

## STOL CH 801

### AIRCRAFT FINISHING “Assembling the Front Seat Frames”



**STOL CH 801 Front Seat**  
(shown with custom leather upholstery)

- The front seat frame assembly is supplied without upholstery.
- The seat back is hinged at the bottom to allow the seat back to fold forward for convenient access to the rear seat area.
- The seat is adjustable before boarding the aircraft.



Photo fs1-a

The Seat Lock Rod 8F10-10 (3/16-inch diameter) locks the seat assembly to the fuselage.

Front left seat. Seat set in the full back position.

- The seat position is set prior to boarding the aircraft.
- To adjust the seat position: With the door open and the seat unoccupied, rotate the handle of the Seat Lock Rod forward and pull the rod completely out. Move the seat to the desired position, insert the rod through the hole in line with the Seat Lock Cross Tube 6F10-8 & 9, and turn the handle back to the locked position.

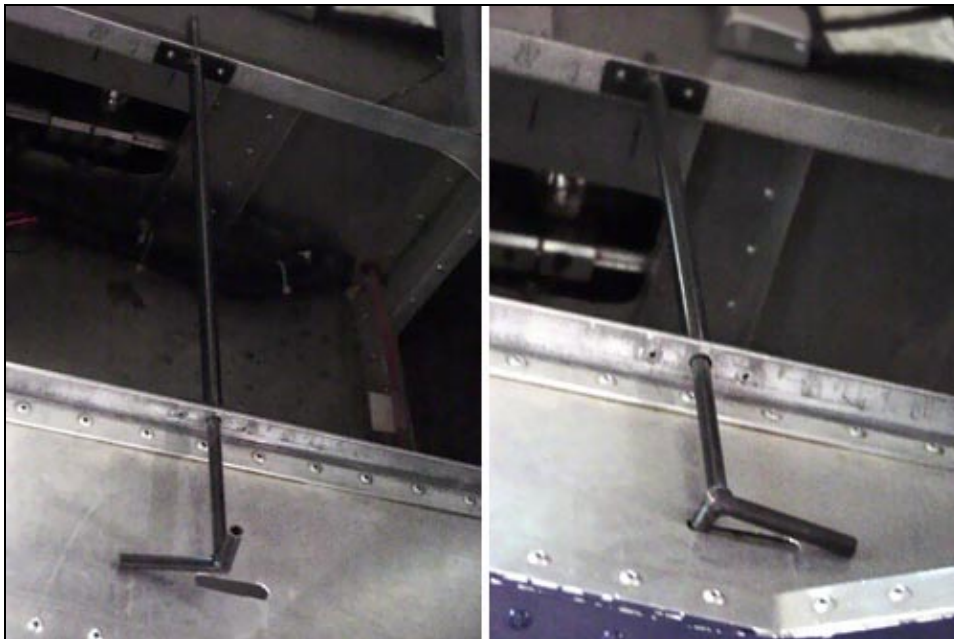


Photo fs1-b

The Seat Lock Rod 8F10-10 has a long arm (handle) and a short arm (lock).

Location of the slot cut-out in the seat panel 8F16-1:  
55 mm. from the fuselage skin, approx. 35 mm. long for the lock arm. In the locked position the handle makes contact with the skin.

- Left Side: The handle of the Seat Lock Rod is turned forward (to disengage the lock) to pull the rod out.
- Right Side: The handle is turned back to engage the short arm in the slot to lock the Seat Lock Rod.



Photo fs1-1

- 8F20-1: Front Seat Pan
- 8F20-2: Hinge Brackets: Left and right steel welded assembly (shown in black).
- 8F20-5: Front Seat Forward Stiffener
- 8F20-6: Front Seat Rear Stiffener

The black strip shown attached to 8F20-5 is a strip of “velcro” to hold the seat cushion.

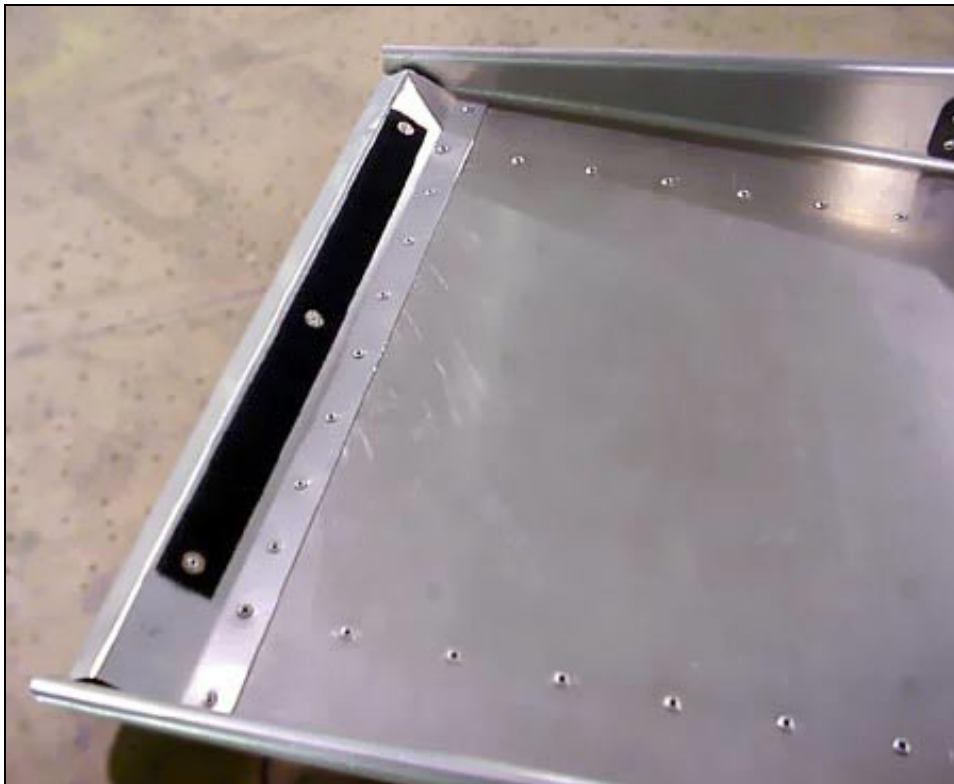


Photo fs1-5

The front seat forward stiffener 8F20-5 is positioned inside the seat pan 8F10-1. Two rivet lines: one through the front; the other through the rear flange of 8F20-5: A4, pitch 40. (The front flange is riveted from the bottom side).

The black strip shown attached to 8F20-5 is a strip of “velcro” to hold the seat cushion.

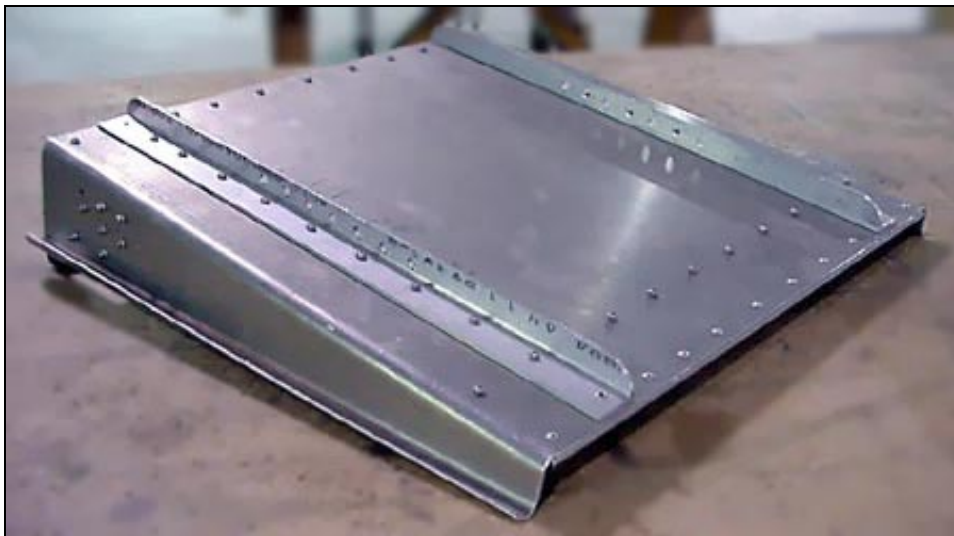
Note: Rivet at the intersection with 8F20-7 on the underside of the seat pan.



Front seat tray – View from front

Photo fs1-2

8F20-6: Front Seat Rear Stiffener: 20 mm. cut-out in top flange of the extrusion for the seat back frame 8F20-3. Drill and rivet A5, pitch 40.



8F20-7: Front Seat Adjustment Extrusions.

Position the extrusions on top of 8F16-4 to mark the height of the center of the rod 8F10-10.

Drill 7 3/16" position holes in the extrusion. First hole is 120 mm. from the front of the extrusion. Hole spacing: 20 mm.

Photo fs1-3

The extrusions are centered on the seat – the inside distance between 8F20-7 is the outside distance between the seat attachment brackets 8F16-1 of the riveted forward fuselage assembly.

The left and right seats are equidistant from the aircraft centerline. Measure the distance from the centerline of the left seat to the aircraft centerline. Use this measurement to set the distance of the left seat. Note: The right seat is not centered on the extrusions.

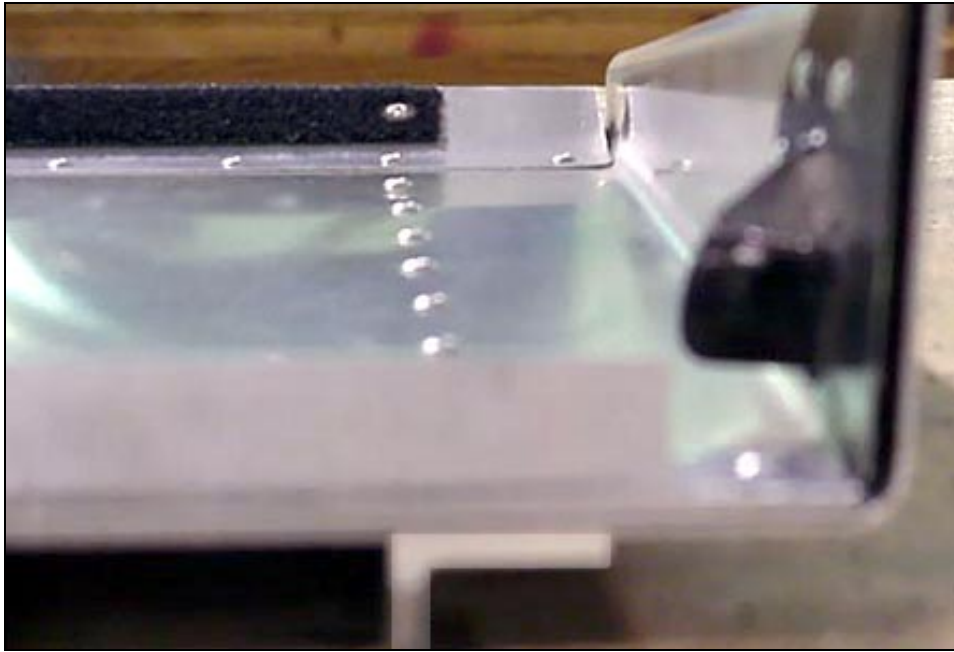


Photo fs1-4

The front seat tray –  
view from back of seat.

Work on the left seat  
first.

The seat pan is centered  
between 8F16-1

Install 8F20-7 square to the front edge of the seat pan 8F20-1. Drill and cleco one side. Align to the fuselage and insert the Seat Lock Rod 8F10-10 and position the second side extrusion through the corresponding hole..

Drill and rivet 8F20-7 to 8F20-1. A5 rivets, pitch 40.

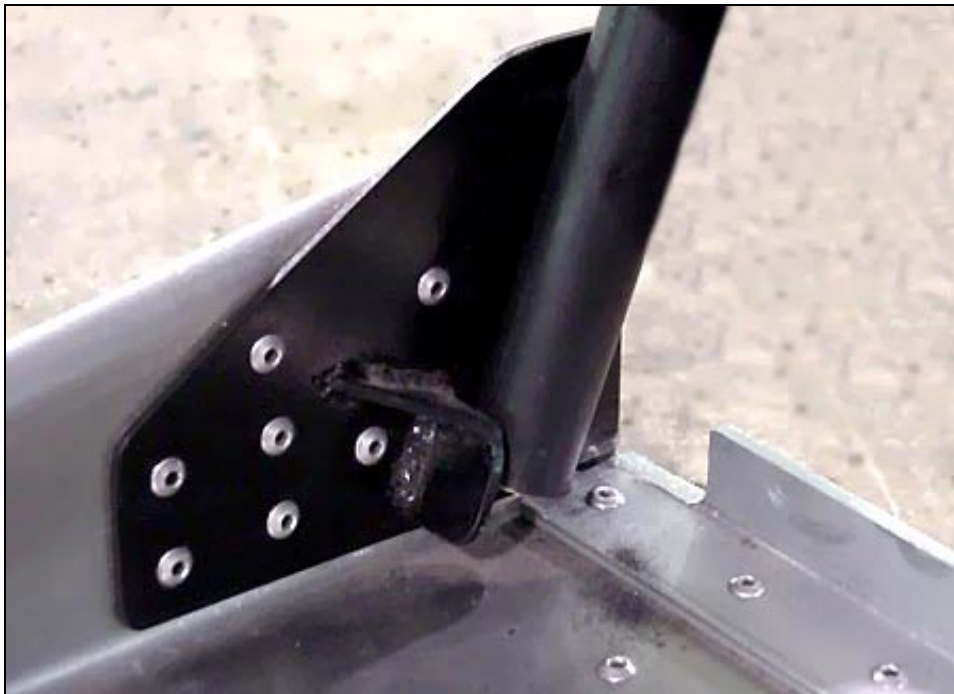


Photo fs1-7

Left side of seat shown –  
inside view.

8F20-3: Seat Back  
Frame.

8 x AS5 stainless-steel rivets in hinge brackets 8F20-2. First clamp the brackets to the seat pan. Adjust the height of the brackets for clearance between the bottom of the seat back frame 8F20-3 and rivet in stiffener 8F20-6.



Left side of seat shown – outside view.

Photo fs1-8

Welded rods on the sides of the Seat Back Frame fit in the ¼-inch hole in the Hinge Brackets 8F20-2.

Drill a 1/16-inch hole in the rod for a AN380-2-2 Cotter Pin.



Seat Back Frame 8F20-3: shown as supplied (welded assembly).

Photo fs1-9

The Seat Back Frame.

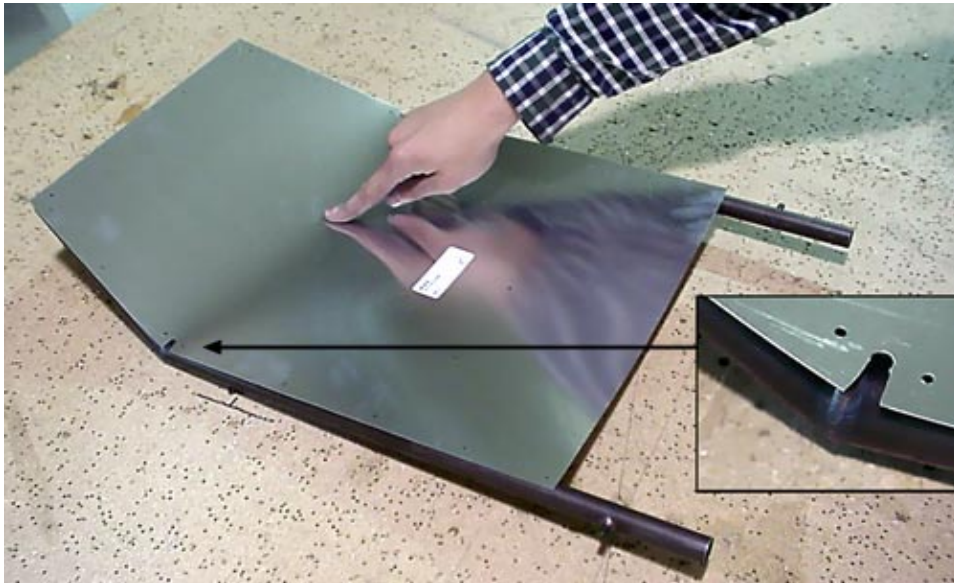


Photo fs1-10

The Seat Back Panel 8F20-4 Frame on the Seat Back Frame 8F20-3.

- Rivet on the front side of the Seat Back Frame with A4 rivets in the pre-drilled pilot holes.
- Align relief hole in at the bend (photo detail) – push in the middle of the skin before drilling (as shown).
- Finish the panel by hammering the edges of the panel around the tube frame.