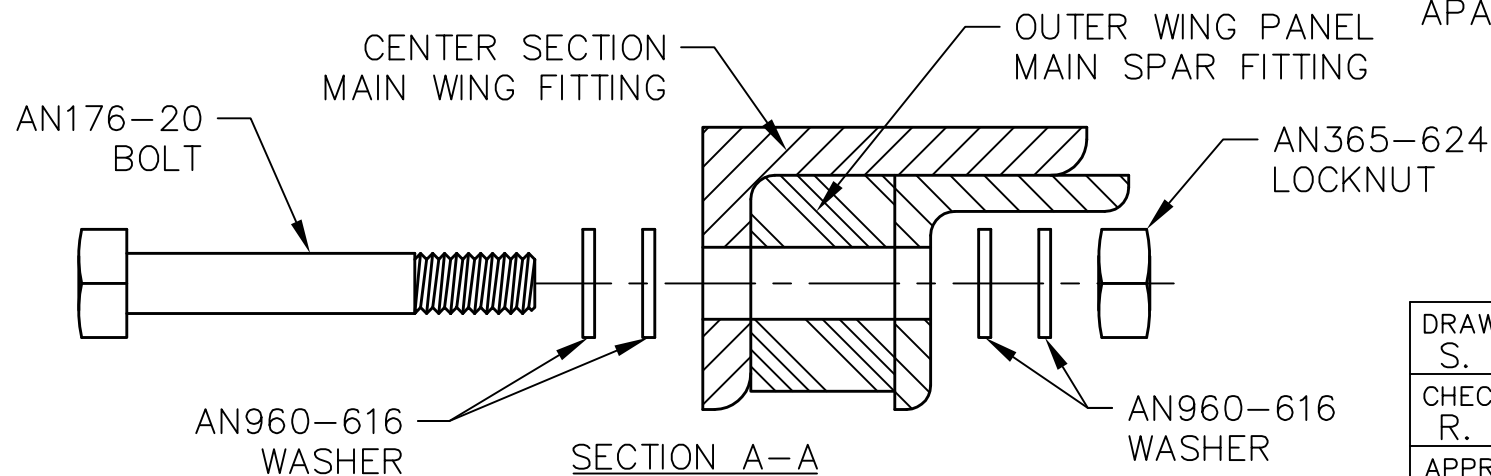


L.H.  
FWD

(2) AN3-15A BOLT, (2) AN960-10 WASHER,  
& (2) AN365-1032 LOCKNUT

(2) AN176-20 CLOSE TOLERANCE BOLT,  
(8) AN960-616 WASHER, & (2) AN365-624 LOCKNUT

(2) AN3-16A BOLT, (2) AN960-10 WASHER,  
& (2) AN365-1032 LOCKNUT



REVISIONS

| E.C. NO. | REV. | DESCRIPTION      | BY | DATE |
|----------|------|------------------|----|------|
|          | A    | DRAWING RELEASED | SH | 7/09 |
|          |      |                  |    |      |
|          |      |                  |    |      |

NOTES:

- ALL BOLT HOLES FOR THE WING FITTINGS WILL NEED TO BE CLEANED FROM ANY DEBRIS. BE SURE TO GREASE ALL BOLTS AND FITTINGS BEFORE ATTEMPTING TO INSTALL THE WING INTO THE CENTER SECTION. ALL BOLTS USED TO ATTACH THE WING TO THE CENTER SECTION MUST HAVE THE BOLT HEADS FACING AFT.
- BEFORE INSTALLING THE OUTER WING PANELS TO THE CENTER SECTION, CHECK THE FIT OF THE 3/8" MAIN WING BOLTS (AN176-20 CLOSE TOLERANCE BOLT). MAKE SURE THEY SLIDE INTO THE OUTER WING PANEL MAIN SPAR FITTINGS AND MAKE SURE THEY SLIDE INTO THE 3/8" HOLES AT THE CENTER SECTION MAIN WING FITTINGS. THESE HOLES WERE REAMED AT THE FACTORY AND SHOULD FIT VERY CLOSELY. THE BOLTS SHOULD NOT BE A PRESS FIT, BUT SHOULD ALSO NOT HAVE ANY LOOSENESS.
- INSPECT FITTINGS TO MAKE SURE THEY HAVE NO SHARP EDGES OR BURRS. IF THERE ARE ANY SHARP EDGES OR BURRS, LIGHTLY WET SAND THE AFFECTED AREA WITH #400 OR FINER SANDPAPER. CLEAN THE FITTINGS WITH A SOFT CLOTH AND COMPRESSED AIR AFTER ANY SANDING.
- TEMPORARILY INSTALL A WING IN THE CENTER SECTION BY SLIDING THE OUTBOARD WING MAIN SPAR FITTINGS INTO THE CENTER SECTION MAIN SPAR SOCKETS. BE SURE TO LUBRICATE THE FITTINGS WITH SOME GREASE TO PREVENT GALLING THE FITTINGS. THIS IS A TIGHT FIT. SEVERAL PEOPLE MAY BE NEEDED TO STEADY THE STRUCTURES. SLIDE THE WING ALL THE WAY IN SO THE BOLT HOLES ALIGN. IF THE WING WON'T GO ALL THE WAY IN, LOOK CLOSELY TO SEE WHERE THE INTERFERENCE IS. SOMETIMES SMALL SPOTS OF ADHESIVE, FOAM OR ALUMINUM MAY NEED TO BE TRIMMED OR FILED. CAUTION: MAKE SURE NOT TO SCRATCH OR GOUGE THE WING FITTINGS! WRAPPING THE FITTINGS IN TAPE PRIOR TO TRIMMING OR FILING CAN PREVENT SCRATCHES. WHEN THE HOLES ARE ALIGNED, INSTALL THE 3/8" MAIN WING BOLTS (AN176-20 CLOSE TOLERANCE BOLTS) WITHOUT NUTS FOR NOW. IF THE BOLTS DON'T FIT, THE WING IS PROBABLY NOT ALL THE WAY IN. DO NOT USE A TAPERED PUNCH OR SIMILAR TOOL TO ALIGN THE FITTINGS! USING A TAPERED TOOL DAMAGES THE FITTINGS. THE WING NEEDS TO BE IN ALL THE WAY TO GET THE BOLTS IN. IF THE BOLTS FIT WHEN THE ASSEMBLY WAS APART, THEY WILL FIT WHEN THE ASSEMBLY IS TOGETHER.

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

DETAIL NAME CENTER SECTION & WING MATTING INSTRUCTIONS

|                       |                 |  |                  |
|-----------------------|-----------------|--|------------------|
| DRAWN<br>S. HENDERSON | DATE<br>7/13/09 | SCALE<br>N/A                           | PART NO.         |
| CHECKED<br>R. INGLE   | DATE<br>6/1/10  | ASSEMBLY NAME                          |                  |
| APPROVED<br>K. BROOKS | DATE<br>6/1/10  | PART NO.                               | DRAWING NO. WO.5 |
|                       |                 | DRAWING NO. <b>B T51-09-INS-1849-A</b> |                  |

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