

PROCEDURE 4.140

WINDOW INSTALLATION

In this procedure...

The aft cabin windows, door windows and windscreen will be trim and installed in their respective positions.

Supplied Material:

<u>Part No</u>	<u>Qty</u>	<u>Description</u>
112-61-021-01	1	Window, Aft Left
112-61-021-02	1	Window, Aft Right
112-61-020-01	1	Window, Door Left
112-61-020-02	1	Window, Door Right
1112-61-022	1	Windscreen

Step 1. Prepare window joggle area.

Use sand paper and remove all the gel coat from the window joggle area extending approximately 1" on to the side of the fuselage around the entire window opening.

Step 2. Trim windows to fit joggle.

Place the window over joggle area and mark the window outline. Using a 2-fluted bit in a router or a band saw cut out the window. Use caution not to cut the window to small. It is best to cut the window approximately 1/8" oversize and sand to final shape using a belt sander. This allows you to remove all rough area, which could cause a high stress line and break the window.

Step 3. Laminate window into joggle.

Mask the window so that you do not drip resin onto the window surface. Apply a mixture of milled fiber and cabosil to the joggle area. Carefully fit the window into position. Use shims in several areas to insure that the window fits flush with the outer skin of the aircraft. Hold the window in place by drill several small 1/8" holes through the **fiberglass** just outside of the window and install a 1/8" bolt with large area washer lapping onto the edge of the window. **Clean off all the excess milled fiber from the inside of the fuselage before it cures.** The better the inside edge is finished off at this time the easier it will be to finish the window for upholstery.

Step 4. Laminate tapes around window.

After the milled fiber is cured sand it smooth and laminate two plies of 2" cloth around the window. Lap the cloth half on the window and half on the fiberglass fuselage. When cured body work to a smooth finish.

Note: It is recommend that you start with the rear windows, to gain proficiency prior to installing the windscreen. **The doors should be fit and locked in place while installing the window.** If the engine mount and engine have been installed prior to installing the windscreen the weight of the engine should be removed from the fuselage prior to installing the windscreen.