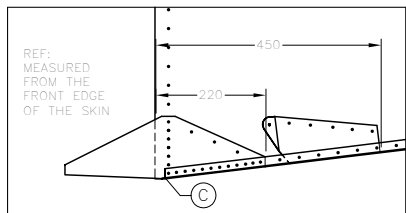
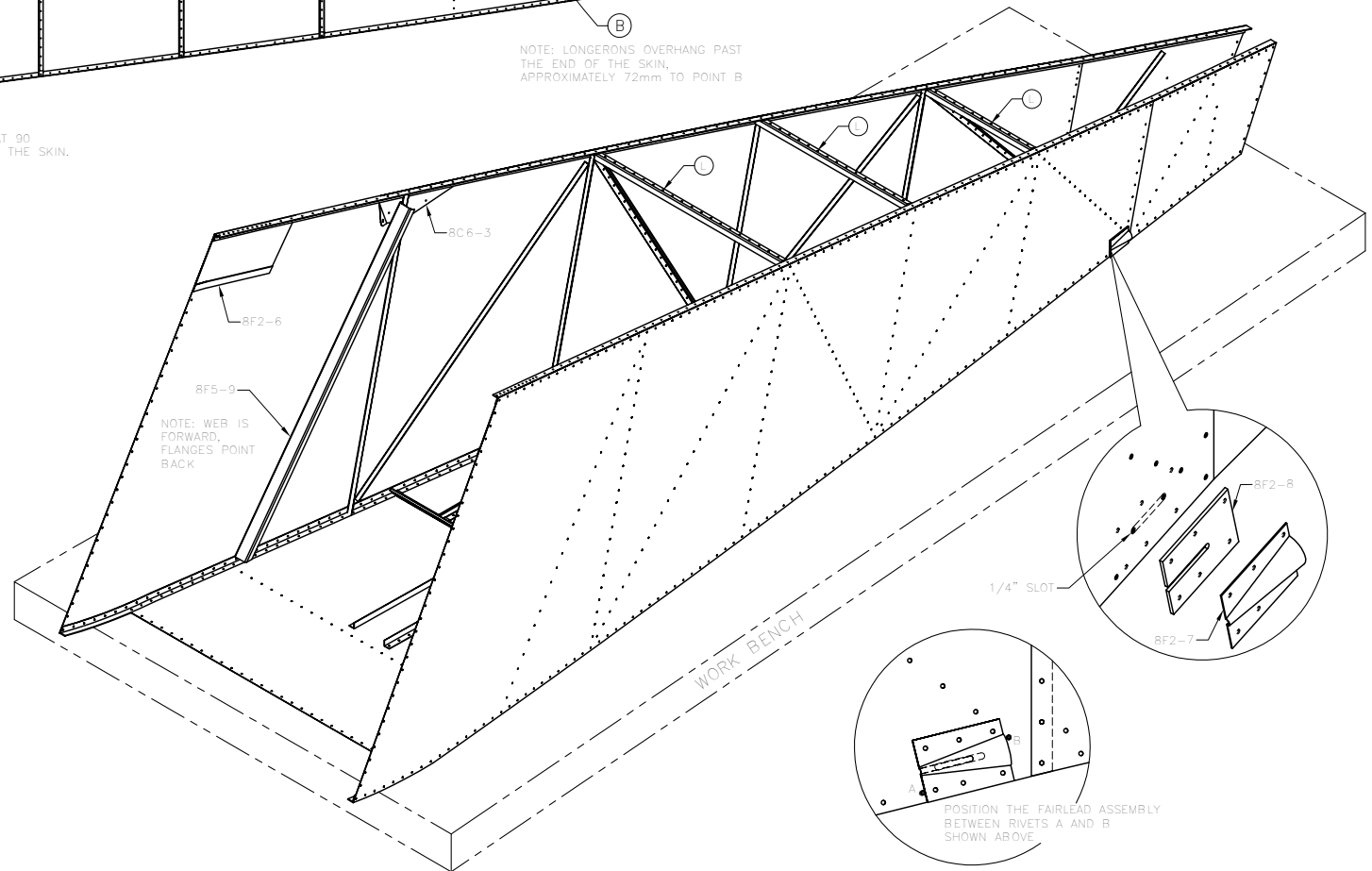


NOTE: THE FRONT EDGE OF THE TOP SKIN OVERHANGS PAST THE FRONT EDGE OF THE LONGERONS AND SIDE SKIN. (THE RIVET LINE FOR 8F5-4 AND 8F5-3 ARE IN LINE).



NOTE: GUSSET 8F3-3 t=.040" 200 TO C (LENGTH 400)



## BUILDING SEQUENCE

- LAYOUT THE CENTER LINE 8F2-1
- DRILL AND CLECO:
  - HORIZONTAL "L"; REMOVE AND TRIM
  - 8F11-13 WITH A CLECO THROUGH A HOLE ON THE CENTER LINE, DRILL WHEN THE FLANGE CENTER LINE IS VISIBLE. (WAIT TO DRILL 8F5-10)
  - 8F3-3 & 8F16-12
  - CLAMP LONGERONS: 8F3-1B REFERENCED 20mm FROM THE FRONT EDGE OF THE SKIN

- REAR FUSELAGE ASSEMBLY:** RIVET THE LONGERONS & L ANGLES TO THE BOTTOM SKIN.
- RIVET THE TOP LONGERON TO THE SIDE SKIN. CLECO SIDE SKIN TO THE BOTTOM LONGERON.
  - REMOVE THE L ANGLES FROM THE TOP SKIN TO CLECO THEM ACROSS THE TOP LONGERONS.
  - CLECO 8C5-19 AND 8F2-6 BETWEEN THE SKIN AND THE LONGERONS. RIVET THE SKIN TO THE LONGERONS AND TO THE L ANGLES. WAIT TO RIVET 8F5-9
  - RIVET THE TOP SKIN TO THE LONGERONS AND L ANGLES.

STOL  
CH 801

ORIGINAL INFO  
MJM 03/07/01  
REVISION INFO  
MJM 03/20/02

DESCRIPTION  
REAR FUSELAGE ASSEMBLY:  
TOP SKIN AND ASSEMBLING THE SKINS

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ASSY NO.

**8FR-3**