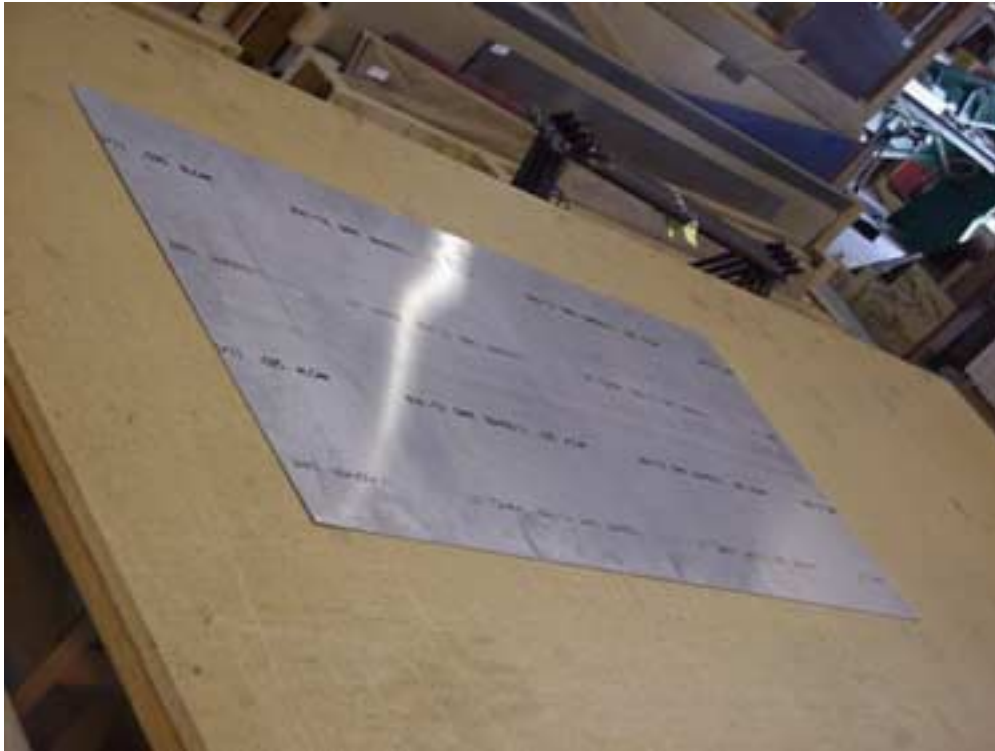


STOL CH 801 FUSELAGE CABIN ASSEMBLY

SECTION 7 Forward Top Skin



Skin over the instrument panel and the firewall.
The bottom edge is trimmed after the skin is drilled.



**INSTRUMENT PANEL
TOP SKIN
8F14-4**

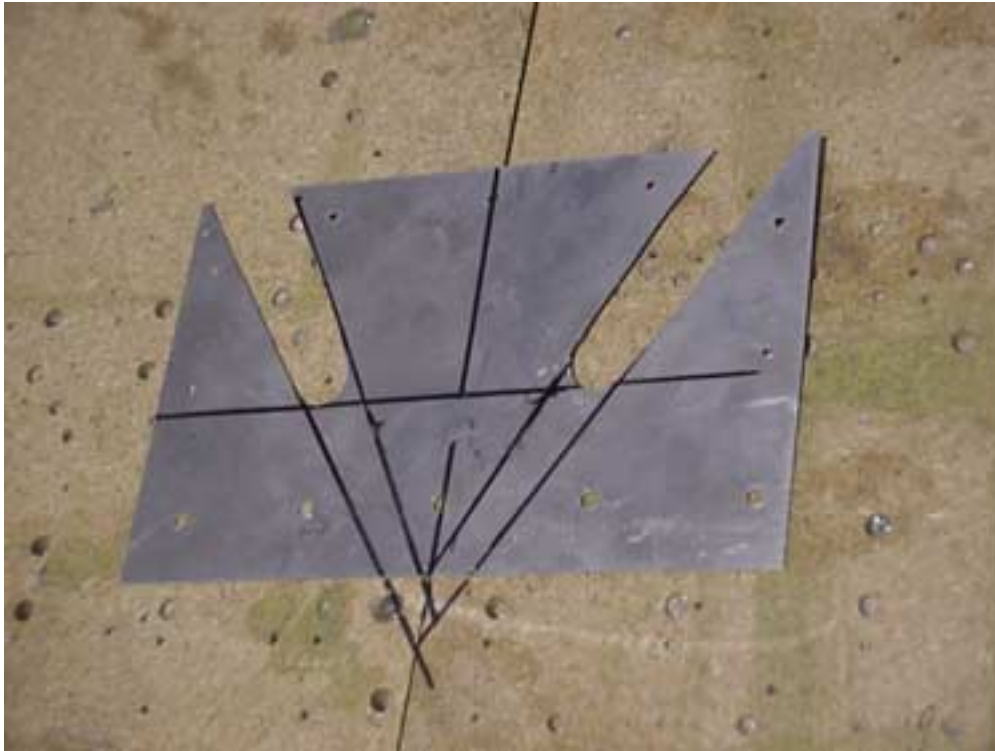
Mark the centerline along the long side.



Mark a line at 65mm from the aft edge along the centerline (through the rivet line of the instrument panel).

Measure between the rivet line in the instrument panel and the rivet line in the firewall: layout the distance from the 65mm line (approximately 435mm)

Drill pilot holes on the aircraft centerline through the rivet line in the instrument panel and the firewall



**INSTR. PANEL TOP
COVER PLATE
8F14-9**

Layout the centerline
along the long side
(190mm)

To the left and right of
center line layout:
55 & 80

From the top edge along
the center line, layout:
105 & 125

Join the 55 and 105 line
Join the 80 and 125 line

Mark a depth line 55mm
from the top edge.

Firewall rivet line to the aft
edge of the plate = 85mm

Size: 190x120mm

Cutout to make room for the front tube welded on the cabin frame.
Use the cutout on 8F14-9 to layout the cutout on the top skin 8F14-5



NOTE: the hole on the
centerline at the end of the
triangular point.

Trace the cutout. Remove
8F14-9 to extend the lines
to the edge of the sheet.

SUGGESTION: make a
paper template first.

Cleco 8F14-9 to the corresponding hole on the centerline.



8F14-9 will overlap on top of 8F14-4.



Layout the rivet pitch, locate the rivets between the crimps on the firewall and for the instrument panel.

PITCH 40

Pre-drill the holes on the instrument panel and firewall flange.

Mark the rivet line 10mm from the edge.



Work one side at a time:
Either use a hole finder
and drill down from the
top, or tape the bottom
edge to the side skin, and
drill up through the pilot
holes in the flange.

Cleco the top skin through corresponding holes on the centerline.



Drill & Cleco one side,
then the other.

A5 PITCH 40

Into the firewall 8F1-1,

A4 PITCH 40

In the Instrument Panel
8F1-2

Another way is to raise one side of the skin to drill through the pre-drilled pilot holes into 8F14-4.



A5 PITCH 30

Layout along the bottom edge into the Front Side Skin 8F14-3 and the Forward side Skin Longeron 8F14-8.

Open all holes that have been drilled with a #20 drill except for the holes in the top flange of the instrument panel - these are opened to #30 drill size.



Do not trim the skins any longer than 3mm past the firewall as the increased length will make forming the bend later very difficult.

Mark the inside edge of the side and top skin 3mm past the firewall for trimming.