

*Serial
tail
1580*

INSTRUCTIONS FOR INSTALLATION OF THE RULETO MODEL
5FK-1 METAL FUSELAGE KIT FOR STINSON 108 SERIES AIRPLANES

- 1 Remove wings, all fairings around doors and windows, stringers, and all fabric down to the bare welded fuselage frame. Remove rear seats.
- 2 Remove all clips from old discarded stringers, and replace clips at stations from which they were removed. Note: THESE CLIPS ARE TO BE REUSED WITH THE NEW FORMERS. If desired lift handle at tail section may be cut off. Between stations 46.25 and 100.00 cut off small channel tabs along left and right sides. (NOTE: Do not cut off any of the tubular tabs). Aft of station 58.00 cut off existing left and right cabin top formers. (NOTE: Do not cut off any tubular tabs).
- 3 CLEAN ALL FRAME MEMBERS THOROUGHLY BEFORE RE-CHROMATING.
- 4 Take new formers as marked for top and bottom, and place at stations marked on formers with markings facing front of ship. Place these snugly against frame, and clamp to clips with small "C" clamps temporarily.
- 5 The tabs that are on each side of the fuselage frame, to which the Longerons are to be attached are to be cut so that they are all of equal length. Place each longeron as marked on these tabs, and rivet in place, keeping a natural contour in the longerons, maintaining alignment as near as possible with the contour of the ship.
- 6 At stations 30.50 and 188.55 locate centers at top. Use chalk line between these points to establish centers for all stations on top. Use same procedure from stations 18.75 to 202.10 to establish centers for all stations at bottom.
- 7 Take metal Skin Sections marked (#2 ToP), right and left, and cleco together. Lay these skin sections with chromated side next to formers, placing clecoed section in center of former or chalk line. Place the forward edge of these skin sections even with the forward edge of former 90.50. Drill and cleco one center hole through skins and former #90.50. Do likewise with formers at each station working toward rear of ship.
- 8 Place light webbing or soft cotton rope over these skin sections, and around entire fuselage frame at stations 90.50 and station 164.00. Tighten webbing or rope to form skin to contour of the formers.
- 9 Drill and rivet each station (EXCEPT STATION 90.50), starting from centers working outward. (NOTE: All rivets to be placed on 1 1/2" centers), using rivets furnished with kit. Maintain 1/4" edge distance on edges of formers.
- 10 Place #3 Top skin to lap over #2 Top Skin (over station 90.50), and center of skin over center line of formers, and pilot drill through skins and former, and cleco in place. Center #3 Top skin over center of former 58.00, and drill and cleco one center hole. Any excessive material lapping lower edge of formers may be trimmed or not trimmed as desired.