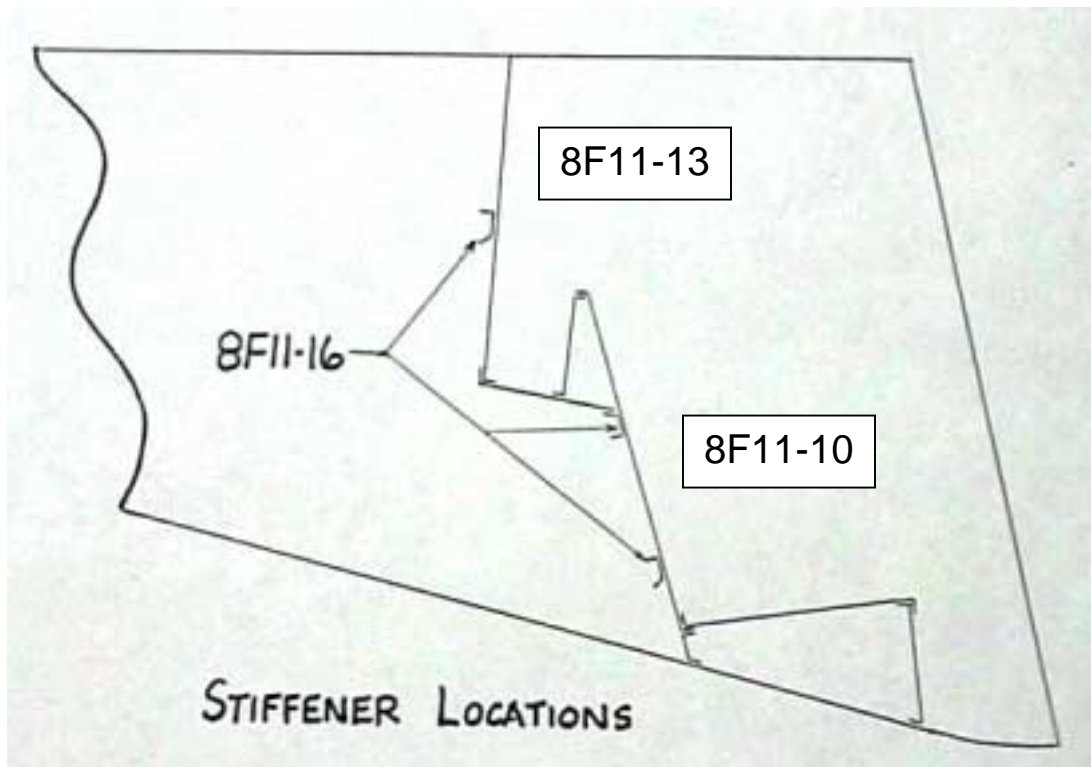


STOL CH 801 REAR FUSELAGE ASSEMBLY

SECTION 7 Baggage and Rear Seat Panels



Drill with #40 pilot holes. When all the parts are installed in this section, go back and open up the holes for the specified rivet size. Also check the rivet pitch that no rivet is overlooked.



**BAGGAGE BACK
PANEL
8F11-13**

Mark the aircraft center line square to the top and bottom flange.
Mark the rivet line across the top of the top flange.

Top flange points towards the rear, front flange points forward.

Identify and mark the orientation of the part.

The cutouts are in the top flange. The pre-drilled holes are in the bottom flange.



**BAGGAGE FLOOR
8F11-15**

Installed with the rear flange pointing down.

Layout the aircraft center line square to the aft flange.

On each side of the center line layout a line 67mm (rivet line for the Horizontal Tail Bearing Support Channel 8C1-2)

Identify the part orientation.

The corner cutouts are along the front edge to make room for the Upright channels 8F5-9



Line up center line.

A4 PITCH 40
In each flange

Sub assembly: Clamp the flanges together, drill and Cleco each flange through the pre-drill pilot holes.
Disassemble to install the Baggage Back to the fuselage.



8F11-13 fits behind 8F5-10 and uses the same rivet holes in the top skin.

CHECK: the corner cutout in the Baggage Back Panel clears the Uprights 8F5-9

Detail of top corner: the top flange of the Baggage Back Panel 8F11-13 overlaps on the underside of the Top Rear Channel Stiffener 8F5-10. The top flange is back drilled through the existing pilot for the rivet line in the top skin and the Stiffener.



Position of 8F11-13
Line up the aircraft center lines.

The top flange points back and overlaps with the fuselage top skin.

Clamp the sides of the Baggage Back to the L angle riveted to the fuselage side skin.

Layout pitch 40 on the L angle

Back drill and Cleco the upper flange through the pilot holes in the top skin from above the aircraft with the helper holding a wood block inside the fuselage.

Hold a block of wood against 8F11-13 while the helper drills from the inside. Drill the left and right sides of 8F11-13.



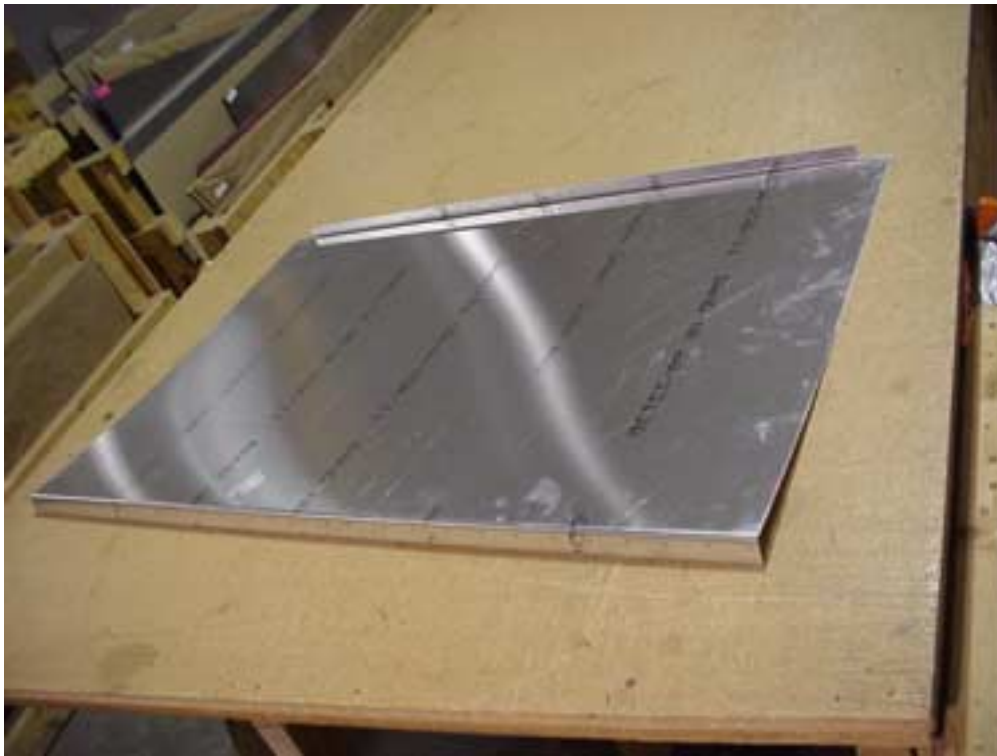
A4 PITCH 40

Seat Back Panel 8F11-13
Through top skin 8F2-1
and Stiffener 8F5-10

A4 PITCH 40

Seat Back Panel 8F11-13
In vertical L Angle on
Fuselage Side skin.

Un-Cleco the seat back, remove the plywood jig, re-install the seat back and cleco.



**REAR SEAT BACK
8F11-10**

Layout the aircraft center line square to the top and bottom flange.

The rivet line 155mm from the bottom is for the bottom Stiffener 8F11-16.

Cut outs are in the top flange.



**BAGGAGE FRONT
PANEL
8F11-14**

Layout the aircraft center line square to the top and bottom flange.

Also mark the rivet line on the top side of the top flange.

Identify and mark the orientation on the part:
The cutouts are in the top flange.
The pre-drilled holes are in the Bottom flange.



A4 PITCH 40

Through the top flanges

Disassemble to install the Seat Back to the fuselage

Sub assembly: Clamp the Front Panel 8F11-14 underneath the back side of the top flange of the Seat Back 8F11-10. Check that the center lines are in line. Drill and Cleco when the rivet line is visible through the predrilled holes.



Position 8F11-10
The bottom flange overlaps on top of the Rear Seat Panel 8F11-9

The sides overlap on the front side of the Upright Channels 9F5-9

A5 PITCH 40

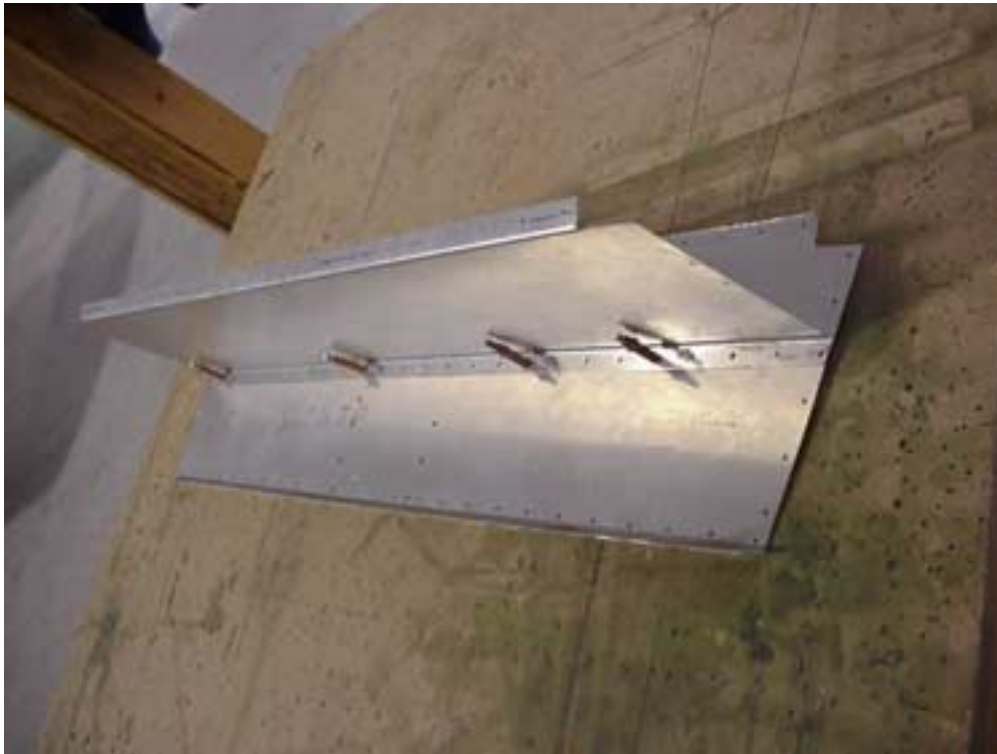
Bottom flange of 8F11-10 in the top side of the Seat Panel 8F11-9

A4 PITCH 40

Side of 8F11-10 in the Upright Channels 8F5-9

Note: 150mm is the distance from the aft edge of the flange on 8F11-10 to the Back Panel 8F11-13

NOTE: The sides of the Seat Back do not reach to the fuselage side skin, the overlap with the Upright Channel 8F5-4 is approximately 35mm.



Drill and Cleco the Front Panel 8F11-14 to the Baggage Floor 8F11-15

Layout the rivet line parallel to the aft flange 140mm from the aft edge of the flange

(150mm = distance from bent to bend)

A5 PITCH 40

Note: plan for a rivet at the intersection with the 67mm lines.

Sub assembly. The cutouts are towards the front.
 Note: The Baggage Front Panel 8F11-14 is parallel to the Baggage Back Panel 8F11-13



L angles are used to connect the top of the Channel Supports 8C1-2 to the Baggage Floor 8F11-15

A5 PITCH 40

(The end holes are drilled through the rivet line for 8F11-16 and 8F11-13)

Note: 8C1-2 is installed from inside the fuselage with the Rear Seat Back Clecoed in place.

COMMENT: Use the 118mm spacer block shown on drawing 8FR-2 to drill the two L angles to the underside of the Baggage Floor 8F11-15 (centered on the aircraft center line, flanges are installed with the bend I/B, cut the length of the L angles flush with the edge of the skin)



Re-install the baggage floor 8F11-15 and the Baggage Front Panel 8F11-14

Check that the corner cutout does not interfere with the Upright 8F5-9



REAR SEAT BACK STIFFENERS 8F11-16

Layout the aircraft center line in the middle.

Mark the rivet line between the two flanges, on the front side (flanges are installed towards the back)

Supplied length = 940

Note: The rear fuselage is wider at the bottom than at the top, the Stiffeners will have to be trimmed to fit between L angles and Upright Channels 8F5-9



From inside the fuselage
Mark the position of the
Baggage Floor 8F11-15
on the side of the Upright
Channel 8F5-9. If
necessary trim back the
front edge of the skin to
allow for a few millimeters
clearance.

Remove the Seat Back
Panel to Clamp the
Stiffener 8F11-16
underneath the Baggage
Floor.

A4 PITCH 40
8F11-16 to 8F11-15

Cut the length of the Stiffeners to fit between the Upright Channels, length approximately 915mm
Check: The Stiffener is flush to the Upright Channels.



Mark the center line of the
Stiffener to the O/B edge
of the Upright Channels.

Re-install and Cleco the
Seat Back Panel 8F11-10

Layout the rivet line for
the Stiffener 8F11-16

A4 PITCH 40
8F11-16 to 8F10-11

Note: Set the Clecos in the Stiffener from the bottom.



file F100-58

Photo F5-32

Have a helper with a wood block on the opposite side hold the skin while drilling.

An alternative is having an assistant hold the Stiffeners from inside the fuselage, first drill through the Seat back. Then from inside, drill up through the top flange of the stiffener into the baggage floor.



Drill & Cleco the Stiffener 8F11-16 to the Baggage Back Panel 8F11-16 (Pre-drilled pilot holes approximately 325mm up from the bottom flange).

A4 PITCH 40

Check: The length of the Stiffener fits between the L angles, length approximately 930mm



A4 PITCH 40

Drill & Cleco the Stiffener 8F11-16 to the Seat Back 8F11-10
Pre-drilled pilot holes approximately 160mm from the bottom flange.



Rear fuselage

Tip: The fuselage overhangs past the edge of the work bench to gain entrance into the bottom access panel to install 8C1-2 in the next section.