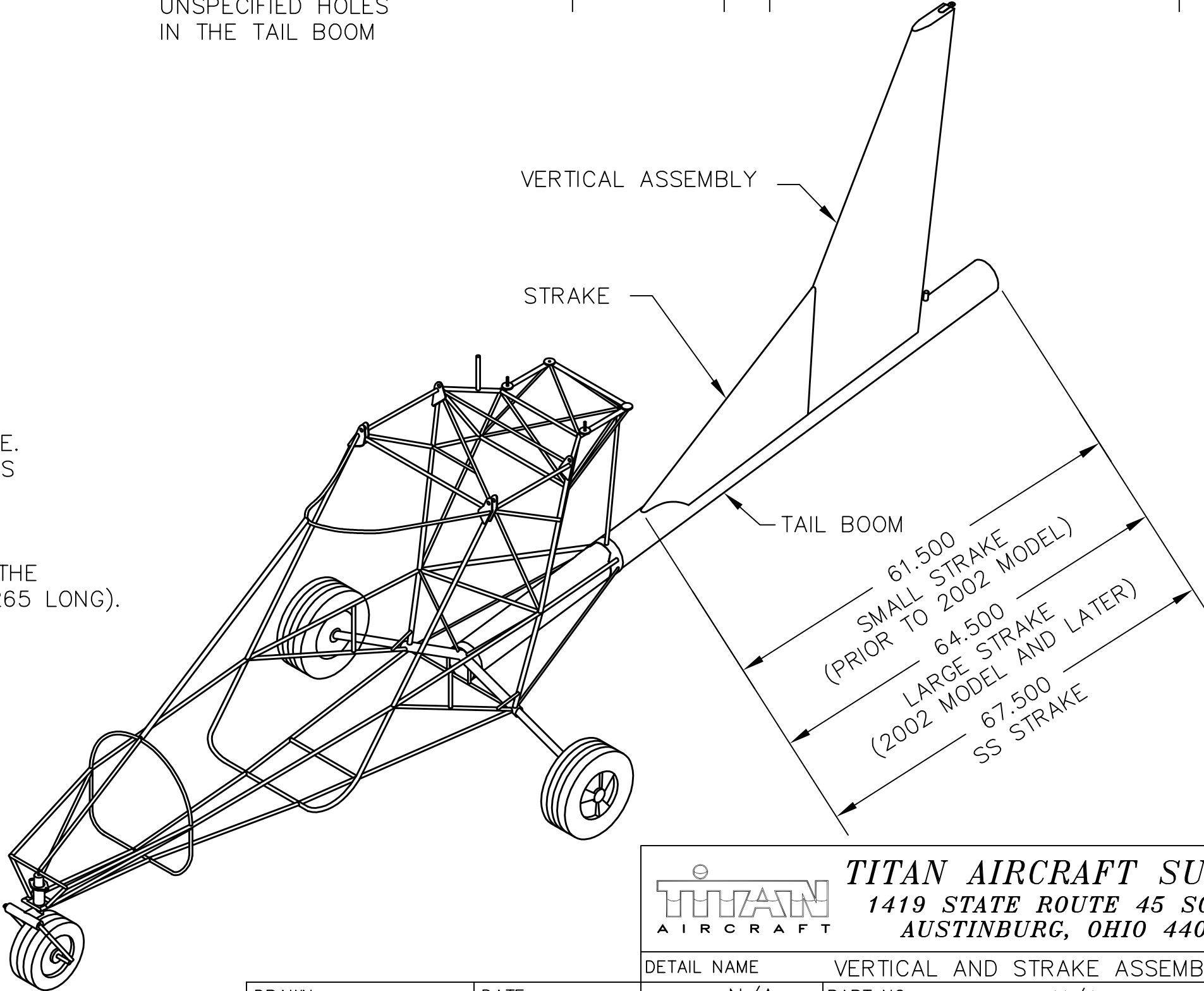


ASSEMBLY NOTES:

- ALL DIMENSIONS ARE INCHES.
- TEMPORARILY MOUNT THE VERTICAL ASSEMBLY TO THE TAIL BOOM USING THE FOUR PREDRILLED HOLES.
- DRILL RIVET HOLES THRU BOTTOM OF VERTICAL ASSEMBLY AND TAIL BOOM ON 1.500 INCH CENTERS USING #30 DRILL (.1285 DIA).
- POSITION STRAKE SO THAT ITS FORWARD EDGE IS 61.500 INCHES FROM THE END OF THE TAIL BOOM, AS SHOWN.
- DRILL RIVET HOLES THRU BOTTOM OF STRAKE AND TAIL BOOM ON 1.500 INCH CENTERS USING #30 DRILL (.1285 DIA).
- DRILL RIVET HOLES ALONG BACK EDGE OF STRAKE ON 1.500 INCH CENTERS. USE #30 DRILL (.1285 DIA.).
- REMOVE STRAKE AND VERTICAL ASSEMBLY AND DEBURR RIVET HOLES.
- SAND ALL MATING SURFACES OF TAIL BOOM, VERTICAL ASSEMBLY AND STRAKE FOR BONDING.
- BOND AND RIVET VERTICAL ASSEMBLY INTO PLACE. BOND WITH URLANE 8089 AND RIVET WITH SD42BS RIVETS (.125 DIA X .265 LONG).
- BOND AND RIVET STRAKE INTO PLACE. BOND WITH URLANE 8089. RIVET BOTTOM EDGES WITH SD42BS RIVETS (.125 DIA X .265 LONG). RIVET THE BACK EDGE WITH AD42ABS RIVETS (.125 DIA X .265 LONG).

WARNING
DO NOT DRILL ANY
UNSPECIFIED HOLES
IN THE TAIL BOOM

REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
2029	C	ADDED LG. STRAKE DIMENSION	KL	10/01
2169	D	ADDED SS STRAKE DIMENSION	CE	10/05





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

DETAIL NAME		VERTICAL AND STRAKE ASSEMBLY	
SCALE	N/A	PART NO.	N/A
ASSEMBLY NAME			
PART NO.		DRAWING NO.	
DRAWING NO.		B 92-INS-0183-D	

DRAWN	J. PRESTON	DATE	10/7/92
CHECKED	GAT	DATE	10/5/05
APPROVED	JW	DATE	10/7/05

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