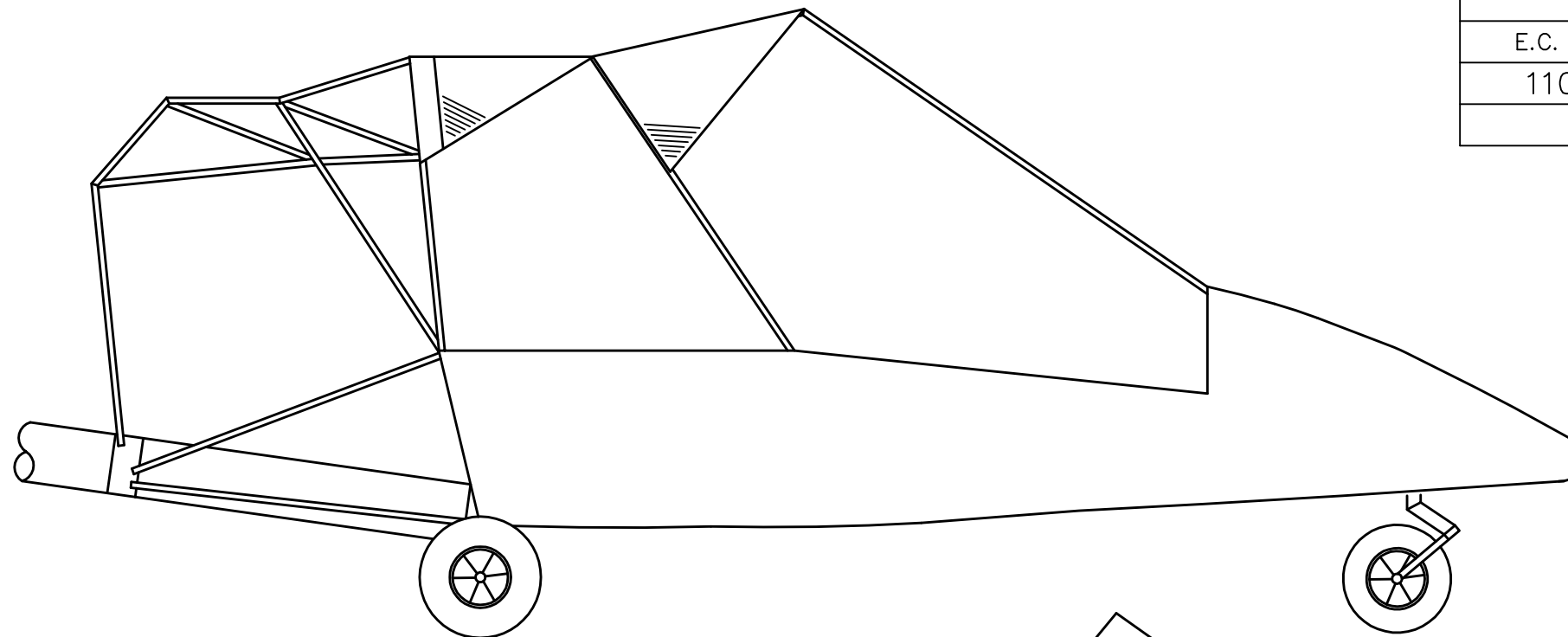


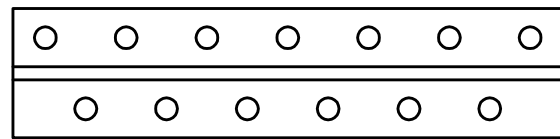
REVISIONS

E.C. NO.	REV.	DESCRIPTION	BY	DATE
1107	C	DRAWING WAS TWO PLACE ONLY	K.B.	6/97

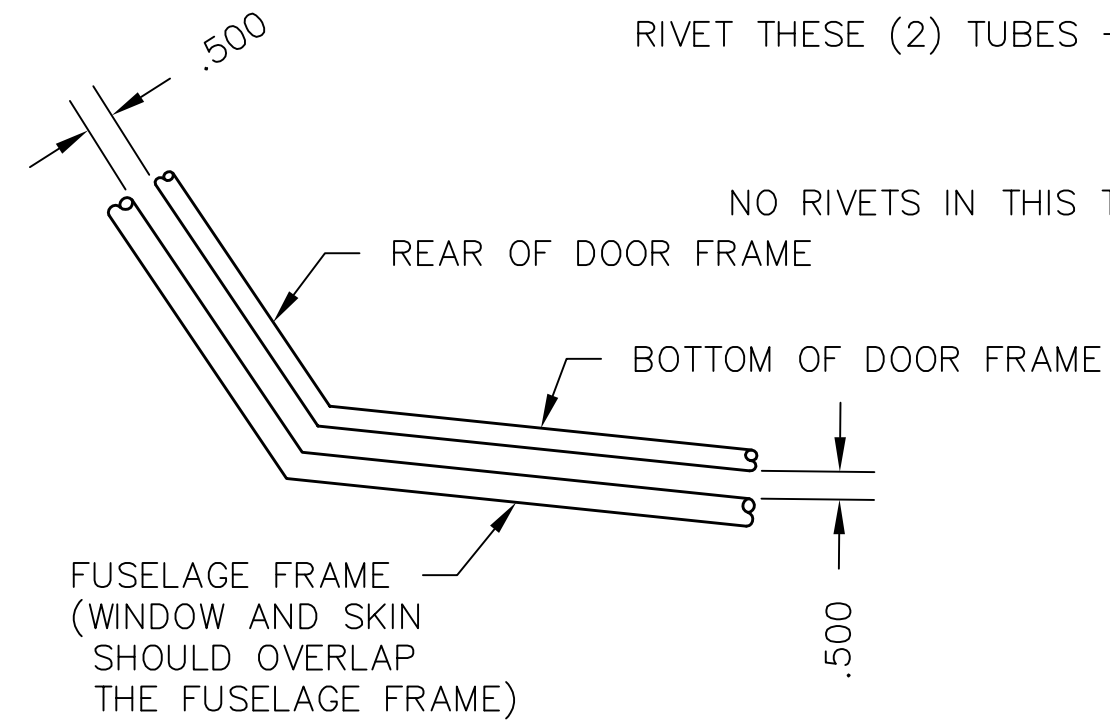
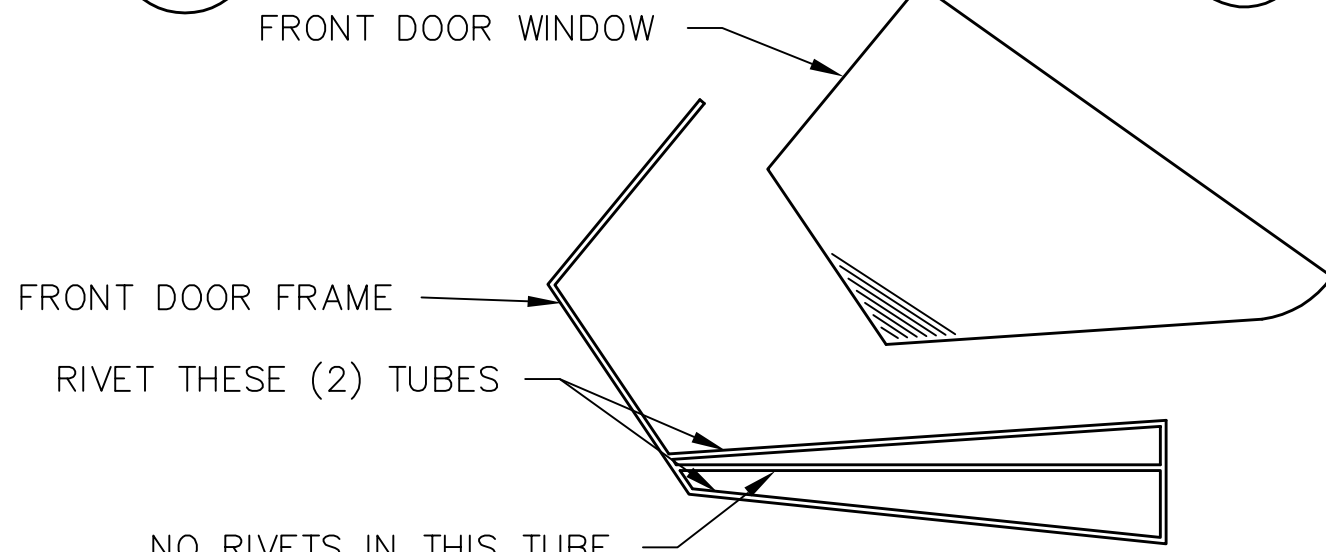


NOTES:

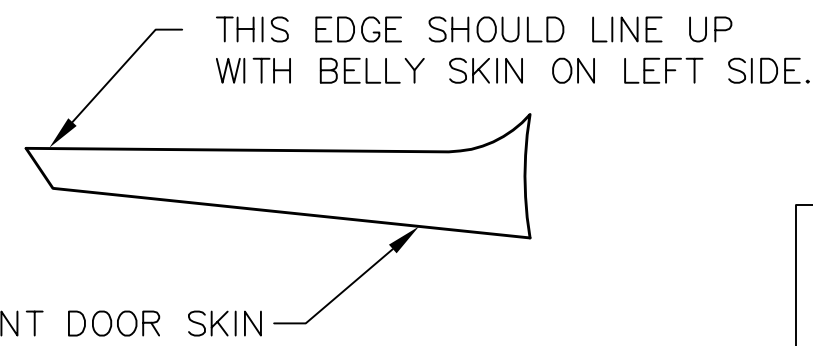
- ALL DIMENSIONS ARE INCHES.
- CUT ALL PATTERNS 1 - 2" OVERSIZED AND TRIM TO FIT.
- CUT FRONT DOOR SKIN OUT OF SHEET METAL USING THE PATTERN PROVIDED.
- CUT FRONT DOOR WINDOW OUT OF LEXAN USING THE PATTERN PROVIDED.
- CLAMP FRONT DOOR FRAME ONTO FUSELAGE LEAVING APPROXIMATELY .500 INCH CLEARANCE BETWEEN THE BOTTOM AND REAR OF THE DOOR FRAME AND THE FUSELAGE FRAME. WE RECOMMEND THAT A .500 INCH THICK BLOCK BE CLAMPED BETWEEN THE FUSELAGE AND DOOR FRAME FROM THIS.
- CLAMP DOOR SKIN SO THAT ITS TOP EDGE IS IN LINE WITH TOP EDGE OF THE BELLY SKIN ON THE OPPOSITE SIDE OF THE AIRCRAFT AND SO IT LINES UP EVENLY AT THE NOSE.
- DRILL ALL MOUNTING HOLES ON 2.000 INCH CENTERS USING #30 DRILL (.1285 DIA). CLECO AS YOU DRILL.
- TRACE OUT DOOR FRAME ON DOOR SKIN FROM INSIDE AIRCRAFT.
- REMOVE AND PREDRILL DOOR SKIN.
- REINSTALL DOOR SKIN WITH CLAMPS TO INSURE PREDRILLED HOLES ALIGN WITH CENTER OF THE DOOR FRAME TUBES. DRILL AND CLECO.
- REMOVE LEFT SIDE WINDOW.
- CLAMP FRONT DOOR WINDOW INTO POSITION. THE DOOR SKIN SHOULD OVERLAP THE DOOR WINDOW.
- DRILL MOUNTING HOLES THRU BOTTOM OF DOOR WINDOW AND DOOR SKIN FIRST.
- DRILL MOUNTING HOLES ALONG REAR SIDE AND TOP OF DOOR NEXT.
- CLECO LEFT SIDE WINDOW BACK ONTO FUSELAGE INCLUDING HINGE AND LEXAN STRIP.
- DRILL MOUNTING HOLES THRU HINGE AND FRONT DOOR WINDOW. STAGGER THE HOLES FROM THOSE ON THE LEFT HAND SIDE OF THE HINGE.
- DO NOT RIVET UNTIL ALL WINDOWS HAVE BEEN FITTED.
- USE AD42ABS RIVETS (.125 DIA X .265 LONG) FOR MOUNTING HOLES THRU DOOR SKIN AND DOOR FRAME.
- USE AD42ABS RIVETS AND #4 RIVET WASHERS FOR MOUNTING HOLES THRU DOOR SKIN AND WINDOW.
- USE AD42ABSLF RIVETS (.125 DIA X .265 LONG) FOR MOUNTING HOLES THRU WINDOW AND DOOR FRAME.
- USE AD42ABSLF RIVETS AND #4 RIVET WASHERS FOR MOUNTING HOLES THRU WINDOW AND HINGE.



EXAMPLE OF STAGGERD HOLE PATTERN IN HINGE



EXAMPLE OF DOOR FRAME PLACEMENT IN FUSELAGE



FRONT DOOR SKIN

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

DETAIL NAME		FRONT DOOR INSTALLATION	
SCALE	N/A	PART NO.	
ASSEMBLY NAME		SINGLE AND TWO PLACE TORNADO	
PART NO.		DRAWING NO.	
DRAWING NO.		B 92-INS-0316-C	

DRAWN	J. PRESTON	DATE	11/25/92
CHECKED	B. PASSAFIUME	DATE	6/17/97
APPROVED	J. SUTCH	DATE	6/20/97

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.