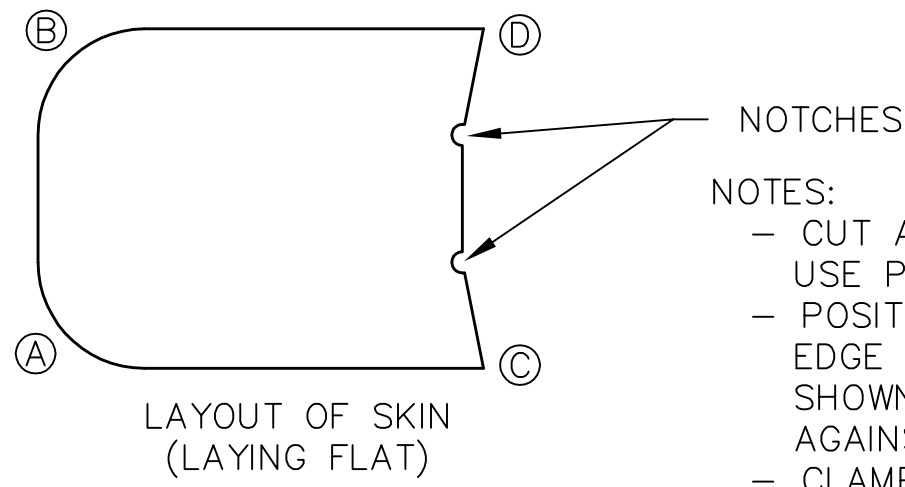
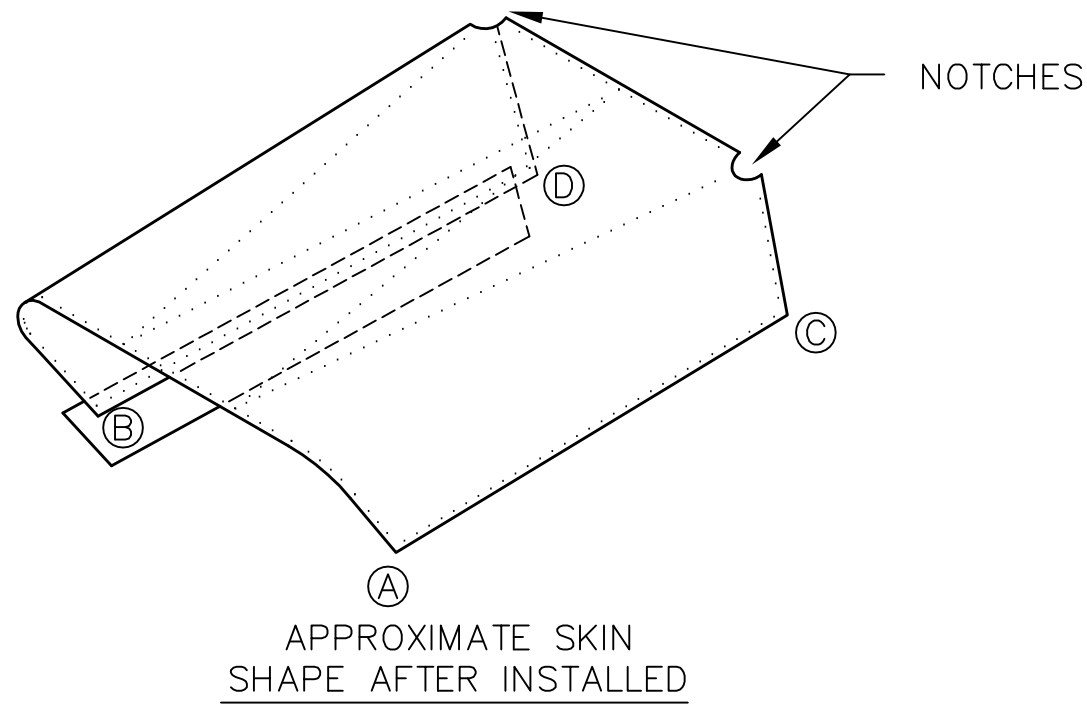
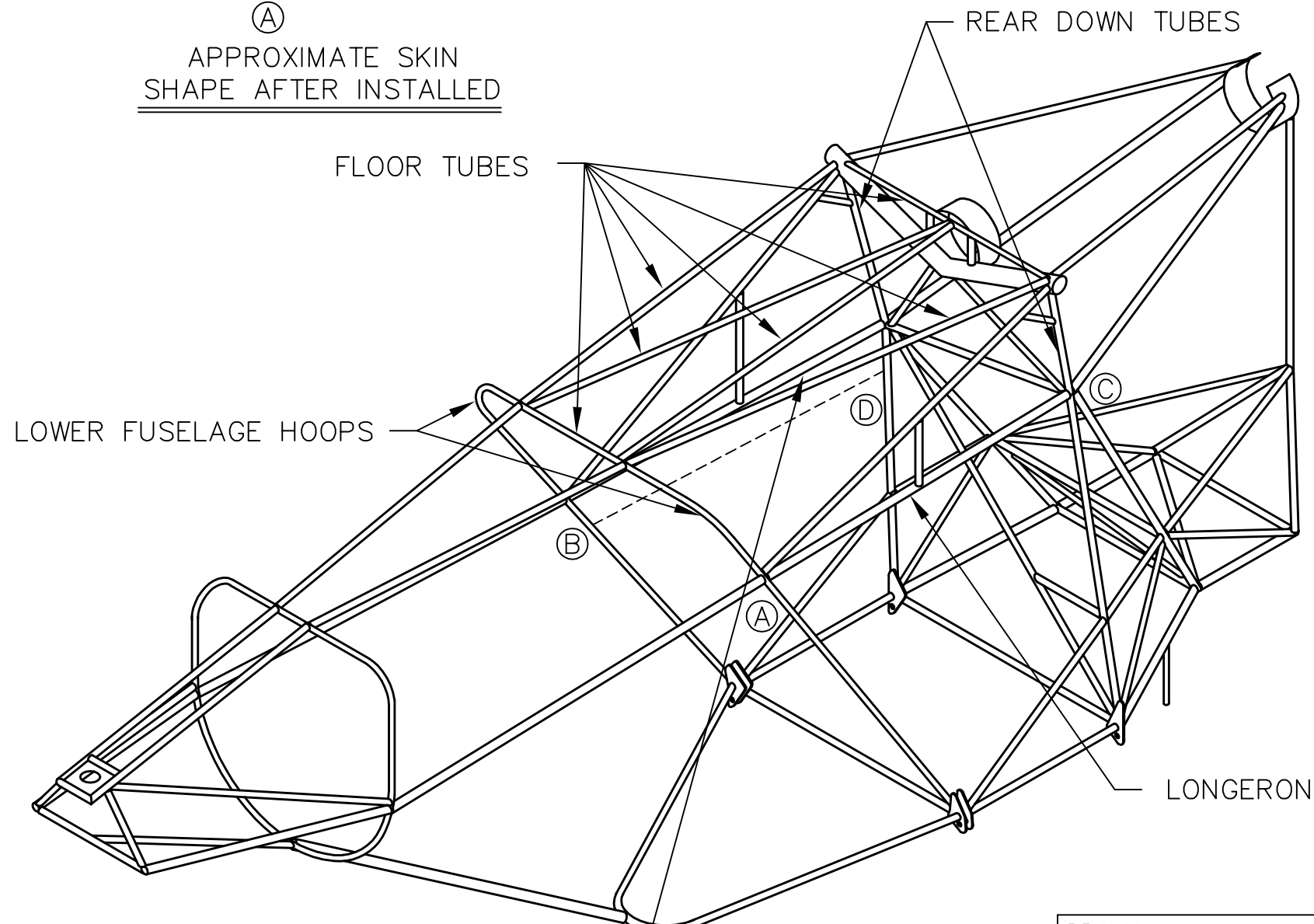


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NOTES:

- CUT AFT BELLY SKIN OUT OF SHEET METAL, USE PATTERN PROVIDED.
- POSITION SKIN ON FUSELAGE SO THAT THE SKIN EDGE IS 4.000" ABOVE FUSELAGE LONGERON TUBE SHOWN. PULL SKIN BACK UNTIL NOTCHES ARE FLUSH AGAINST THE GEAR LEG TUBES.
- CLAMP SKIN TO FUSELAGE. TO HELP HOLD SKIN FLAT, CLAMP A BOARD TO SKIN AND FUSELAGE NEAR TUBES THAT ARE TO BE DRILLED.
- CHECK SKIN TO BE SURE IT IS TIGHT AGAINST FUSELAGE.
- ALL RIVET HOLES *MUST* BE DRILLED THRU THE CENTERS OF FUSELAGE TUBES. DRILL ALL RIVET HOLES WITH #30 DRILL (.1285 DIA). CLECO SKIN TO FRAME AS IT IS BEING DRILLED.
- FIRST, DRILL RIVET HOLES THRU ALL "FLOOR TUBES". DRILL ON 1.500 INCH CENTERS. MAKE SURE SKIN IS HELD TIGHT AND SQUARE BEFORE DRILLING.
- DRILL LONGERON TUBES NEXT. DRILL ON 1.500 INCH CENTERS. BE SURE SKIN IS TIGHT AROUND CURVED TUBES BEFORE DRILLING. DRILL AND CLECO PROGRESSIVELY.
- DRILL "REAR DOWN TUBES" ON 1.500 INCH CENTERS. DO NOT DRILL PAST LONGERON TUBES AS THE LEXAN WINDOWS WILL BE FITTED UNDER ALUMINUM SKIN.
- DRILL "LOWER FUSELAGE HOOPS" ON 1.500 INCH CENTERS NEXT. DO NOT DRILL PAST LONGERON TUBES AS THE LEXAN WINDOWS WILL BE FITTED UNDER ALUMINUM SKIN.
- DO NOT DRILL RIVET HOLES ON ANY OTHER TUBES. RIVETING TO OTHER TUBES MAY CAUSE DENTS IN THE SKIN.



LONGERON
EDGE OF SKIN IS PLACED
4.000 INCHES ABOVE THIS
TUBE (ALONG DASHED LINE).

TITAN AIRCRAFT SUPPLY	
1419 STATE ROUTE 45 SOUTH AUSTINBURG, OHIO 44010	
DETAIL NAME AFT BELLY SKIN INSTALLATION	
SCALE N/A	PART NO.
ASSEMBLY NAME SS TORNADO	
PART NO.	DRAWING NO.
DRAWING NO. B 05-INS-1435-A	

DRAWN C. EMERY	DATE 10/4/05
CHECKED G. TRUEX	DATE 10/4/05
APPROVED J. WILLIAMS	DATE 10/5/05