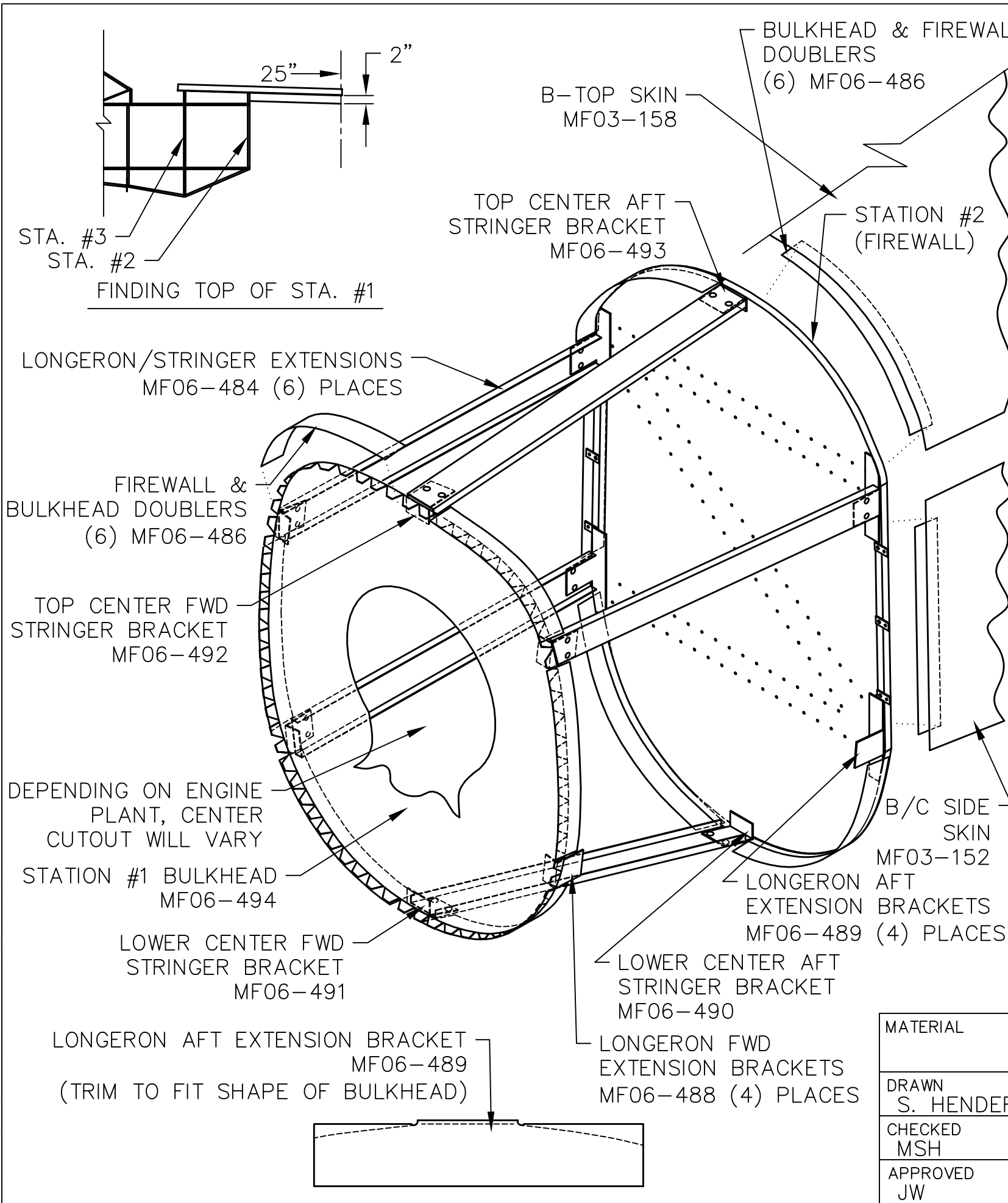



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REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	SH	6/06

NOTES:

- (BE SURE THE FIREWALL IS ATTACHED.)
- SET MF06-489 ON FIREWALL ALIGNED W/ LONGERON TUBES (4) PLACES & MARK OUTSIDE POSITIONS. (EACH MF06-489 WILL NEED TO BE CUT-TO-FIT THE SHAPE OF THE FIREWALL AS SHOWN.) CLAMP IN PLACE.
- LOCATE MF06-490 & MF06-493, SET IN DESIGNATED LOCATIONS (AS SHOWN IN CENTER OF STATION #2 BULKHEAD.) CLAMP IN PLACE.
- USE A PIECE OF ANGLE APPROX. 45" LONG, SET ONE END OF THE ANGLE ON THE TOP-CENTER OF STA. #3 BULKHEAD, WHILE DOING SO CLAMP ANGLE TO STA. #2 BULKHEAD. MEASURE 25" FROM STA. #2 ON THE ANGLE & MARK, THEN MEASURE DOWN 2" FROM 25" MARK ON ANGLE, THIS IS WHERE THE TOP-CENTER OF STA. #1 (MF06-494) WILL BE. (NOTE: IN V6 APPLICATIONS THIS IS CONTROLLED BY THE #1 BULKHEAD & THE MOTOR MOUNT.)
- CLAMP EACH LONGERON/STRINGER EXTENSION (MF06-484) TO THE (6) BRACKETS PREVIOUSLY CLAMPED TO FIREWALL. USE MF06-494 & SET IN POSITION AT THE END OF LONGERON/STRINGER EXTENSIONS, MARK WHERE EXTENSIONS MEET STA. #1 & ADJUST IF NEEDED.
- CLAMP THE FWD LONGERON/STRINGER BRACKETS (MF06-488, 491, & 492) TO STATION #1 IN PREVIOUSLY MARKED AREAS, THEN CLAMP BRACKETS TO LONGERON/STRINGER EXTENSIONS. (ADJUST IF NEEDED.)
- WHEN SATISFIED WITH POSITIONING, USE A #30 DRILL AND MATCH DRILL & RIVET ALL BRACKETS TO STATION #1 & FIREWALL.
- WHEN ATTACHING BRACKETS TO FIREWALL/STATION #1, USE SD43BS RIVETS ON MF06-489, SD42BS RIVETS ON ALL OTHER BRACKETS. TO ATTACH MF06-486 DOUBLERS TO MF06-494, USE MS20426A3 SOLID RIVETS. (NOTE: STA. #2 (MF06-486) DOUBLERS ARE FITTED BETWEEN #2 BULKHEAD & THE FWD EDGE OF THE SKINS THAT TERMINATE AT STA. #2.)
- THE 4 LONGERON EXTENSIONS WILL NEED ANGLES CUT AT STATION #1, SO THE END OF THE EXTENSION IS PARALLEL W/ THE EDGE OF STATION #1.
- MATCH DRILL LONGERON/STRINGER EXTENSIONS TO BRACKETS ATTACHED TO FIREWALL & STATION #1, USE (4) NUTPLATES & SCREWS ON EACH LONGERON/STRINGER EXTENSION.

 TITAN AIRCRAFT SUPPLY 1419 STATE ROUTE 45 SOUTH AUSTINBURG, OHIO 44010	
DETAIL NAME LONGERON EXTENSION INSTRUCTIONAL	
SCALE 1"=1"	PART NO.
ASSEMBLY NAME FOR ROTAX POWERED AIRCRAFTS	
PART NO.	DRAWING NO.
DRAWING NO. B T51-06-INS-1477-A	

MATERIAL	
DRAWN S. HENDERSON	DATE 6/26/06
CHECKED MSH	DATE 1/23/07
APPROVED JW	DATE 1/23/07