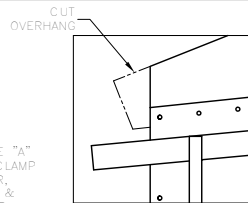


BUILDING SEQUENCE

REAR SKIN: - CUT ALONG BOTTOM LINE (FIRST MAKE A ROUGH CUT 1/2" FROM THE LINE THEN TRIM ON THE LINE) TRIM EACH SIDE SEPARATELY.
 - USE BODY FILE TO FILE A SMOOTH FINISH ON THE TRIMMED EDGE.
 - SET UP THE TWO 2x4" BOARDS WITH THE 32mm SPACER
 - CHECK: THE RIB FLANGE CENTER LINES ARE CLEARLY VISIBLE.
 - ALIGN THE PILOT HOLES IN THE SKIN WITH THE RIVET LINE IN THE SPAR.

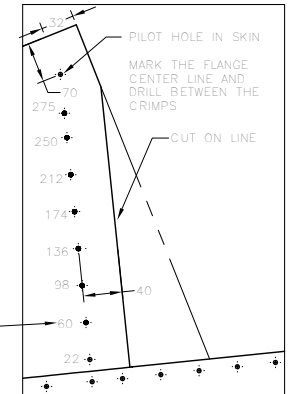
TIP RIB: THE TOP EDGE OF THE SKIN STOPS WHERE THE BEND RADIUS ENDS ON THE TIP RIB. CLECO TO THE SPAR, THEN TO THE SKIN.

NOSE SKIN: - SLIDE THE SKIN BETWEEN THE SPAR AND THE REAR SKIN
 - ADJUST THE NOSE RIB TO CLECO C AND D
 - ADJUST THE SKIN AND NOSE RIB UNTIL IT IS 90 DEGREE WITH THE SPAR
 - USE A STRAP TO HOLD SKIN OVER THE RADIUS OF THE TIP RIB.

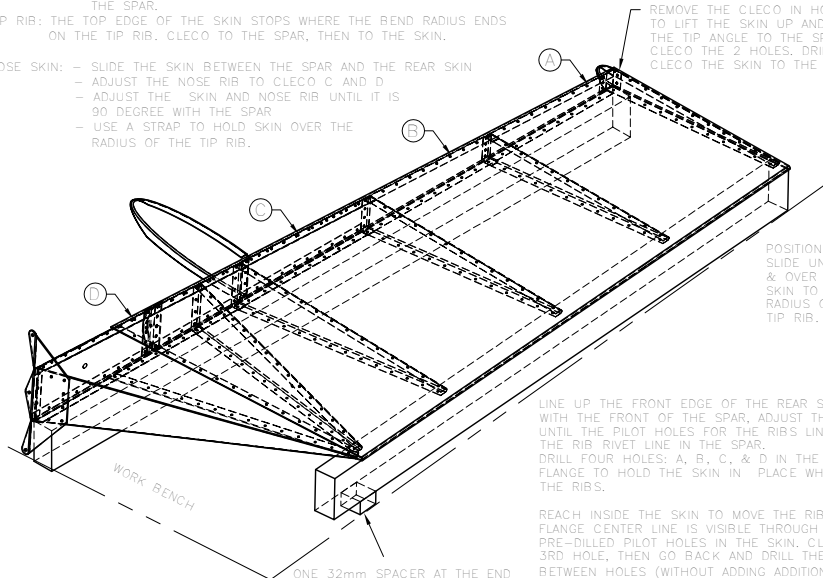


LAYOUT: TRACE ALONG THE INSIDE OF THE SKIN AROUND THE TIP RIB TO MARK THE OVERHANG.

THE RUDDER JIG CONVENIENTLY HOLDS THE RUDDER ASSEMBLY IN AN UPRIGHT POSITION TO INSTALL THE NOSE SKIN. CHECK THE RIB FLANGE CENTER LINE IS CLEARLY VISIBLE; THE RIB IS APPROXIMATELY 90 DEGREES TO THE SPAR. SLIP THE SKIN IN BETWEEN THE SPAR AND THE REAR SKIN, THEN INSERT THE 1x2" STRIP INTO THE CUT OUT NOTCH IN THE JIG. PUSH DOWN ON THE SKIN TO ALIGN THE RADIUS WITH THE NOSE RIB. DRILL & CLECO HOLES: E & F THROUGH THE RIB FLANGE CENTER LINE. USE A STRAP TO KEEP THE NOSE SKIN OVER THE RIB IS AT 90 DEGREES WITH THE SPAR. DRILL & CLECO HOLE: G. DRILL & CLECO EVERY 3RD HOLE THEN GO BACK AND DRILL THE IN BETWEEN HOLES.



LAYOUT A 40mm OFFSET LINE FROM THE RIB FLANGE CENTER LINE. TRIM ALONG THE LINE.



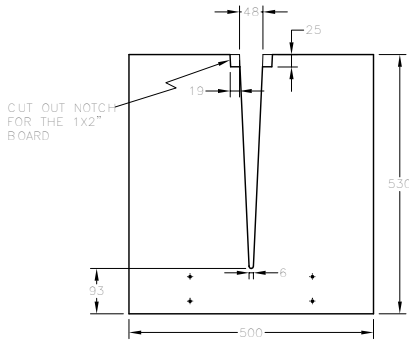
POSITION OF STRAP: SLIDE UNDER JIG & OVER THE NOSE SKIN TO PUSH THE RADIUS OVER THE TIP RIB.

LINE UP THE FRONT EDGE OF THE REAR SKIN FLUSH WITH THE FRONT OF THE SPAR, ADJUST THE SKIN UNTIL THE PILOT HOLES FOR THE RIBS LINE UP WITH THE RIB RIVET LINE IN THE SPAR. DRILL FOUR HOLES: A, B, C, & D IN THE SPAR FLANGE TO HOLD THE SKIN IN PLACE WHILE DRILLING THE RIBS.

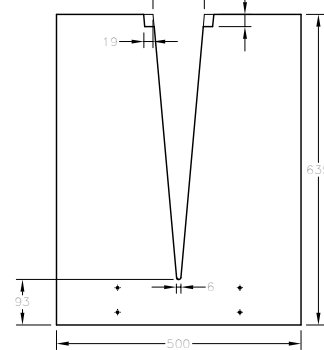
REACH INSIDE THE SKIN TO MOVE THE RIB UNTIL THE FLANGE CENTER LINE IS VISIBLE THROUGH THE PRE-DILLED PILOT HOLES IN THE SKIN. CLECO EVERY 3RD HOLE, THEN GO BACK AND DRILL THE IN BETWEEN HOLES (WITHOUT ADDING ADDITIONAL CLECOES).

TURN THE RUDDER OVER, ADJUST THE 2x4" AND THE 32mm SPACER. DRILL & CLECO THE RIBS.

ONE 32mm SPACER AT THE END OF THE BOTTOM RIB. THE SPACER IS TO CENTER THE TRAILING EDGE IN LINE WITH THE AIRCRAFT CENTER. **NOTE:** THE TAPERED SPAR.

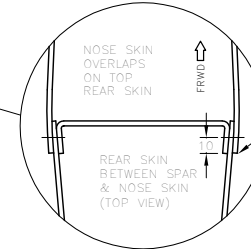
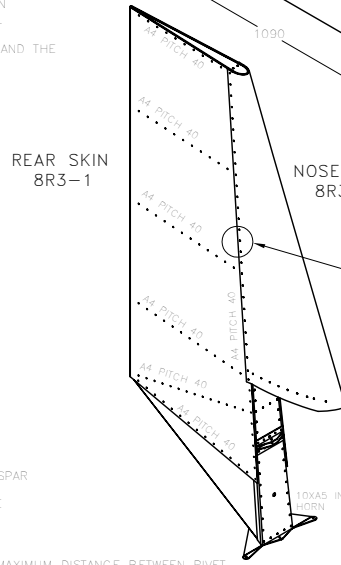


CUT OUT NOTCH FOR THE 1x2" BOARD

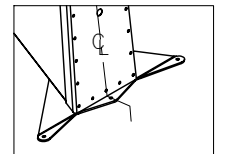
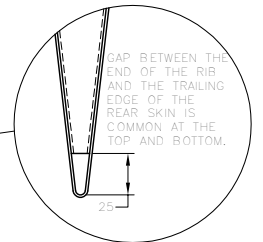


REAR SKIN 8R3-1

NOSE SKIN 8R3-2



MARK A 10mm OFFSET LINE FROM THE RIVET LINE AND TRIM-OFF EXCESS MATERIAL



OPTIONAL 1/2" PLYWOOD JIG, SLIDE THE RUDDER ASSEMBLY IN THE THE JIG, SLIDE THE NOSE SKIN BETWEEN THE SPAR AND THE REAR SKIN THEN ADD THE 1x2" STRIP TO PUSH THE REAR SKIN ON THE SPAR. IF THE JIG IS NOT MADE, INSTALL THE NOSE SKIN WITH THE RUDDER ASSEMBLY ON THE 2x4 BEAMS WITH THE 32mm SPACER BETWEEN THE WORKBENCH AND THE BEAM AT THE BOTTOM OF THE RUDDER.

PITCH IS THE MAXIMUM DISTANCE BETWEEN RIVET PITCH40 = RIVET SPACING APPROXIMATELY 40mm

STOL CH 801	ORIGINAL INFO MJM 06/19/00 REVISION INFO MJM 02/25/02	DESCRIPTION	ASSY NO.
		INSTALLATION OF REAR SKIN, AND NOSE SKIN	8RU-2
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