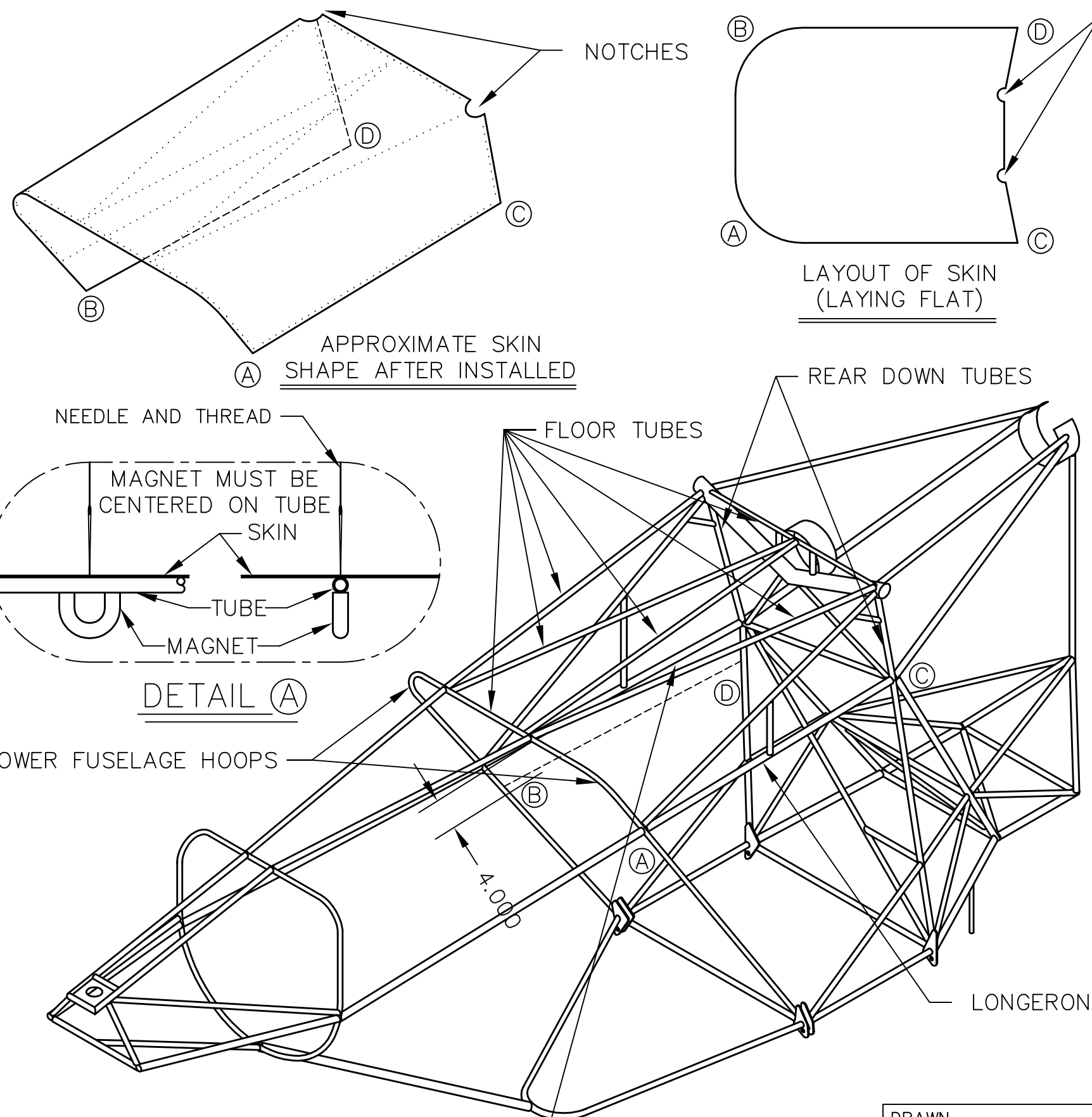


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LONGERON
EDGE OF SKIN IS PLACED
4.000 INCHES ABOVE THIS
TUBE (ALONG DASHED LINE).

NOTCHES

NOTES:

- CUT AFT BELLY SKIN OUT OF SHEET ALUMINUM, USE PATTERN PROVIDED. CUT OVERSIZE BY 1-2" AND TRIM TO FIT.
- POSITION SKIN ON FUSELAGE SO THAT THE SKIN EDGE IS 4.000" ABOVE THE FUSELAGE LONGERON TUBE SHOWN. PULL SKIN BACK UNTIL THE NOTCHES ARE FLUSH AGAINST THE GEAR LEG TUBES.
- CLAMP SKIN TO THE FUSELAGE. TO HELP HOLD SKIN FLAT, CLAMP A BOARD TO THE SKIN AND FUSELAGE NEAR TUBES THAT ARE TO BE DRILLED.
- CHECK SKIN TO BE SURE IT IS TIGHT AGAINST THE FUSELAGE.
- ALL RIVET HOLES *MUST* BE DRILLED THRU THE CENTERS OF THE FUSELAGE TUBES. DRILL ALL RIVET HOLES WITH #30 DRILL (.1285 DIA). CLECO SKIN TO FRAME AS IT IS BEING DRILLED.
- A MAGNET PLACED ON THE CENTER OF THE TUBE FROM THE INSIDE OF THE AIRCRAFT WITH A NEEDLE ON A STRING ATTACHED TO IT, WILL HELP LOCATE THE CENTER OF THE TUBES. SEE DETAIL A FOR DETAILS.
- 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 THE 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 THE ALUMINUM SKIN.
- DO NOT DRILL RIVET HOLES ON ANY OTHER TUBES. RIVETING TO OTHER TUBES MAY CAUSE DENTS IN THE SKIN.

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

DRAWN J. PRESTON		DATE 10/9/92		DETAIL NAME AFT BELLY SKIN INSTALLATION	
CHECKED B. PASSAFIUME		DATE 11/21/96		SCALE N/A	PART NO.
APPROVED J. WILLIAMS		DATE 11/26/96		ASSEMBLY NAME TWO PLACE TORNADO	
				PART NO.	DRAWING NO.
				DRAWING NO. B 92-INS-0254-B	