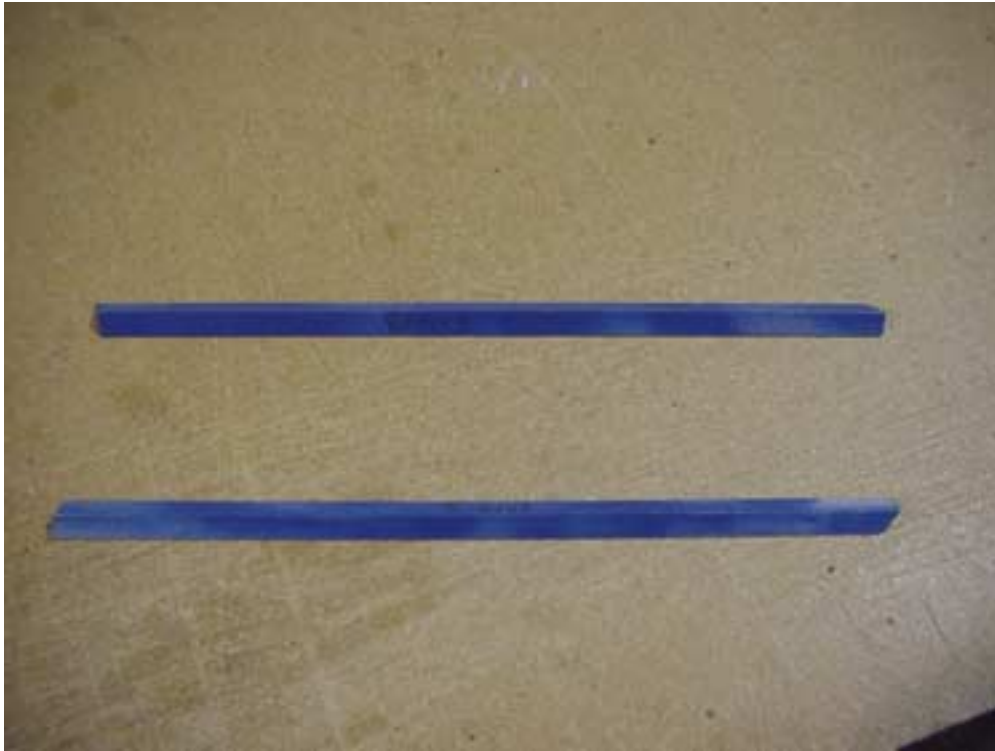


# STOL CH 801 FUSELAGE CABIN ASSEMBLY

## SECTION 6 Forward Gussets



Gussets at the end of the side tube on the cabin frame



**FORWARD SIDE SKIN  
LONGERON  
8F14-8**

Left and right Longerons, the ends of the top flanges are cut at 90 degrees, the sides are cut on an angle.



The aft end fits in front of the side tubes of the cabin frame, the front end of the Longeron overlaps the flange of the firewall.

Clamp the top flange of the Longeron 8F14-8 to the bottom flange of the instrument panel.

End hole 10mm from the aft edge of 8F14-8 and cleco. Drill one hole at each side of the instrument panel where it sits on the extruded "L" 8F14-8.



Location on the firewall:  
Level the top surface of  
the Longeron 8F14-8

Wait to trim the overhang  
of the side skin until after  
the Top Skin is installed.

Drill one hole into the firewall flange and 8F14-8.  
Do not drill any other holes in 8F14-8 at this time.



**INSTRUMENT PANEL  
GUSSET  
8F15-2**

Left and right gussets; the flange is installed pointing up. The long side is  
O/B.



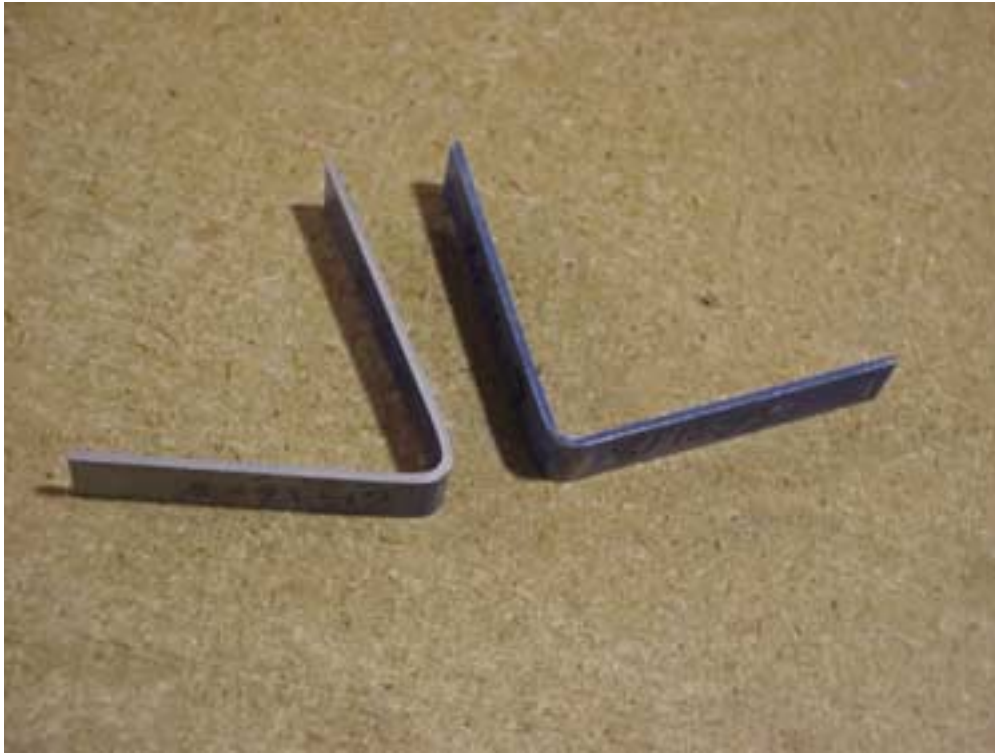
Note the cleco in the corner beside the instrument panel.

Drill the rear O/B hole in 8F15-2 before installing that part.

Re-install the instrument panel with 8F15-1 attached and cleco the parts in place along with the gusset 8F15-2.



Drill the rivet holes to secure the gusset to the instrument panel and the longerons. Open holes with a #20 drill.



**CABIN FRAME BOTTOM  
REAR GUSSET  
8F16-8**

**CABIN FRAME BOTTOM  
FORWARD GUSSET  
8F16-9**

Qty: 2 of each required



End hole 10mm from the end, the two holes pitch 20

Drill a total of three 5/32" holes in each leg of the doublers.



**2 RIVETS A5**

In each leg of each Gusset.

Insert an AN3 bolt in the hole near the bend:

Carefully locate the centerline of the side tube in the middle of the flange.



**5 RIVETS A5**

Cabin side in the cabin frame.

**8 RIVETS A5**

Side Skin in the cabin frame.

Drill the Front Side Skins 8F14-3 to the Side tube on the Cabin sides.  
**IMPORTANT:** Keep the rivet line in the middle of the tube.



### CABIN FRAME GUSSET 8F10-5

The overhang of the cabin side skin is trimmed 10mm from the rivet line in the side tubes.

Install the gusset 8F10-5 between the cabin frame and the cabin side skin.  
Back drill and Cleco.