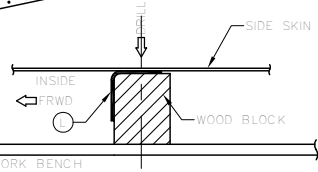


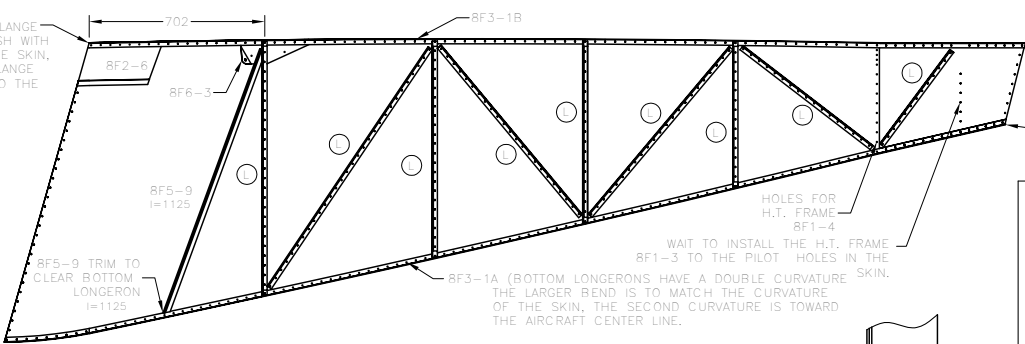
BUILDING SEQUENCE

- DRILL AND CLECO
- OVERLAP 8F2-2B ON 8F2-2A
- VERTICAL "L"; REMOVE AND TRIM
- DIAGONAL "L"; REMOVE AND TRIM
- 8F5-9
- CLAMP LONGERONS: 8F3-1B REFERENCED TOP AFT CORNER, 8F3-1A REFERENCED FRONT BOTTOM CORNER
- PLACE 8F6-3 AND 8F2-6
- TRACE THE ENDS OF THE SKIN ON THE LONGERONS, TRIM LONGERONS FLUSH WITH EDGE OF THE SKIN.
- DO NOT RIVET

DRILLING THE L ANGLES WHEN THE FLANGE CENTER LINE IS VISIBLE THROUGH THE PILOT HOLES IN THE SKIN, ANGLE IS SUPPORTED OVER A WOOD BLOCK

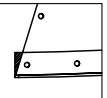
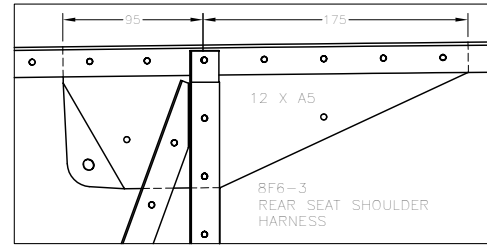
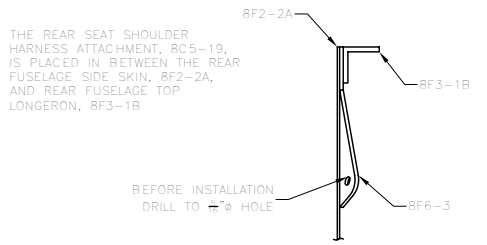
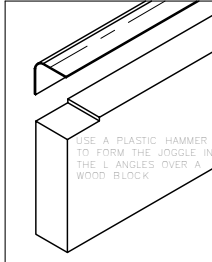


TRIM THE SIDE FLANGE OF 8F3-1B FLUSH WITH THE EDGE OF THE SKIN, TRIM THE TOP FLANGE AT 90 DEGREE TO THE SIDES.



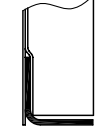
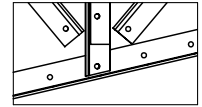
REFERENCE: ALIGN 8F3-1B FLUSH WITH TOP CORNER OF THE SKIN.

TRIM THE SIDE FLANGE OF THE LONGERONS FLUSH WITH EDGE OF SKIN AFTER DRILLED AND CLECO. THE HORIZONTAL FLANGE AT 90 DEGREE TO THE SIDES.



TRIM THE SIDE FLANGE OF 8F3-1B FLUSH WITH THE SKIN, THE BOTTOM FLANGE IS TRIMMED AT 90 DEGREE TO THE SIDE.

TRIM THE L ANGLES AFTER THEY ARE DRILLED, THEY ARE INSTALLED WITH THE ENDS OVERHANGING THE EDGE OF THE SKIN, TRACE THE EDGE OF THE SKIN ON ANGLE AND TRIM FLUSH WITH THE EDGE OF THE SKIN, THE ENDS OF THE DIAGONAL ANGLES ARE CUT AT 90 DEGREE WITH A 10MM EDGE DISTANCE TO LAST HOLE.



THE VERTICAL L's ARE JOGGLED AT THE ENDS TO OVERLAP ON TOP OF THE LONGERONS

REFERENCE: ALIGN THE FRONT CORNER OF THE BOTTOM LONGERON 8F3-1B FLUSH WITH THE FRONT BOTTOM CORNER OF THE SKIN.

STOL CH 801	ORIGINAL INFO MJM 04/24/01 REVISION INFO MJM 03/29/02	DESCRIPTION REAR FUSELAGE ASSEMBLY: SIDE SKIN	ASSY NO. 8FR-1
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