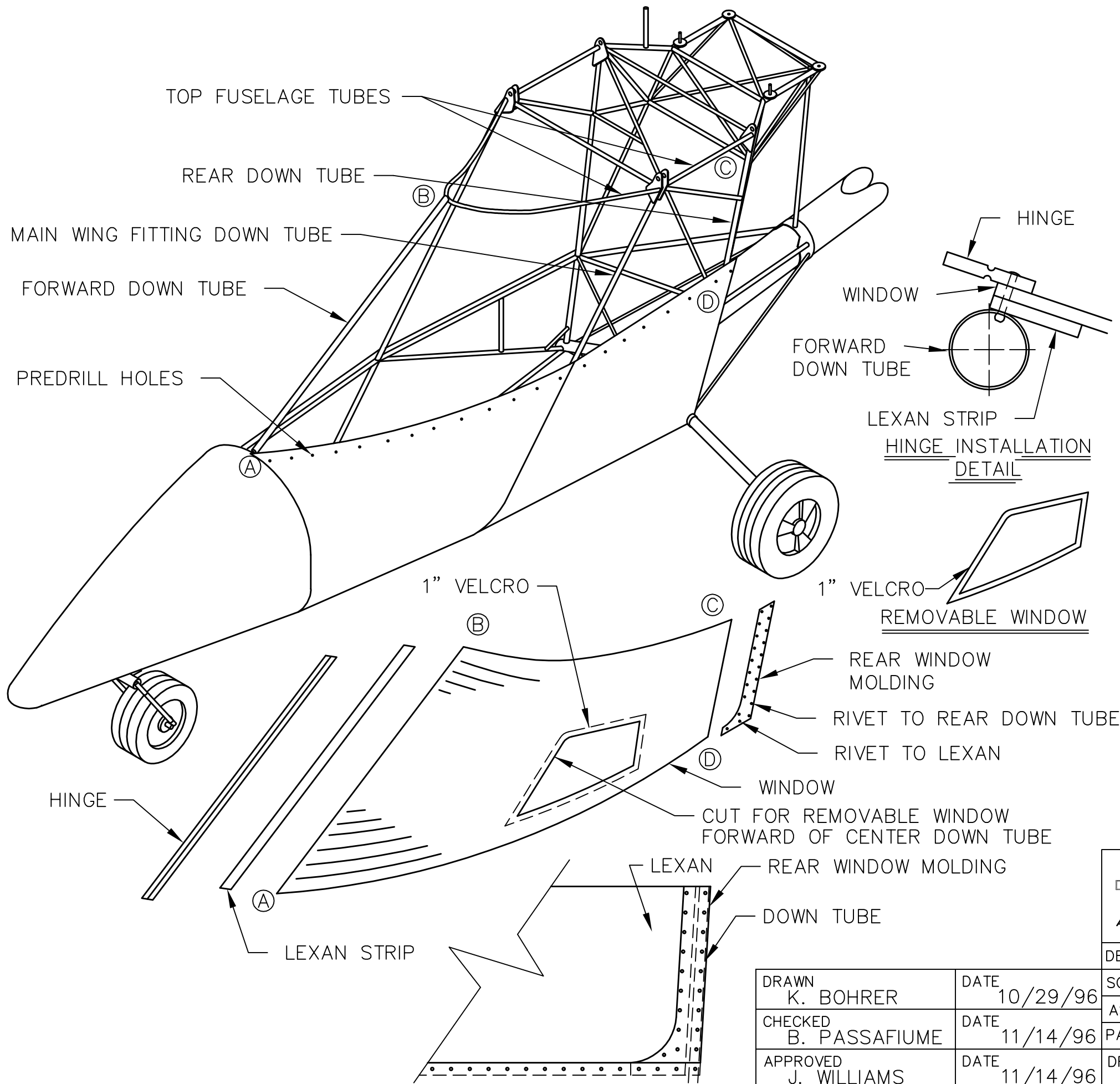


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- NOTES:
- CUT WINDOW OUT OF LEXAN. CUT WINDOW 1 - 2" LARGER THAN TEMPLATE PROVIDED.
  - DRILL ALL MOUNTING HOLES ON 2.000 INCH CENTERS WITH A #30 DRILL (.1285 DIA). CLECO WINDOW TO FRAME AS IT IS BEING DRILLED.
  - PREDRILL ALL MOUNTING HOLES THRU BELLY SKIN.
  - POSITION AND CLAMP WINDOW TO FUSELAGE FRAME. NOTE, LEXAN SHOULD FALL SHORT OF THE REAR DOWN TUBE AND ALL SKINS SHOULD OVERLAP THE WINDOW.
  - DRILL MOUNTING HOLES THRU BOTTOM OF WINDOW USING EXISTING HOLES IN BELLY SKIN AS A GUIDE.
  - DRILL MOUNTING HOLES THRU THE TOP FUSELAGE TUBES AND WINDOW. DO NOT DRILL WITHIN 1/2" OF THE WING FITTING WELD.
  - POSITION REAR WINDOW MOLDING OVER REAR DOWN TUBE. DRILL MOUNTING HOLES THRU MOLDING AND DOWN TUBE. DO NOT DRILL WITHIN 1/2" OF THE WING FITTING WELD.
  - DRILL MOUNTING HOLES THRU REAR MOLDING AND WINDOWS.
  - DRILL (4) MOUNTING HOLES EQUALLY SPACED THRU THE WINDOW AND MAIN WING FITTING DOWN TUBE. THIS HELPS TO REDUCE VIBRATION AND NOISE. DO NOT DRILL WITHIN 1/2" OF THE WING FITTING WELD.
  - MARK WINDOW ALONG THE CENTER OF FORWARD DOWN TUBE. REMOVE WINDOW AND TRIM ALONG THIS LINE. TRIM ANY OTHER EXCESS OFF THE WINDOW.
  - CLECO WINDOW BACK ONTO THE FUSELAGE. DRILL MOUNTING HOLES THRU WINDOW AND FORWARD DOWN TUBE, ABOUT .200 INCHES IN FROM THE EDGE OF THE WINDOW.
  - CUT A STRIP OF LEXAN APPROXIMATELY .500 INCHES WIDE AND THE LENGTH OF THE FORWARD DOWN TUBE. KITS WITH .090 LEXAN HAVE A .060 STRIP PROVIDED FOR THIS. RIVETS CANNOT GRIP AN .090 STRIP.
  - PLACE HINGE BETWEEN WINDOW AND FORWARD DOWN TUBE SO THAT ITS CENTERLINE IS POSITIONED OVER THE DOWN TUBES CENTERLINE. DRILL THRU HINGE USE EXISTING HOLES IN WINDOWS AS A GUIDE.
  - REPLACE HINGE WITH LEXAN STRIP. POSITION LEXAN STRIP SO THAT ITS EDGE IS FLUSH WITH THE EDGE OF THE WINDOW. DRILL THRU LEXAN STRIP USING EXISTING HOLES IN WINDOW AS A GUIDE.
  - USING REMOVABLE WINDOW AS A PATTERN, CUT LEXAN AS SHOWN LEAVING A 1" OVERLAP. APPLY 1" VELCRO STRIP TO OUTSIDE EDGE OF REMOVABLE WINDOW AND INSIDE EDGE OF OPENING.
  - DO NOT RIVET UNTIL ALL WINDOWS HAVE BEEN FITTED.
  - DO NOT RIVET ALONG TOP FUSELAGE TUBES UNTIL THE RUBBER GAP SEAL IS READY TO BE INSTALLED.
  - USE AD42ABS RIVETS (.125 DIA X .265 LONG) AND #4 RIVET WASHERS FOR WINDOW / ALUMINUM SKIN JOINTS.
  - USE AD42ABSLF RIVETS (.125 DIA X .265 LONG) FOR CENTER DOWN TUBE / WINDOW JOINT.
  - USE AD44ABSLF (.125 DIA X .390 LONG) RIVETS FOR THE LEXAN STRIP / WINDOW / HINGE JOINT.


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

DETAIL NAME LEFT WINDOW W/ REMOVABLE WINDOW INSTALLATION

DRAWN K. BOHRER	DATE 10/29/96
CHECKED B. PASSAFIUME	DATE 11/14/96
APPROVED J. WILLIAMS	DATE 11/14/96

SCALE	N/A	PART NO.
ASSEMBLY NAME	SINGLE AND TWO PLACE TORNADO	
PART NO.	DRAWING NO.	
DRAWING NO.	B 96-INS-0766-A	