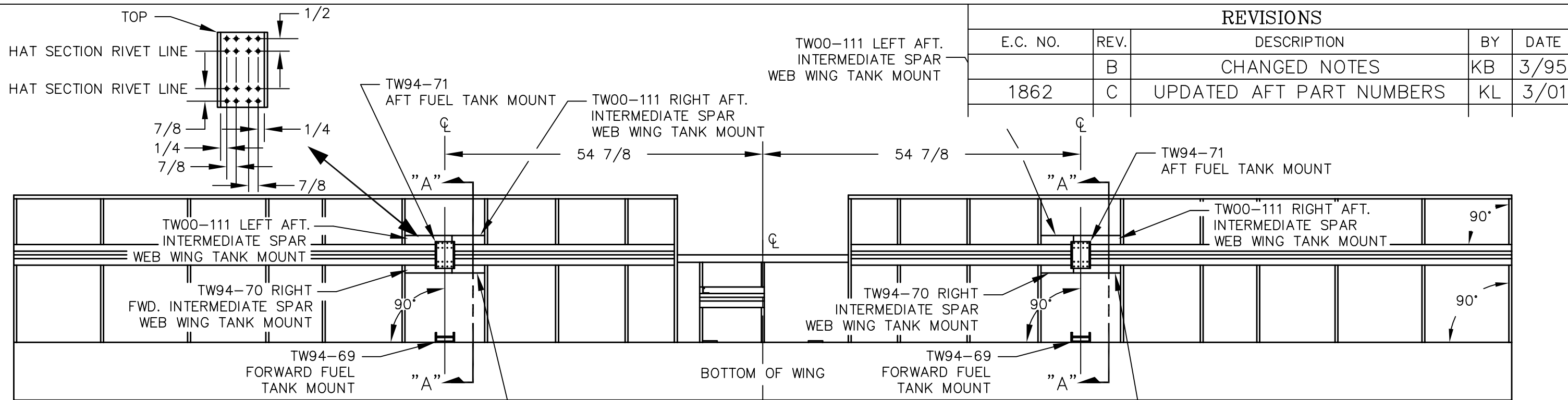
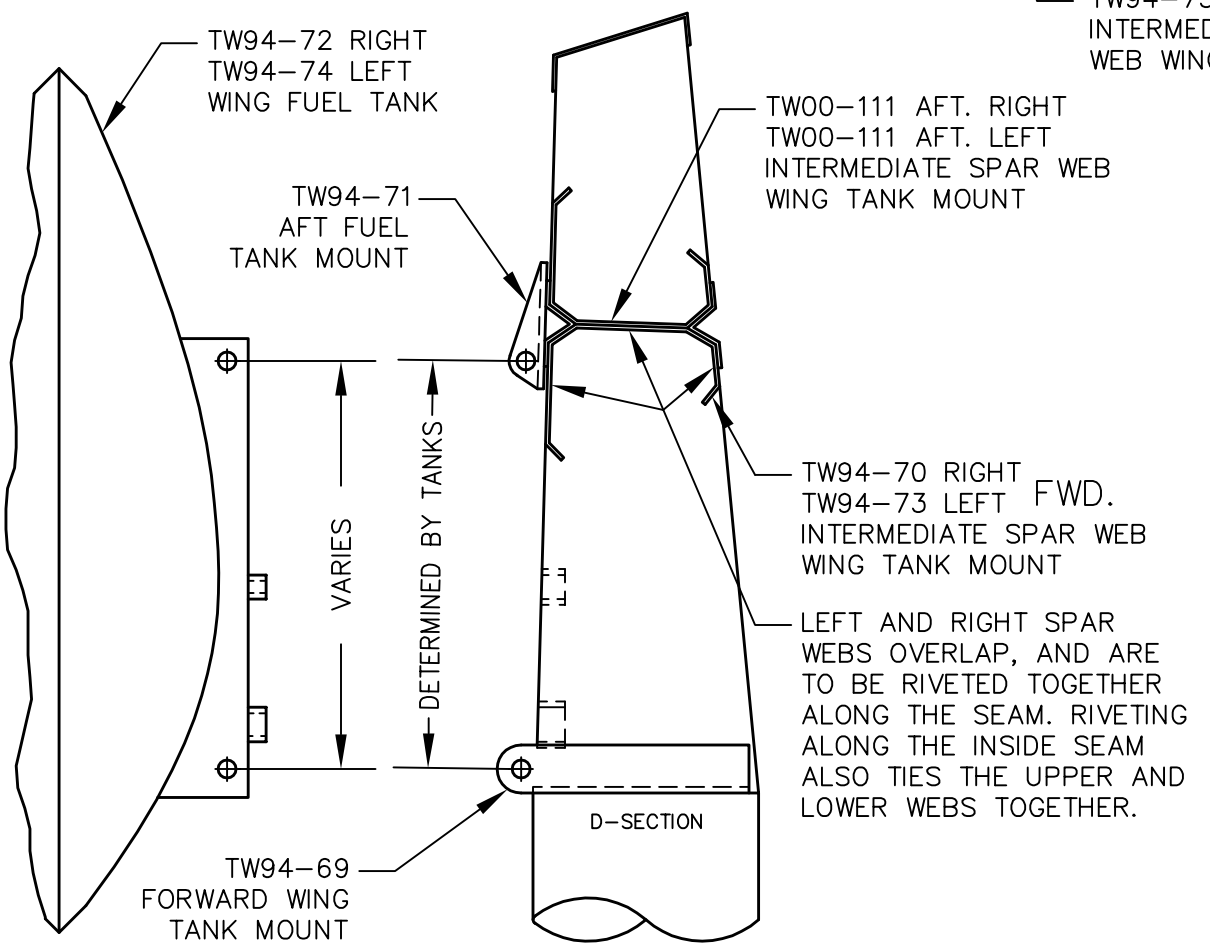


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REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	B	CHANGED NOTES	KB	3/95
1862	C	UPDATED AFT PART NUMBERS	KL	3/01



SECTION "A-A"

1. POSITION THE TW94-70 & TW74-73 INTERMEDIATE SPAR WEB WING TANK MOUNTS INSIDE OF THE TOP AND BOTTOM HAT SECTIONS, AS DETAILED ON DWG. NO.: B92-INS-0232. THE LARGE FLANGES ARE TO BE ON THE LOWER SURFACE OF THE WING. THERE IS TO BE (4) WEBS PER SIDE, (2) ABOVE THE HAT SECTION, AND (2) BELOW. THE LEFT AND RIGHT ALSO OVERLAP, CREATING A SEAM WHICH WILL BE RIVETED TOGETHER.
2. DRILL THE SPAR WEB RIVET HOLES THRU THE HAT SECTION AND RIBS, WITH A #30 (.1285 DIA) DRILL, FOLLOWING THE STANDARD SPAR WEB RIVET PATTERN AS DETAILED ON DWG. NO.: B92-INS-0232. ALSO DRILL RIVET HOLES THRU THE SEAM CREATED BY THE LEFT AND RIGHT, UPPER AND LOWER SPAR WEB OVERLAP. RIVET THE ENTIRE ASSEMBLY TOGETHER AND TO THE WING USING SD42BS (1/8 DIA X 17/64 LONG) RIVETS.
3. AFTER THE INTERMEDIATE SPAR WEB WING TANK MOUNTS ARE INSTALLED, THE TW94-71 AFT FUEL TANK MOUNTS MUST BE LOCATED IN THE PROPER POSITION. AS EACH FUEL TANK MOUNTING DIMENSIONS VARY SLIGHTLY, THE FACORY SUGGESTS MAKING A METAL HOLE-TO-HOLE FIXTURE FOR EACH TANK. SUCH A FIXTURE COULD BE TEMPORARILY INSTALLED TO THE TW94-69 FORWARD WING TANK MOUNTS ATTACHED TO THE SPAR, AND LAID BACK AGAINST THE WING TO HOLD THE TW94-71 AFT WING TANK MOUNTS INTO POSITION.

- YOU WILL WANT TO HAVE THE FIXTURE ON THE OUTSIDE OF THE TANK MOUNTING EARS, SO THE MOUNTING SURFACE OF THE AFT FUEL TANK MOUNT WILL BE EXPOSED FOR MARKING THE RIVET PATTERN.
4. USING A #30 (.1285 DIA) DRILL, DRILL THE AFT FUEL TANK MOUNT RIVET HOLES THRU THE HAT SECTION AND THE INTERMEDIATE SPAR WEBS. THE RIVET PATTERN MUST BE AS DETAILED AT THE TOP OF THIS DRAWING, LOCATING THE HAT SECTION RIVET LINE FIRST, THEN LOCATING THE OUTSIDE RIVET LINES OFF OF THAT.

**\*\*DO NOT PERMANENTLY INSTALL THE AFT WING TANK MOUNT AT THIS TIME\*\***

5. THE BOTTOM OF THE WING SHOULD BE SKINNED FIRST. AFTER THE BOTTOM WING SKINS HAVE BEEN PERMANENTLY INSTALLED, DRILL THE AFT WING TANK MOUNT RIVET PATTERN INTO THE SKINS, WORKING FROM THE TOP SIDE OF THE WING, USING THE PATTERN DRILLED THRU THE INTERMEDIATE SPAR WEBS AND HAT SECTIONS (USING A #30 DRILL). WHEN COMPLETE, PERMANENTLY INSTALL THE AFT WING TANK MOUNTS WITH URLANE AND SD45BS (1/8 DIA. X 25/64 LONG) RIVETS.

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

DRAWN	J. SUTCH	DATE	1/31/94
CHECKED	R. INGLE	DATE	3/2/01
APPROVED	J. WILLIAMS	DATE	3/2/01

DETAIL NAME	AFT TANK MOUNT INSTALLATION		
SCALE	PART NO.		
ASSEMBLY NAME	TORNADO WING FUEL TANK OPTION		
PART NO.	DRAWING NO.		
DRAWING NO.	B 94-INS-0423-C		