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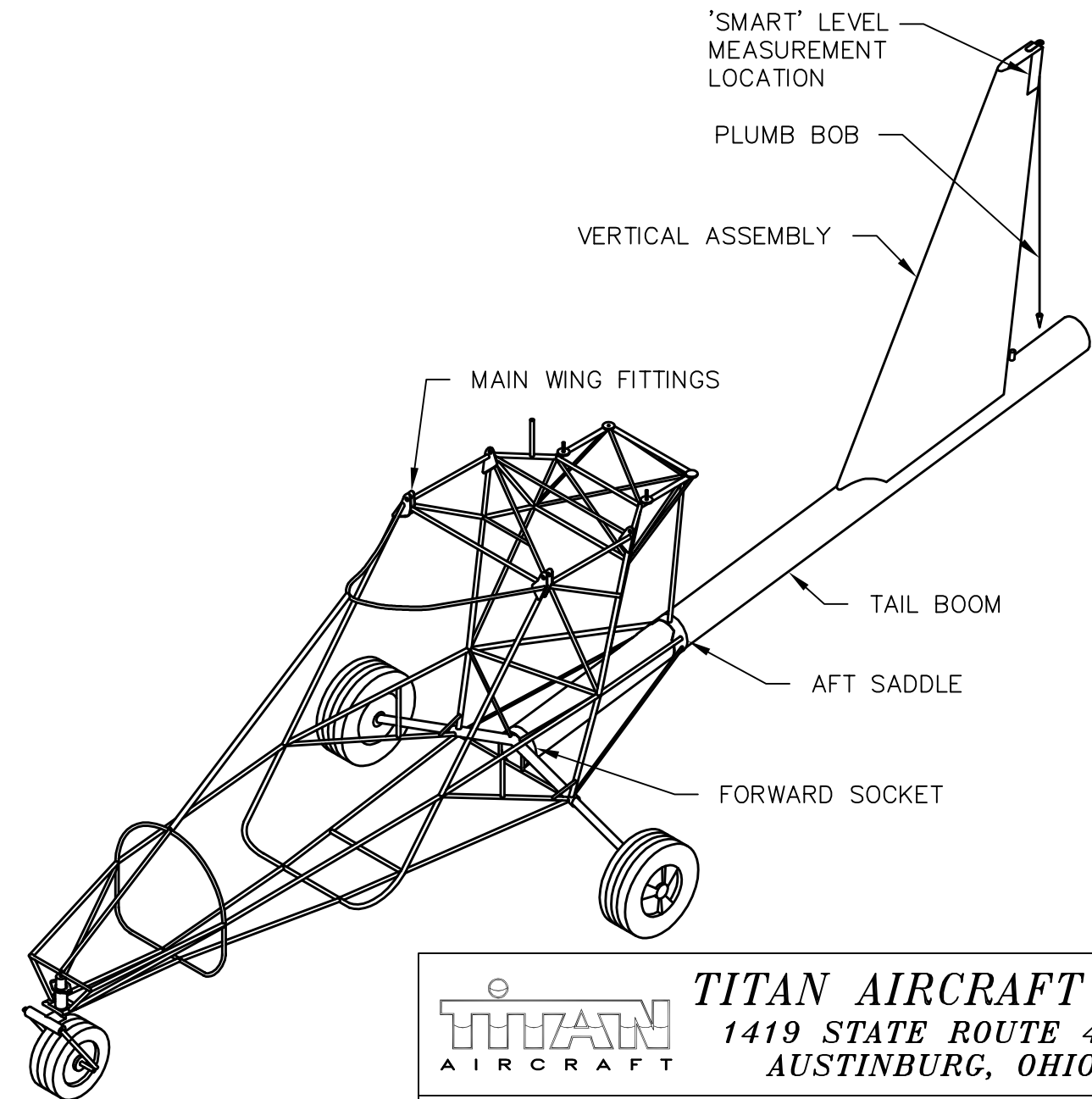
WARNING

DO NOT DRILL ANY UNSPECIFIED HOLES IN THE TAIL BOOM.

REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	J.P.	4/92
1042	B	DRILL WARNING ADDED	K.B.	11/96
1257	C	RIVETS WERE SD42BS	H.O.	9/99

ASSEMBLY PROCEDURES:

- LEVEL AIRPLANE BY PLACING A BOLT THROUGH BOTH MAIN WING FITTINGS. LAY A STRAIGHT EDGE ACROSS THE BOLTS, USE THIS AS A BASE FOR THE LEVEL. WE RECOMEND USING A 'SMART LEVEL' FOR THIS ASSEMBLY PROCESS. A 'SMART LEVEL' IS AN ELECTRONIC LEVEL CAPABLE OF ANGULAR READINGS. IF YOU ARE UNABLE TO FIND ONE, STANDARD LEVELING PROCEDURES CAN BE FOLLOWED.
- SLIDE TAIL BOOM INTO THE SOCKETS THAT ARE WELDED TO THE FRAME. YOU MAY USE A LUBRICANT IF NECESSARY.
- TEMPORARLY INSTALL THE VERTICAL ASSEMBLY TO THE TAIL BOOM USING THE FOUR PREDRILLED HOLES.
- LEVEL THE VERTICAL ASSEMBLY. THIS IS DONE BY HOLDING THE 'SMART' LEVEL TO A FLAT SURFACE ON THE SIDE OF THE VERTICAL ASSEMBLY AND TAKING A READING. NEXT TAKE A READING FROM THE SAME POSITION ON THE OPPOSITE SIDE. IF BOTH READINGS ARE NOT EQUAL SLIGHTLY ROTATE THE TAIL BOOM IN THE APPROPRIATE DIRECTION. REPEAT THIS STEP UNTIL THE LEVEL READS THE SAME ON BOTH SIDES OF THE VERTICAL ASSEMBLY. STANDERD PLUMB BOB LEVELING PROCEDURES CAN ALSO BE USED.
- AFTER DOUBLE CHECKING PLUMB OF THE VERTICAL AND MAKING SURE THE TAIL BOOM FULLY INSERTED.
- DRILL RIVET MOUNTING HOLES THROUGH TAIL BOOM WITH #30 DRILL (.1285 DIA) USING EXISTING HOLES ON THE SADLES AS A GUIDE.
- REMOVE THE VERTICAL ASSEMBLY AND TAIL BOOM.
- DEBURR THE TAIL BOOM MOUNTING HOLES AND SAND THE SURFACE IN WHICH THE SOCKETS RIDE.
- PERMANENTLY INSTALL THE TAIL BOOM USING EPOXY AND RIVETS. RIVET WITH SD45BS RIVETS ON THE AFT SADDLE AND SD44BS RIVETS ON THE FORWARD SOCKET.




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

DRAWN J. PRESTON		DATE 4/1/92	DETAIL NAME TAIL BOOM ASSEMBLY AND ALIGNMENT	
CHECKED R. INGLE		DATE 6/21/00	SCALE N/A	PART NO.
APPROVED J. WILLIAMS		DATE 10/19/00	ASSEMBLY NAME	
			PART NO.	DRAWING NO.
			DRAWING NO. <i>B92-INS-0182-C</i>	