



REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
	A	DRAWING RELEASED	BH	5/10

NOTES:

- SEE DRAWING T51-09-INS-1809 FOR TOP PLENUM AND STRINGER INSTALLATION.
- FROM THE EXHAUST SIDE OF THE FIBERGLASS BELLY (MF06-470), MARK OUT THE EXHAUST DOOR 13" WIDE X 17" LONG. CAREFULLY CUT OUT THE DOOR USING A CUTOFF WHEEL.
- REMOVE "E" SIDES SKINS IF THEY ARE CURRENTLY ON THE AIRCRAFT.
- CLAMP THE BELLY TO THE FRAME, MAKE SURE THE LIP ON THE INLET SIDE LINES UP WITH THE FLANGE ON BULKHEAD L8.
- CHECK THE FLANGES ON L9 AND L10 TO MAKE SURE THEY ARE FLUSH WITH THE BELLY. IF THEY ARE NOT, THE BULKHEADS MAY NEED TO BE MOVED UP OR DOWN DEPENDING ON YOUR SITUATION.
- STARTING AT THE CENTERLINE OF BULKHEAD L9, DRILL #30 RIVET HOLES EVERY 1" O.C. THROUGH THE BELLY AND FLANGE, WORKING YOUR WAY UP TOWARDS THE LOWER LONGERON TUBE. BE SURE TO CLECO AS YOU GO. REPEAT THIS ON BULKHEADS L10 AND L11. DO NOT DRILL BULKHEAD L8, YOU WILL DO THIS WHEN YOU INSTALL THE FIBERGLASS SCOOP (MF03-133), SEE DRAWING T51-10-INS-1884.
- MATCH DRILL THE RIVET HOLES IN THE LOWER LONGERON HAT SECTION INTO THE BELLY. CLECO AS YOU GO.
- FOR THE BELLY STRINGERS, SIDE PLENUM ATTACH ANGLES, AND CENTER ENCLOSURE SIDES; DRILL #30 RIVET HOLES EVERY 1 1/2" O.C. CLECO AS YOU GO.
- WHEN ATTACHING THE BELLY, BOND AND USE AD42BS RIVETS. DO NOT PUT RIVETS IN THE LOWER LONGERON HAT SECTION OR THE L11 BULKHEAD, THESE WILL GET RIVETED WHEN THE SKINS ARE INSTALLED.

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TITAN AIRCRAFT SUPPLY
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DETAIL NAME		FIBERGLASS BELLY INSTALLATION	
SCALE	N/A	PART NO.	
ASSEMBLY NAME			
PART NO.		DRAWING NO. 09	
DRAWING NO. B T51-10-INS-1890-A			

DRAWN B. HARE	DATE 5/26/10
CHECKED R. INGLE	DATE 6/25/10
APPROVED K. BROOKS	DATE 6/25/10