

STOL CH 801 REAR FUSELAGE ASSEMBLY

SECTION 8 Baggage and Rear Seat Stiffeners



Rear Seat Stiffeners



**REAR SEAT PANEL
8F11-9**

Mark the orientation on the part:

The lightening holes are towards the front, they are flanged down: the front flange points down (the front flange is longer than the rear flange), the rear flange points up.



Sub-assembly:
Clamp the flanges together; Check that the centerlines line up.

Note: the two parts are not the same width: the outside edges do not line up.

A5 PITCH 40
8F11-10 to 8F11-9

Two rivet lines, one in each flange (the bottom rivet line will also rivet into 8F11-8)

OVERLAP

Remove the Seat Back 8F11-10 from the fuselage. The Seat panel overlaps on top of the bottom flange of the Seat back.



End hole: intersection of rivet lines (similar to the rivet line along the front edge of the seat panel)

With a straight edge and marker, extend the line of the pre-drilled pilot hole in the Seat Panel to aft flange. If there is not rivet at the intersection with the rear rivet line, drill a hole at the intersection, this will be the end hole for the Rear Seat Bottom Stiffeners 8F11-12



**REAR CENTER SEAT
BELT ATTACHMENT
8F6-1**

Prime steel parts to prevent rusting.

Steel welded assembly, 5/16" pre-drilled hole in the 1/8" plate.

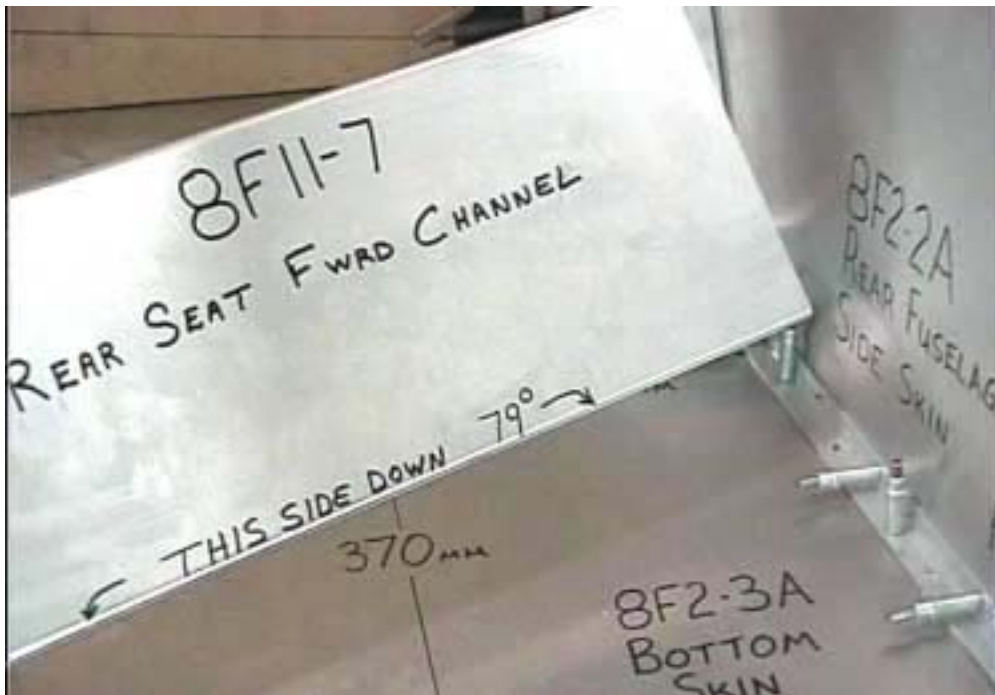


2 BOLTS AN3-4
(End holes in 8C1-2)

Plus

10 RIVETS A5
(4 rivets in the top flange
& 6 rivets in the top
flange)

8F6-1 is centered on the aircraft center line, overlaps on top of the seat panel 8F11-9
The end holes will pick up through the Support 8C1-2 or 67mm from the aircraft centerline.



Also Cleco the Seat Back 8F11-10 to the Upright Channels 8F5-9

Re cleco the rear seat forward channel along the front edge of the bottom skin.



Cleco the Seat Panel 8F11-9 to the Seat back 8F11-10 and to the Seat Rear Channels 8F11-8

The front flange overlaps on top and the front side of the Rear Seat Forward Channel 8F11-7

Check: The Sides are tapered to match the sides of the fuselage skin.

The Rear Seat Panel 8F11-9 is installed next.

Disregard the Clecos at the rear of the seat panel in this photo, the seat back is not shown in this photo.



A5 PITCH 40

Front flange of 8F11-9 to 8F11-7

SUGGESTION: Before removing the seat Bottom from the fuselage, mark the location of the pre-drilled holes for the channel on the Seat back and on the Front Channel (identify the intersection holes)

From the back, push the Channel 8F11-7 forward against the bottom flange of the Seat Panel 8F11-9. Drill & Cleco



**REAR SEAT BOTTOM
STIFFENER
8F11-12**

Qty: 4

Photo to show orientation of flanges:
Note that the center channel is placed on its back with 2 rivet lines. The I/B channel has the bends I/B, the O/B has the bends for the flange O/B

Stiffener installed on the under side of the Rear Seat Panel 8F11-9



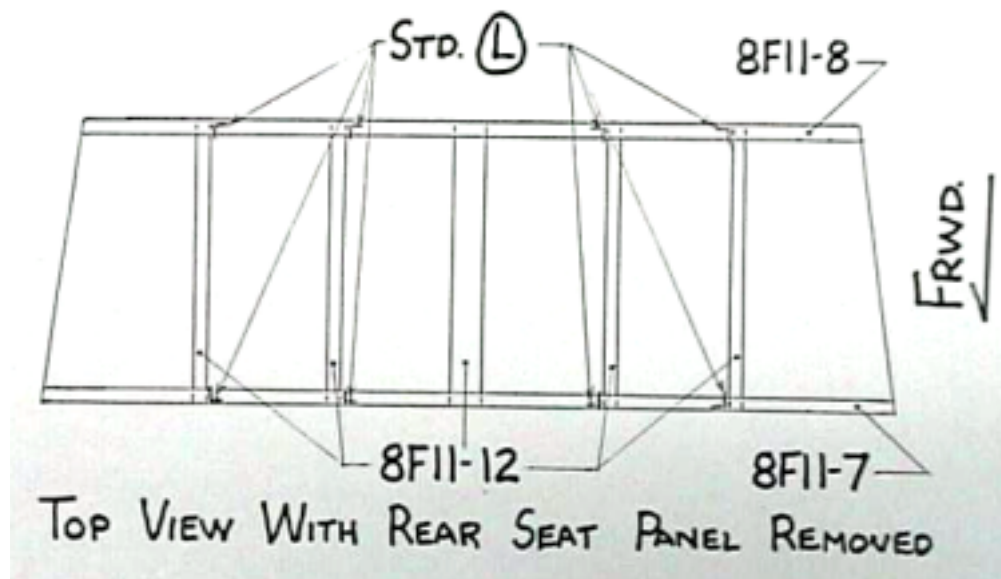
A5 PITCH 40
8F11-12 to 8F11-9

Note: the end holes are on the intersection with the front and rear rivet lines.

Drill through the pre-drilled pilot holes when the flange rivet line is visible.
Cleco the channels, do not rivet until after the controls are installed.



Remove each Channel one at a time and cleco them through their corresponding end holes in the Forward Channel 8F11-7 and Rear Channel 8F11-8



Note: There are no L angles on the middle Stiffener.

Not shown in the diagram are the L angles to tie the ends of the Channels to the Fuselage Side Skins.

L angles:

Qty: 6, length = 57mm (to fit inside the Rear Channel 8F11-8)

Qty: 6, length = 197mm (to fit inside the Front Channel 8F11-7)



2 RIVETS A5

L angle and 8F11-12

2 RIVETS A5

L angle and 8F11-8

L angle riveted to the side of the stiffener and inside the Rear channel



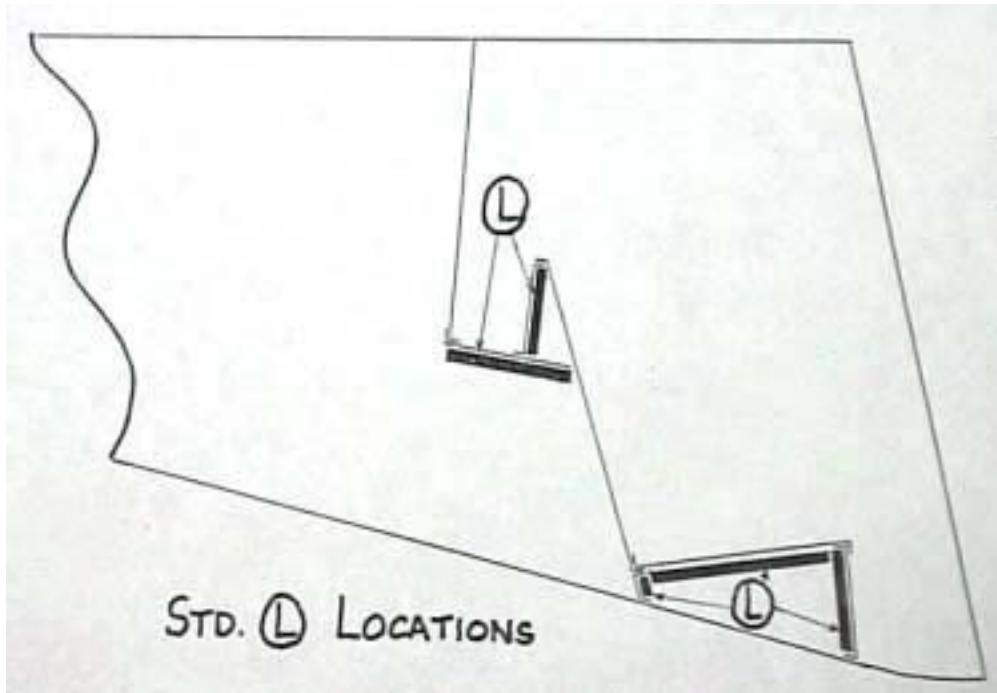
2 RIVETS A5

L angle and 8F11-12

5 RIVETS A5

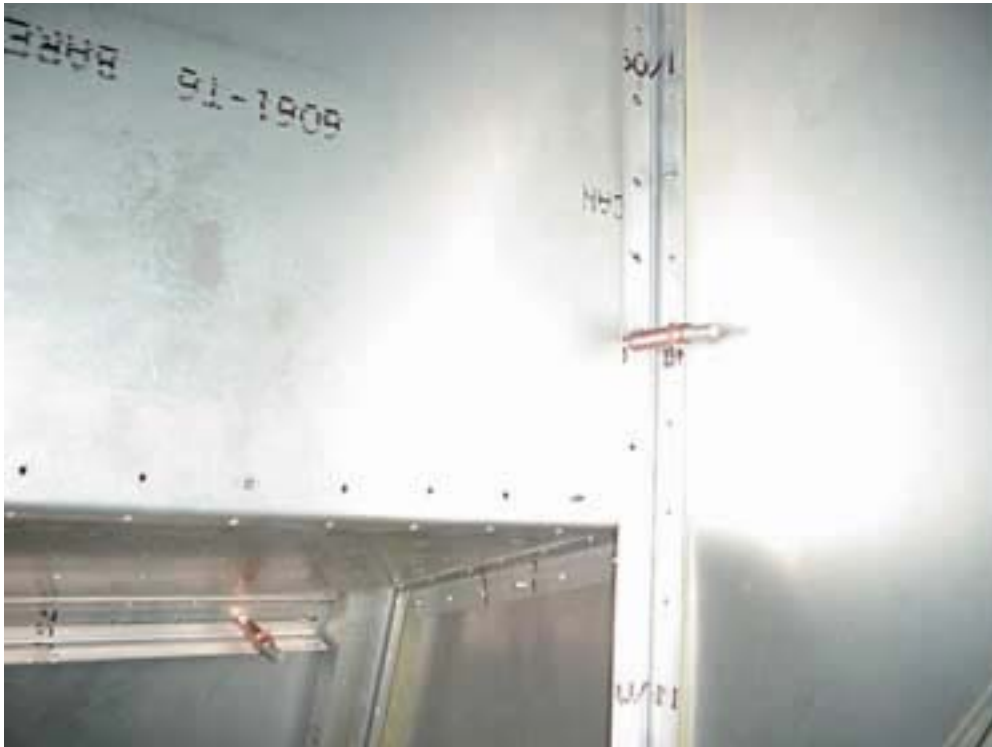
L angle and 8F11-7
 (The top rivet is through the rivet line with the Seat panel 8F11-9)

L angles on the Rear Seat Forward Channel
 Qty: 4



L angle rivets to the fuselage side skin

Note: The L angle in the corner of the Baggage Front Panel 8F11-14 with the fuselage side skin can be installed on the back of the panel instead of on the front side as shown above.



A4 PITCH 40

L angle in the fuselage side skin 8F2-2A and the Baggage Floor 8F11-15

A4 PITCH 40

L angle in the fuselage side skin 8F2-2A and the Baggage Front Panel 8F11-14

Inside view of right side, L angle in the corner of the fuselage side skin and the baggage floor.



A5 PITCH 40

In each flange: In fuselage side skin 8F2-2A and Seat Panel 8F11-9

L angle flush to the Seat Channels riveted to side skin.



Detail of Stiffeners with the seat panel and seat back removed.

Position of the Rear Side Seat Attachment 8F6-2 in installed in next section.