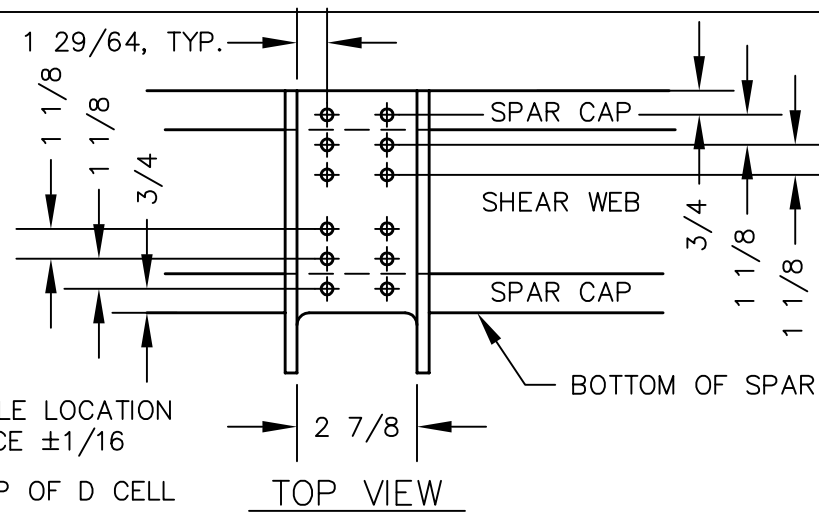
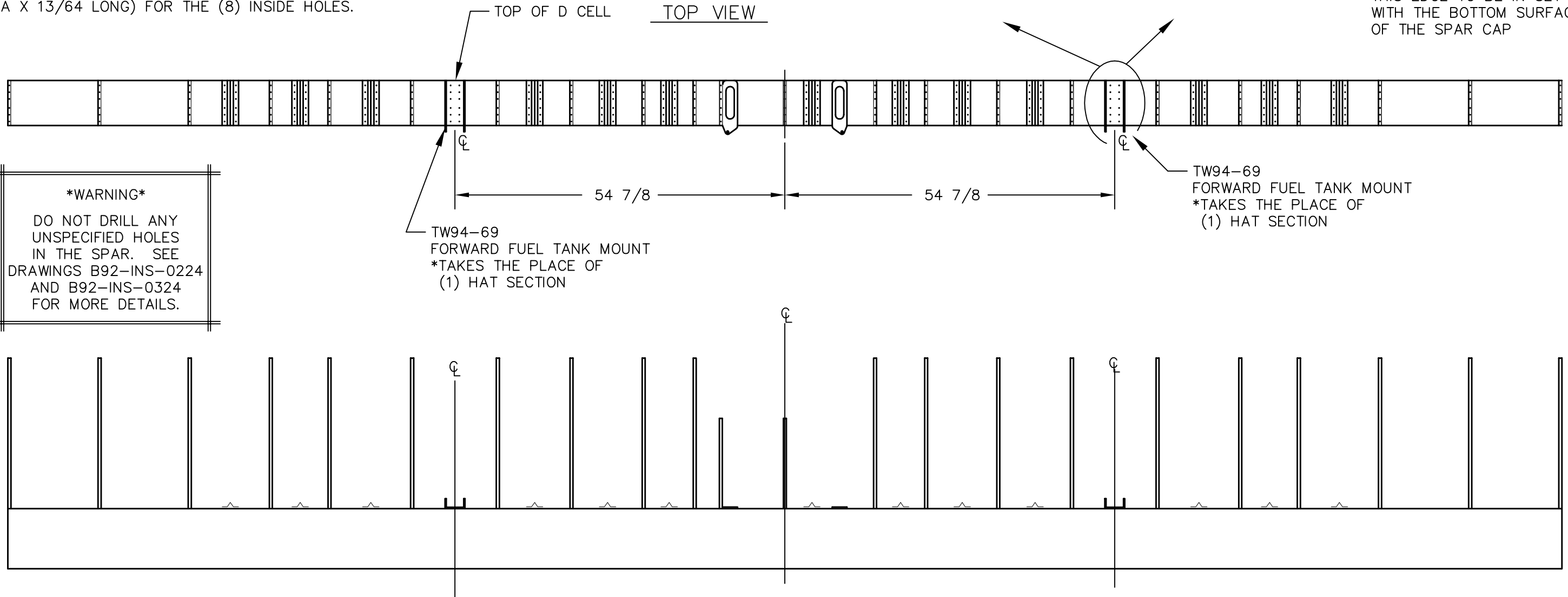
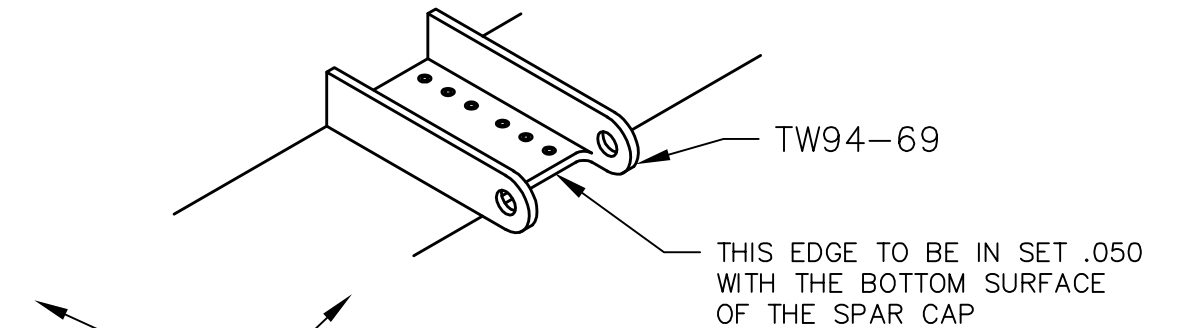


1. LOCATE THE TW94-69 FORWARD FUEL TANK MOUNTS HORIZONTALLY ON THE SPAR USING THE DIMENSIONS GIVEN. THE EARS OF THE BRACKETS SHOULD PROJECT OUT THE BOTTOM OF THE WING, SO THAT THE FRONT EDGE IS INSET .050 WITH THE OUTSIDE OF THE SPAR CAP.
2. WHEN THE MOUNTS ARE IN THE PROPER POSITION, DRILL THE OUTER HOLES WITH A #30 (.1285 DIA.) DRILL, AND CLECO IN PLACE. PAY CAREFULL ATTENTION TO THE HOLE PATTERN SPACING. DRILL THE REMAINING HOLES.
3. REMOVE THE MOUNTS, SAND THE MOUNTING AREA OF THE SPAR, AND CLEAN WITH ACETONE.
4. EPOXY AND RIVET THE TANK MOUNTS TO THE SPAR. SD48BS (1/8 DIA X 41/64 LONG) RIVETS SHOULD BE USED FOR THE OUTSIDE (4) HOLES, AND SD43BS (1/8 DIA X 13/64 LONG) FOR THE (8) INSIDE HOLES.



NOTE!
RIVET HOLE LOCATION
TOLERANCE $\pm 1/16$

| REVISIONS | | | | |
|-----------|------|---------------|----|------|
| E.C. NO. | REV. | DESCRIPTION | BY | DATE |
| | B | CHANGED NOTE | KB | 3/95 |
| 1861 | C | ADDED TW94-69 | KL | 3/01 |



WARNING
DO NOT DRILL ANY UNSPECIFIED HOLES IN THE SPAR. SEE DRAWINGS B92-INS-0224 AND B92-INS-0324 FOR MORE DETAILS.

NOTE: REFER TO DWG. NO. B92-INS-0324 FOR RIB AND HAT SECTION INSTALLATION. ADHERE TO ALL SPECIFICATIONS AND PRECAUTIONS WHEN WORKING WITH THE SPAR.

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

| | | | |
|----------|-------------|------|---------|
| DRAWN | J. SUTCH | DATE | 1/31/94 |
| CHECKED | R. INGLE | DATE | 3/2/01 |
| APPROVED | J. WILLIAMS | DATE | 3/2/01 |

| | | | |
|---------------|-----|---------------------------------|--|
| DETAIL NAME | | FORWARD TANK MOUNT INSTALLATION | |
| SCALE | N/A | PART NO. | |
| ASSEMBLY NAME | | TORNADO WING FUEL TANK OPTION | |
| PART NO. | | DRAWING NO. | |
| DRAWING NO. | | B 94-INS-0422-C | |