

# STOL CH 801 FUSELAGE CABIN ASSEMBLY

## SECTION 2 Firewall and Instrument Panel Position Ref Dwg 8FC-3



- The firewall is installed at 75.5 degrees to the floor skin
- Note: the width of the template is not critical, the purpose of the template is to hold the instrument panel level to the floor skin at 540mm to the floor skin
- The side skins will be installed later after the Cabin Frame is in place.



### FIREWALL TEMPLATE

$\frac{3}{4}$ " Plywood template to hold the firewall at 75.5 degrees to the cabin floor

Note: The extrusion angles are to cleco the firewall and floor skin to the template.

Ref.  
CAD drawing 8FC-3

The cutouts at the bottom are to clear the channels 8C4-5 and 8F8-3  
The larger rectangular cutout is to clear 8F7-7  
The cutout at the top left is for the instrument panel.



### INSTRUMENT PANEL TEMPLATE

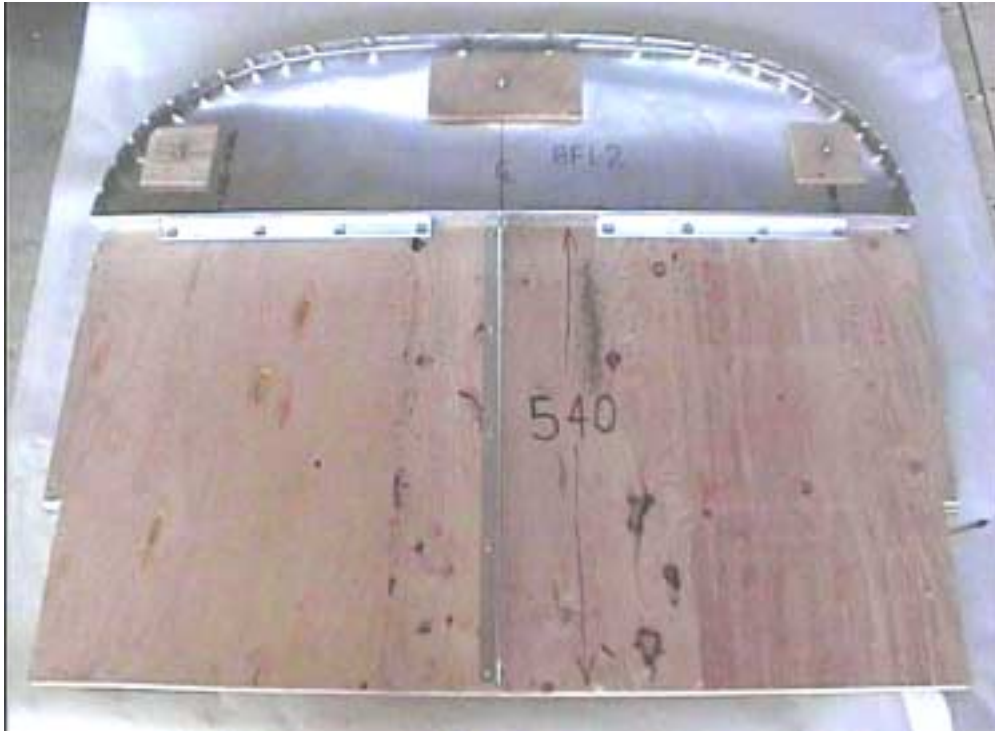
Cut the template from  $\frac{3}{8}$ " or thicker plywood.

Mark the centerline square to the bottom edge.

Screw support angles or boards 540mm from the bottom to support the bottom of the instrument panel.

Note: the curvature of the template is approx. 15 mm smaller than the instrument panel.

Note: the dimension of the template is smaller than the width of the fuselage, the cutouts along the sides are not required.  
**IMPORTANT:** Align the template on the aircraft centerline.



Instrument panel bolted to the backside of the template.

Position the instrument panel on the 540 mm line with its centerline on the vertical centerline of the jig.  
Secure the instrument panel in place using screws.



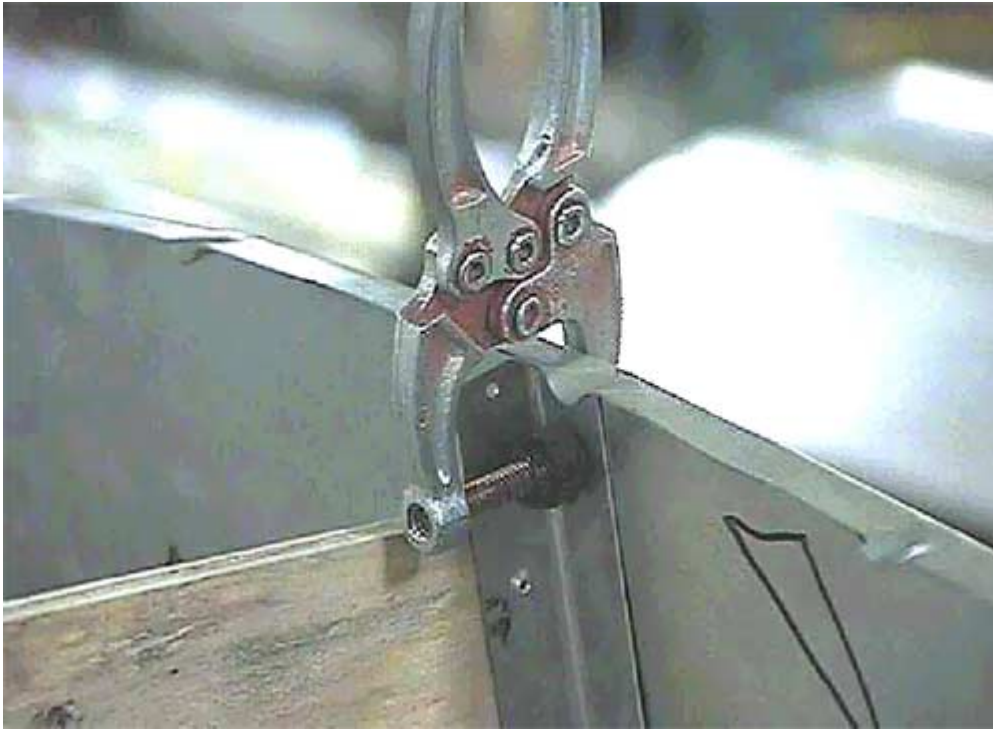
Screw the Instrument panel template A to the Firewall template C, add the template support B to the side of C.

Position the templates on the cabin floor skin, cleco the firewall along the front edge of the cabin floor.

Cleco the firewall to template C

Line up the centerline on A with the aircraft centerline.

Cleco the firewall to the cabin floor skin.  
This is how things should be placed (the sides skins are installed after the cabin frame is positioned)



A short piece of std "L" can be used to clamp the jig to the firewall.



Notch the lower edge of the jig to make room for lower angle 8F7-8

CHECK: The Upper Horizontal Z is level; the bottom of the instrument panel is also level.

Push the jig forward by placing a wedge between it and the forward most floor stiffener.