

STOL CH 801 REAR FUSELAGE ASSEMBLY

SECTION 9 Rear Seat Belt Attachment; Horizontal Tail Bellcrank Bearing Support Channels



Behind the rear seat back



March 2002 change to part numbers

Ref. CAD drawing 8XF-1 (01/25/02)

8C5-17 change to 8F6-1

8C5-18 change to 8F6-2

file 801fa-61

Photo fa3-73

The rear seat belt attachment brackets.



**REAR SIDE SEAT BELT
ATTACHMENT
8F6-2**

Orientation: The chamfered corner is towards the bottom rear.



6 RIVETS A5

There is one rivet between the bend and the Upright Channel

The aft end overlaps on the inside of the Bottom Rear Longeron 8F3-1A



Rivet through the Upright Channel 8F5-9

Rivet through the Bottom Rear Longeron 8F3-1A

Ensure that it is riveted to the structural members and not just the side skin.



Detail of 8F6-2

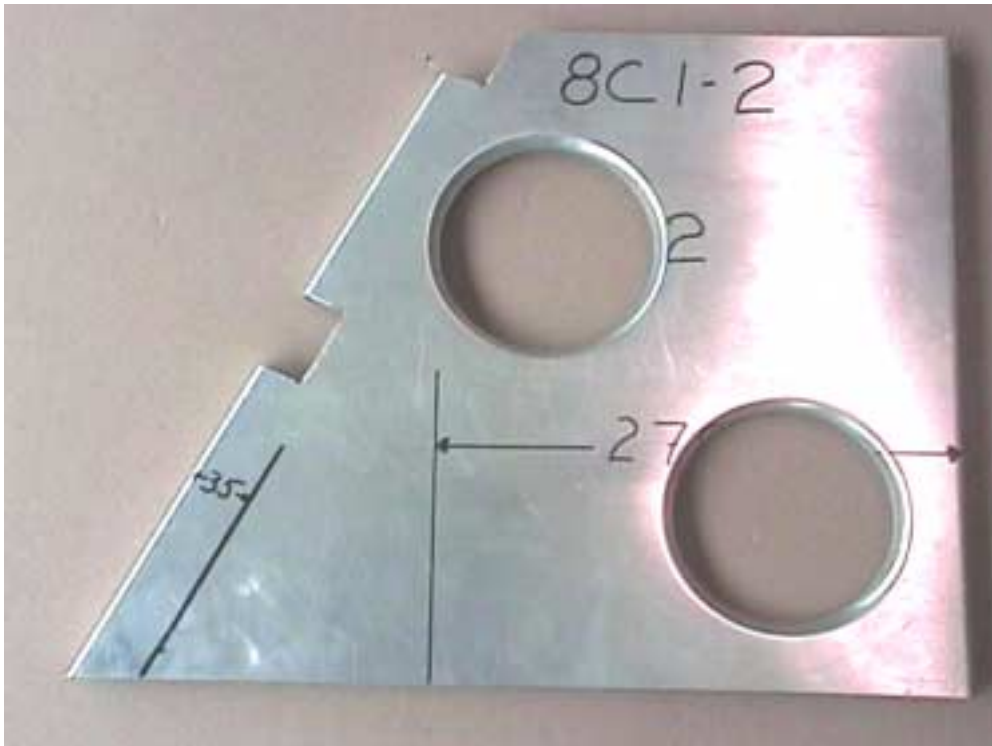
With the Seat panel and seat back in the plane.



**HORIZONTAL TAIL
BEARING SUPPORT
CHANNEL
8C1-2**

Mark the rivet line across
the front flange.

Orientation: flanged lightening holes point O/B
The Long side with no flange is the bottom
The back flange is at 90 degrees to the bottom and point O/B



Notch 35mm deep.

Note: The bores for the Bellcrank 8C1-1 are drilled later in the control section.

Start by cutting notches across the front flange for the stiffeners on the rear seat panel.



Layout the two rivets lines for the Support Channels. Distance between rivet line = 138mm

5 RIVETS A5
Between the Stiffeners
8F11-16

3 RIVETS A5
Between the bottom
Stiffener and the Center
Seat Belt Attachment
8F6-1

Check:

The end holes above and below the rivet line through the Stiffeners have adequate edge distance to the notch cutout in the Support Channel.



Cleco the Seat Back 8F11-10 to the fuselage.

From inside the fuselage overlap the front flange of the Support Channel to the backside of the Seat Back.

Check: The top and bottom the Support Channel fit between the Fuselage Bottom Skin 8F2-3A and the Baggage Floor 8F11-15. If necessary trim the top and bottom of the Support Channel to fit.



The front flange overlaps the back side of the

Note: The std "L" used to attach 8C1-2 to the fuselage bottom floor extends aft as far as the std "Z" which frames the access door.

The Support Channel 8C1-2 overlap on the O/B side of the L angles on the bottom skin, Ref 8FR-2



Inside the rear fuselage.

Detail of left Support Channel



7 RIVETS A5

8C1-2 & top L angles in corner with 8F14-15

A5 PITCH 40

8C1-2 & bottom L angle in corner with 8F2-3A

Wait to rivet the Seat Panel, the Bottom Stiffeners 8F11-12, the Seat Back and the Support Channels.

The forward flange sit tight against the rear seat panel
 The top and bottom L angle are used to secure 8C1-2 to the fuselage bottom skin and the baggage floor.