

TC92-98 FLAP TORQUE TUBE AND TC97-302 FLAP TORQUE TUBE INNER DOUBLER
 CENTER FLAP DRIVER
 TOP OF WING
 AILERON TORQUE TUBE

CENTER FLAP DRIVER ORIENTATION

ROTATE FLAP DRIVER AROUND TORQUE TUBE UNTIL BOLT CENTER IS IN LINE WITH ELECTRIC FLAP MOTOR BALL JOINT. MOTOR MUST BE FULLY RETRACTED AT THE TIME OF INSTALLATION. DRILL A 3/16" HOLE THRU BOTH SIDE OF THE TORQUE TUBE AND DOUBLER USING THE FLAP DRIVER AS A GUIDE AND DRILL 8 #30 (.1285 ϕ) HOLES THRU BOTH SIDES ALSO USING THE FLAP DRIVER AS A GUIDE. REMOVE THE DRIVER, SAND, AND ACETONE THR DRIVER, TORQUE TUBE AND DOUBLER AND BOND WITH CIBA GEIGY 5776 A & B URLANE ADHESIVE. RIVET WITH SD43BS RIVETS AND BOLT WITH AN3-14A BOLT, AN365-1032 NYLON LOCK NUT AND AN960-10 WASHER

- NOTES:
- ALL DIMENSIONS ARE INCHES.
 - RIVET BUSHINGS WITH SD43BS RIVETS (1/8 DIA X 21/64 LONG). THE HEAD OF THE RIVETS SHOULD BE AGAINST THE NYLON.
 - DO NOT DRILL MOUNTING HOLES FOR BUSHINGS UNTIL THE WASHOUT OF THE WING IS SET CORRECTLY.

END FLAP DRIVERS
 FLAP TORQUE TUBE
 TOP OF WING

END FLAP DRIVER ORIENTATION

ROTATE FLAP DRIVER AROUND TORQUE TUBE UNTIL THE CENTER OF THE ARM IS 8 1/2 INCHES FROM THE REAR OF SPAR WEB. DRILL A 3/16" HOLE THRU BOTH SIDES OF THE TORQUE TUBE AND DOUBLER USING THE FLAP DRIVER AS A GUIDE AND DRILL 8 #30 (.1285 ϕ) HOLES THRU BOTH SIDES ALSO USING THE FLAP DRIVER AS A GUIDE, REMOVE THE DRIVER, SAND AND ACETONE THE DRIVER TORQUE TUBE AND DOUBLER, AND BOND WITH CIBA GIEGY 5776 A & B URLANE ADHESIVE. RIVET WITH SD43BS RIVETS AND BOLT WITH AN3-14A BOLT AN365-1032 NYLON LOCK NUT AND AN960-10 WASHER

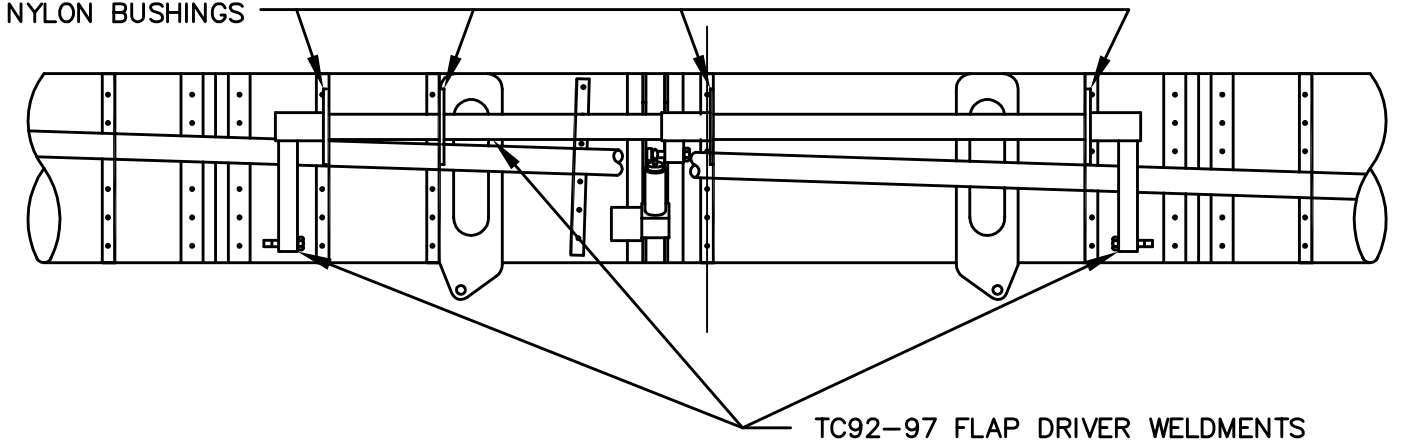
- FOR ADDITIONAL MOTOR MOUNTING INSTRUCTIONS SEE DRAWING B95-INS-0593
- FOR WINGS THAT DO NOT HAVE FACTORY INSTALLED MOTOR MOUNTS, SEE DRAWING B96-INS-0860 FOR RETRO FIT KIT INSTRUCTIONS

NEUTRAL POSITION

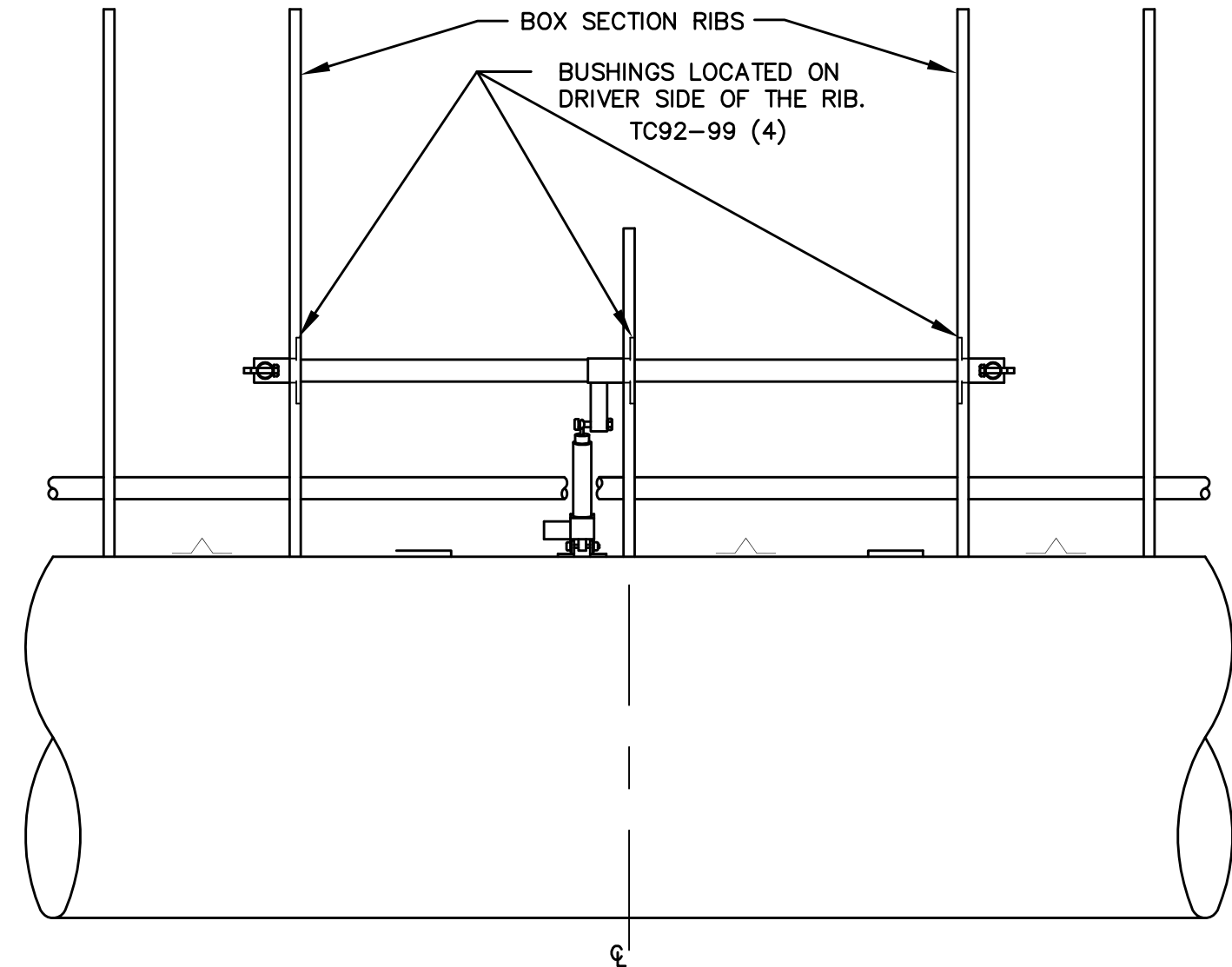
8 1/2

REAR OF SPAR WEB

TC92-99 NYLON BUSHINGS



TC92-97 FLAP DRIVER WELDMENTS



BOX SECTION RIBS

BUSHINGS LOCATED ON DRIVER SIDE OF THE RIB.
 TC92-99 (4)

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

DETAIL NAME **MOTORIZED FLAP CONTROL SYSTEM**

SCALE **N/A** PART NO.

ASSEMBLY NAME **ALL TORNADO WINGS AFTER 1995**

PART NO. DRAWING NO.

DRAWING NO. **B 95-INS-0595-F**

DRAWN	K. BOHRER	DATE	9-26-95
CHECKED	GAT	DATE	10/4/05
APPROVED	JW	DATE	10/5/05

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