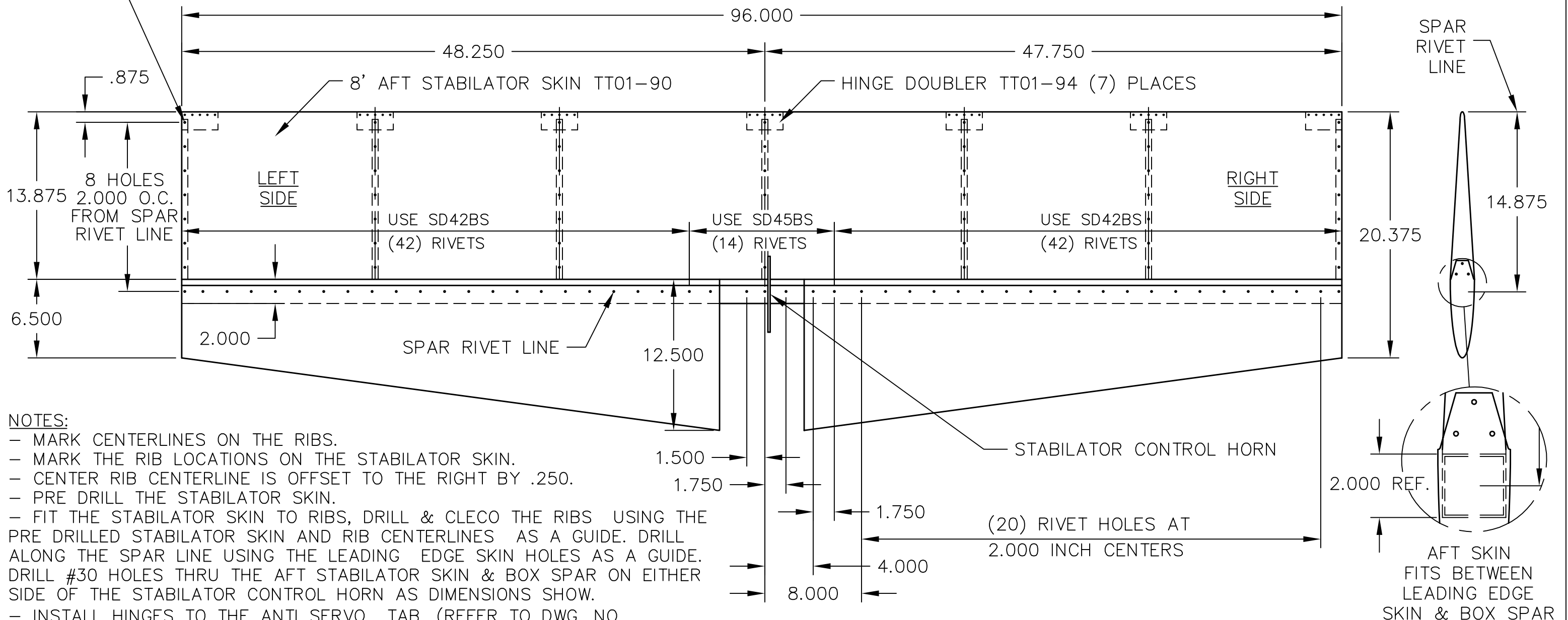


REVISIONS

E.C. NO.	REV.	DESCRIPTION	BY	DATE
2114	B	DIM. WAS FROM FRONT OF SPAR	KL	3/03
2176	C	ADDED DIMENSIONS	CE	11/05
2234	D	CHANGED DIMENSIONS	BH	4/10

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

USE AD42ABS
 ALUMINUM RIVETS
 ON ALL RIBS



- NOTES:**
- MARK CENTERLINES ON THE RIBS.
 - MARK THE RIB LOCATIONS ON THE STABILATOR SKIN.
 - CENTER RIB CENTERLINE IS OFFSET TO THE RIGHT BY .250.
 - PRE DRILL THE STABILATOR SKIN.
 - FIT THE STABILATOR SKIN TO RIBS, DRILL & CLECO THE RIBS USING THE PRE DRILLED STABILATOR SKIN AND RIB CENTERLINES AS A GUIDE. DRILL ALONG THE SPAR LINE USING THE LEADING EDGE SKIN HOLES AS A GUIDE. DRILL #30 HOLES THRU THE AFT STABILATOR SKIN & BOX SPAR ON EITHER SIDE OF THE STABILATOR CONTROL HORN AS DIMENSIONS SHOW.
 - INSTALL HINGES TO THE ANTI SERVO TAB. (REFER TO DWG. NO. B01-INS-1238 AND B01-INS-1239 FOR MORE DETAILS)
 - PRE FIT THE ANTI SERVO TAB TO THE BOTTOM OF THE STABILATOR SKIN.
 - REMOVE THE STABILATOR SKIN FROM THE ASSEMBLY AT THIS TIME.
 - PRE FIT HINGE DOUBLERS TO THE HOLE PATTERN IN THE STABILATOR SKIN FOR HINGES.
 - CLECO HINGE DOUBLERS IN PLACE, CHECK FOR FIT.
 - GLUE HINGE DOUBLERS IN PLACE.
 - RIVET THE STABILATOR SKIN TO RIBS STARTING AT THE TRAILING EDGE WORKING FORWARD WITH AD42BS RIVETS. RIVET SPAR LINE LAST WITH SD42BS & SD45BS RIVETS WHERE NOTED.
 - ATTACH THE ANTI SERVO TAB.

BOTTOM VIEW OF STABILATOR

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

TITAN AIRCRAFT

DETAIL NAME: 8' STABILATOR SKIN
 SCALE: 1/8"=1" PART NO.: TT01-90
 ASSEMBLY NAME: TORNADO S
 PART NO.: DRAWING NO.:
 DRAWING NO.: **B 01-INS-1313-D**

DRAWN K. LIPLIN	DATE 11/9/01
CHECKED R. INGLE	DATE 4/27/10
APPROVED K. BROOKS	DATE 4/27/10

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