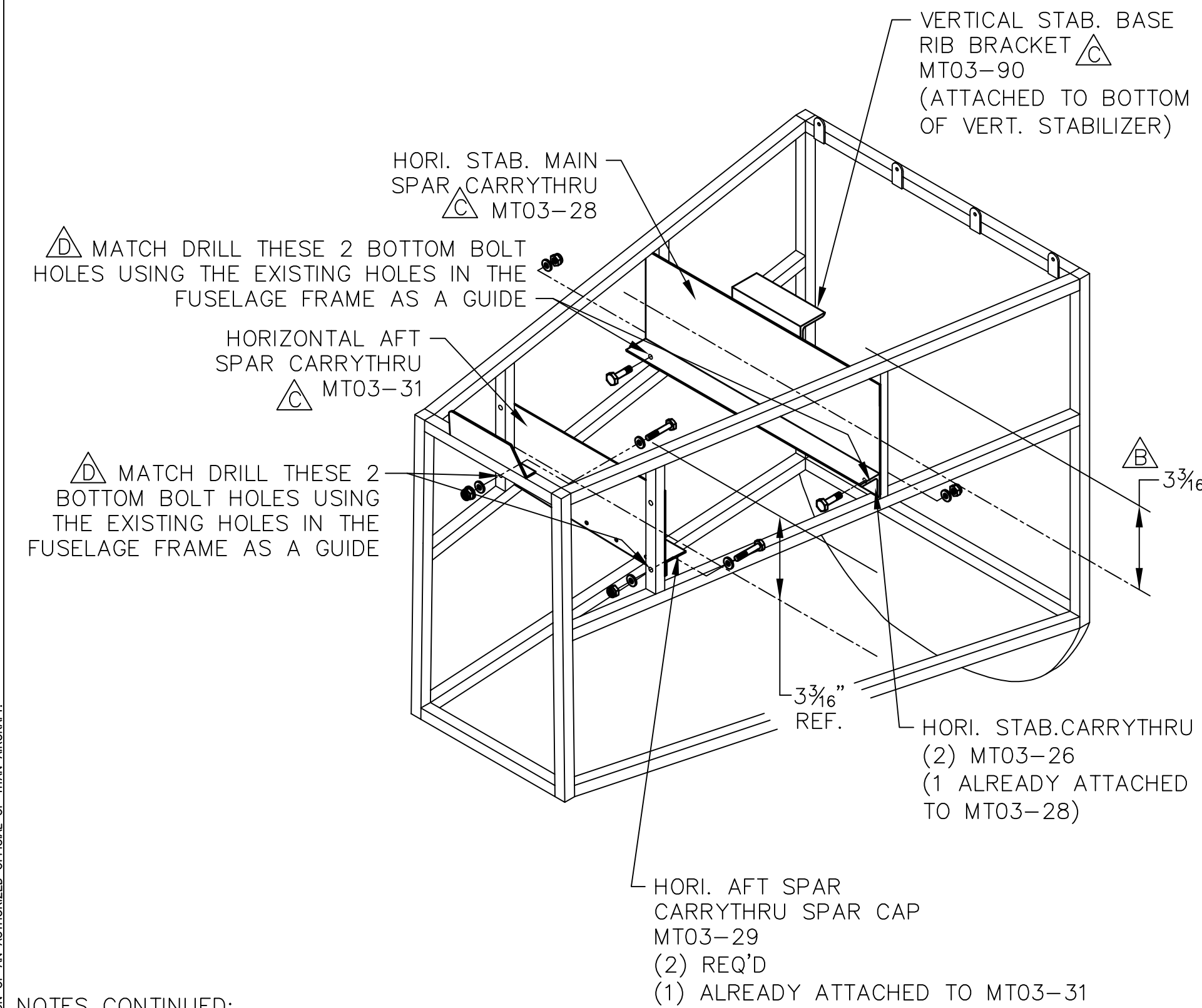


REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	BH	7/03
0056	B	ADDED CENTERLINE DIMENSIONS	CE	12/03
0377	C	NOTES ADDED	SH	11/06
0480	D	DRAWING CORRECTED	SH	6/07
0746	E	BOLT CHANGE	SH	8/08
0859	F	NOTES ADDED	SH	1/09



NOTES:

- IT IS RECOMMENDED TO INSTALL THE VERTICAL STABILIZER FIRST, BEFORE INSTALLING THE CARRYTHRUS.
- THE TOP FLANGE ON EACH CARRYTHRU IS NOT ATTACHED TO MAKE IT EASIER TO MOUNT THE HORIZONTALS IN PLACE. (THE TOP FLANGES SHOULD BE ADDED WHEN THE HORIZONTALS ARE BUILT.)
- LEVEL OUT THE FUSELAGE FRAME, ENSURE AREAS WHERE FLIGHT SURFACES ATTACHED ARE LEVEL.
- MARK THE CENTER OF EACH SPAR/CARRYTHRU ASSEMBLY $3\frac{3}{16}$ " DOWN FROM THE TOP LONGERON AS SHOWN IN DRAWING AND MARK ON EACH SIDE OF THE FRAME.
- MATCH THE CENTER LINES ON THE CARRYTHRU TO THE $3\frac{3}{16}$ " MARKS ON THE FRAME, MAKE SURE THE SPAR/CARRYTHRU ASSEMBLIES ARE LEVEL AND CLAMP IN PLACE WHEN SATISFIED. (BE SURE NOT TO COVER THE HOLES ON THE FUSELAGE WITH THE CLAMPS.)
- USING A $\frac{3}{16}$ " DRILL, MATCH DRILL THE HOLES LOCATED ON THE FUSELAGE TO THE LOWER HALF OF EACH CARRYTHRU AND DEBURR.
- USE (4) AN3-10A BOLTS, AN960-10L WASHERS, AND AN365-1032 LOCKNUTS ON FWD CARRYTHRU. USE (4) AN3-10A BOLTS, AN365-1032 LOCKNUTS, & (8) AN960-10 WASHERS ON AFT CARRYTHRU.

NOTES CONTINUED:

- THE FWD AND AFT SPARS AND CARRYTHRUS SHOULD BE ASSEMBLED ON A FLAT TABLE BEFORE MOUNTING TO THE FUSELAGE FRAME. REFER TO DRAWING T51-09-INS-1808-A FOR DIMENSIONS TO MEASURE POINTS "A" AND "B".

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

DETAIL NAME HORIZONTAL MAIN SPAR CARRYTHRU INSTALLATION			
SCALE N/A	PART NO. \triangle		
ASSEMBLY NAME			
PART NO.	DRAWING NO. F33		
DRAWING NO. B T51-03-INS-0822-F			

DRAWN B. HODGKINSON	DATE 7/14/03
CHECKED R. INGLE	DATE 2/16/10
APPROVED K. BROOKS	DATE 2/16/10

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