

# STOL CH 801 FORWARD FUSELAGE ASSEMBLY

## SECTION 5 Seat Channels & Bottom Stiffeners



Front seat, viewed from right side.



**FRONT SEAT O/B  
STIFFENER  
8F16-5**  
Qty: 2

Layout the rivet line along  
the top flange of 8F16-5

Orientation: bends I/B

Remove the O/B brackets 8F16-4 to back drill through the Top Panel into the 8F16-5. Drill & Cleco when the rivet line is visible through the pre-drilled holes.



**L ANGLES**  
(Horizontal)

Length = 180mm  
Qty = 2

**5 RIVETS A5**  
Evenly spaced holes in  
both flanges of the L  
angle.

L angle fits in the corner of the Top Panel with the cabin side between the Rear Panel 8F11-11 and the cabin side longeron.

Drill a hole at each end of the L angle and cleco. Drill the other three when the seat panel is removed for deburring.



**5 RIVETS A5**

Photo of rivet line through the cabin sides and the vertical flange of the L angle.

Drilling the cabin sides to the L angles. Five evenly spaced rivet holes (three holes between the clecos shown).



**L ANGLES**  
(Vertical)

Length = 180mm  
Qty: 4

**2 RIVETS A5 in 8F16-5**  
**(each end)**  
**5 RIVETS A5 in 8F11-1**  
**5 RIVETS 8F11-11**

Photo of left side (rear panel 8F11-11) showing the vertical L angle Clecoed to the side of the Stiffener 8F16-5

L angle riveted inside of the Channel inside the front and rear seat panels 8F11-1 and 8F11-11 to the side of the Stiffener 8F16-5.

Note: The horizontal L angle at the top of the photo in the "corner" of the Seat Top Panel and the cabin side.

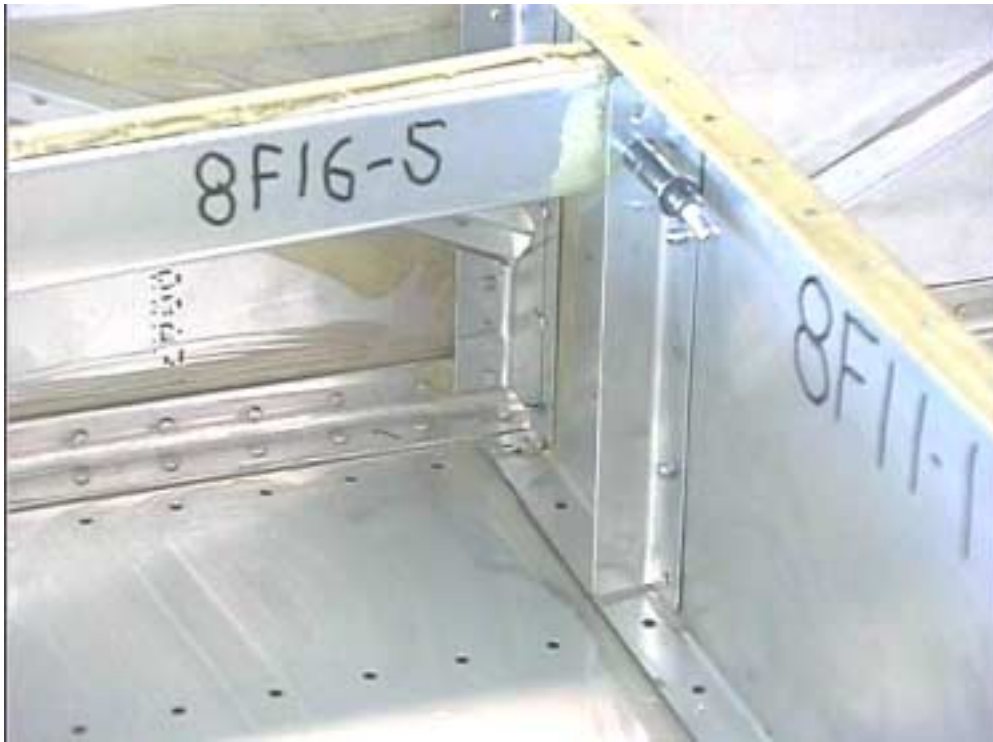


Photo of the vertical L angle at the front of the stiffener 8F16-5

It's easy to drill the top and the bottom holes in the 'L' and finish drilling when the seat panel is removed.



**L ANGLES  
(Vertical)**

Length = 180mm  
Qty: 4

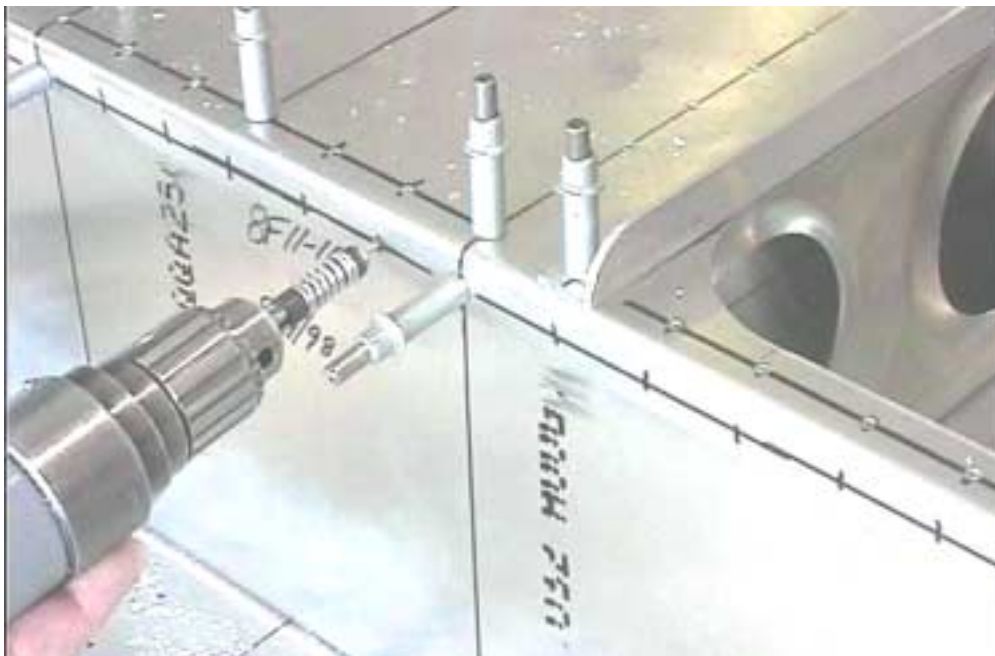
**5 RIVETS A5**  
In each flange.

Vertical L installed on the inside corner of the Stiffeners 8F16-6L & 6R and the Seat Panels 8F11-1 & 11 (front and rear)





Vertical rivet line through L angles



Layout the rivet pitch along the front and rear flange of 8F16-1, drill and cleco #20

### A5 PTICH 30

Open all the holes in the seat panels and std 'L', which is easily accessible from above (we will be turning the whole assembly over soon to drill from the bottom) with a #20 drill, and cleco.



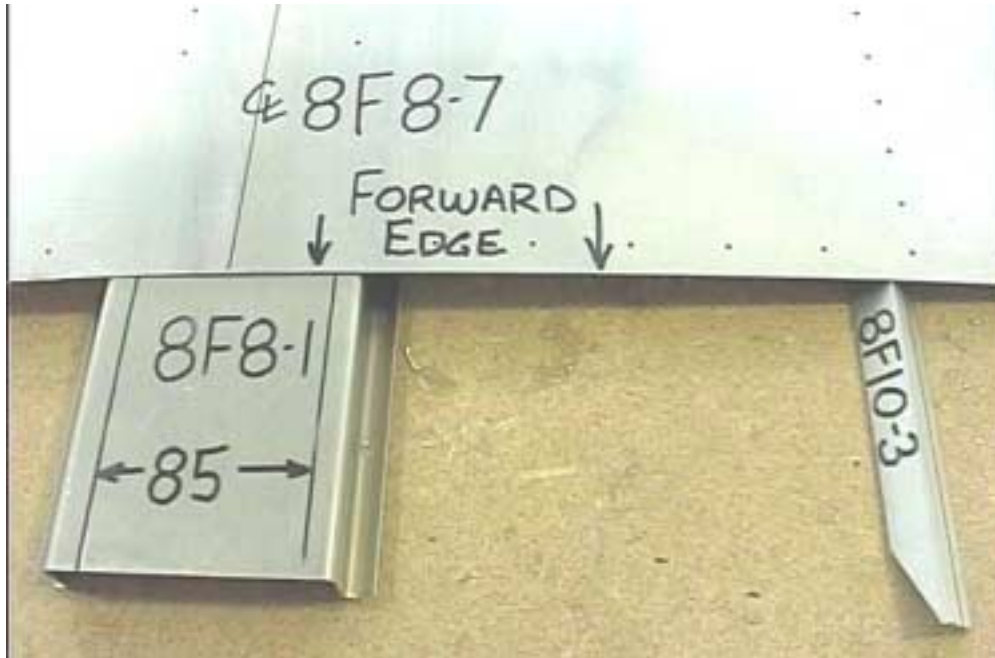
**LOWER LONGERON  
8F10-3  
(Left & Right)**

File the ends smooth (remove saw marks).



The vertical flange is inboard.

Separate the left and right Longerons.



Mark the rivet line on the top side of the Longerons.

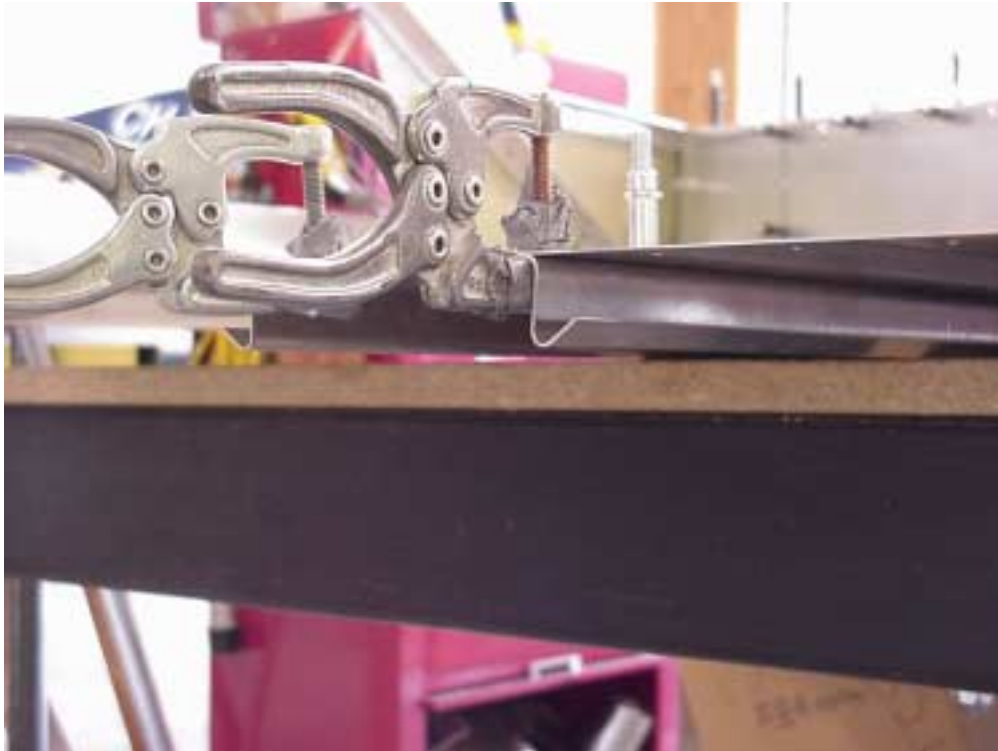
Mark the center line on the Stiffeners.

Clamp the center floor stiffener 8F8-1 and longerons 8F10-3, L & R in place under the skin (over the pre-drilled holes in the floor skin)



**CENTER FORWARD FLOOR STIFFENER 8F8-1**

Note: the Stiffener is the same length



**A5 PITCH 30**

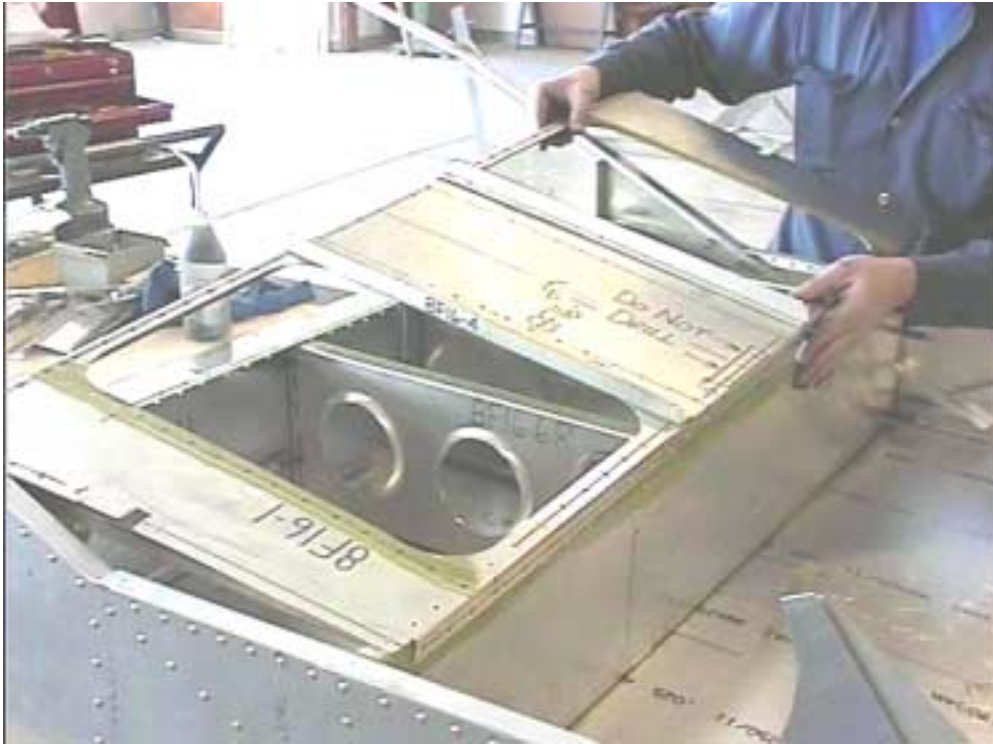
The Both the stiffener and the Longerons are set flush to 2mm forward of the floor skin.

First back drill and cleco with pilot holes 3/32" then open with #20 drill.



Turn the assembly on its side to finish drilling the rivet line through the channels.





Parts being removed.

**All rivets are A5**

Wait to re-assembly.  
In the next section the  
Channels 8F16-10 are  
drilled to the Stiffeners  
8F16-6L

Disassemble and complete the drilling of any portion of std 'L' which was not completed, deburr and rivet the std "L's" in place on the seat panels 8F11-11 and 8F11-1.