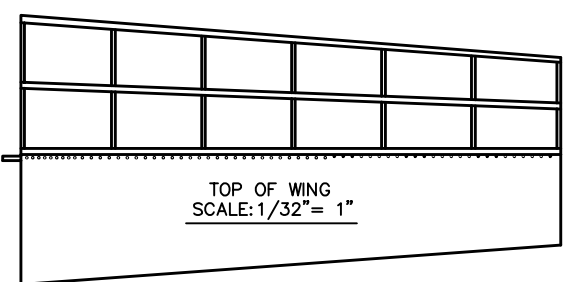
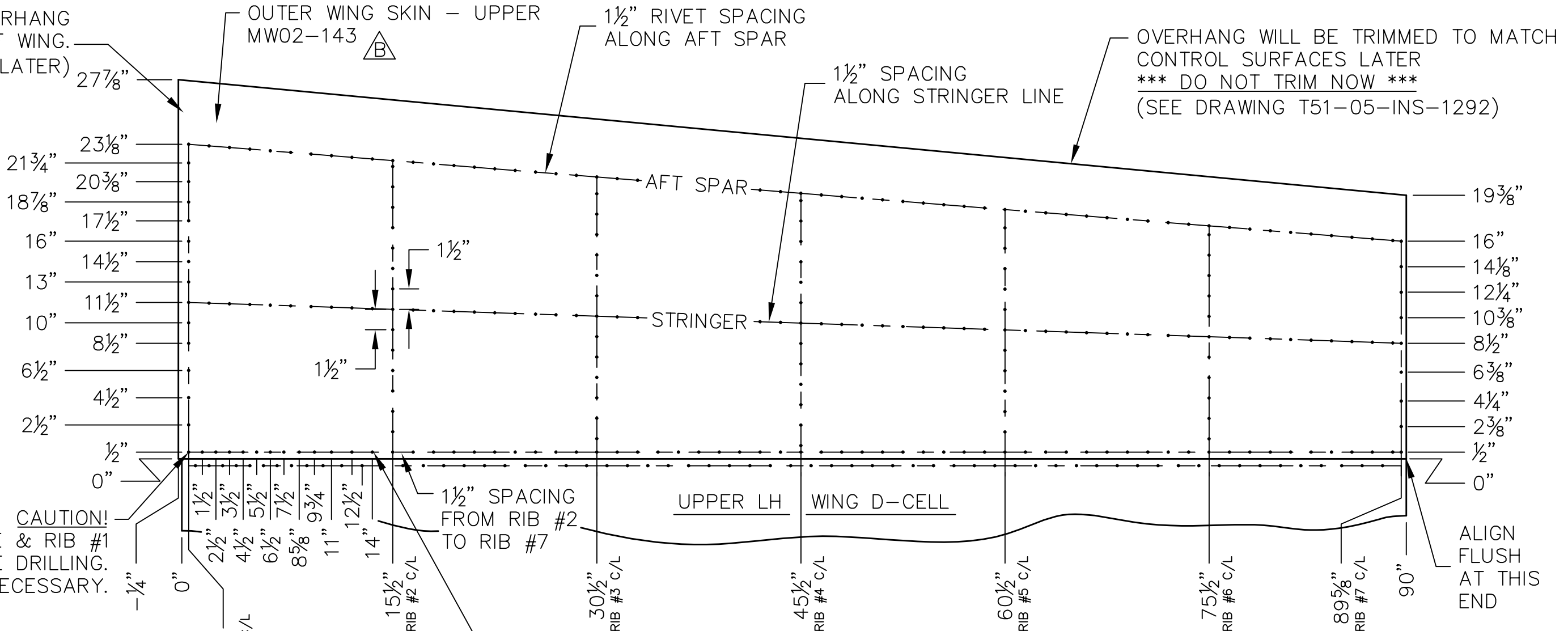


NOTES:

- USE A SHARPIE OR SIMILAR MARKER AND LAYOUT GRID AS SHOWN BELOW.
- DRILL LOCATIONS WILL BECOME THE INTERSECTION OF THE GRID LINES.
- POSITION THE SKIN FLUSH WITH THE D-CELL LEADING EDGE SKIN AND THE TIP OF THE WING.
- BEFORE DRILLING ANY HOLES IN RIBS, AFT SPAR OR STRINGER, ENSURE DRILL HOLE LAYOUTS ARE IN THE CENTER OF THE FLANGES. (ADJUST IF NECESSARY)
- MATCH DRILL SKIN TO RIBS, STRINGER, AND AFT SPAR. CLECO AS YOU GO.
- REFER TO DRAWING T51-02-INS-0558 FOR RIVET CALLOUT.
- DRILL STARTING FROM THE MAIN SPAR AND WORK YOUR WAY BACK TO THE AFT SPAR, TO ENSURE NO BUCKLES IN THE SKIN.
- VERTICAL SPACING OF 1 1/2" OFF OF STRINGER C/L RIB #2 TO RIB #6

REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	KL	11/02
0389	B	PART # ADDED	SH	12/06
0869	C	DIMENSIONS CHANGED	SH	2/09

SKIN SHOULD OVERHANG THE ROOT END OF WING. (TO BE TRIMMED LATER)



WHEN DRILLING RIVET HOLES IN LEADING EDGE OF WING SKIN (MW02-143), BE SURE TO HAVE HOLE LAYOUT EQUALLY OFFSET FROM THE EXISTING MAIN SPAR LEADING EDGE SKINS HOLE LAYOUT.

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

DETAIL NAME		UPPER WING SKIN INSTALLATION	
SCALE	1/8" = 1"	PART NO.	
ASSEMBLY NAME			
PART NO.		DRAWING NO. W8	
DRAWING NO.		B T51-02-INS-0546-C	

DRAWN	K. LIPLIN	DATE	11/6/02
CHECKED	R. INGLE	DATE	10/16/09
APPROVED	K. BROOKS	DATE	10/19/09

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