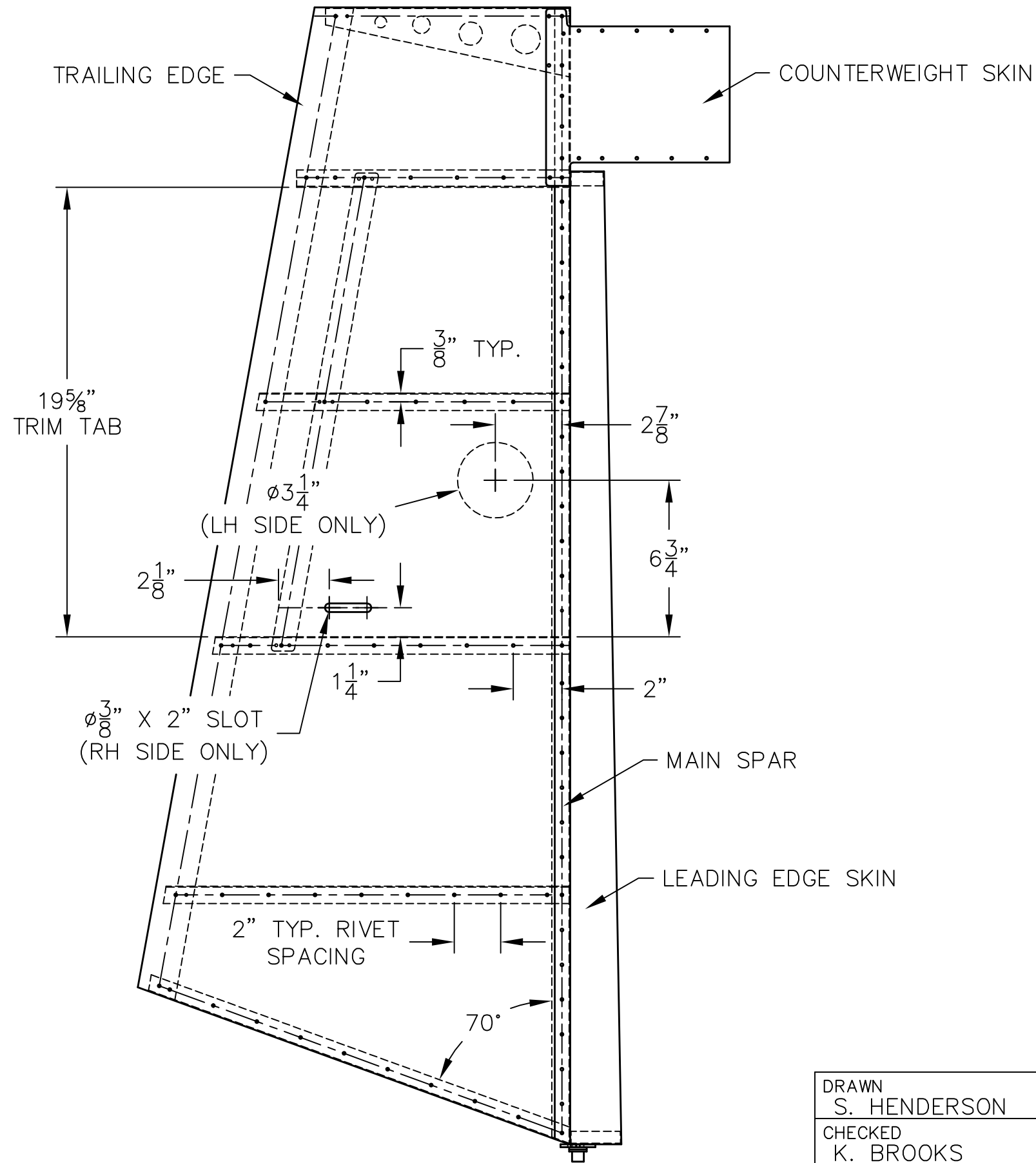


REVISIONS

| E.C. NO. | REV. | DESCRIPTION      | BY | DATE  |
|----------|------|------------------|----|-------|
|          | A    | DRAWING RELEASED | SH | 4/09  |
| 1136     | B    | NOTES ADDED      | BH | 10/11 |

NOTES:

- REMOVE THE RIVETS FROM THE MAIN SPAR IN THE LEADING EDGE SKIN AND THE COUNTERWEIGHT SKIN.
- PEEL UP THE AFT EDGE OF THE LEADING EDGE SKINS, SO THE ALUMINUM RUDDER SKIN CAN BE SANDWICHED BETWEEN THE MAIN SPAR AND THE LEADING EDGE SKIN.
- REMOVE THE TRAILING EDGE(S) FROM RUDDER ASSEMBLY.
- POSITION THE RUDDER SKIN AND MARK OUT THE RIVET PATTERN. DRILL THE SKIN AND CLECO IT IN PLACE. IF THE RUDDER HAS A TRIM TAB, NOW WOULD BE THE TIME TO MARK ITS LOCATION, THE HOLES FOR THE P/P ROD, AND THE ACCESS PANEL TO MOTOR. THE ACCESS PANEL WILL NEED A  $\phi 4$ " ALUMINUM COVER & SHOULD BE ATTACHED WITH SD42BS RIVETS.
- DURING FINAL ASSEMBLY, BOND AND RIVET THE SKIN IN PLACE USING AD42ABS RIVETS ON THE RIBS AND SD42BS RIVETS ON THE MAIN SPAR.



**TITAN AIRCRAFT SUPPLY**  
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 AUSTINBURG, OHIO 44010

|               |                                   |             |    |
|---------------|-----------------------------------|-------------|----|
| DETAIL NAME   | RUDDER ALUMINUM SKIN INSTALLATION |             |    |
| SCALE         | 3/16"=1"                          | PART NO.    |    |
| ASSEMBLY NAME |                                   |             |    |
| PART NO.      |                                   | DRAWING NO. | 03 |
| DRAWING NO.   | B T51-09-INS-1820-B               |             |    |

|          |              |      |          |
|----------|--------------|------|----------|
| DRAWN    | S. HENDERSON | DATE | 4/8/09   |
| CHECKED  | K. BROOKS    | DATE | 10/17/11 |
| APPROVED | B. KOLENO    | DATE | 10/27/11 |

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