


NOTES:

- REMOVE STITS SKIN, ALL GLUE RESIDUE, TRAILING EDGE (TT92-32), & "D" SKIN (TT92-40X) FROM RUDDER ASSEMBLY. USE A #30 DRILL TO DRILL OUT RIVETS. (TRIM EXCESS "D" SKIN MATERIAL)
- MEASURE 1/2" DOWN FROM TOP RIB (TT92-26) & MARK. CUTOFF ALL EXCESS RIB MATERIAL BELOW THE 1/2" MARK & DEBURR RIBS EDGE.
- PUT ALUM. SKIN IN PLACE ON RUDDER, USE A #30 DRILL & MATCH DRILL MIDDLE RIBS (TT92-35 & TT92-34) & SKIN ON BOTH SIDES. (CLECO IN PLACE TO CHECK THE POSITIONING OF THE SKIN OR USE A PIECE OF LEXAN FOR MATCH DRILLING THESE HOLES, THEN TRANSFER THE HOLES FROM THE LEXAN TO THE ALUMINUM SKIN.)
- WHEN SATISFIED WITH POSITIONING OF THE SKIN, MATCH DRILL THE SKIN TO THE RUDDER SPAR (TT92-39X), ALSO MATCH DRILL LOWER RIB (TT92-36) & TOP RIB (TT92-26).
- CLEAN RUDDER OF DEBRIS & DEBURR ALL HOLES AFTER DONE DRILLING.
- ATTACH ALUM. SKIN TO RIBS USING AD42BS RIVETS & TRAILING EDGE OF THE SKIN WITH AD41BS RIVETS. ONCE ALUM. SKIN IS ATTACHED TO RIBS, REATTACH "D" SKIN (TT92-40X) TO RUDDER SPAR (TT92-39X) WITH SD42BS RIVETS.

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		TITAN AIRCRAFT SUPPLY 1419 STATE ROUTE 45 SOUTH AUSTINBURG, OHIO 44010	
DETAIL NAME		RUDDER ALUMINUM SKIN INSTALLATION	
DRAWN		SCALE 1/4"=1" PART NO.	
S. HENDERSON		DATE 11/10/06	
CHECKED		ASSEMBLY NAME	
DATE		PART NO.	
APPROVED		DRAWING NO.	
DATE		DRAWING NO. B 06-INS-1442-A	