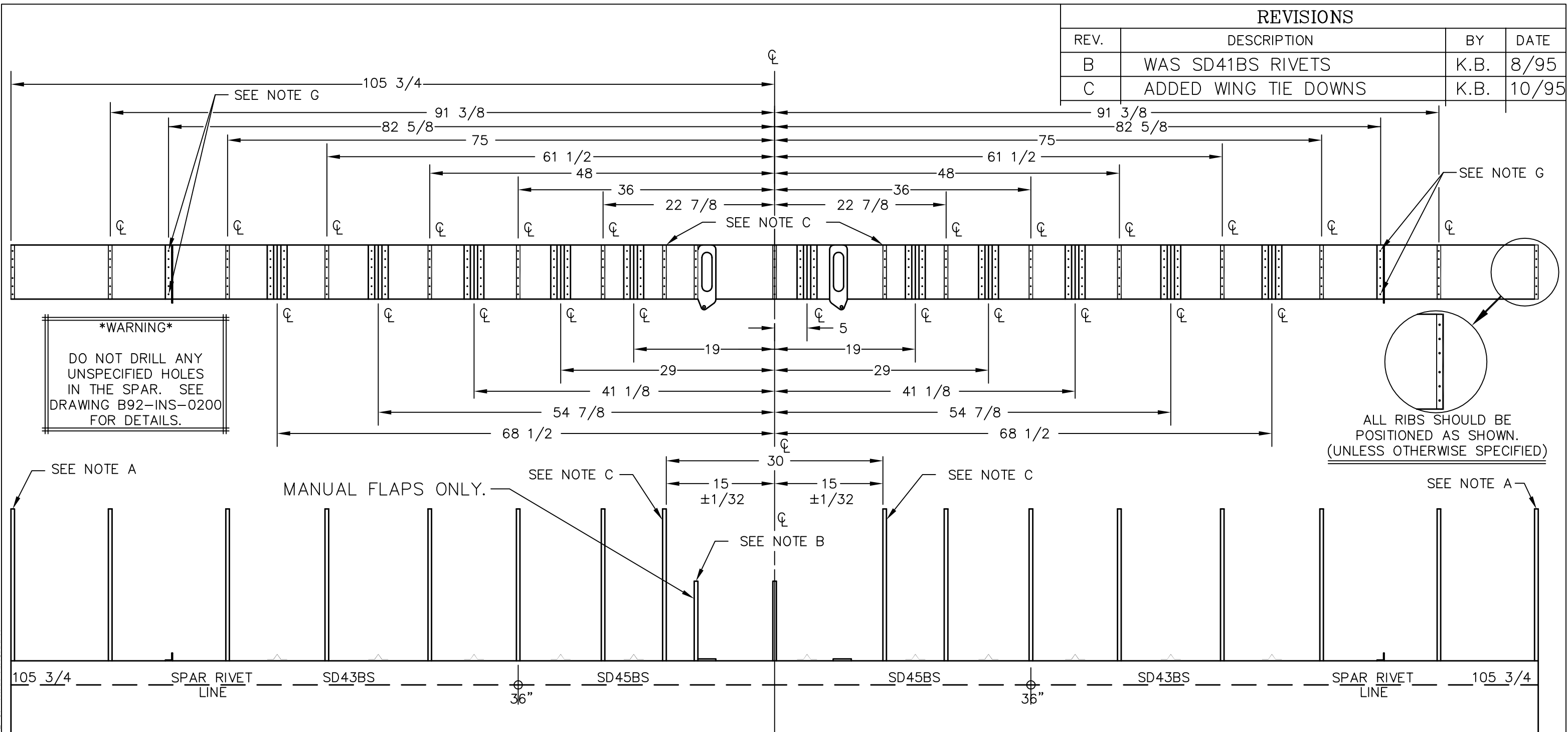


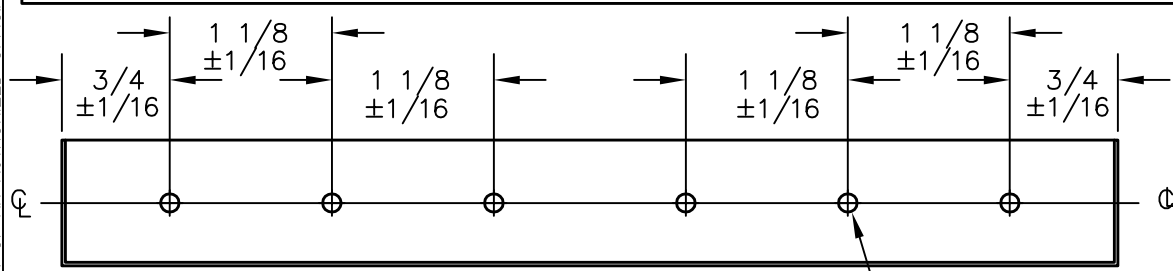
REVISIONS

REV.	DESCRIPTION	BY	DATE
B	WAS SD41BS RIVETS	K.B.	8/95
C	ADDED WING TIE DOWNS	K.B.	10/95



WARNING
DO NOT DRILL ANY UNSPECIFIED HOLES IN THE SPAR. SEE DRAWING B92-INS-0200 FOR DETAILS.

ALL RIBS SHOULD BE POSITIONED AS SHOWN. (UNLESS OTHERWISE SPECIFIED)



RIB AND HAT NOTES:
- RIVET TWO OUTER HOLES WITH SD45BS RIVETS. (1/8 DIA X 29/64 LONG)
- RIVET FOUR INNER HOLES WITH SD42BS RIVETS. (1/8 DIA X 17/64 LONG)

NOTES FOR TIE DOWNS:
- RIVET TWO OUTER HOLES WITH SD45BS RIVETS. (1/8 DIA X 29/64 LONG)
- RIVET FOUR INNER HOLES WITH SD42BS RIVETS. (1/8 DIA X 17/64 LONG)

#30 DRILL (.1285 DIA) THRU (6) PLACES
MOUNTING HOLE DETAILS FOR HAT SECTION, RIBS AND WING TIE DOWNS

ASSEMBLY NOTES:

A) OUTSIDE EDGE OF THESE RIBS ARE TO BE MOUNTED FLUSH WITH EDGE OF D-SECTION. RIVET THESE TWO RIBS ONLY WITH SD43BS RIVETS. (1/8 DIA X 17/64 LONG)

B) THIS RIB IS TO BE MOUNTED FLUSH WITH WING FITTING.

C) THESE RIBS ONLY HAVE ONE LIGHTENING HOLE. ALSO NOTE THEY ARE NOT DIMENSIONED FROM THEIR CENTER LINE BUT FROM THEIR INSIDE SURFACE. THEIR FLAT SURFACE MUST BE TOWARD THE CENTER OF THE WING (THERE IS A RIGHT AND LEFT SIDE).

D) ALL DIMENSIONS ARE INCHES.
E) TOLERANCE: ±1/8, UNLESS OTHERWISE SPECIFIED.
F) INSERT FLAP CONTROL SYSTEM BEFORE PERMANENTLY MOUNTING RIBS. DO NOT RIVET THE FLAP SYSTEM INTO PLACE UNTIL THE WING STRUCTURE IS COMPLETE AND THE WASHOUT IS SET.
G) SPAR RIVETS AT THESE LOCATIONS MUST BE DRILLED OUT. USE SAME HOLES FOR TIE DOWNS.

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

DRAWN J. PRESTON	DATE 1/5/93	DETAIL NAME HAT SECTION AND RIB LAYOUT
CHECKED R. INGLE	DATE 3/20/01	SCALE PART NO.
APPROVED J. WILLIAMS	DATE 3/20/01	ASSEMBLY NAME SINGLE PLACE 20' WING
		PART NO. DRAWING NO.
		DRAWING NO. B 93-INS-0335-E

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.