

STOL CH 801 WING ASSEMBLY

SECTION 2

“SLAT SUPPORT AND NOSE RIB ASSEMBLY”

PREPARING THE STANDARD “L” ANGLES

Compass Check

1. Prepare eight pieces of standard “L” angle.
2. Make the assembly fixture.
3. Drill all holes - Inspect.
4. Open holes to correct size.
5. Identify matched sets for future re-assembly.

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PREPARING THE STANDARD “L” ANGLES

Helpful Building Tips

1. Check photo # V2-11 to view final assembly.
2. Use the assembly fixture shown in photo V2-7.
3. Check the fit as shown in photo V2-10 - it's easy to make adjustments at this time.
4. Remember to identify the individual “sets”.

Section 2: "SLAT SUPPORT AND NOSE RIB ASSEMBLY" / PREPARING STD "L"



file V-4

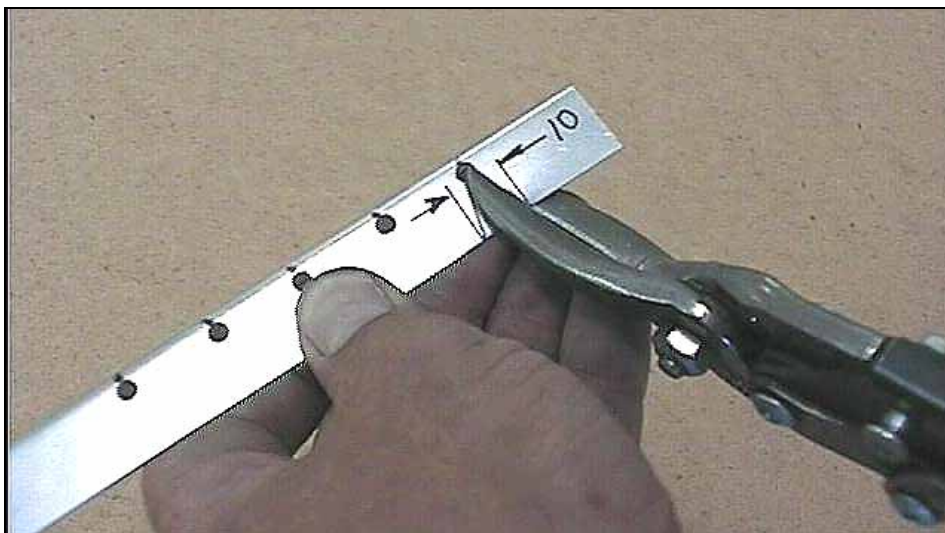
Photo V2-1

This assembly procedure affects ribs at position 1,3,5,7 only.

Parts are in matched sets identified by letters A, B, C, etc .

Slat pickups have been correctly positioned on the nose ribs and drilled at the factory.

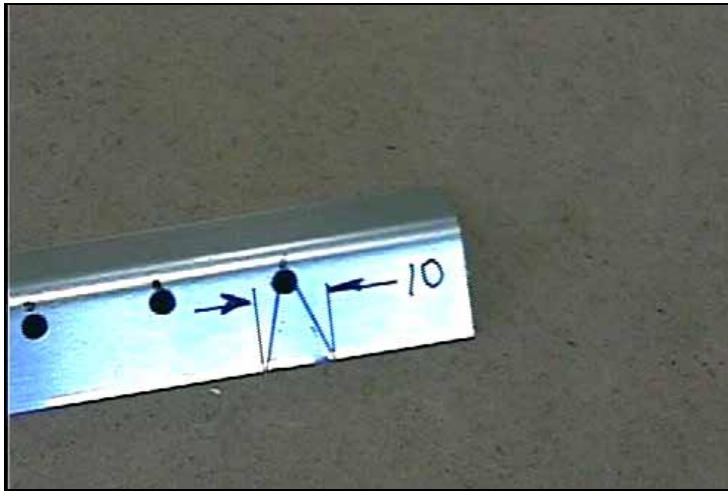
Pair them in their matched sets - but do not assemble them yet.



file V-12

Photo V2-2

Cut 8 pieces of std "L" 145 mm long.
Measure in from one end 30mm then pitch 4 more centers at 21mm.
Drill 5 holes with #20 drill at edge the of radius.

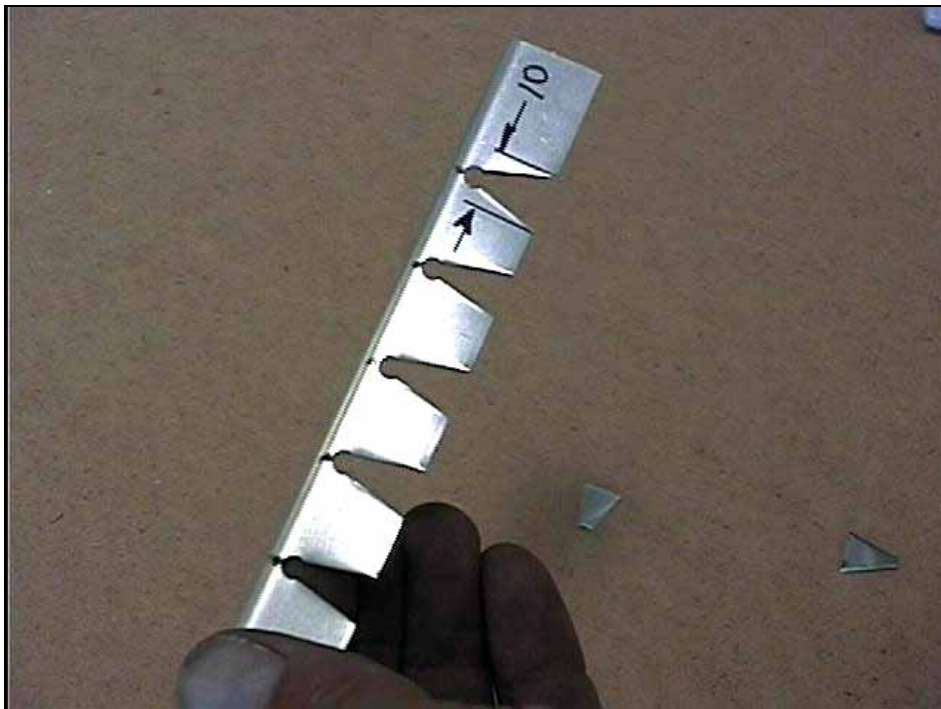


file V-13

Photo V2-3

The shown dimension of 10 mm is approximate.

Layout for the "V" notches as shown.



file V-15

Photo V2-4

Cut all five notches as shown.



file V-16

Photo V2-5

Photo illustrates making a quick prebend using the rib as a form block.

Bend "L" around nose of rib to establish the approximate shape.



file V-18

Photo V2-6

The centers marked on the "L" are just a check against the rib rivet hole locations. It is not necessary to mark these centers on the "L".

Put the "L" on top of the rib to check the bend.



file V-19

Photo V2-7

Fixture made from shipping crate material.

The space between the two blocks should be a snug slide fit for .025 material.

Keep the fixture simple. This one took only minutes to make!

A simple fixture to help install the std "L" on the nose ribs 1, 3, 5, 7 (Both wings).



file V-20

Photo V2-8

Place "L" in fixture, rib on top, push nose of rib tight against stop block (large block)



file V-21

Photo V2-9

Keep the nose rib pressed tightly against the 2 x 4 block.

Drill first hole and cleco 3/32 drill.
Rotate rib and drill and cleco drill all holes into "L".



file V-23

Photo V2-10

Slight adjustments can be made at this time since all holes will be opened with a #20 drill later. - see photo V2-11

Wrap a piece of .025 material around nose of ribs to check fit of "L".
The strip represents the fitting of the leading edge skin.



Re cleco with 5/32 cleco's as drilling proceeds.

file V-24

Photo V2-11

Assemble the correct slat pickup and "L" angle to the nose rib. Open the rivet holes with a #20 drill.



file V-25

Photo V2-12

Identify all sets of parts with a letter or number.
Set all parts aside, riveting is done later during the installation of wing skins.

I have checked my work and parts list and confirm to myself, that all items listed in this portion of the elevator hinge have been installed.

Signed: _____ Date: _____

Revision List:

Revision	Summary	Revised By:	Date:
3.0	Reformat	SH	8/12/1999