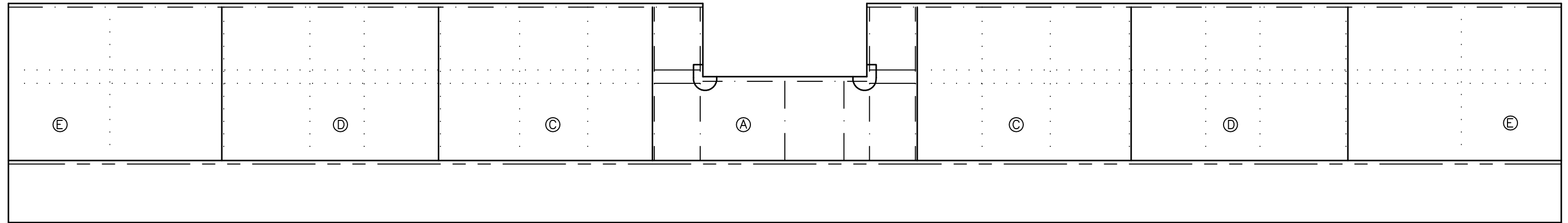
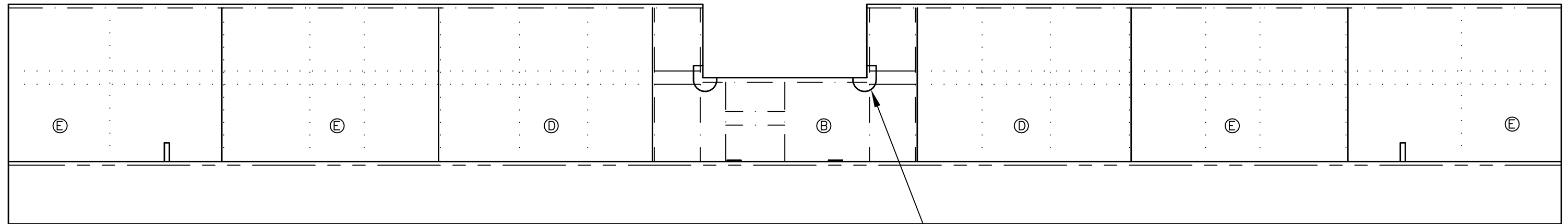


REVISIONS

| E.C. NO. | REV. | DESCRIPTION                   | BY   | DATE  |
|----------|------|-------------------------------|------|-------|
|          | B    | WING TIE DOWNS ADDED          | K.B. | 10/95 |
| 1086     | C    | DASHDOT LINES WEREN'T VISABLE | K.B. | 3/97  |



TOP OF WING



BOTTOM OF WING

RIVET NOTES:

- RIVET SPACING ON RIBS ARE 2 INCH CENTERS.
  - SPAR IS PREDRILLED. DRILL 'D' SECTION SKIN TO MATCH EXISTING HOLES. WE RECOMMEND USING A STRAP DUPLICATOR FOR THIS PROCESS.
  - ALL OTHER HOLES ARE DRILLED ON 1 1/2 INCH CENTERS.
  - DRILL ALL RIVET HOLES WITH #30 DRILL (.1285 DIA).
  - RIVET LINE KEY: RIVET
- |             |                               |
|-------------|-------------------------------|
| — — — — —   | SD42BS (1/8 DIA X 17/64 LONG) |
| · · · · ·   | AD42BS (1/8 DIA X 17/64 LONG) |
| — · — · — · | SD48BS (1/8 DIA X 41/64 LONG) |
- RIVET LINES RUN DOWN CENTER LINES OF REAR SPAR, RIBS AND OUTER SURFACES OF HAT SECTIONS.
  - RIBS AT WING TIPS ARE NOT TO BE RIVETED UNTIL WINGTIPS ARE INSTALLED.
  - RIVET SPAR LINE LAST. WASHOUT CAN NOT BE ADJUSTED AFTER SPAR LINE RIVETS ARE INSTALLED. CLECO SPAR LINE AND CHECK WASHOUT BEFORE INSTALLING RIVETS.
  - BOND AND RIVET INTERMEDIATE SPAR DOUBLER IN PLACE. BOND WITH URALANE 8089 AND RIVET WITH SD42BS RIVETS.

NOTES:

- CHECK WASHOUT PERIODICALLY DURING THE SKINNING PROCESS.
  - TEMPORARLY INSTALL ALL SKINS WITH CLECOS. RIVET AND BOND SKINS AT FINAL ASSEMBLY. BOND WITH URALANE 8089.
  - START SKINNING WING AT THE TIPS AND WORK INWARD. THE CENTER WING SKINS SHOULD BE THE LAST INSTALLED.
  - TRIM WING SKINS SO THEY ONLY OVERLAP EACH OTHER APPROXIMATELY ONE INCH.
  - WING SKIN THICKNESS:
- | REF | SKIN THICKNESS | QNTY |
|-----|----------------|------|
| (A) | .040           | 1    |
| (B) | .032           | 1    |
| (C) | .025           | 2    |
| (D) | .020           | 4    |
| (E) | .016           | 6    |
- USE 26 1/4 INCH WIDE SKINS ON TOP OF WING AND 25 1/8 INCH WIDE SKINS ON BOTTOM OF WING.

TW92-36 INTERMEDIATE SPAR DOUBLER - (4) TOTAL. DO NOT INSTALL RIVETS IN THESE AREAS UNTIL DOUBLERS ARE FITTED AND IN PLACE. USE SD43BS RIVETS IN THIS AREA.

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

|                          |                  |                                       |
|--------------------------|------------------|---------------------------------------|
| DRAWN<br>J. PRESTON      | DATE<br>12/29/92 | DETAIL NAME<br>WING SKIN INSTALLATION |
| CHECKED<br>B. PASSAFIUME | DATE<br>6/26/97  | SCALE N/A PART NO.                    |
| APPROVED<br>J. SUTCH     | DATE<br>7/1/97   | ASSEMBLY NAME<br>23 1/2 FOOT WING     |
|                          |                  | PART NO. DRAWING NO.                  |
|                          |                  | DRAWING NO. <b>B 92-INS-0328-C</b>    |

THIS DOCUMENT PROPRIETARY TO TITAN AIRCRAFT, AND IS NOT TO BE USED, CIRCULATED, REPRODUCED, COPIED, OR DISCLOSED IN ANY MANNER WITHOUT PRIOR WRITTEN PERMISSION OF AN AUTHORIZED OFFICIAL OF TITAN AIRCRAFT.