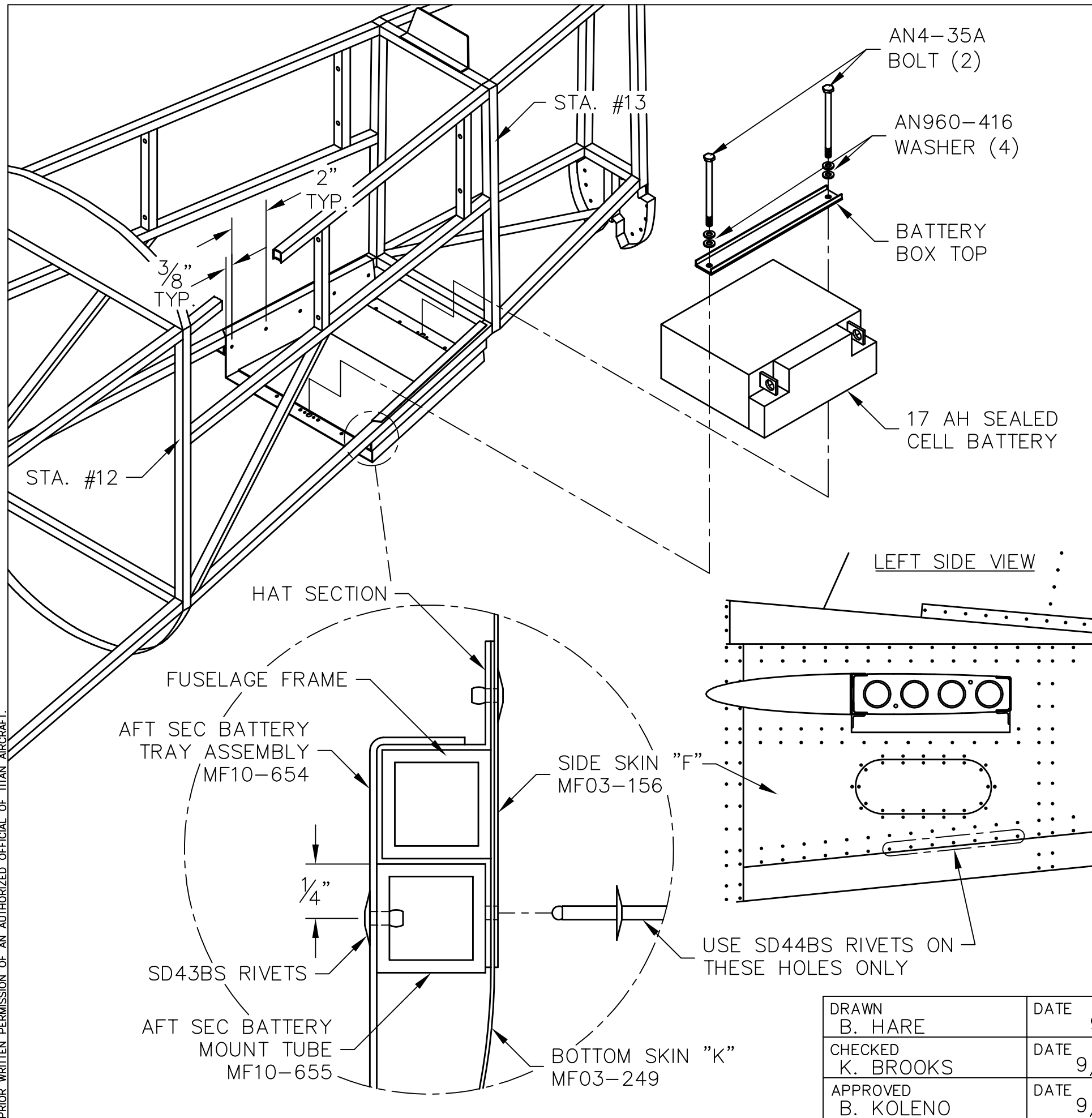


THIS DOCUMENT PROPRIETARY TO TITAN AIRCRAFT, AND IS NOT TO BE USED, CIRCULATED, REPRODUCED, COPIED, OR DISCLOSED IN ANY MANNER WITHOUT PRIOR WRITTEN PERMISSION OF AN AUTHORIZED OFFICIAL OF TITAN AIRCRAFT.



REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	BH	9/10

- NOTES:**
- TO EASE INSTALLATION OF THE AFT SECONDARY BATTERY MOUNT (MF10-642), IT IS RECOMMENDED TO REMOVE THE LEFT "F" SIDE SKIN (MF03-156).
  - SLIDE THE AFT SECONDARY BATTERY TRAY ASSEMBLY (MF10-654) AS FAR BACK AS IT WILL GO ON THE LOWER FUSELAGE FRAME RAILS BETWEEN STATIONS #12 AND #13 (REMOVAL OF THE AN4-35A BOLTS, AN960-416 WASHERS, AND BATTERY BOX TOP MAY BE NECESSARY).
  - MARK WHERE THE BOTTOM OF THE FRAME RAILS ARE ON BOTH SIDES OF THE TRAY ASSEMBLY AND REMOVE IT FROM THE FUSELAGE.
  - MEASURE DOWN 1/4" AND DRAW A LINE CONNECTING THE TWO POINTS ON BOTH SIDES.
  - USING THESE LINES, CENTER THE AFT SEC BATTERY MOUNT TUBES (MF10-655) AND CLAMP IN PLACE.
  - USING THE DIMENSIONS LISTED, DRILL (5) #30 RIVET HOLES IN EACH SIDE.
  - USE SD43BS RIVETS TO SECURE.
  - SLIDE THE COMPLETED ASSEMBLY BACK INTO THE FUSELAGE FRAME AND CLAMP IN PLACE.
  - INSTALL BATTERY, ALONG WITH BATTERY BOX TOP, WASHERS, AND BOLTS.
  - CLECO THE LEFT "F" SIDE SKIN BACK IN PLACE.
  - USING THE RIVET HOLE LOCATIONS ON THE "F" SIDE SKINS, MATCH DRILL (7) #30 HOLES INTO EACH AFT SEC BATTERY MOUNT TUBES.
  - USE SD44BS RIVET JUST ON THESE 14 HOLES AND SD42BS ON THE REST OF THE SKIN TO SECURE.


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

DRAWN B. HARE		DATE 9/8/10		DETAIL NAME AFT SEC BATTERY MOUNT INSTALLATION	
CHECKED K. BROOKS		DATE 9/22/10		SCALE N/A	PART NO.
APPROVED B. KOLENO		DATE 9/22/10		ASSEMBLY NAME	
				PART NO. MF10-642	DRAWING NO. 010
				DRAWING NO. <b>B T51-10-INS-1930-A</b>	