

NOTE:

– USE HAT SECTIONS (MF02-109) ON ALL VERTICAL & HORIZONTAL TUBES FROM STATION #4 THRU STATION #14 ON BOTH SIDES OF THE FUSELAGE. ALSO USE THE HAT SECTIONS (MF02-109) AS STRINGERS & CUT PIECES TO FIT IN BETWEEN STATION #4 THRU STATION #12 AS SPECIFIED IN DRAWING.

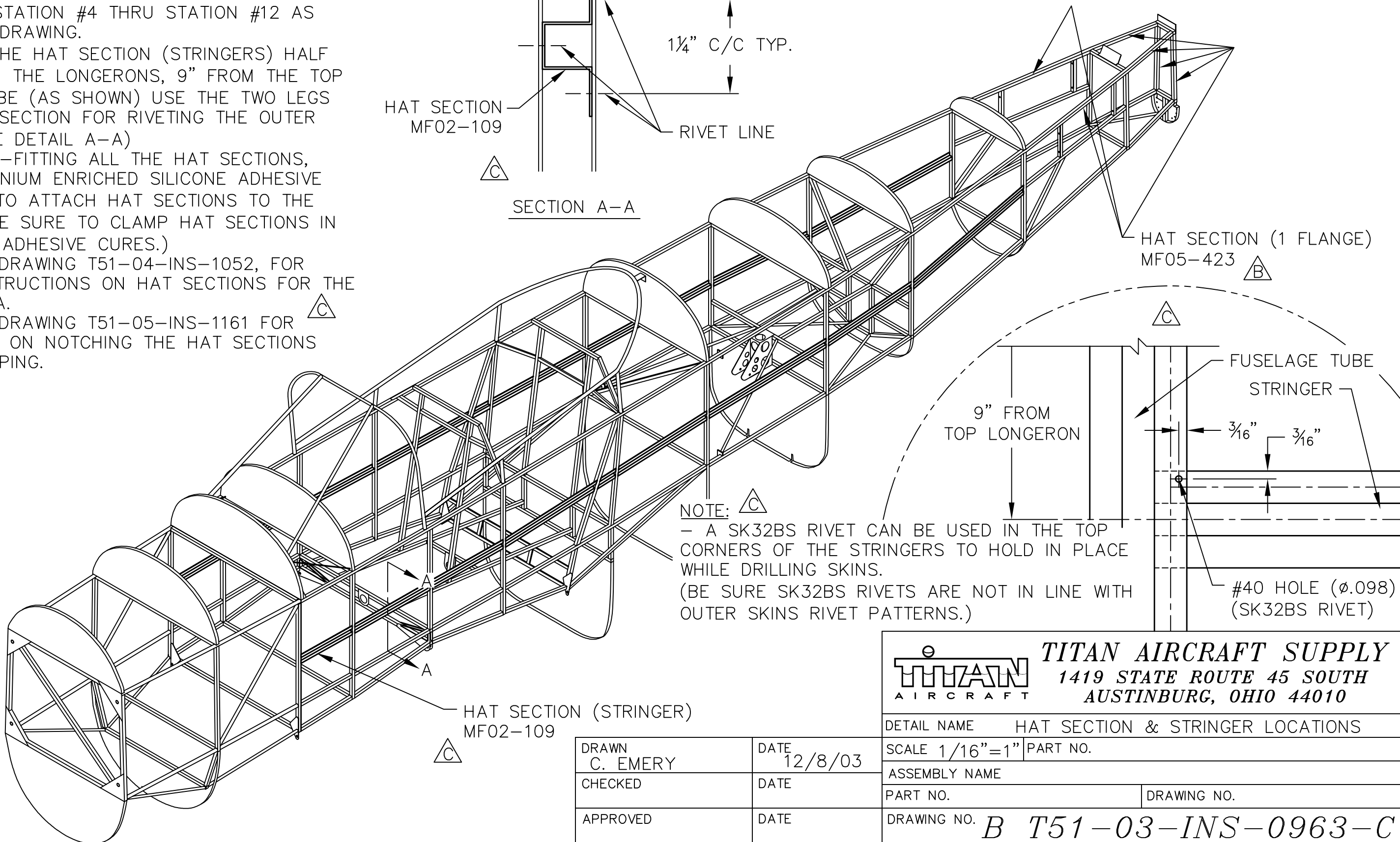
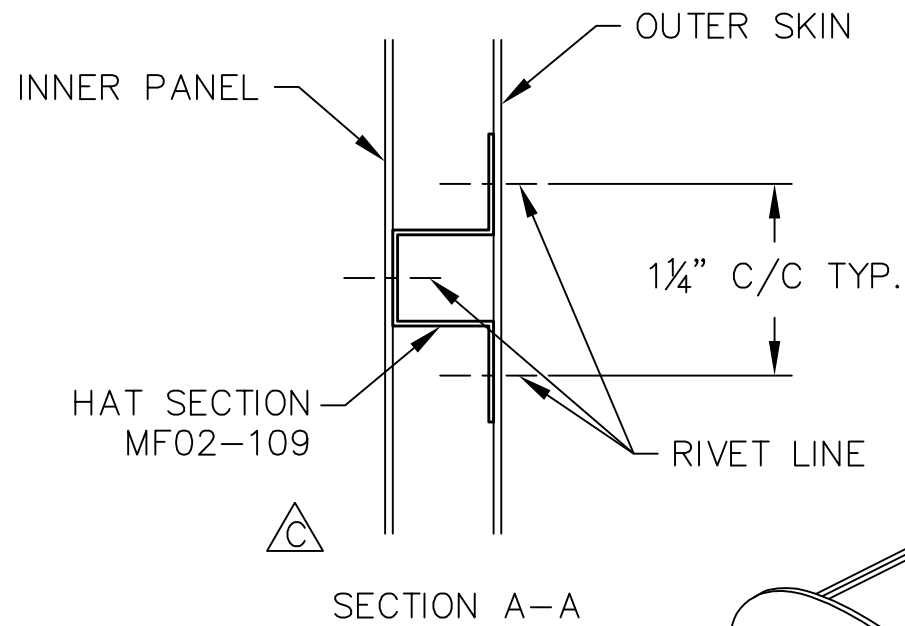
– POSITION THE HAT SECTION (STRINGERS) HALF WAY BETWEEN THE LONGERONS, 9" FROM THE TOP FUSELAGE TUBE (AS SHOWN) USE THE TWO LEGS ON THE HAT SECTION FOR RIVETING THE OUTER SKIN TO. (SEE DETAIL A-A)

– AFTER PRE-FITTING ALL THE HAT SECTIONS, USE THE TITANIUM ENRICHED SILICONE ADHESIVE (MF05-447) TO ATTACH HAT SECTIONS TO THE FUSELAGE. (BE SURE TO CLAMP HAT SECTIONS IN PLACE WHILE ADHESIVE CURES.)

– REFER TO DRAWING T51-04-INS-1052, FOR DETAILED INSTRUCTIONS ON HAT SECTIONS FOR THE COCKPIT AREA.

– REFER TO DRAWING T51-05-INS-1161 FOR INSTRUCTIONS ON NOTCHING THE HAT SECTIONS FOR OVERLAPPING.

REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	CE	12/03
0450	B	UPDATED DRAWING	SH	3/07
0781	C	NOTES ADDED	SH	10/08



NOTE:
 – A SK32BS RIVET CAN BE USED IN THE TOP CORNERS OF THE STRINGERS TO HOLD IN PLACE WHILE DRILLING SKINS.
 (BE SURE SK32BS RIVETS ARE NOT IN LINE WITH OUTER SKINS RIVET PATTERNS.)



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

DETAIL NAME	HAT SECTION & STRINGER LOCATIONS		
SCALE	1/16"=1"	PART NO.	
ASSEMBLY NAME			
PART NO.			DRAWING NO.
DRAWING NO.	B T51-03-INS-0963-C		

DRAWN	C. EMERY	DATE	12/8/03
CHECKED		DATE	
APPROVED		DATE	

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