

STOL CH 801 WING ASSEMBLY

SECTION 3

“Rear Wing Spar Assembly”

And

“Rear Strut Attachment Bracket”

Compass Check

1. Check the orientation of the parts.
2. Mark the center on the splice.
3. Clamp the parts in position.
4. Check the alignment.
5. Drill and re-check the alignment.
6. Open the holes and rivet the parts together.

STOL CH 801 WING ASSEMBLY

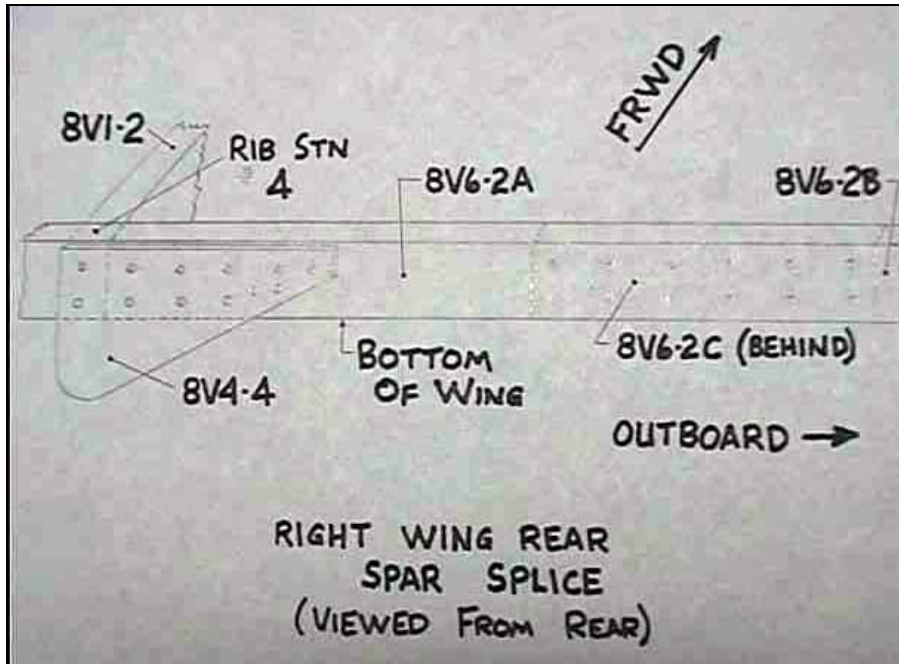
SECTION 3

“Rear Wing Spar Assembly” And “Rear Strut Attachment Bracket”

Helpful Building Tips

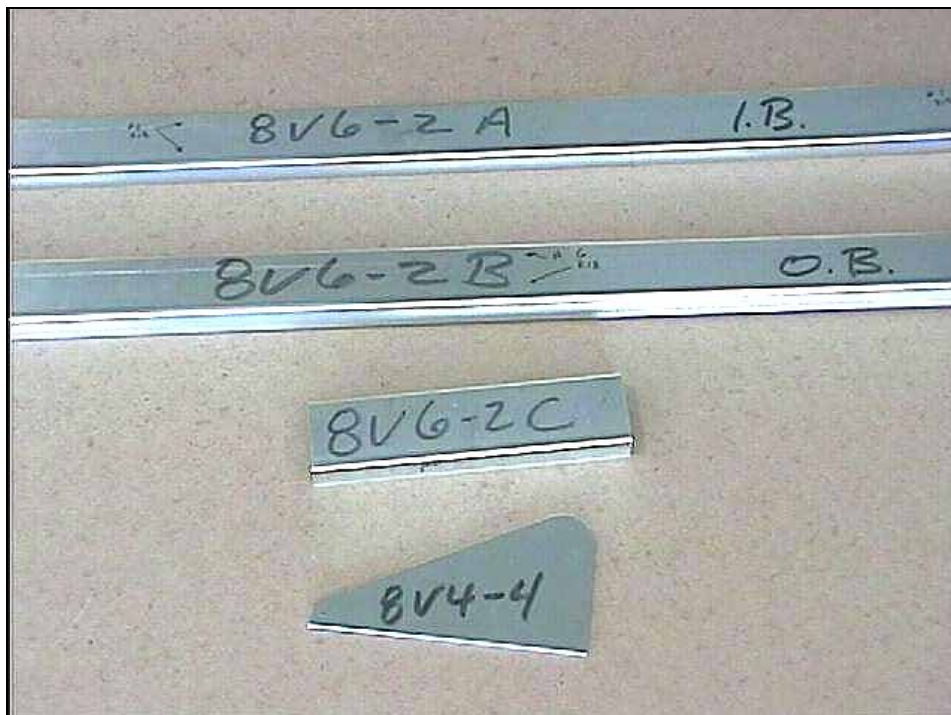
1. Set both assemblies on the table to check the position of the parts prior to drilling.
2. Work on a flat table.
3. The longest section of channel will be assembled towards the inboard side of the wings.
4. The predrilled holes and flange angle provide the best indicator to determine the positioning of the channels.
5. A thread stretched taught about 1/8” from the edge of the channel flange provides an excellent straight edge.

Section 3: Rear Wing Spar Assembly And Rear Strut Attachment Bracket



file V200-95

Photo V3-0



file V-26

Photo V3-1

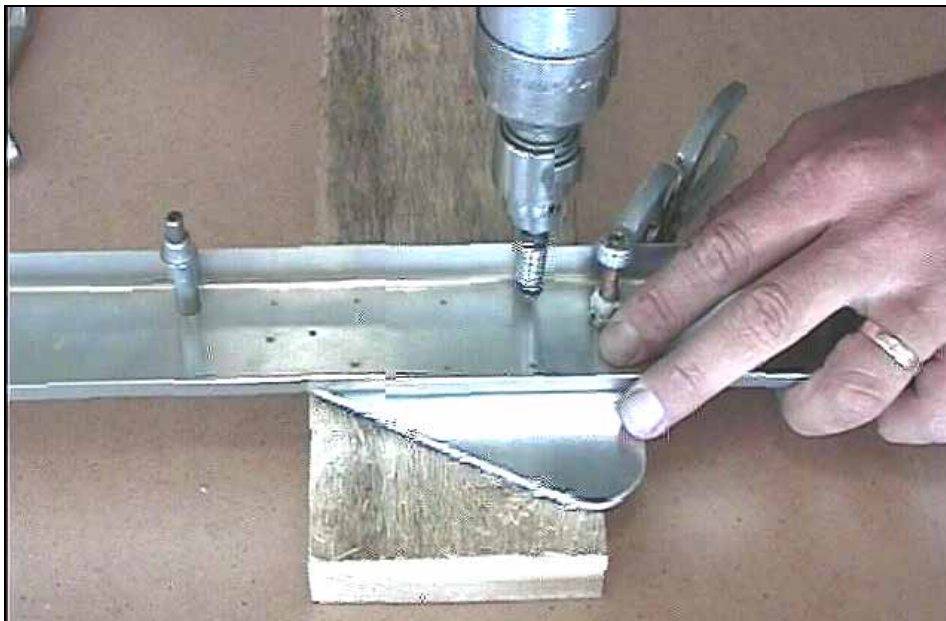
Build a total of two assemblies.
One left, one right.

The two assemblies will be mirror images of one another.

The top edge of the spar has a 90° flange.

The parts required.

Before doing any drilling place the parts for both spars in position on the bench. Confirm the correct orientation by locating the 90° flange and predrilled holes for the splice bracket 8V4-4.



file V-27

Photo V3-2

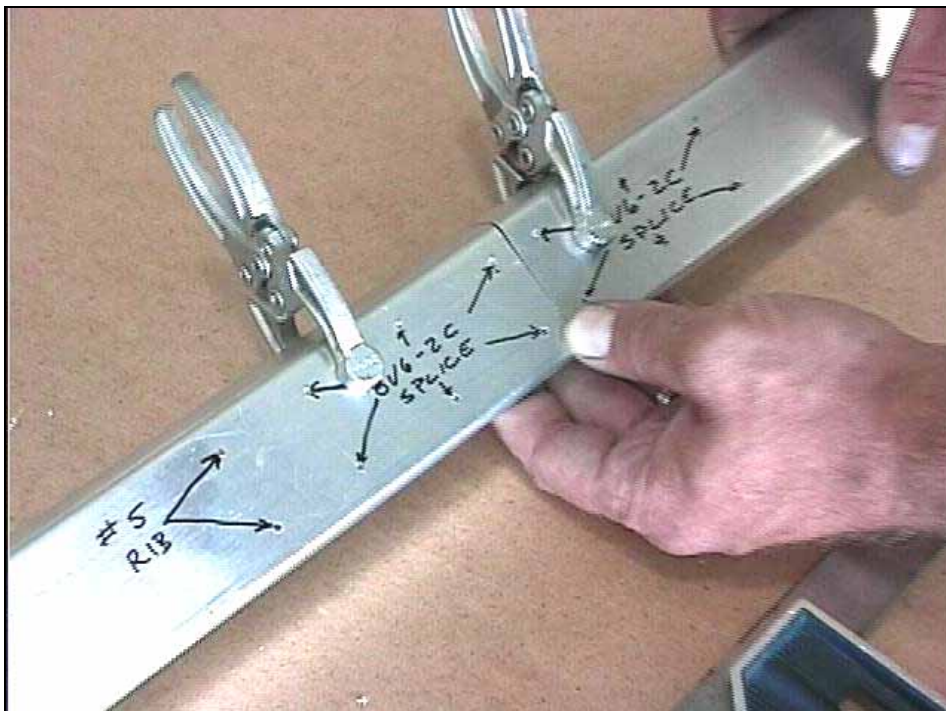
Right wing spar is shown in this photo.

The spar has predrilled holes to locate bracket 8V4-4.

Bracket 8V4-4 has one predrilled hole located at the most outbound position.

The bracket 8V4-4 points to the lower side of the wing.

Install one cleco at the most outboard position. Align the top edge so that it is parallel with the flange on the channel, clamp and drill all the holes in bracket 8V4-4 - Drill size is #20. Identify bracket ie. Left or right and place aside for now.



file V-28

Photo V3-3

Mark the centerline on the splice and position it behind the channels with the centerline at the joint. See photo V3-8.



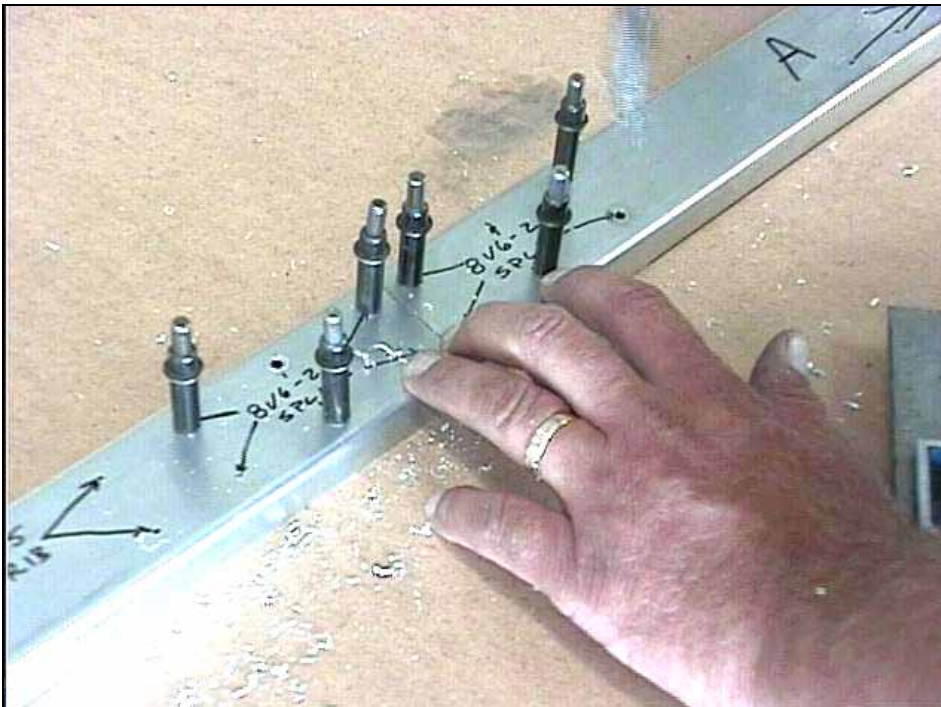
file V-29

Photo V3-4

The wing will only be as straight as the spar.

Take time to assure parts are aligned properly.

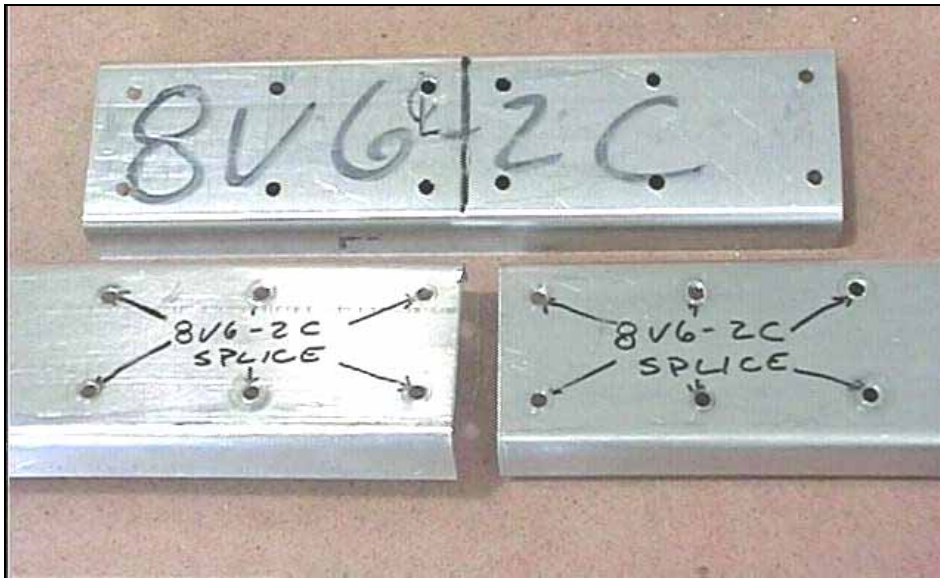
Spar kept flat on table to keep splice straight. Use a 3/32 drill.



file V-30

Photo V3-5

After confirming the straightness of the splice open the holes with a #20 drill. Cleco as drilling progresses.

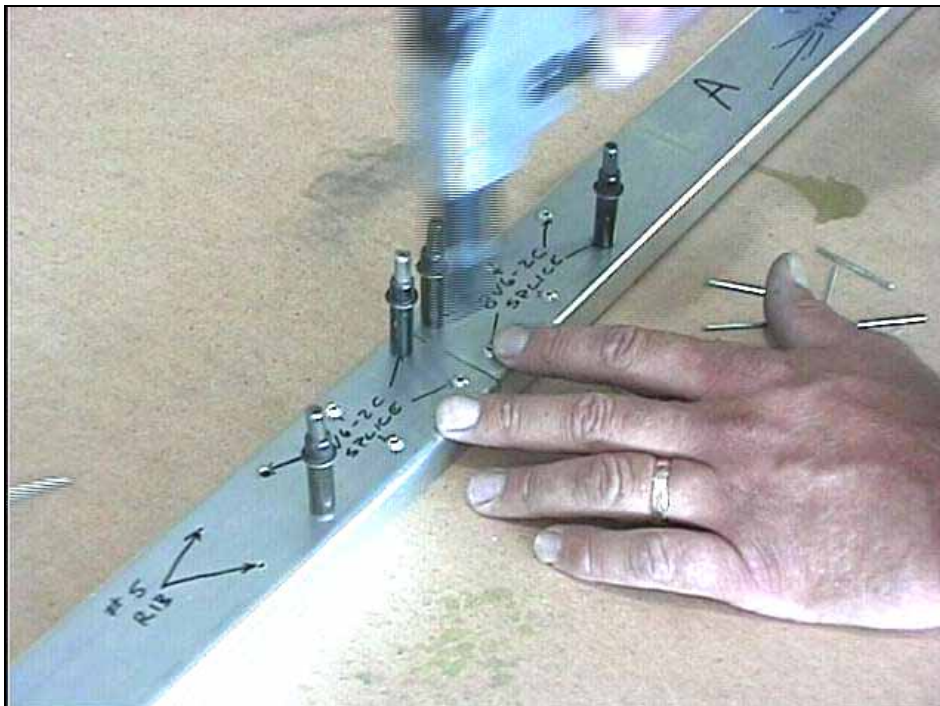


The centerline on the splice plate will allow confirmation of positioning prior to drilling.

file V-31

Photo V3-6

Drilled and deburred parts.



file V-32

Photo V3-7

Rivet together - A5 rivets

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: _____

