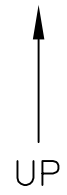


REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
2043	B	ADDED NOTE ABOUT SD42BS RIVETS	KL	12/01
2075	C	RIVET WAS ALUM.	KL	7/02
2236	D	CHANGED DIMENSIONS	BH	4/10

(B) ****WARNING****
 TOP RIVET PATTERN
 IS 1/4" OFFSET FWD. MORE
 THAN BOTTOM PATTERN
 FOR RIVET CLEARANCE.

BOTTOM VIEW OF STABILATOR



- NOTES:
- ALL DIMENSIONS ARE INCHES.
 - CENTER RIB CENTERLINE IS OFFSET TO THE RIGHT BY .250.
 - (2) OUTER HINGES MOUNT FLUSH WITH EDGE OF ANTISERVO TAB.
 - BARRELS OF HINGES SHOULD HAVE MINIMUM 1/32 OF FREE SPACE ON EACH SIDE. THIS PREVENTS MOVING HINGE PARTS FROM RIDING ON THE STABILATOR AND ANTI SERVO TAB.
 - TO ENSURE SMOOTH ANTI SERVO TAB CONTROL, HINGE BARRELS MUST BE POSITIONED ON CENTER WITH EACH OTHER.
 - DRILL MOUNTING HOLES WITH #30 (φ.1285) DRILL.
 - BOND HINGES TO ANTI SERVO TAB WITH EPOXY AND RIVET WITH SD42BS RIVETS (φ.125 X .265 LONG) AND SD43BS RIVETS (φ.125 X .328 LONG) WHERE SHOWN. (B)
 - ATTACH HINGES TO STABILATOR WITH SD42BS RIVETS (φ.125 X .265 LONG). (B)
 - HINGE DOUBLER MUST BE MOUNTED TO THE INSIDE OF THE AFT STABILATOR SKIN.

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

DETAIL NAME: 8' ANTI SERVO TAB INSTALLATION

SCALE: 1/8" = 1" PART NO.

ASSEMBLY NAME: TORNADO S

PART NO. DRAWING NO.

DRAWING NO. **B 01-INS-1239-D**

DRAWN K. LIPLIN	DATE 6/12/01
CHECKED R. INGLE	DATE 4/14/10
APPROVED K. BROOKS	DATE 4/26/10

THIS DOCUMENT PROPRIETARY TO TITAN AIRCRAFT, AND IS NOT TO BE USED, CIRCULATED, REPRODUCED, COPIED, OR DISCLOSED IN ANY MANNER WITHOUT PRIOR WRITTEN PERMISSION OF AN AUTHORIZED OFFICIAL OF TITAN AIRCRAFT.