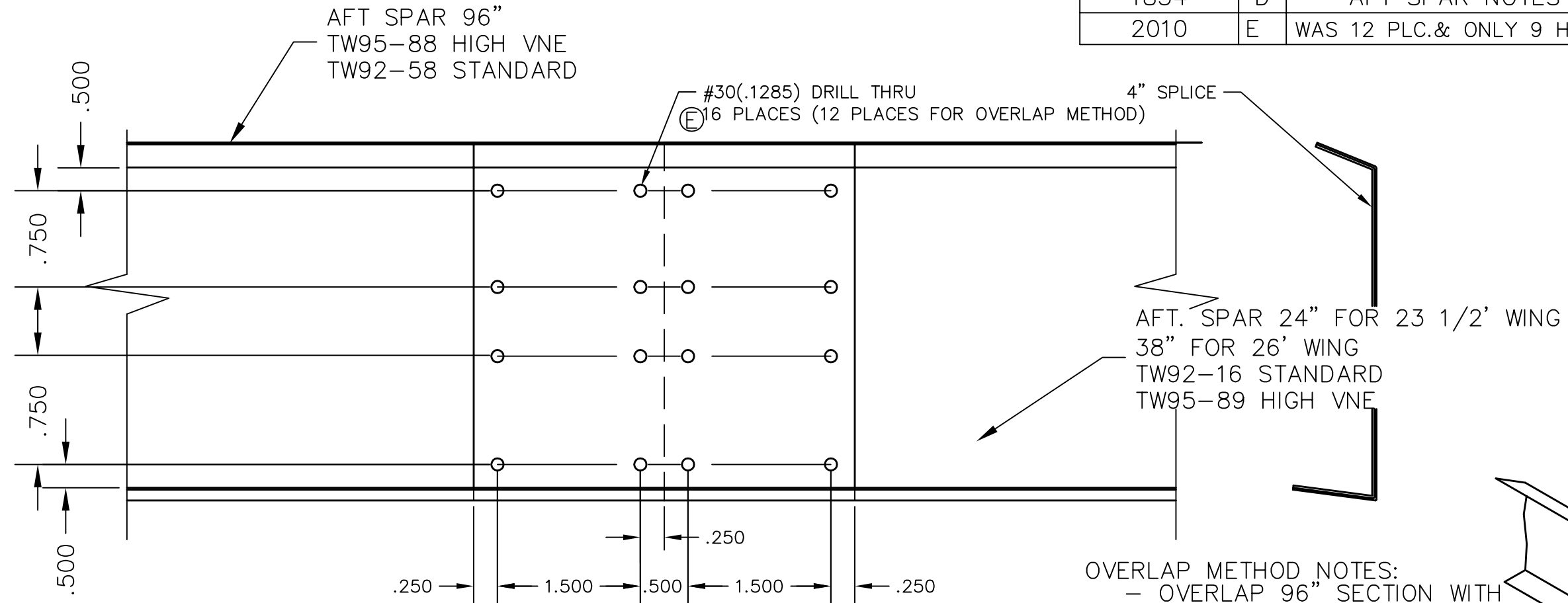
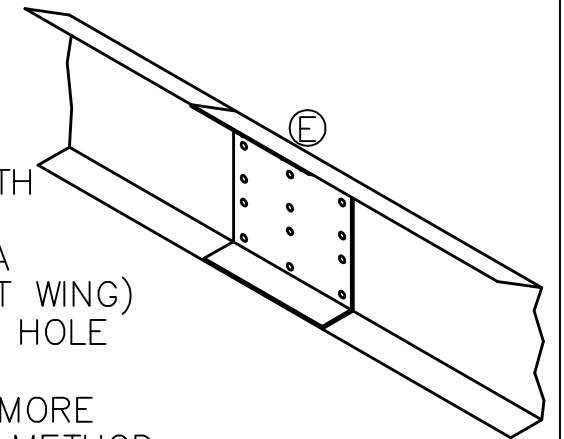


REVISIONS

| E.C. NO. | REV. | DESCRIPTION | BY | DATE |
|----------|------|---------------------------------|------|-------|
| 1039 | B | ALTERNATE METHOD SHOWN | K.B. | 10/96 |
| 1136 | C | ADAPTED TO FIT 26 FOOT WING | K.B. | 7/97 |
| 1854 | D | AFT SPAR NOTES ADDED | KL | 3/01 |
| 2010 | E | WAS 12 PLC.& ONLY 9 HOLES SHOWN | KL | 9/01 |



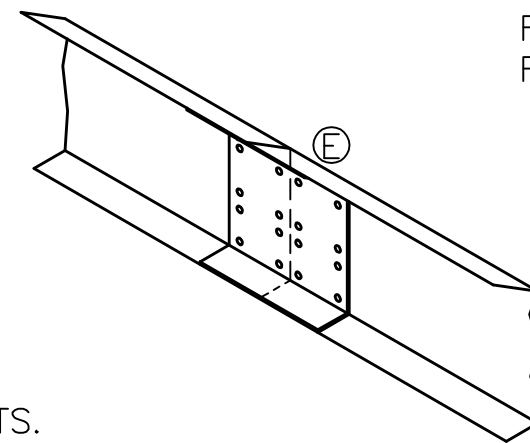
OVERLAP METHOD NOTES:
 - OVERLAP 96" SECTION WITH 24" SECTION BY 4" - 6" (CUT A 36" PIECE FROM A 48" SECTION FOR 26 FOOT WING)
 - BOND AND RIVET WITH 12 HOLE PATTERN AS SHOWN.
 - BUTT-SPLICE METHOD IS MORE COSMETIC WHILE OVERLAP METHOD IS DESIGNED FOR SIMPLICITY. EITHER METHOD IS EQUALLY FUNCTIONAL.
 (E)



CHECK TO INSURE BEFORE DRILLING
 (E) THAT BUTT SPLICE DOES NOT
 OVERLAP ON A RIB.

AFT SPAR LENGTHS:
 MAINTAIN 114" FOR 23 1/2
 FOOT WING AND 127 1/2"
 FOR 26 FOOT WING.

BUTT-SPLICE METHOD NOTES:
 - CUT TWO 4" AND TWO 18" PIECES FROM TWO 24" REAR SPAR SECTION. (FOR 26 FOOT WING CUT TWO 31 1/2" PIECES FROM 48" SECTIONS PROVIDED) PLACE 96" SECTION FLUSH AGAINST 18" SECTION. PLACE 4" PIECE CENTERED UNDER THE SEAM. (E)
 - USE #30(.1285 DIA.) DRILL. LAYOUT HOLES ACCORDING TO INSTRUCTIONS. BOND WITH CIBA GIEGY 5776 ADHESIVE. SECURE WITH SD42BS RIVETS.
 (E)



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

| | | | |
|---------------|-----|--------------------------------|--|
| DETAIL NAME | | AFT SPAR ASSEMBLY INSTRUCTIONS | |
| SCALE | N/A | PART NO. | |
| ASSEMBLY NAME | | 23 1/2 AND 26 FOOT WING | |
| PART NO. | | DRAWING NO. | |
| DRAWING NO. | | B 96-INS-0635-E | |

| | | | |
|----------|-----------|------|----------|
| DRAWN | K. BOHRER | DATE | 2/1/96 |
| CHECKED | G. TRUJEX | DATE | 9/27/01 |
| APPROVED | R. INGLE | DATE | 11/30/01 |

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.