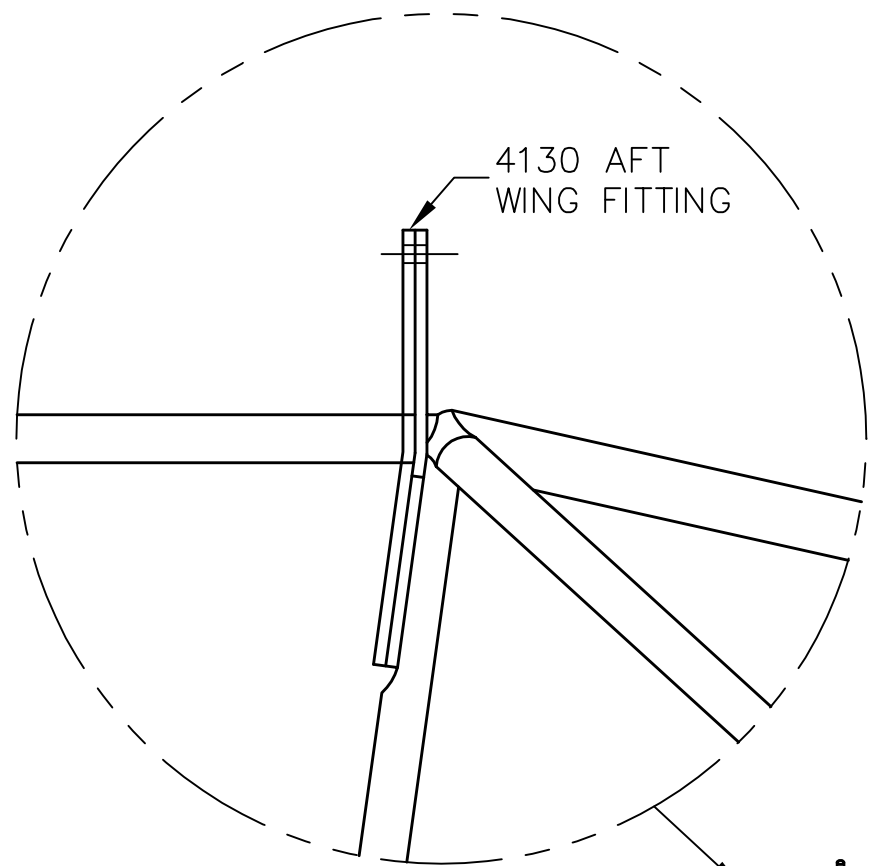
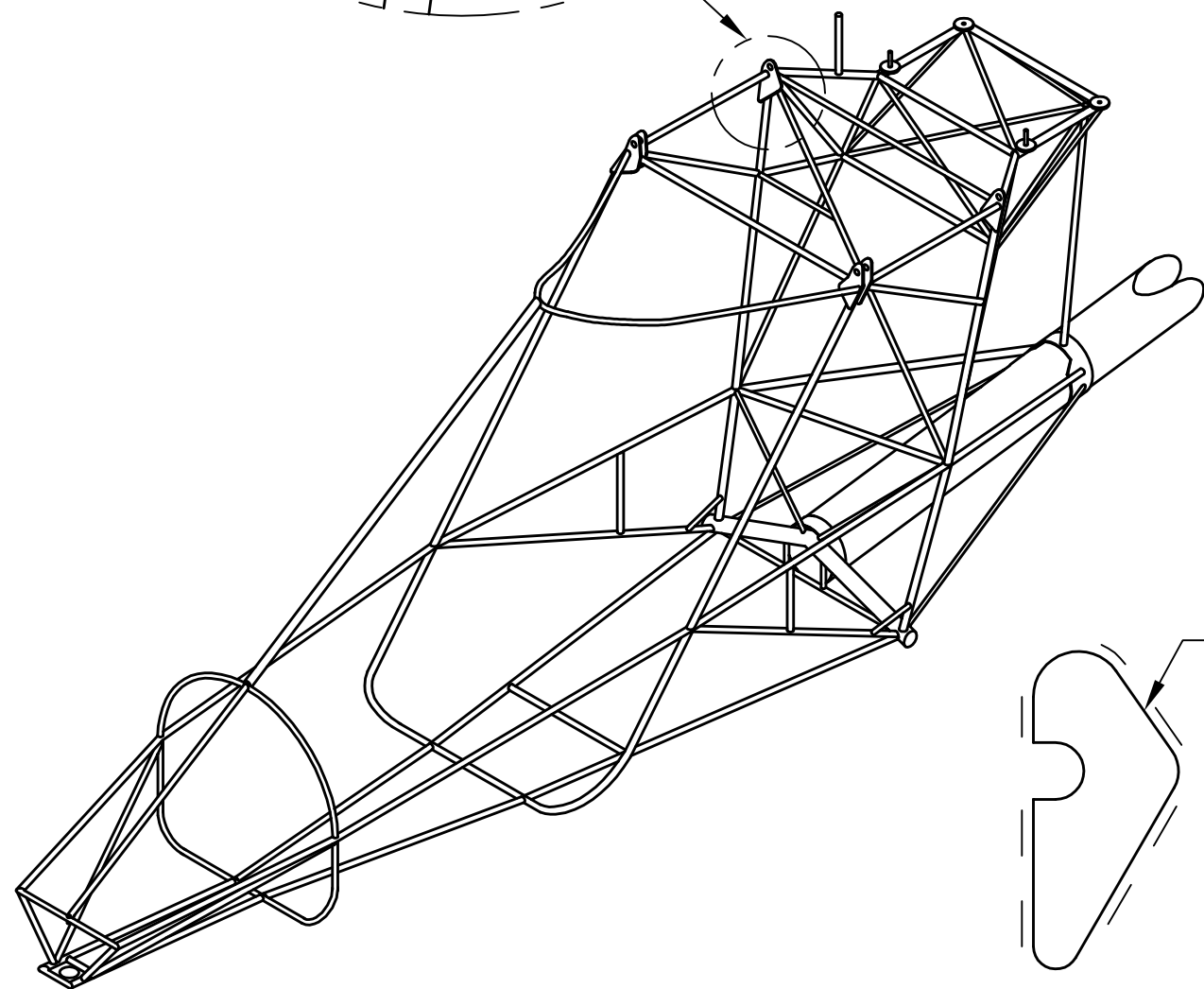


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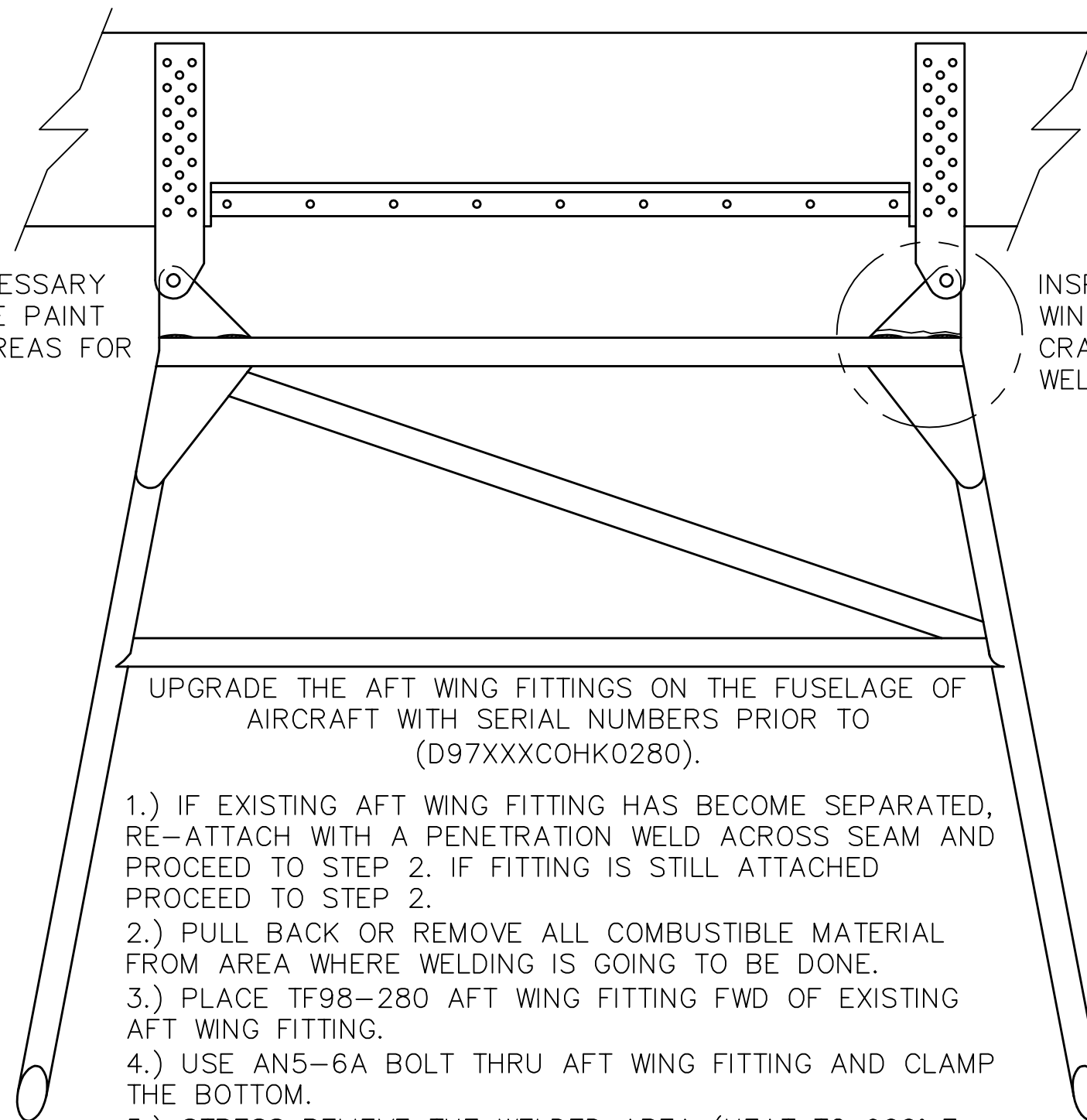
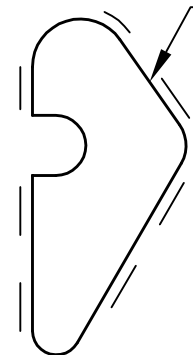


4130 AFT WING FITTING

IT MAY BE NECESSARY TO REMOVE THE PAINT FROM THESE AREAS FOR INSPECTION.



TF98-280



INSPECT BASE OF WING FITTINGS FOR CRACKS NEAR THE WELD TO FUSELAGE

UPGRADE THE AFT WING FITTINGS ON THE FUSELAGE OF AIRCRAFT WITH SERIAL NUMBERS PRIOR TO (D97XXXCOHK0280).

- 1.) IF EXISTING AFT WING FITTING HAS BECOME SEPARATED, RE-ATTACH WITH A PENETRATION WELD ACROSS SEAM AND PROCEED TO STEP 2. IF FITTING IS STILL ATTACHED PROCEED TO STEP 2.
- 2.) PULL BACK OR REMOVE ALL COMBUSTIBLE MATERIAL FROM AREA WHERE WELDING IS GOING TO BE DONE.
- 3.) PLACE TF98-280 AFT WING FITTING FWD OF EXISTING AFT WING FITTING.
- 4.) USE AN5-6A BOLT THRU AFT WING FITTING AND CLAMP THE BOTTOM.
- 5.) STRESS RELIEVE THE WELDED AREA (HEAT TO 900° F AND ALLOW TO COOL IN STILL AIR AT 60° F TO 80° F.)



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

DRAWN	K. BOHRER	DATE	10/24/96
CHECKED		DATE	
APPROVED		DATE	

DETAIL NAME		REAR WING MOUNT INSPECTION NOTICE	
SCALE	N/A	PART NO.	
ASSEMBLY NAME			
PART NO.		DRAWING NO.	
DRAWING NO.		B 96-INS-0764-C	