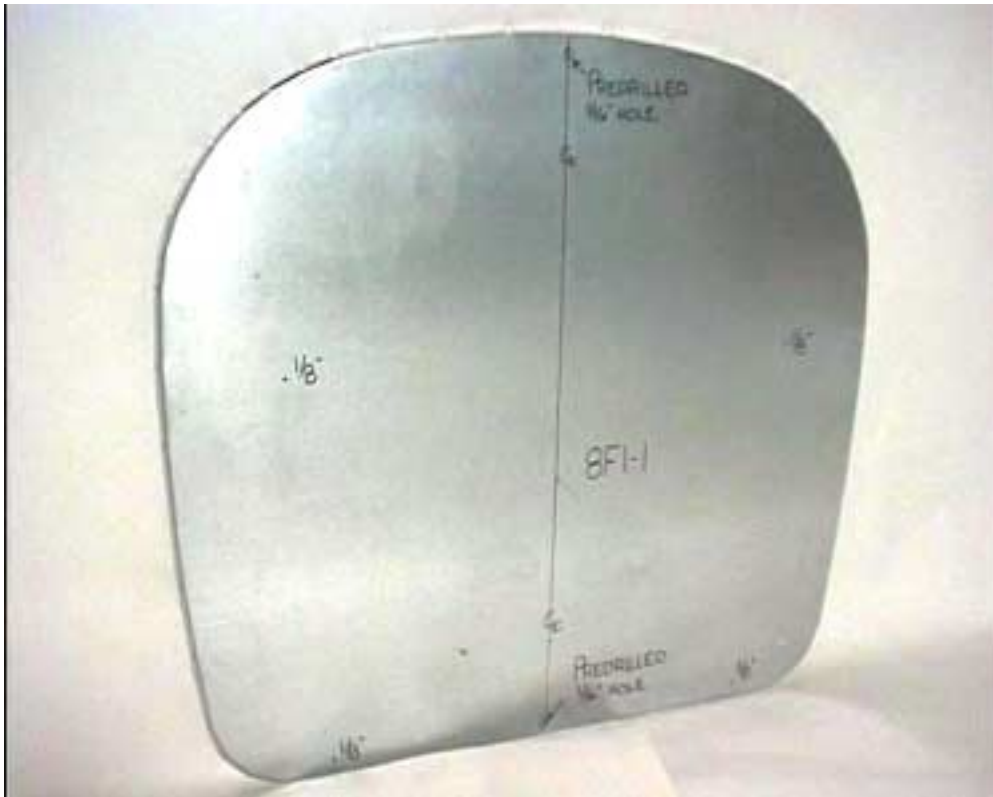


STOL CH 801 FORWARD FUSELAGE ASSEMBLY

SECTION 1 Firewall Assembly: Upper Horizontal 'Z' and Firewall Stiffeners



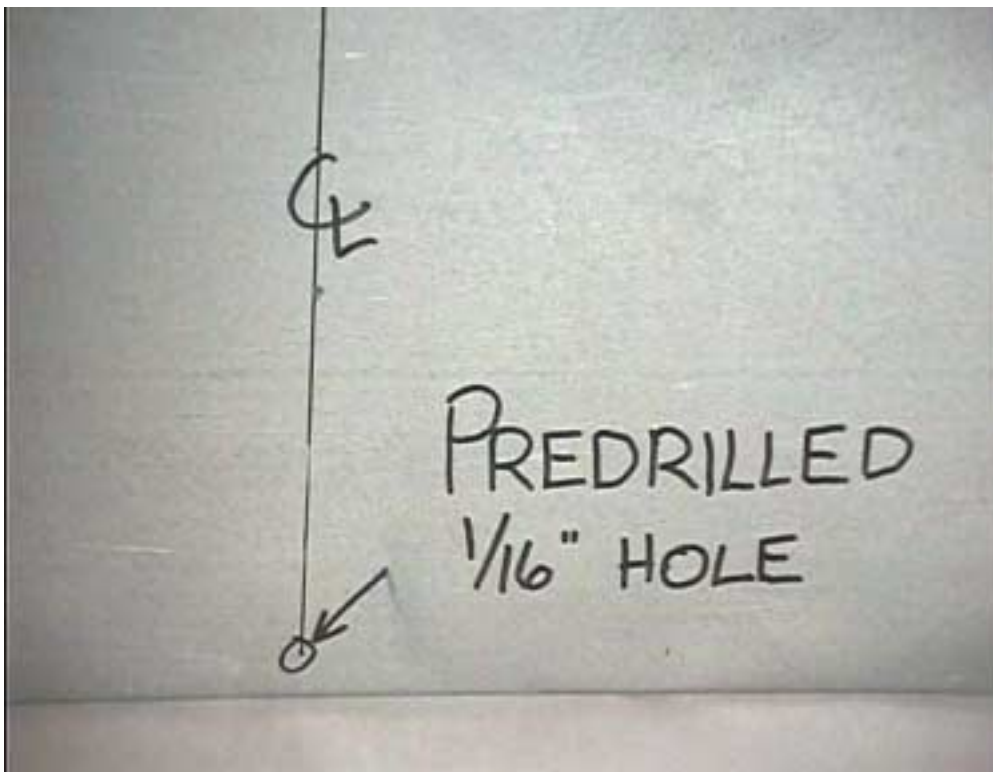
FRONT SIDE



FIREWALL 8F1-1

The firewall is supplied with two 1/16" diameter holes and four 1/8" diameter holes predrilled in it. The 1/8" holes are at the locations of the engine mount bolts. The other two holes are used to layout the vertical centerlines to facilitate the assembly of the firewall

Firewall: galvanized steel.



CHECK: Center line is square to the bottom of the firewall. Equal distance from the center to the engine mount holes (two upper & two lower).

Mark the aircraft center line on both sides of the firewall.



**UPPER HORIZONTAL 'Z'
(FRONT)
8F7-1**

t = .063"

Part supplied formed with the 2" hole for the nose gear pre-drilled.



Layout the aircraft center line.

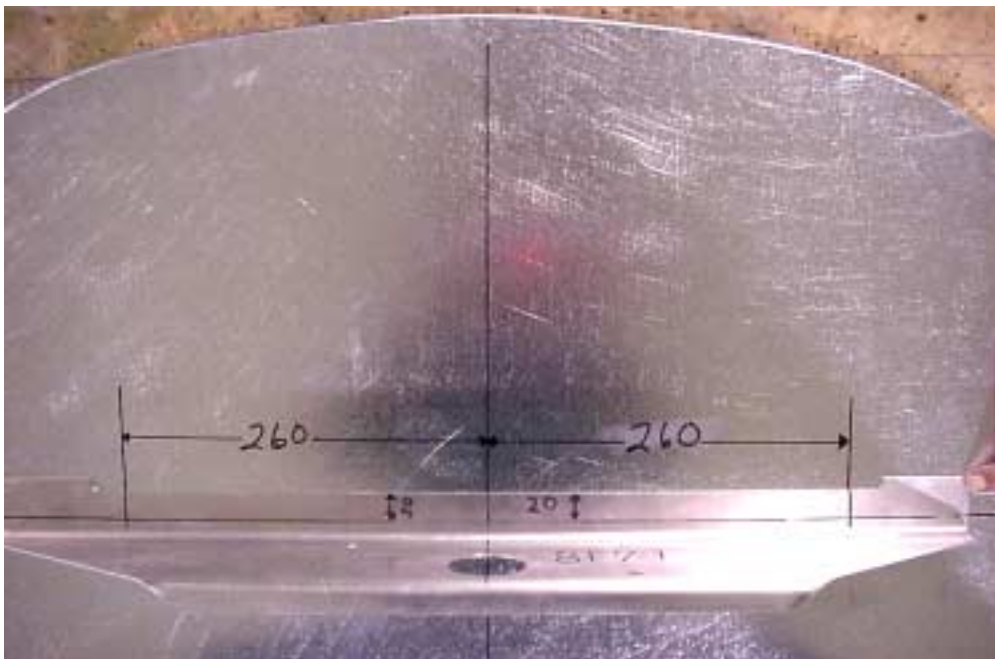
Layout the rivet line,
20mm down from the top edge.

Note: rivet line is not in the center of the flange.



25mm line from the bottom (left and right).

Mark the horizontal centerline of the engine mount bolt holes on the back of 8F7-1.



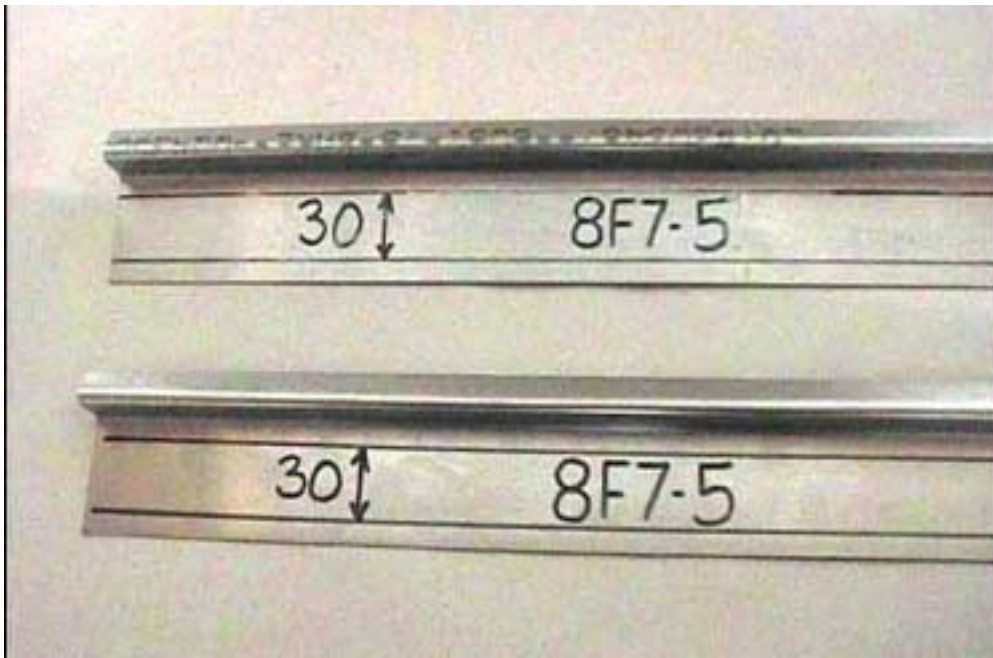
CHECK: Lay a square on the Z to check that it is square with the center line.

Place 8F7-1 on the firewall, aligning the centerlines of the two parts. Vertical positioning is established by viewing the centerline on the back of 8F7-1 through the two pre-located engine mount holes. Drill and Cleco hole through the firewall, Check that the 'Z' is square to the center line, Drill and Cleco the second hole.



Location of the end hole of the rivet line 260mm from center line.

Layout two rivet holes on the rivet line, as shown, Drill & Cleco. Remove the Cleco in the engine mount holes.



**FIREWALL STIFFENERS
8F7-5**

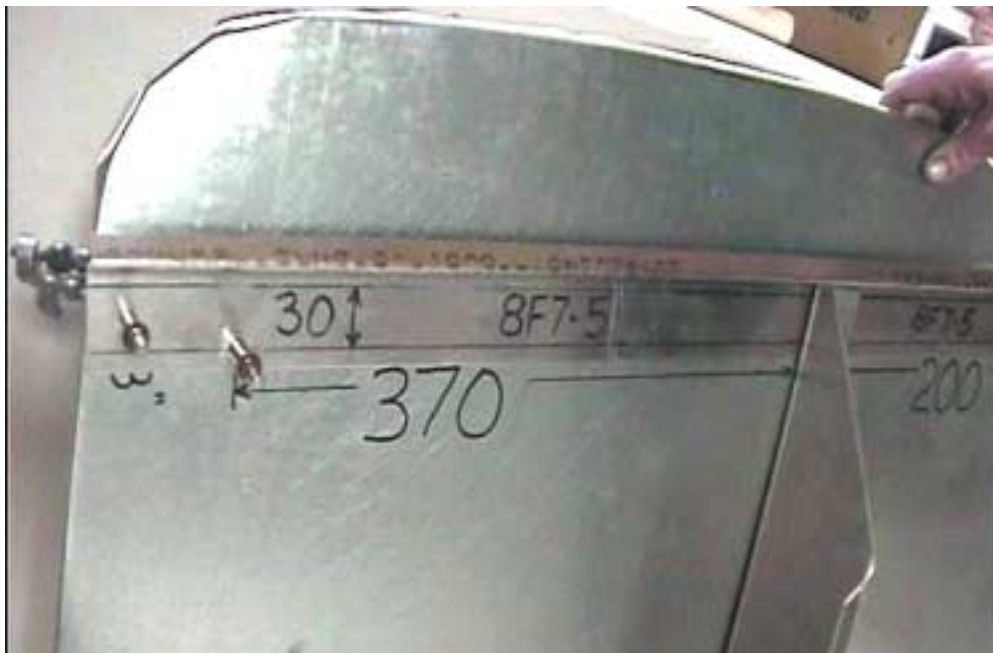
The two parallel rivet lines on the front side of the stiffeners.



The Z flange points outboard.

Mark the center line on the bottom portion of the left and right Stiffeners.

Mark the Center line on the back side of the Stiffener on approximately 100mm (alignment line with the pre-drilled engine mount bolt holes in the firewall)



CHECK: The inboard corner of the Stiffener is even with the bottom of the firewall.

Later the ends of the Stiffener will be trimmed flush with the firewall.

Slide the Stiffener between the firewall and the ends of the Z. Adjust the bottom position by aligning the centerline with the lower engine mount predrilled holes.



Detail of the ends of the Z 8F7-1 overlapping on top of the stiffener
 8F7-1 (the end stops at the bend tangent line, do not push it in too far or 8F7-1 will slide on top of the bend and there will be a gap)

Align the upper end of 8F7-5 next to 8F7-1. Drill and Cleco the four engine mount bolt holes in the left and right Stiffeners (#30 or #40)



Top hole: 200mm from the top edge of 8F7-1

Bottom hole: 370mm from the underside of 8F7-1

Drill two holes on the inboard rivet in 8F7-5, as indicated, and cleco (#30 or #40).