

**NOTES:**

– SEE DRAWING T51-10-INS-1890 FOR FIBERGLASS BELLY INSTALLATION OR T51-04-INS-1011 FOR ALUMINUM BELLY STINGER INSTALLATION AND T51-03-INS-0944 FOR ALUMINUM BELLY SKIN LOCATION.

– CAREFULLY CUTOUT THE INLET AREA ON THE FIBERGLASS SCOOP (MF03-133) USING A CUTOFF WHEEL, CLEANUP WITH A BLOCK OR DRUM SANDER.

– ATTACH THE SCOOP TO THE BELLY WITH DUCT TAPE, MAKE SURE THE FRONT OF THE SCOOP IS LEVEL AND APPROXIMATELY 2<sup>3</sup>/<sub>4</sub>" FROM THE CENTER SECTION.

– FIND THE CENTER POINT ON THE BELLY AND SCOOP, STARTING HERE DRILL #30 RIVET HOLES EVERY 1" O.C. THROUGH THE SCOOP, BELLY, AND L8 FLANGE.

– REACHING THROUGH THE OPENING IN THE SCOOP, MARK THE CENTER POINT ON THE FUSELAGE FOR THE FIBERGLASS SCOOP FORMER (MF10-622).

– REMOVE SCOOP.

– DRILL #30 RIVET HOLES EVERY 1" O.C. IN THE TOP BEND OF THE FORMER.

– USE THE SCOOP AS A TEMPLATE TO BEND THE FORMER TO MATCH THE INSIDE UPPER CONTOUR AND THE FILLER (MF10-621) TO MATCH THE OUTSIDE CONTOUR.

– ALIGN THE FORMER ON THE CENTER SECTION WITH THE MARK YOU MADE EARLIER AND BEGIN TO MATCH DRILL THE RIVET HOLES, CLECO AS YOU GO. (NOTE: WATCH DEPTH OF DRILL SO YOU DO NOT HIT THE FUEL TANK.)

– CLECO THE SCOOP TO THE BELLY.

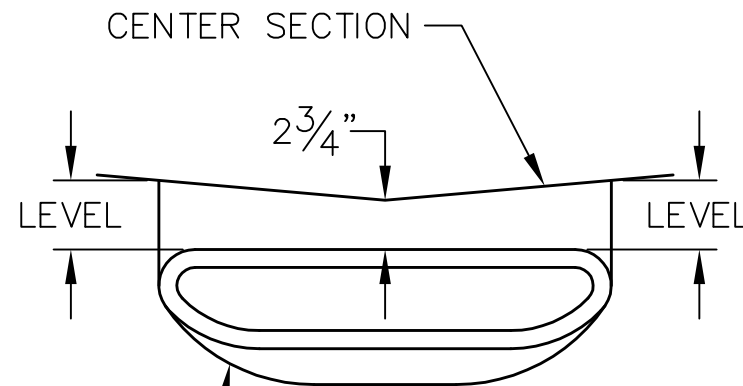
– MAKE SURE THE FRONT OF THE SCOOP IS STILL LEVEL AND APPROXIMATELY 2<sup>3</sup>/<sub>4</sub>" FROM THE CENTER SECTION.

– PLACE THE FILLER BETWEEN THE SCOOP AND THE CENTER SECTION, ATTACH WITH DUCT TAPE.

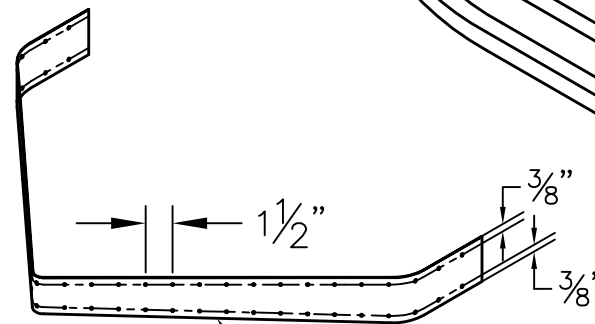
– MEASURE UP 3/8" ON THE SCOOP SIDE AND DOWN 3/8" ON THE CENTER SECTION FOR RIVET LINES.

– STARTING AT THE FILLER CENTER AND WORKING OUTWARDS, DRILL #30 RIVET HOLES THROUGH THE FILLER INTO THE FORMER AND SCOOP EVERY 1<sup>1</sup>/<sub>2</sub>" O.C., CLECO IN PLACE AS YOU GO.

– MAKE ANY FINAL ADJUSTMENTS TO THE SCOOP BEFORE YOU USE AD44ABSLF RIVETS TO SECURE IT IN PLACE.

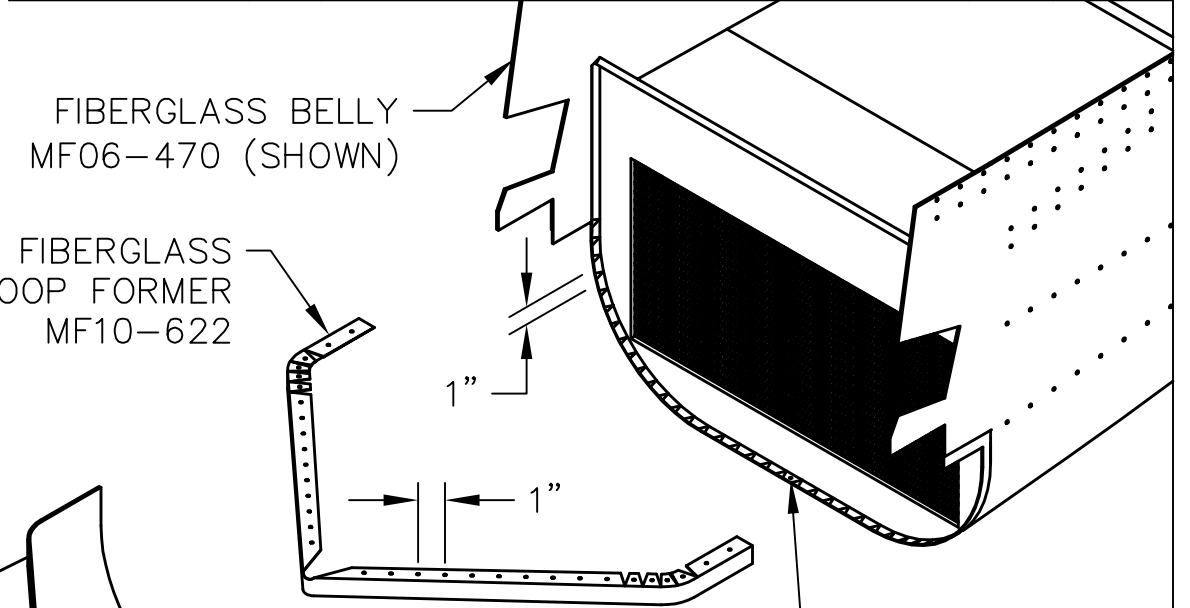


FIBERGLASS SCOOP MF03-133



FIBERGLASS SCOOP FILLER MF10-621

REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	BH	3/10



FIBERGLASS BELLY MF06-470 (SHOWN)

FIBERGLASS SCOOP FORMER MF10-622

CENTER POINTS

MARK FORMER CENTER POINT HERE ON CENTER SECTION

CUTOUT INLET AREA

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

DETAIL NAME		FIBERGLASS SCOOP INSTALLATION		
SCALE	PART NO.			
ASSEMBLY NAME				
PART NO.	DRAWING NO.		S18	
DRAWING NO.	B T51-10-INS-1884-A			

DRAWN	DATE	5/13/10
B. HARE		
CHECKED	DATE	7/27/10
R. INGLE		
APPROVED	DATE	7/30/10
K. BROOKS		

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