

# STOL CH 801 FUSELAGE CABIN ASSEMBLY

## SECTION 5 Engine Mount Brackets



8F7-7 used as a convenient mounting tray for accessories: filter for vacuum pump, shunt, and transponder encoder

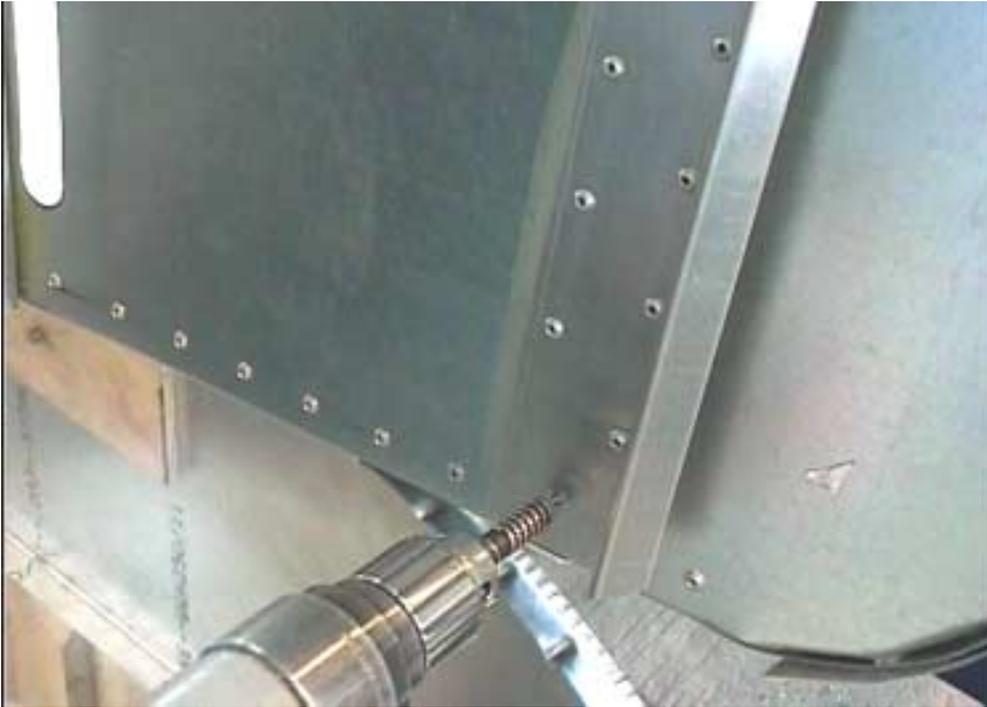


**LOWER ENGINE MOUNT  
BRACKETS  
8F7-12**

Layout the centerline on the lower engine mount bracket 8F7-12



The mounts are positioned by placing the vertical centerline behind the 1/8" engine mount location hole on the firewall.



Have an assistant hold the bracket in place, pressing firmly into the firewall and down on the floor. Drill through the 1/8 hole in the firewall and cleco.



**AN3-5A Bolts**  
Qty: 6  
(3 in each engine mount  
bracket 8F7-12)

Drill the three holes from the underside and cleco.  
Add a .040" shim between the engine mount bracket 8F7-12 and the floor skin.



Bolts Lower Engine Mount brackets 8F7-12 and the Lower Longerons 8F10-3



UPPER ENGINE MOUNT BRACKETS 8F7-11

The upper engine mount bracket is part 8F7-11. Layout the centerlines and drill these holes with a 3/32 drill bit.



Take steps to ensure the location of the holes do not drift while opening them to 3/8" diameter.

Open the engine mount bolt holes of the mounts and the firewall to 3/8" diameter.



Bottom 3/8" holes.



**UPPER HORIZONTAL  
'Z' REAR  
8F7-7**

The shorter 20mm flange is at the back and points up.

The Longer 30mm flange overlaps the back of the firewall and points down

Note: The ends are tapered.



Position the Upper Horizontal Z rear 8F7-7 on top of the “front cabin side Longerons” with the 30mm flange pointing down against the firewall.

Temporarily bolt the two mounts to the firewall with a 3/8” bolt.

**AN3-4A Bolts**

Qty: 6  
(3 in each engine mount bracket)

Clamp 8F7-7 to 8F7-11. Check that there is no gap between 8F7-7 and the firewall.

Drill the three 3/16” holes in each upper engine mount bracket 8F7-11 into the Upper Horizontal Z rear 8F7-7. Temporarily bolt the mounts to 8F7-7.



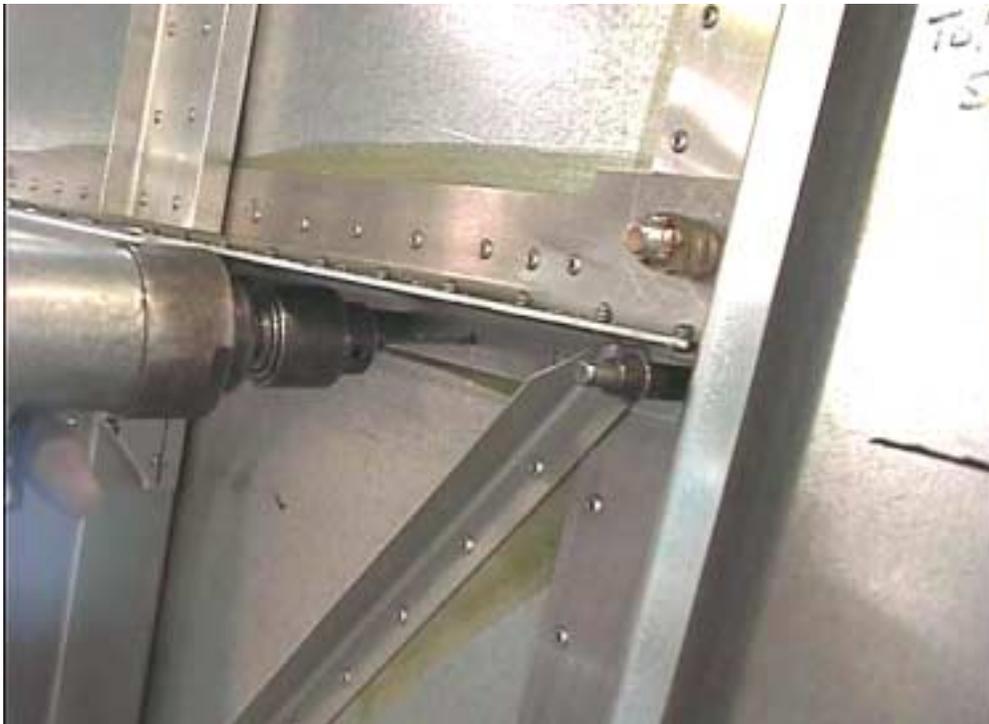
Clamp the cabin side extrusions to the underside of 8F7-7 Check that the Longerons made contact with the side skin

Layout and drill ten evenly spaced #20 holes, drill and cleco.

**10 RIVETS AS5**

Stainless steel rivets AS5, qty: 10, each side, riveting the ends of 8F7-7 into the cabin side longerons.

First drill pilot holes and Cleco.



Drill through the L angle (riveted to the underside of 8F7-1 on the front side of the firewall) into the 30mm flange of 8F7-7

**A5 PITCH 40**

COMMENT: If the engine mount is available, this would be a good time to bolt the engine mount to the firewall.



**A5 PITCH 30**  
(Side skin and the  
Longeron)

**A5 PITCH 40**  
(Side Skin into the firewall  
flange - between the  
crimps)

Layout the rivet line for the forward cabin side Longeron in the cabin side skin.

Drill & cleco the skin and firewall rivet holes with a nominal pitch of 35 - 40.  
Avoid the crimps on the firewall.