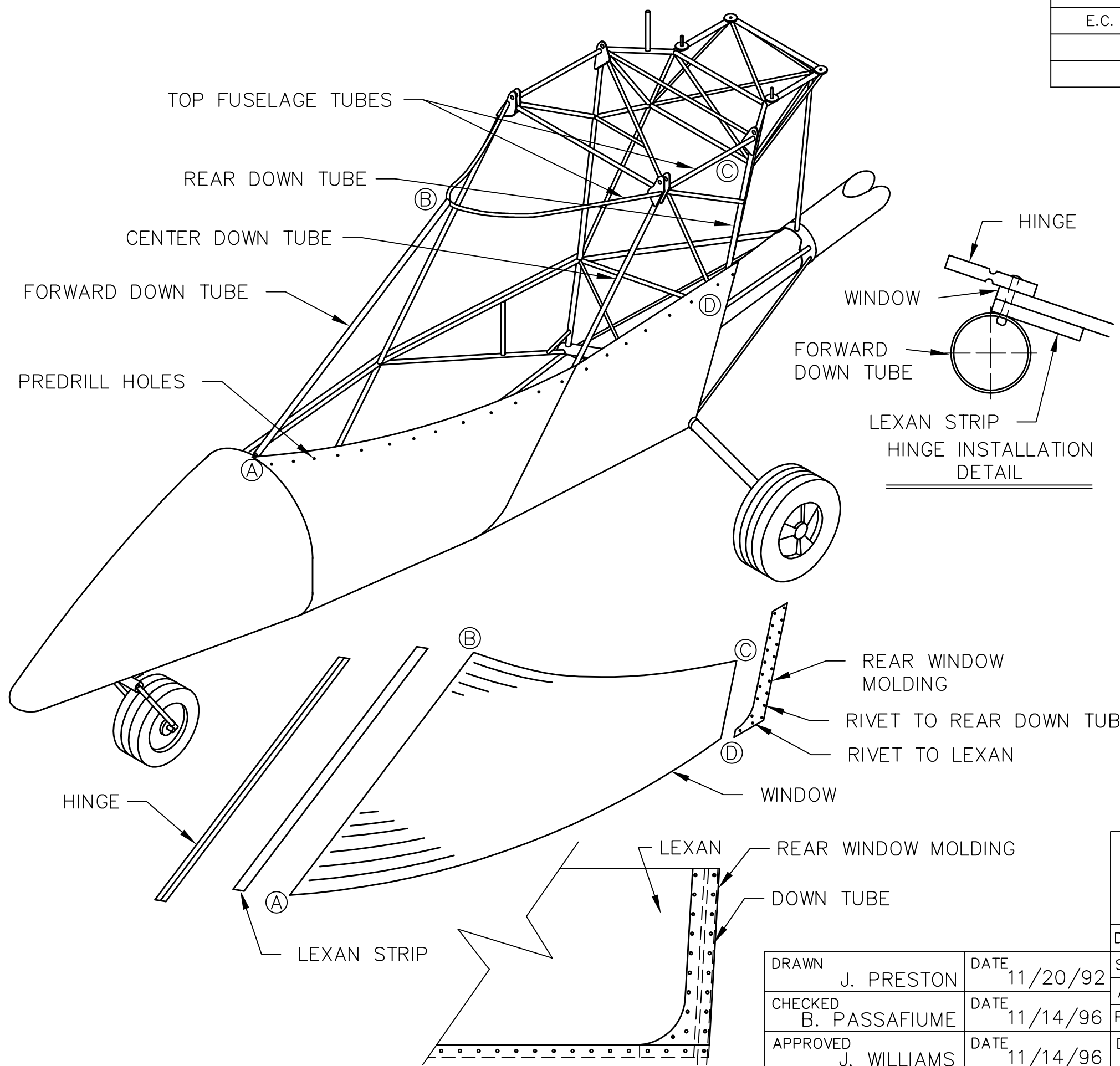


REVISIONS

E.C. NO.	REV.	DESCRIPTION	BY	DATE



NOTES:

- CUT WINDOW OUT OF LEXAN. CUT WINDOW 1 - 2" LARGER THAN TEMPLATE PROVIDED.
- DRILL ALL MOUNTING HOLES ON 2.000 INCH CENTERS WITH A #30 DRILL (.1285 DIA). CLECO WINDOW TO FRAME AS IT IS BEING DRILLED.
- PREDRILL ALL MOUNTING HOLES THRU BELLY SKIN.
- POSITION AND CLAMP WINDOW TO FUSELAGE FRAME. NOTE, LEXAN SHOULD FALL SHORT OF THE REAR DOWN TUBE AND ALL SKINS SHOULD OVERLAP THE WINDOW.
- DRILL MOUNTING HOLES THRU BOTTOM OF WINDOW USING EXISTING HOLES IN BELLY SKIN AS A GUIDE.
- DRILL MOUNTING HOLES THRU THE TOP FUSELAGE TUBES AND WINDOW. DO NOT DRILL WITHIN 1/2" OF THE WING FITTING WELD.
- POSITION REAR WINDOW MOLDING OVER REAR DOWN TUBE. DRILL MOUNTING HOLES THRU MOLDING AND DOWN TUBE. DO NOT DRILL WITHIN 1/2" OF THE WING FITTING WELD.
- DRILL MOUNTING HOLES THRU REAR MOLDING AND WINDOWS.
- DRILL (4) MOUNTING HOLES EQUALLY SPACED THRU THE WINDOW AND MAIN WING FITTING DOWN TUBE. THIS HELPS TO REDUCE VIBRATION AND NOISE. DO NOT DRILL WITHIN 1/2" OF THE WING FITTING WELD.
- MARK WINDOW ALONG THE CENTER OF FORWARD DOWN TUBE. REMOVE WINDOW AND TRIM ALONG THIS LINE. TRIM ANY OTHER EXCESS OFF THE WINDOW.
- CLECO WINDOW BACK ONTO THE FUSELAGE. DRILL MOUNTING HOLES THRU WINDOW AND FORWARD DOWN TUBE, ABOUT .200 INCHES IN FROM THE EDGE OF THE WINDOW.
- CUT A STRIP OF LEXAN APPROXIMATELY .500 INCHES WIDE AND THE LENGTH OF THE FORWARD DOWN TUBE. KITS WITH .090 LEXAN HAVE A .060 STRIP PROVIDED FOR THIS. RIVETS CANNOT GRIP AN .090 STRIP.
- PLACE HINGE BETWEEN WINDOW AND FORWARD DOWN TUBE SO THAT ITS CENTERLINE IS POSITIONED OVER THE DOWN TUBES CENTERLINE. DRILL THRU HINGE USE EXISTING HOLES IN WINDOWS AS A GUIDE.
- REPLACE HINGE WITH LEXAN STRIP. POSITION LEXAN STRIP SO THAT ITS EDGE IS FLUSH WITH THE EDGE OF THE WINDOW. DRILL THRU LEXAN STRIP USING EXISTING HOLES IN WINDOW AS A GUIDE.
- DO NOT RIVET UNTIL ALL WINDOWS HAVE BEEN FITTED.
- DO NOT RIVET ALONG TOP FUSELAGE TUBES UNTIL THE RUBBER GAP SEAL IS READY TO BE INSTALLED.
- USE AD42ABS RIVETS (.125 DIA X .265 LONG) AND #4 RIVET WASHERS FOR WINDOW / ALUMINUM SKIN JOINTS.
- USE AD42ABSLF RIVETS (.125 DIA X .265 LONG) FOR CENTER DOWN TUBE / WINDOW JOINT.
- USE AD44ABSLF RIVETS (.125 DIA X .390 LONG) FOR THE LEXAN STRIP / WINDOW / HINGE JOINT.

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<b>TITAN AIRCRAFT</b>		<b>TITAN AIRCRAFT SUPPLY</b>	
1419 STATE ROUTE 45 SOUTH		AUSTINBURG, OHIO 44010	
DETAIL NAME		LEFT WINDOW INSTALLATION	
SCALE	N/A	PART NO.	
ASSEMBLY NAME		SINGLE AND TWO PLACE TORNADO	
PART NO.		DRAWING NO.	
DRAWING NO.		<b>B 92-INS-0313-B</b>	

DRAWN	J. PRESTON	DATE	11/20/92
CHECKED	B. PASSAFIUME	DATE	11/14/96
APPROVED	J. WILLIAMS	DATE	11/14/96