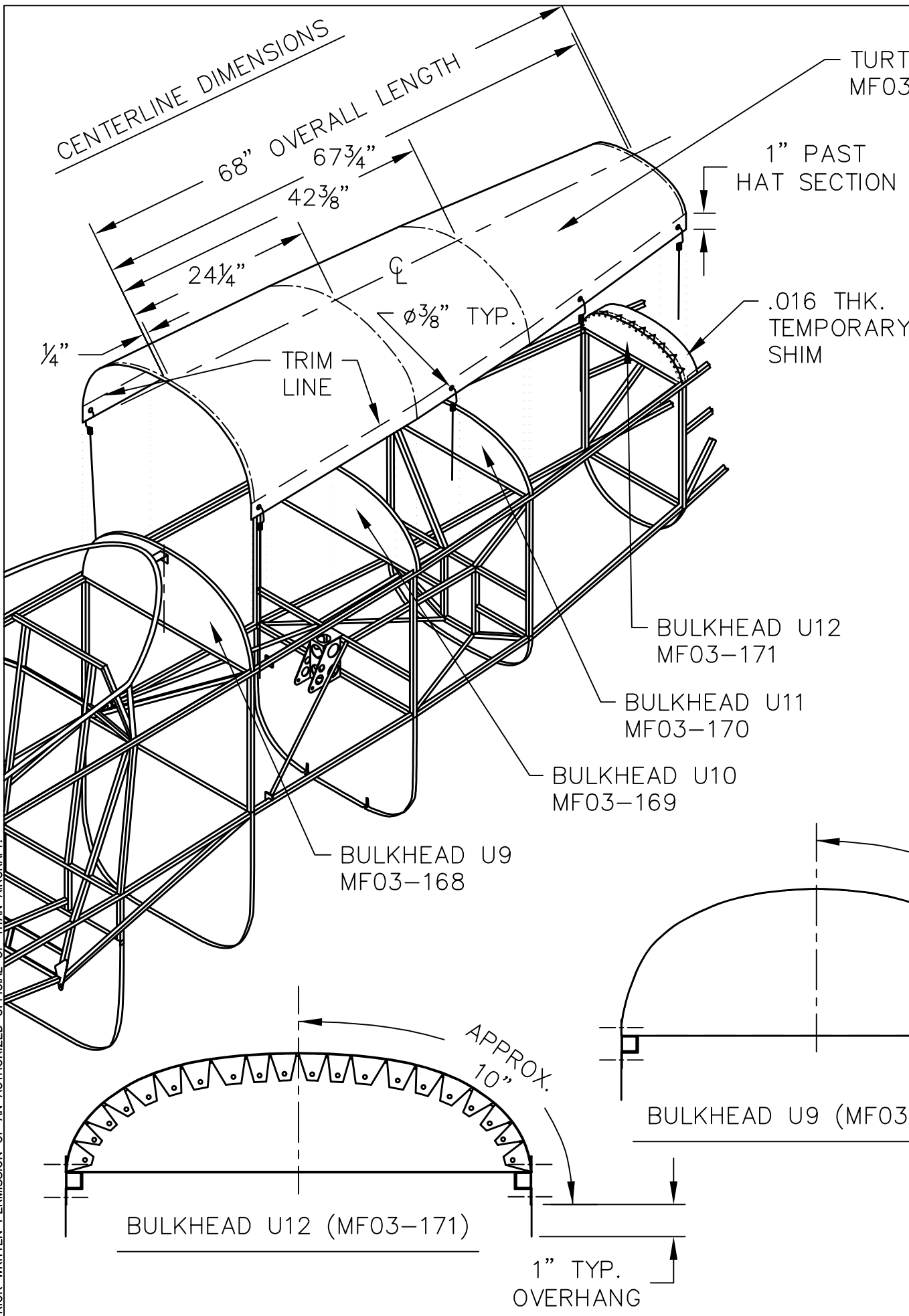
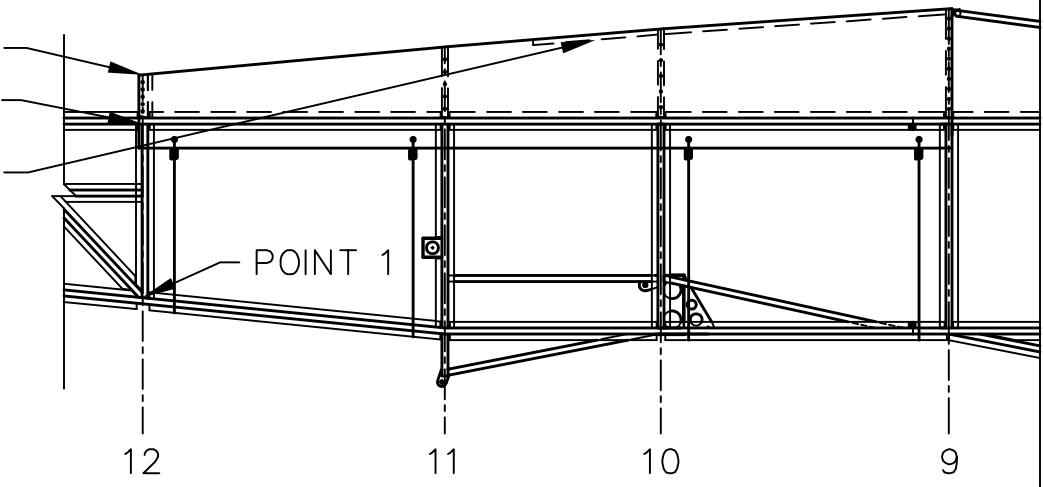
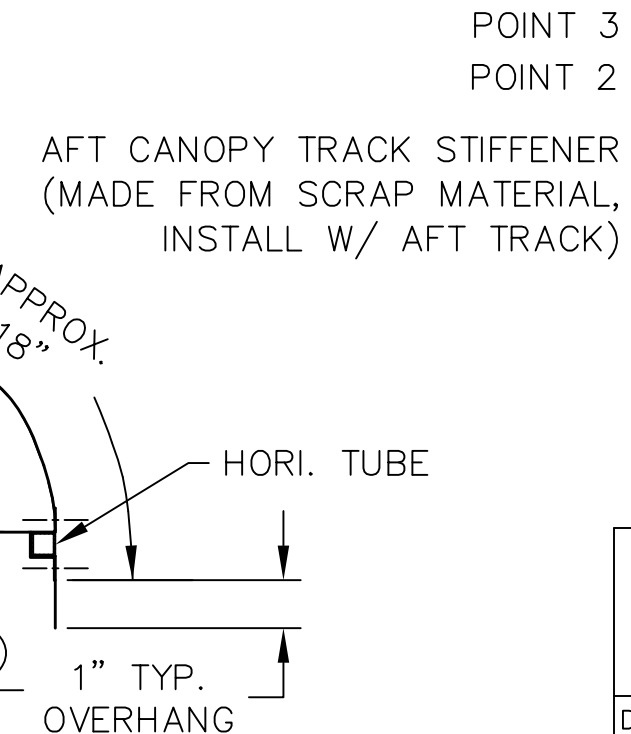


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**NOTES:**

- THE TOP FLANGE OF HAT SECTIONS ATTACHED TO THE HORIZONTAL TUBES BETWEEN STATIONS #9-#12 WILL NEED TO BE BENT INWARD TO MATCH THE CONTOUR OF TURTLE DECK/BULKHEADS.
- POSITION THE TURTLE DECK SKIN IN PLACE. (VIA. DUCT TAPE TO TEMPORARILY HOLD IN PLACE.) TRACE THE FWD EDGE OF U9 AND THE AFT EDGE OF U12 ON THE BOTTOM SIDE OF THE TURTLE DECK. (A .016 THK. SHIM IS NEEDED BETWEEN THE U12 FLANGE AND THE TURTLE DECK DURING POSITIONING, SHIM SHOULD BE APPROX. 2" WIDE & AS LONG AS THE BULKHEAD FLANGE.) THE SHIM SIMULATES VERTICAL FAIRINGS (MF03-200 & 204). BE SURE TO NOTCH FWD SIDE OF FLANGE.
- MARK THE TURTLE DECK SO THE BOTTOM EDGE HANGS OVER THE HAT SECTIONS BOTTOM FLANGE BY 1". (TURTLE DECK WILL BE TRIMMED TO THE BOTTOM FLANGE OF THE HAT SECTIONS AFTER SKIN IS DRILLED.)
- FOR BEST FIT IT IS RECOMMENDED TO USE BUNGEE CORDS TO PULL THE SKIN TIGHT WHILE DRILLING. THIS CAN BE DONE BY DRILLING 4-6  $\phi 3/8$ " HOLES IN THE 1" OVER HANG ON THE TURTLE DECK ON BOTH SIDES. THE BUNGEE CORDS SHOULD BE STRUNG FROM ONE SIDE OF THE FUSELAGE TO THE OTHER TO ENSURE TIGHTNESS.
- MARK OUT A 1" RIVET PATTERN STARTING FROM CENTERLINE ON EACH BULKHEAD. WHEN DRILLING BE SURE TO START FROM CENTERLINE AND WORK OUTWARD, DRILLING ONE SET OF HOLES PER SIDE OF THE TURTLE DECK AT A TIME. THIS WILL ENSURE THE SKIN IS TIGHT ALL THE WAY DOWN THE BULKHEADS. WHEN MARKING THE RIVET PATTERN IS IT BEST TO USE A 3-POINT METHOD FOR STRAIGHT RIVET LINES. (SEE BELOW)



REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	SH	11/08

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

DETAIL NAME: TURTLE DECK INSTALLATION

SCALE 1"=1"	PART NO.
ASSEMBLY NAME	
PART NO.	DRAWING NO. F14.1
DRAWING NO. <b>B T51-08-INS-1786-A</b>	

DRAWN S. HENDERSON	DATE 11/14/08
CHECKED RI	DATE 1/21/09
APPROVED KORY B.	DATE 1/26/09