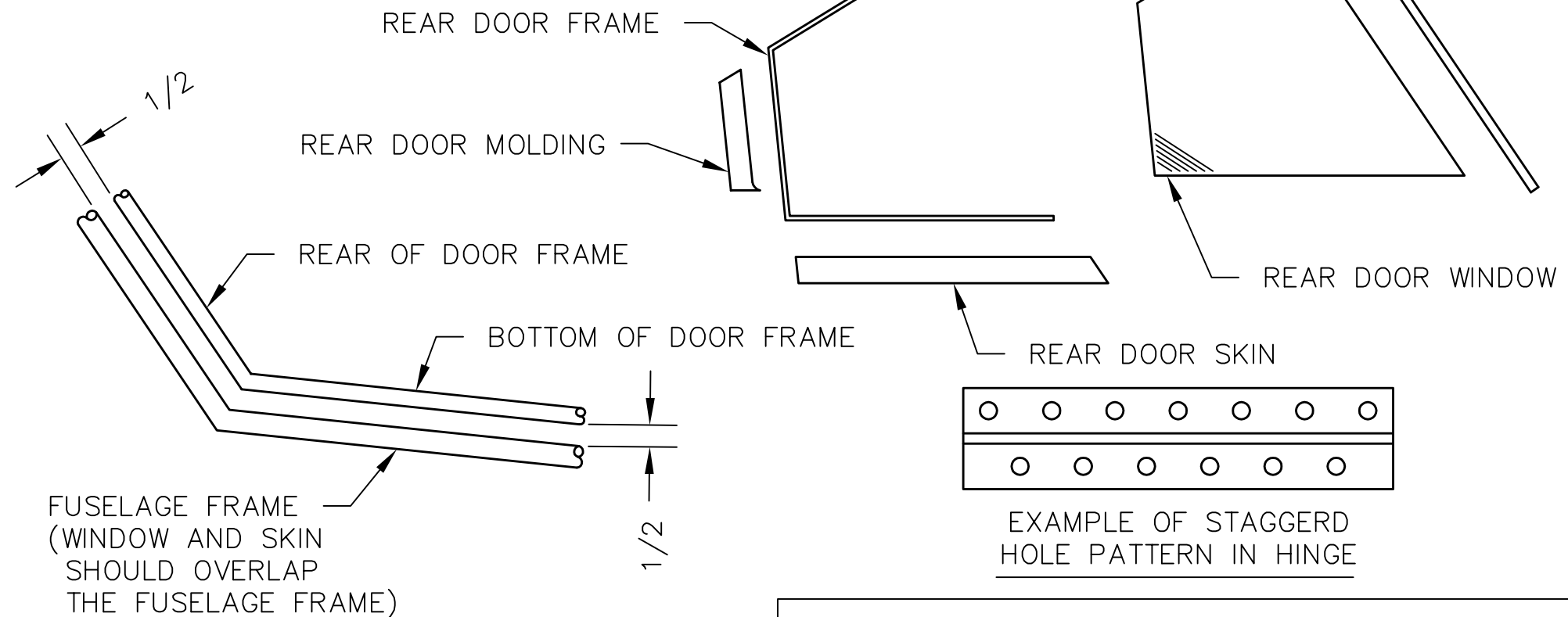
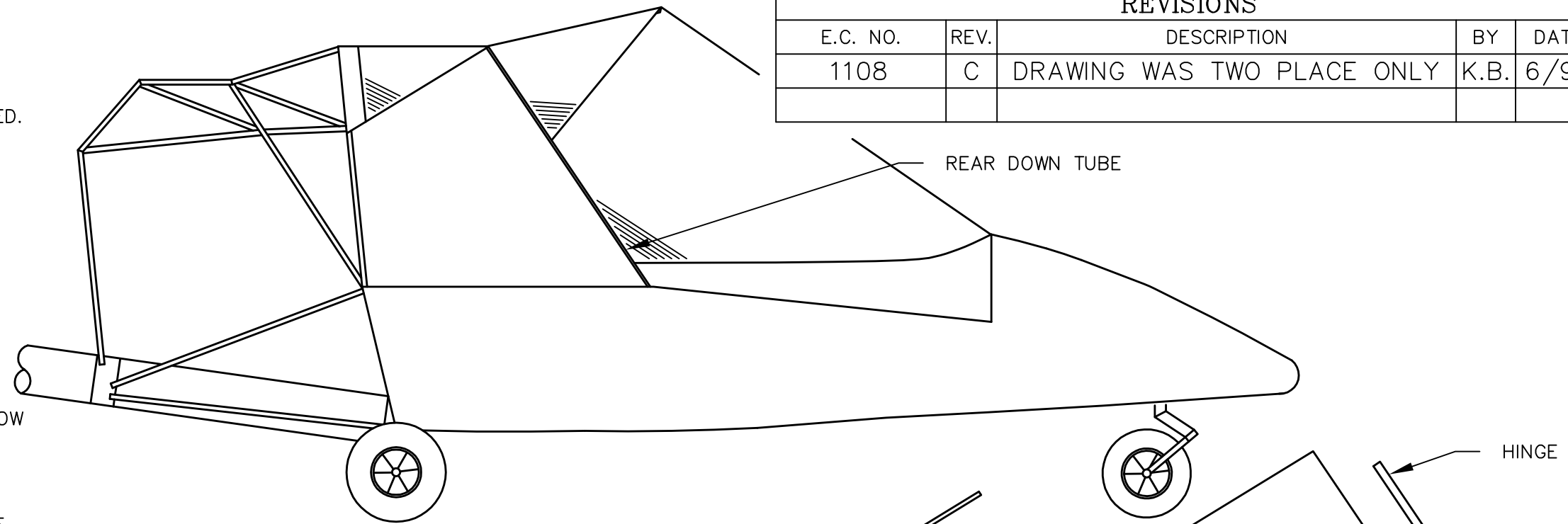


REVISIONS

E.C. NO.	REV.	DESCRIPTION	BY	DATE
1108	C	DRAWING WAS TWO PLACE ONLY	K.B.	6/97

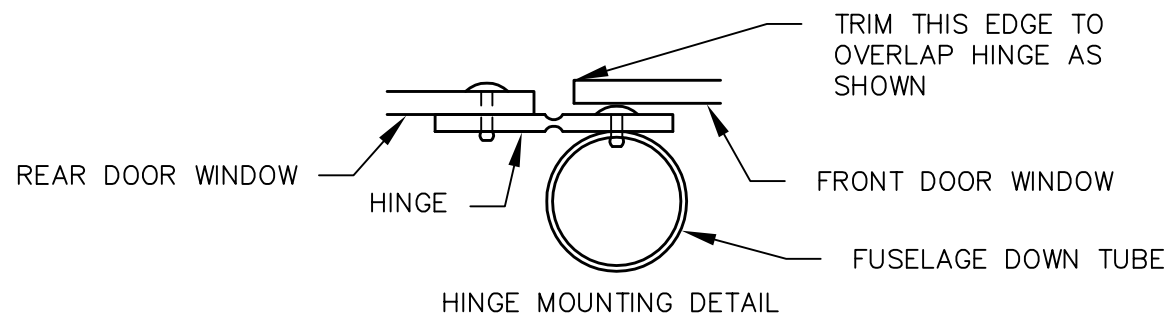
NOTES:

- ALL DIMENSIONS ARE INCHES.
- CUT REAR DOOR SKIN AND MOLDING OUT OF SHEET METAL USING THE PATTERN PROVIDED 1 - 2" OVERSIZED.
- CUT REAR DOOR WINDOW OUT OF LEXAN USING THE PATTERN PROVIDED 1 - 2" OVERSIZED.
- DRILL ALL MOUNTING HOLES ON 2.000 INCH CENTERS USING #30 DRILL (.1285 DIA). CLECO AS YOU DRILL.
- REMOVE FRONT DOOR.
- POSITION HINGE ON FUSELAGE AS SHOWN. DRILL MOUNTING HOLES ALONG CENTER OF DOWN TUBE.
- CLAMP REAR DOOR FRAME ONTO FUSELAGE LEAVING APPROXIMATELY .500 INCH CLEARANCE BETWEEN THE BOTTOM AND REAR OF THE DOOR FRAME AND THE FUSELAGE FRAME. WE RECOMMEND THAT A .500 INCH THICK BLOCK BE CLAMPED BETWEEN THE FUSELAGE AND DOOR FRAME FOR THIS.
- CLAMP REAR DOOR WINDOW INTO POSITION. THE WINDOW SHOULD OVERLAP THE FUSELAGE TUBES.
- DRILL MOUNTING HOLES THROUGH WINDOW AND REAR DOOR FRAME TUBES.
- DRILL MOUNTING HOLES THRU HINGE AND WINDOW, STAGGERING THE HOLES FROM THOSE ON THE OPPOSITE SIDE OF THE HINGE.
- REMOVE CLECOS FROM THE LOWER SECTION OF THE WINDOW.
- SLIDE THE DOOR SKIN UNDER THE WINDOW. CLAMP THE SKIN SO THAT IT IS EVEN WITH THE FRONT DOOR SKIN AND THE BELLY SKIN ON THE OPPOSITE SIDE OF THE AIRCRAFT.
- DRILL MOUNTING HOLES THRU DOOR SKIN USING EXISTING HOLES IN WINDOW AS A GUIDE.
- CLECO DOOR SKIN TO OUTSIDE OF WINDOW. DRILL MOUNTING HOLES THRU TOP OF DOOR SKIN AND WINDOW.
- REMOVE CLECOS FROM THE REAR SECTION OF THE DOOR FRAME.
- POSITION MOLDING UNDER THE WINDOW AND DRILL MOUNTING HOLES THRU MOLDING USING EXISTING HOLES IN WINDOW AS A GUIDE.
- CLECO MOLDING TO OUTSIDE OF WINDOW. DRILL MOUNTING HOLES THRU MOLDING AND WINDOW.
- DO NOT RIVET UNTIL ALL WINDOWS HAVE BEEN FITTED.
- USE AD42ABS RIVETS (.125 DIA X .265 LONG) FOR MOUNTING HOLES THRU DOOR SKIN AND DOOR FRAME.
- USE AD42ABS RIVETS AND #4 RIVET WASHERS FOR MOUNTING HOLES THRU DOOR SKIN AND WINDOW.
- USE AD42ABSLF RIVETS (.125 DIA X .265 LONG) FOR MOUNTING HOLES THRU WINDOW AND DOOR FRAME, AND THRU THE HINGE AND FUSELAGE FRAME.
- USE AD42ABSLF RIVETS AND #4 RIVET WASHERS FOR MOUNTING HOLES THRU WINDOW AND HINGE.



FUSELAGE FRAME (WINDOW AND SKIN SHOULD OVERLAP THE FUSELAGE FRAME)

EXAMPLE OF DOOR FRAME PLACEMENT IN FUSELAGE



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

DETAIL NAME		REAR DOOR INSTALLATION	
DRAWN	J. PRESTON	DATE	11/25/92
CHECKED	B. PASSAFIUME	DATE	6/17/97
APPROVED	J. SUTCH	DATE	6/20/97
SCALE	N/A	PART NO.	
ASSEMBLY NAME	SINGLE AND TWO PLACE TORNADO		
PART NO.		DRAWING NO.	
DRAWING NO.	B 92-INS-0318-C		

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