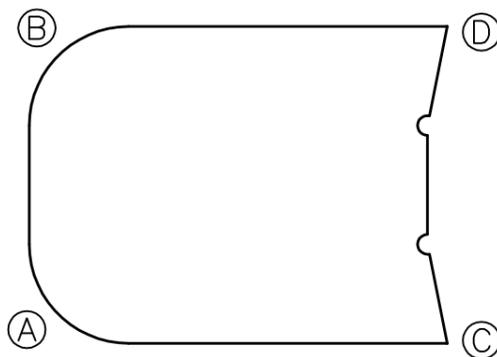
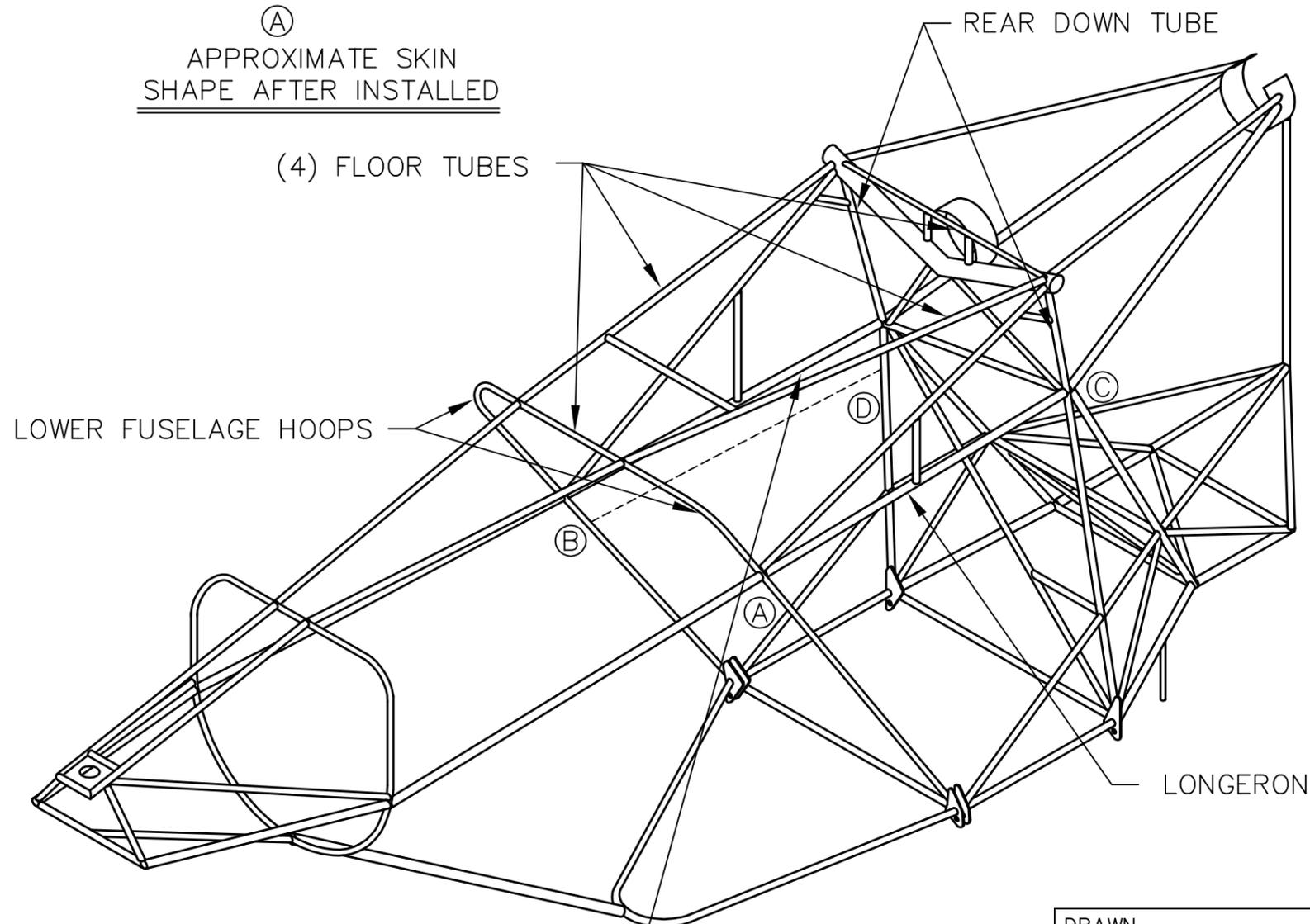


APPROXIMATE SKIN
SHAPE AFTER INSTALLED



LAYOUT OF SKIN
(LAYING FLAT)



LONGERON
EDGE OF SKIN IS PLACED
4.000 INCHES ABOVE THIS
TUBE (ALONG DASHED LINE).

NOTES:

- FORWARD BELLY SKIN SHOULD ALREADY BE FITTED. REMOVE FORWARD BELLY SKIN FROM FUSELAGE.
- CUT AFT BELLY SKIN OUT OF SHEET METAL, USE PATTERN PROVIDED.
- POSITION SKIN ON FUSELAGE SO THAT THE SKIN EDGE IS 4.000" ABOVE FUSELAGE LONGERON TUBE SHOWN. PULL SKIN BACK UNTIL IT IS FLUSH AGAINST THE GEAR LEG TUBES.
- CLAMP SKIN TO FUSELAGE. FOR BEST RESULTS LAY BOARD ACROSS SKIN AND CLAMP BOARD TO FUSELAGE.
- CHECK SKIN TO BE SURE IT IS TIGHT AGAINST FUSELAGE.
- ALL RIVET HOLES *MUST* BE DRILLED THRU THE CENTERS OF FUSELAGE TUBES. DRILL ALL RIVET HOLES WITH #30 DRILL (.1285 DIA). CLECO SKIN TO FRAME AS IT IS BEING DRILLED.
- FIRST, DRILL RIVET HOLES THRU (4) "FLOOR TUBES". DRILL ON 1.500 INCH CENTERS.
- DRILL LONGERON TUBES NEXT. DRILL ON 1.500 INCH CENTERS. BE SURE SKIN IS TIGHT BEFORE DRILLING.
- DRILL "REAR DOWN TUBES" ON 1.500 INCH CENTERS.
- POSITION FORWARD SKIN ON THE FUSELAGE. CLECO FORWARD SKIN TO EACH TUBE EXCEPT THE "LOWER FUSELAGE HOOPS". THE FORWARD SKIN SHOULD OVERLAP THE AFT SKIN AT THE "LOWER FUSELAGE HOOPS". DRILL MOUNTING HOLES THROUGH AFT SKIN USING THE FORWARD SKIN AS A GUIDE.
- DO NOT DRILL RIVET HOLES ON ANY OTHER TUBES. RIVETING TO OTHER TUBES MAY CAUSE DENTS IN THE SKIN.
- REMOVE BOTH SKINS FROM FUSELAGE. TRIM THE EDGES OF SKINS THAT OVERLAP EACH OTHER TO APPROXIMATELY .187 EDGE DISTANCE.
- PERMANENTLY INSTALL SKINS WITH SD42BS RIVETS AFTER INTERIOR OF FUSELAGE IS BUILT UP. FORWARD SKIN SHOULD OVERLAP AFT SKIN.
- AFTER BOTH SKINS ARE INSTALLED, ROLL THE SHORTER EDGE (NOT THE 4.000 INCH EDGE) AROUND THE LONGERON TUBE. FOR BEST RESULTS USE A BREAK OR RUBBER Mallet.

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

DETAIL NAME AFT BELLY SKIN INSTALLATION

DRAWN J. PRESTON DATE 8/24/92

SCALE N/A PART NO.

CHECKED DATE

ASSEMBLY NAME

APPROVED DATE

PART NO. DRAWING NO.

DRAWING NO. **B 92-INS-0250-A**