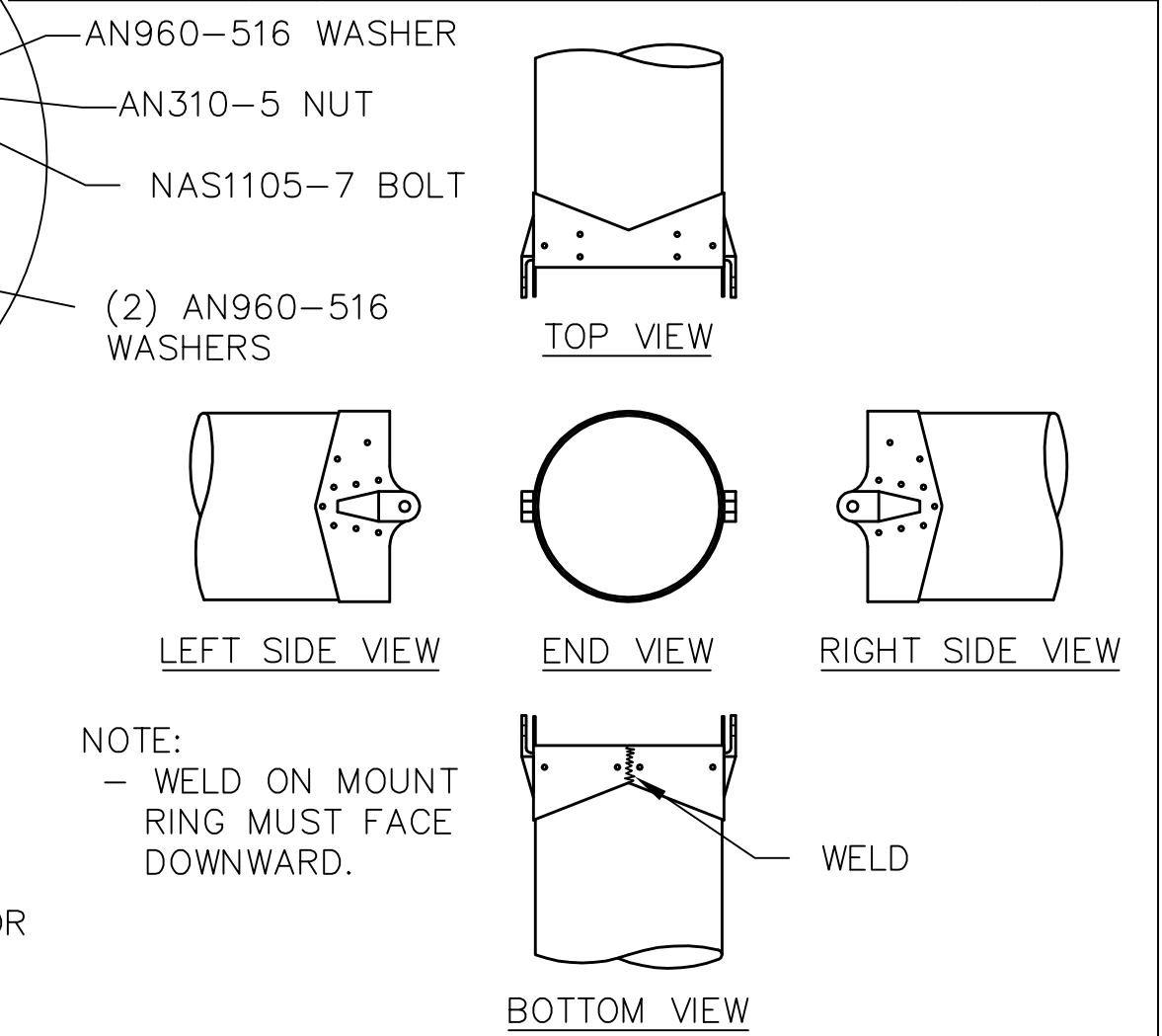


REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	C	COMPRESSTION SLEEVES ADDED	K.B.	7/96
1826	D	ADDED TOP GUSSET NOTE	KL	3/01
2089	E	ADDED TC00-321 TO ASSEMBLY	KL	10/02



ASSEMBLY PROCEDURES:

- USE TAIL BOOM STAND OR WEIGHT NOSE TO RAISE TAIL BOOM OFF THE GROUND.
- SLIDE STABILATOR MOUNT RING OVER END OF TAIL BOOM ORIENTATED AS SHOWN. EDGES OF STABILATOR MOUNT RING AND TAIL BOOM SHOULD BE FLUSH.
- TEMPORARILY MOUNT STABILATOR TO STABILATOR MOUNT RING.
- LEVEL THE AIRPLANE BY PLACING A BOLT THROUGH BOTH MAIN WING FITTINGS AND LAYING A STRAIGHT EDGE ACROSS THE BOLTS. USE THIS AS A BASE FOR THE LEVEL.
- LEVEL STABILATOR.
- MEASURE FROM THE ENDS OF THE STABILATOR LEADING EDGE TO THE AFT FUSELAGE DOWN TUBE. ADJUST STABILATOR UNTIL BOTH MEASUREMENTS ARE EQUAL.
- RECHECK LEVEL AND ALIGNMENT.
- DRILL MOUNTING HOLES FOR THE STABILATOR MOUNT RING THROUGH THE TAIL BOOM AND THEN CLECO. USE EXISTING HOLES IN THE MOUNTING RING AS A GUIDE. USE #30 DRILL (.1285 DIA). STABILATOR MAY BE REMOVED FOR EASY ACCESS TO SIDE MOUNTING HOLES.
- REMOVE STABILATOR MOUNT RING, DEBURR MOUNTING HOLES, AND SAND MATING SURFACES FOR BONDING.
- PERMANENTLY INSTALL STABILATOR MOUNT RING USING EPOXY. RIVET WITH SD42BS RIVETS.

STABILATOR MOUNT RING DETAIL

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TITAN AIRCRAFT SUPPLY
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 AUSTINBURG, OHIO 44010

DRAWN J. PRESTON		DATE 5/13/93		DETAIL NAME STABILATOR MOUNTING INSTRUCTIONS	
CHECKED		DATE		SCALE N/A PART NO.	
APPROVED		DATE		ASSEMBLY NAME ALL TORNADO AIRCRAFT	
				PART NO. DRAWING NO.	
				DRAWING NO. B 92-INS-0185-E	