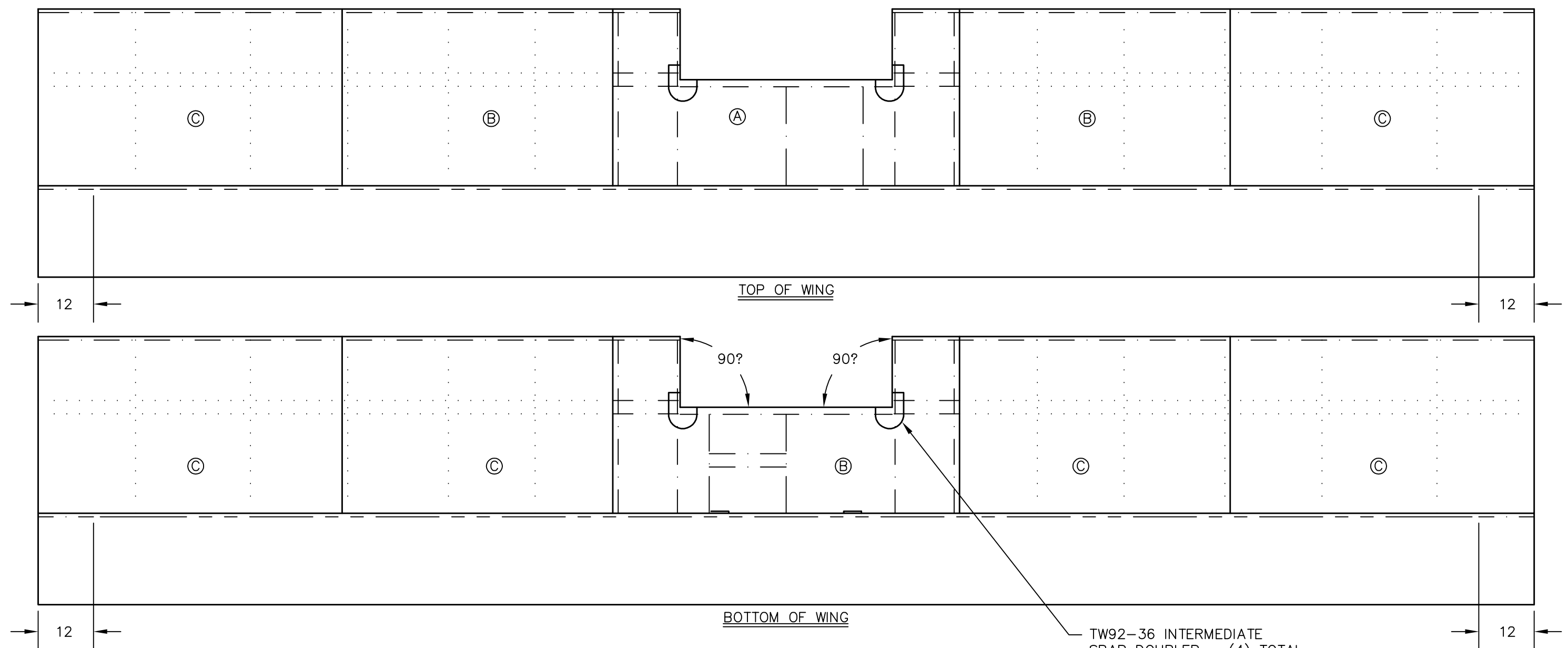


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RIVET NOTES:

- RIVET SPACING ON RIBS ARE 2 INCH CENTERS.
 - SPAR IS PREDRILLED. DRILL 'D' SECTION SKIN TO MATCH EXISTING HOLES. WE RECOMMEND USING A STRAP DUPLICATOR FOR THIS PROCESS.
 - ALL OTHER HOLES ARE DRILLED ON 1 1/2 INCH CENTERS.
 - DRILL ALL RIVET HOLES WITH #30 DRILL (.1285 DIA).
 - RIVET LINE KEY:
- | LINE TYPE | RIVET |
|-----------------------|-------------------------------|
| — — — — — | SD42BS (1/8 DIA X 17/64 LONG) |
| · · · · · | AD42BS (1/8 DIA X 17/64 LONG) |
| — · — · — · — · — · — | SD45BS (1/8 DIA X 29/64 LONG) |
- RIVET LINES RUN DOWN CENTER LINES OF REAR SPAR, RIBS AND OUTER SURFACES OF HAT SECTIONS.
 - RIBS AT WING TIPS ARE NOT TO BE RIVETED UNTIL WINGTIPS ARE INSTALLED.
 - RIVET SPAR LINE LAST. WASHOUT CAN NOT BE ADJUSTED AFTER SPAR LINE RIVETS ARE INSTALLED. CLECO SPAR LINE AND CHECK WASHOUT BEFORE INSTALLING RIVETS.
 - BOND AND RIVET INTERMEDIATE SPAR DOUBLER IN PLACE. BOND WITH URALANE 8089 AND RIVET WITH SD42BS RIVETS.

NOTES:

- DIMENSIONS ARE IN INCHES.
 - CHECK WASHOUT PERIODICALLY DURING THE SKINNING PROCESS.
 - TEMPORARILY INSTALL ALL SKINS WITH CLECOS. RIVET AND BOND SKINS AT FINAL ASSEMBLY. BOND WITH URALANE 8089.
 - START SKINNING WING AT THE TIPS AND WORK INWARD. THE CENTER WING SKINS SHOULD BE THE LAST INSTALLED.
 - TRIM WING SKINS SO THEY ONLY OVERLAP EACH OTHER APPROXIMATELY ONE INCH.
 - WING SKIN THICKNESS:
- | REF | SKIN THICKNESS | QNTY |
|-----|----------------|------|
| (A) | .025 | 1 |
| (B) | .020 | 3 |
| (C) | .016 | 6 |
- USE 26 1/4 INCH WIDE SKINS ON TOP OF WING AND 25 1/8 INCH WIDE SKINS ON BOTTOM OF WING.

TW92-36 INTERMEDIATE SPAR DOUBLER - (4) TOTAL. DO NOT INSTALL RIVETS IN THESE AREAS UNTIL DOUBLERS ARE FITTED IN PLACE.

TITAN AIRCRAFT SUPPLY 1419 STATE ROUTE 45 SOUTH AUSTINBURG, OHIO 44010	
DETAIL NAME WING SKIN INSTALLATION	
SCALE N/A	PART NO.
ASSEMBLY NAME SINGLE PLACE 20' WING	
PART NO.	DRAWING NO.
DRAWING NO. B 93-INS-0341-A	

DRAWN J. PRESTON	DATE 1/19/93
CHECKED B. PASSAFIUME	DATE 10/10/96
APPROVED J. SUTCH	DATE 10/14/96