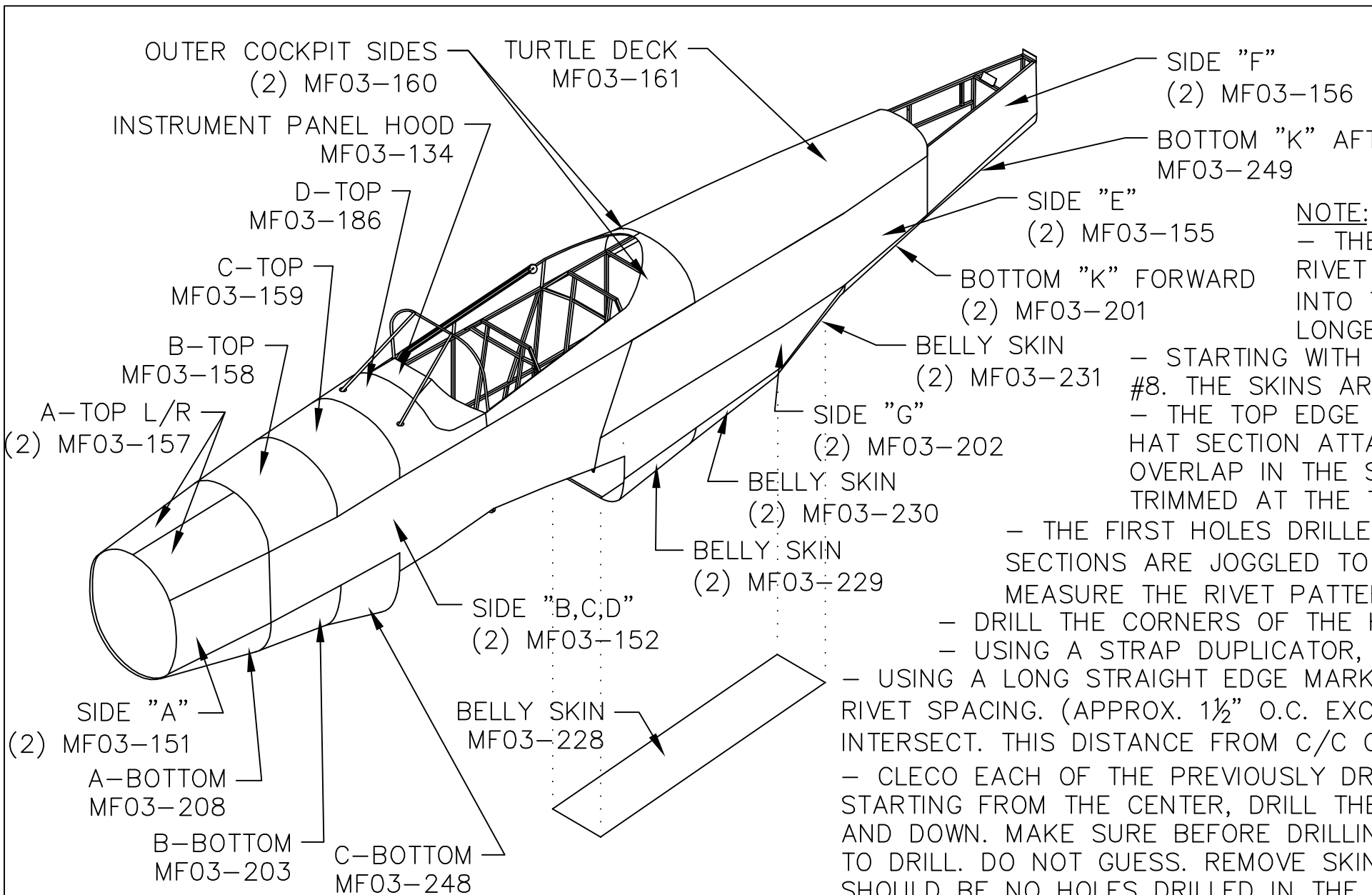


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REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	CE	11/03
0181	B	ADDED TEXT	CE	12/05
0832	C	MF03-152 CHANGED/REMOVED MF03-154	SH	12/08

NOTE:

- THERE ARE 3 MAJOR SIDE SKINS THAT ARE FITTED FIRST. THE RIVET PATTERN DRILLED INTO THESE SKINS WILL BE TRANSFERRED INTO THE TOP AND BOTTOM SKINS AT THE UPPER/LOWER LONGERONS.
- STARTING WITH B,C,D SIDE SKINS, CENTER THE SKIN BETWEEN STATIONS #2 & #8. THE SKINS ARE OVER SIZED AND WILL NEED TO BE TRIMMED TO FIT.
- THE TOP EDGE OF THE SKIN SHOULD BE ABOVE THE TOP FLANGE OF THE HAT SECTION ATTACHED TO THE LONGERON. THE BOTTOM EDGE SHOULD OVERLAP IN THE SAME MANNER. WHEN FINISHED THE SIDE SKINS WILL BE TRIMMED AT THE TOP & BOTTOM TO MATCH BOTH HAT SECTIONS.
- THE FIRST HOLES DRILLED WILL BE AT THE CORNER OF THE JUNCTION WHERE THE HAT SECTIONS ARE JOGGLED TO OVERLAP EACH OTHER. (THIS WILL BE A STARTING POINT TO MEASURE THE RIVET PATTERNS FROM) (REFERENCE DRAWING T51-05-INS-1175)
- DRILL THE CORNERS OF THE HAT SECTIONS BEFORE PUTTING THE SKINS IN PLACE.
- USING A STRAP DUPLICATOR, MATCH DRILL THE HOLES IN THE HAT SECTION CORNERS.
- USING A LONG STRAIGHT EDGE MARK A LINE BETWEEN THE HOLES, AND THEN MARK OUT AN EVEN RIVET SPACING. (APPROX. 1 1/2" O.C. EXCEPT AT CORNERS WHERE VERT. & HORI. HAT SECTION FLANGES INTERSECT. THIS DISTANCE FROM C/C ON HAT SECTION FLANGES IS 1 1/4")
- CLECO EACH OF THE PREVIOUSLY DRILLED CORNER HOLES TO HOLD THE SKIN IN PLACE. STARTING FROM THE CENTER, DRILL THE PREVIOUSLY MARKED HOLES WORKING YOUR WAY OUTWARD AND DOWN. MAKE SURE BEFORE DRILLING YOU MARK OUT THE LOCATIONS ON THE SKIN WHERE NOT TO DRILL. DO NOT GUESS. REMOVE SKIN AND DOUBLE CHECK IF IN DOUBT. WHEN FINISHED THERE SHOULD BE NO HOLES DRILLED IN THE SQUARE STEEL TUBES OF THE FUSELAGE.
- D-TOP SKIN WILL BE THE NEXT SKIN TO PUT IN PLACE.

- IT WILL BE FIT IN THE SAME MANNER AS B,C,D SKIN EXCEPT IT WILL BE SANDWICHED BETWEEN B,C,D SKIN AND THE HAT SECTIONS AT STATIONS #4 & #5.
- MATCH DRILL THE HOLES FROM B,C,D SKIN AT STATION #4 THROUGH D-TOP SKIN WHEN FITTED.
- THIS PROCEDURE WILL BE USED AT MOST JOINING AREAS.
- WHERE SKINS JOIN, ALL FORWARD SKINS WILL OVERLAP THE PROCEEDING AFT SKIN AND ALL SIDE SKINS WILL OVERLAP THE UPPER & LOWER SKINS TO ENSURE SMOOTH AIRFLOW OVER THE SURFACE.
- WHEN FITTING TOP & BOTTOM SKINS, REMOVE THE SIDE SKINS TO FIT & LOCATE TOP & BOTTOM SKINS AT CORNERS.
- REPLACE THE SIDE SKINS TO USE AS A TEMPLATE FOR MATCH DRILLING HOLES IN TOP & BOTTOM SKINS.
- THE TURTLE DECK IS ONE EXCEPTION, BECAUSE OF ITS SIZE, IT IS NECESSARY TO PULL IT INTO POSITION WITH STRAPS AND BUNGEE CORDS WHICH WILL INTERFERE WITH SIDE SKINS. IT WILL BE EASIER TO INSTALL WITH THE SIDE SKINS REMOVED AND MATCH DRILL FROM THE INSIDE THROUGH THE HAT SECTIONS.


TITAN AIRCRAFT SUPPLY
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DRAWN C. EMERY		DATE 11/25/03	DETAIL NAME FUSELAGE SKIN LOCATION	
CHECKED RI		DATE 2/3/09	SCALE 1/32"=1"	PART NO.
APPROVED KORY B.		DATE 2/4/09	ASSEMBLY NAME	
			PART NO.	DRAWING NO. F13
			DRAWING NO. B T51-03-INS-0944-C	